

G6410218

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



0 47700 25679 5

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0 47700 25679 5

SERIAL NO.



66410218

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

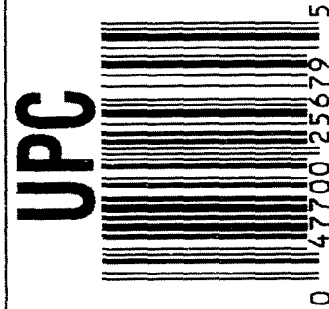
93606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB

DD FORM 96253



ORDER NO.	25679
BARREL LENGTH	24"
CAPACITY	6

G6410218



3/11/2005 9:25:01 AM

Chib

61

Original

25679

M/24 7.62