

G6535436

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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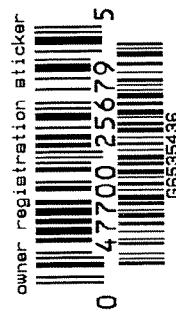
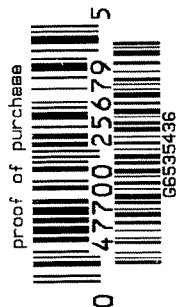
SERIAL NO.



**M/24 7.62 NATO S.W.S.
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
COMPLETE SYSTEM - LE/EXPORT**

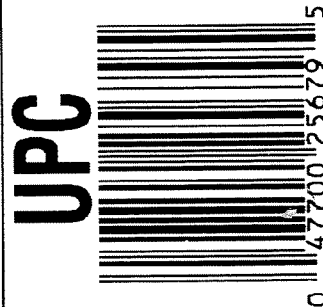
98606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB

DD FORM 96253



ORDER NO.	25679
BARREL LENGTH	24"
CAPACITY	6

G6535436



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G653 5436

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		2-21-06	RTZ
440	PROOF		2-21-06	RTZ
460	CHECK HEADSPACE	MAGNA-FLUX	2-21-06	RTZ
470	DIS-ASSEMBLE ACTION	INSPECTED	2-21-06	RR
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 460 FEB 24 2006 OPERATOR CPD	2-24-06	APD
500	ROLLMARK CALIBER		2-24-06	CW
510	DRILL AND TAP SIGHT HOLES		2-23-06	TRLJ
520	GOFF BLAST BBL / REC		3/1/06	RC
530 & 540	APPLY COATINGS (BARREL ACTION)		3/7	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3/31/06	mgd
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3/31/06	mgd
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3/31/06	mgd
	D) OIL FIRING PIN ASSEMBLY		4-6-06	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		4-20-06	MTM

REV-8405

OP # OPERATION NAME		READINGS			DATE	INITIAL		
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7 lbs.</u>	<u>7 lbs.</u>	<u>7 lbs.</u>	4-20-06	MTM		
CONT.								
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4 lbs.</u>	<u>4 lbs.</u>	<u>4 lbs.</u>	4-20-06	MTM		
	H) TRIGGER PULL TEST AND RETAINABILITY				4-20-06	MTM		
	I) FIRING PIN INDENT .020 MIN	<u>.021</u>	<u>.021</u>	<u>.022</u>	4-20-06	MTM		
	J) ASSEMBLE STOCK				4-6-06	RTZ		
	K) ASSEMBLE SWIVEL STUDS				4-20-06	L.P.D.		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				4-6-06	RTZ		
	M) IRON SIGHT ALIGNMENT				4-6-06	RTZ		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				4-6-06	RTZ		
640 & 650	FUNCTION TEST AND TARGET	PASS	FAIL		4-7-06	MTM		
		PASS	FAIL					
	MALFUNCTION	CORRECTION						
	MALFUNCTION	CORRECTION	N/A					
	MALFUNCTION	CORRECTION						
	MALFUNCTION	CORRECTION						
660	INSPECT FOR LIVE AMMO				4-7-06	L.P.D.		
670	FINAL INSPECTION A) HEADSPACE				4-20-06	MTM		
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.17</u>	<u>2.02</u>	<u>2.12</u>	<u>2.24</u>	<u>2.08</u>	4-18-06	A
	C) FUNCTION				4-20-06	MTM		
690	PACK				4-24-06	OK		

BARBER - M24 0092288
**AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS**

2.50 LBS (plus or minus 0.50 LBS)
3.00 LBS (plus or minus 0.75 LBS)
4.00 LBS (plus or minus 1.00 LBS)

DATE 4/4/06

TESTER MMJ

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	251	263		257	
PULL #2	245	266		256	
PULL #3	260	251		249	
PULL #4	259	250		262	
PULL #5	244	246		261	
TOTAL	1259	1276		1285	
AVERAGE	251	255		257	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	302	306		
PULL #2	312	302		
PULL #3	307	310		
PULL #4	304	310		
PULL #5	295	310		
TOTAL	1520	1538		
AVERAGE	304	307		

	4.00 LBS INITIAL	4.00 LBS AFTER 20 CYCLES	MAX SETTING GREATER THAN 4 LBS	RESET TO 4 LBS FOR TARGET & ACCURACY
PULL #1	401	397		408
PULL #2	399	398		413
PULL #3	404	406		396
PULL #4	398	405		400
PULL #5	403	406		401
TOTAL	2005	2012		2018
AVERAGE	401	402		403

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6535436.___0
FILE DATE AND TIME: 04/07/2006 15:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.045
The Average Y Centroid of the Five Target Set:	-0.050
The Average Point of Impact of the Five Target Set:	0.067
The Average Mean Radius of the Five Target Set:	0.604
The Distance from POA to Centroid Target #1:	0.024
The Distance from Centroid Target #2 to Centroid Target #1:	0.088
The Distance from Centroid Target #3 to Centroid Target #1:	0.076
The Distance from Centroid Target #4 to Centroid Target #1:	0.178
The Distance from Centroid Target #5 to Centroid Target #1:	0.139

SERIAL NUMBER: G6535436. 0

TARGET NUMBER: 1

FILE DATE: 04/07/2006

FILE TIME: 15:22

X CENTROID: 0.014

Y CENTROID: -0.019

POA TO CENTROID: 0.024

HORZ SPREAD: 1.290

VERT SPREAD: 2.300

GROUP SPREAD: 2.300

MIN RADIUS: 0.150

MAX RADIUS: 1.311

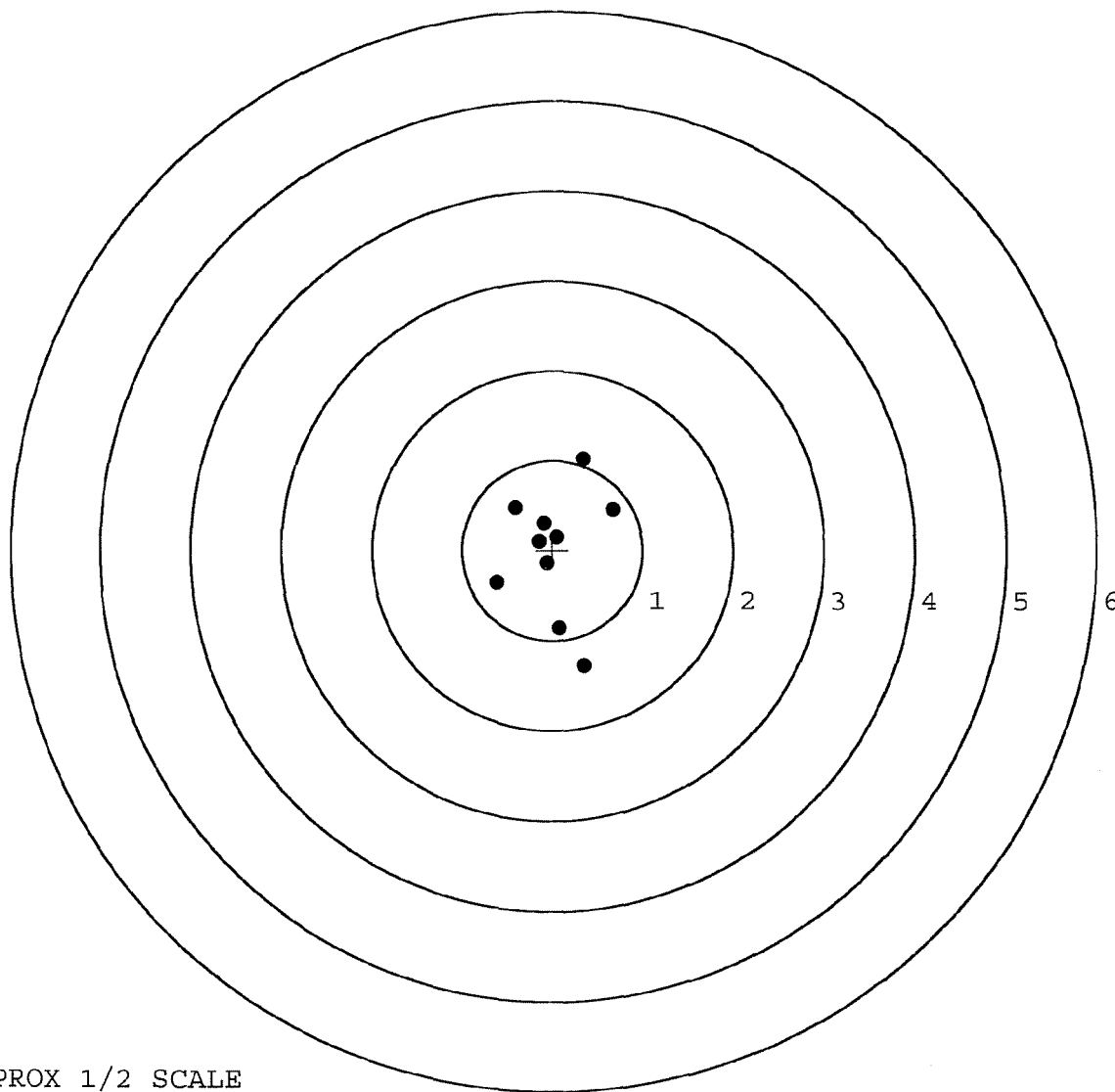
MEAN RADIUS: 0.628

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.334	1.017
2:	0.670	0.450
3:	-0.414	0.471
4:	-0.620	-0.360
5:	0.362	-1.283
6:	0.082	-0.871
7:	-0.063	-0.148
8:	0.047	0.141
9:	-0.106	0.296
10:	-0.148	0.096

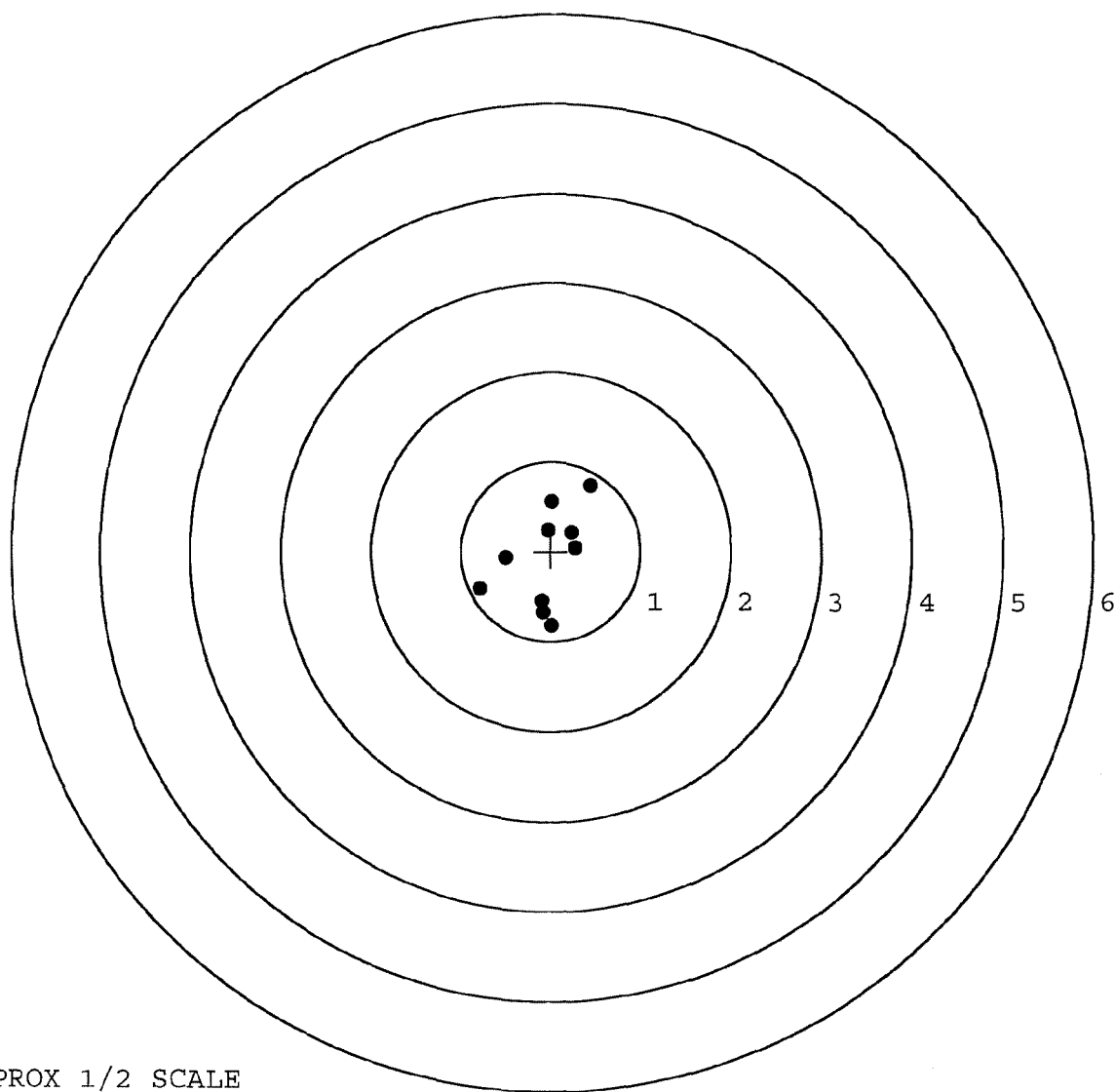


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535436. __0
 TARGET NUMBER: 2
 FILE DATE: 04/07/2006
 FILE TIME: 15:22

POINT#	X	Y
1:	0.446	0.738
2:	0.007	0.555
3:	-0.031	0.238
4:	0.228	0.217
5:	0.275	0.044
6:	-0.501	-0.067
7:	-0.788	-0.416
8:	0.017	-0.829
9:	-0.084	-0.683
10:	-0.094	-0.556

X CENTROID: -0.053
 Y CENTROID: -0.076
 POA TO CENTROID: 0.092
 HORZ SPREAD: 1.234
 VERT SPREAD: 1.567
 GROUP SPREAD: 1.690
 MIN RADIUS: 0.315
 MAX RADIUS: 0.954
 MEAN RADIUS: 0.576
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535436. 0

TARGET NUMBER: 3

FILE DATE: 04/07/2006

FILE TIME: 15:22

POINT#	X	Y
1:	-0.464	-0.741
2:	-0.138	-0.640
3:	0.235	-0.548
4:	0.605	-0.498
5:	0.449	-0.348
6:	0.349	-0.133
7:	-0.205	0.466
8:	-0.018	0.292
9:	-0.215	0.145
10:	-0.270	1.076

X CENTROID: 0.033

Y CENTROID: -0.093

POA TO CENTROID: 0.099

HORZ SPREAD: 1.069

VERT SPREAD: 1.817

GROUP SPREAD: 1.827

MIN RADIUS: 0.319

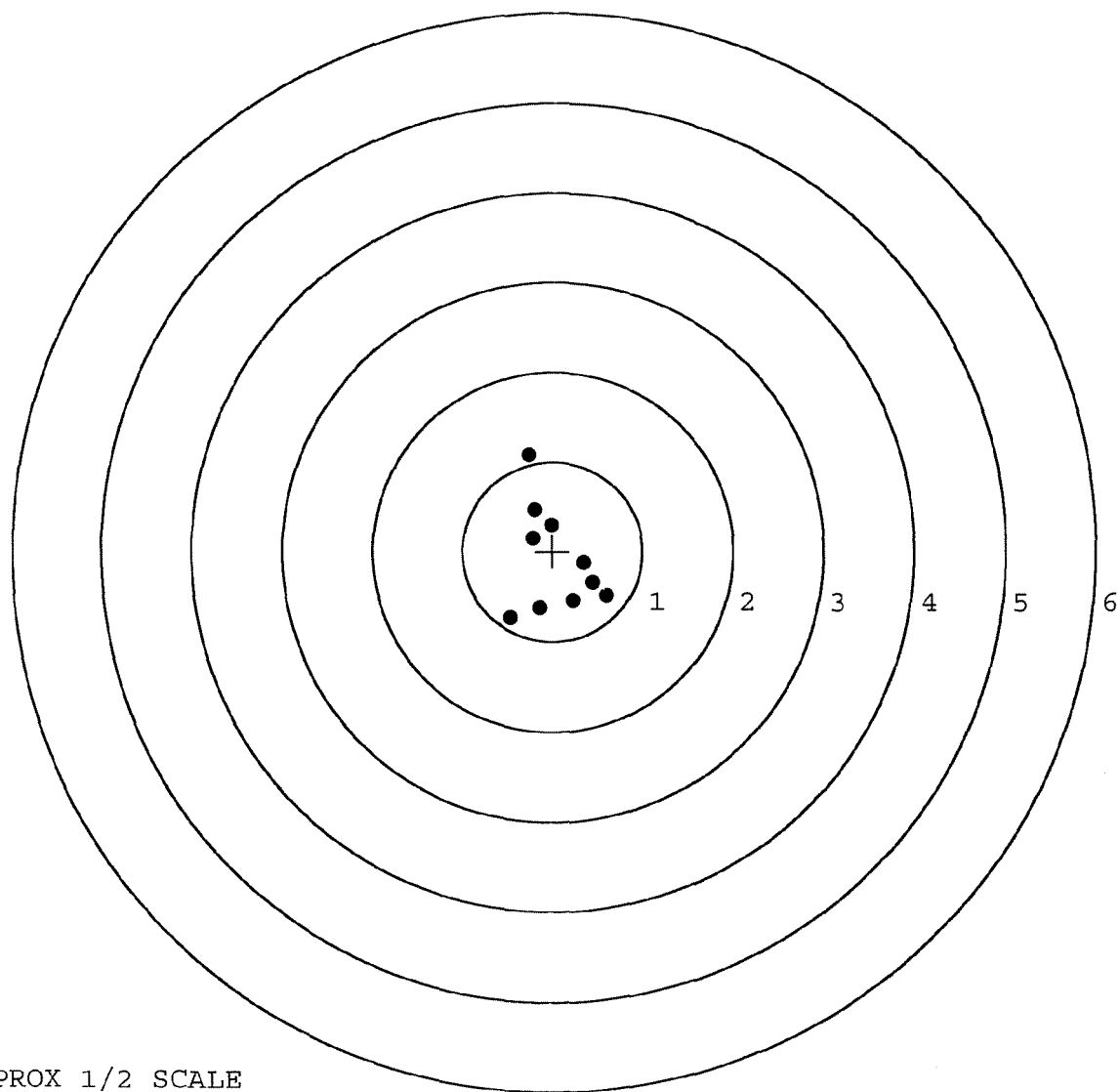
MAX RADIUS: 1.207

MEAN RADIUS: 0.594

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535436. 0

TARGET NUMBER: 4

FILE DATE: 04/07/2006

FILE TIME: 15:22

POINT#	X	Y
1:	0.581	-1.035
2:	-0.605	-0.810
3:	-0.412	-0.555
4:	-0.321	-0.175
5:	0.088	-0.232
6:	0.235	0.086
7:	-0.123	0.343
8:	-0.353	1.008
9:	-0.223	0.134
10:	-0.108	-0.070

X CENTROID: -0.124

Y CENTROID: -0.131

POA TO CENTROID: 0.180

HORZ SPREAD: 1.186

VERT SPREAD: 2.043

GROUP SPREAD: 2.246

MIN RADIUS: 0.063

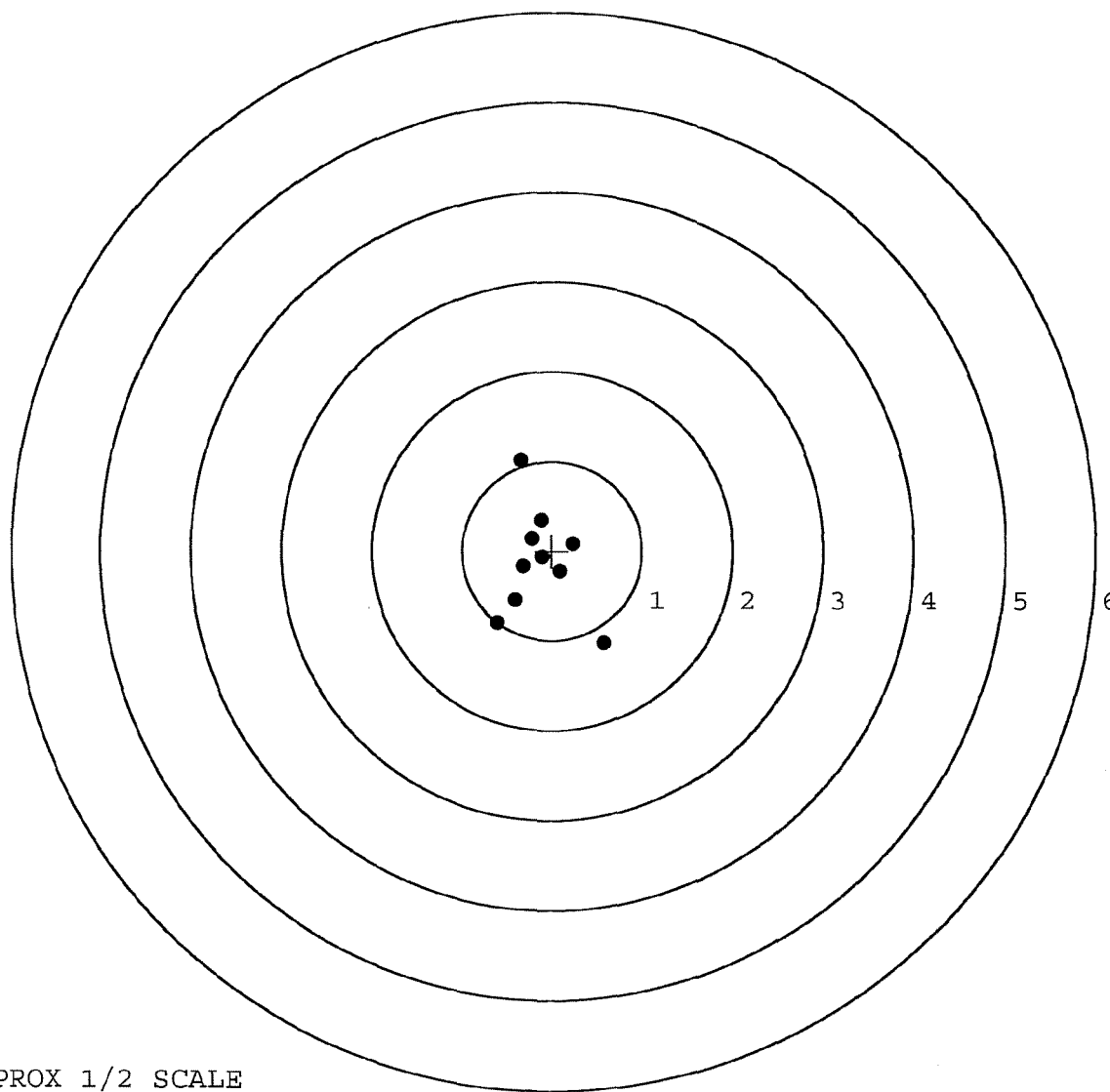
MAX RADIUS: 1.161

MEAN RADIUS: 0.533

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6535436. 0

TARGET NUMBER: 5

FILE DATE: 04/07/2006

FILE TIME: 15:22

POINT#	X	Y
1:	0.409	-0.876
2:	-0.053	-0.433
3:	0.655	-0.315
4:	0.443	-0.178
5:	0.315	0.614
6:	-0.152	0.722
7:	-0.737	0.727
8:	-0.828	-0.073
9:	-0.687	0.276
10:	-0.309	0.204

X CENTROID: -0.094

Y CENTROID: 0.067

POA TO CENTROID: 0.116

HORZ SPREAD: 1.483

VERT SPREAD: 1.603

GROUP SPREAD: 1.971

MIN RADIUS: 0.255

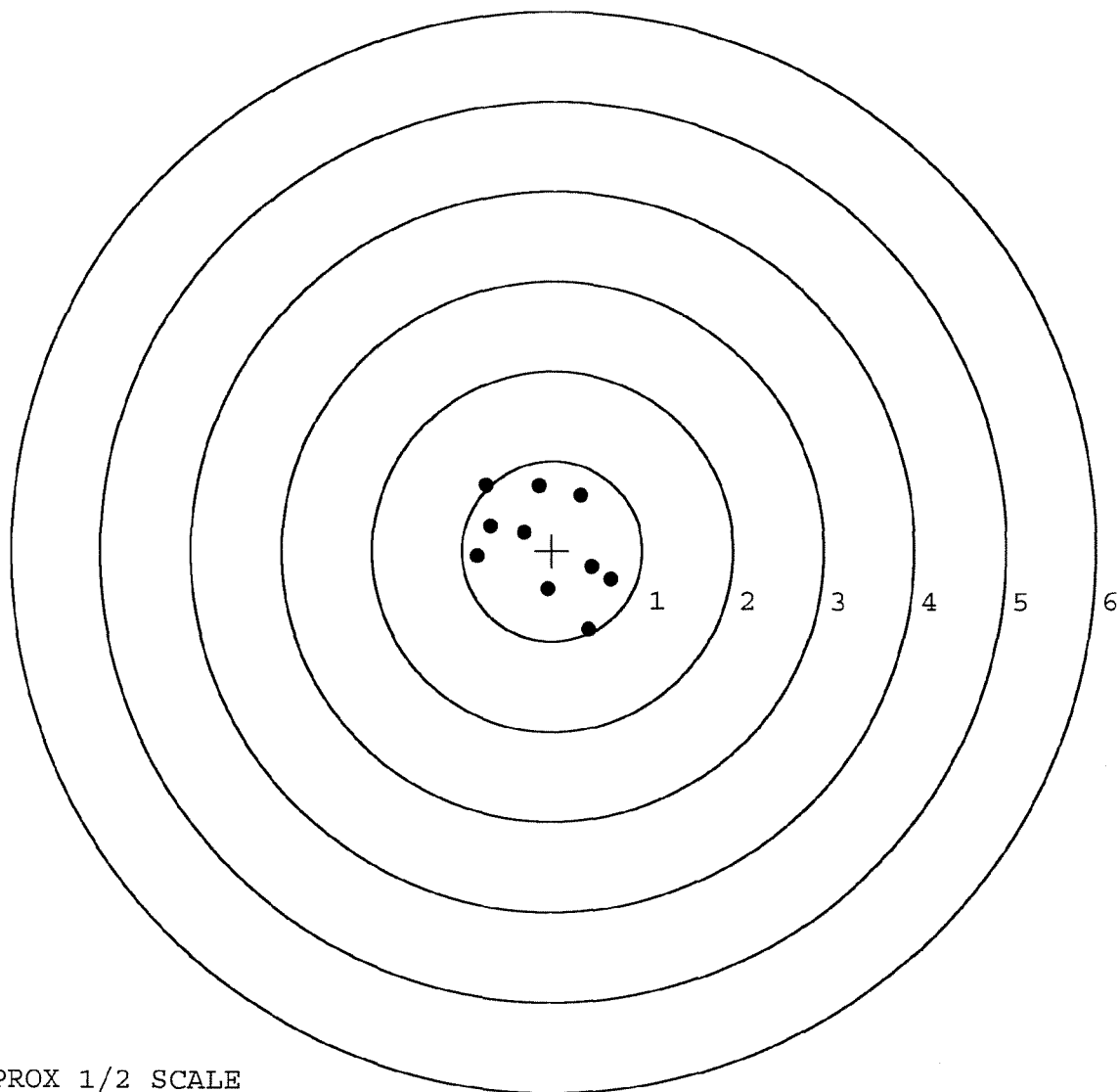
MAX RADIUS: 1.069

MEAN RADIUS: 0.689

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE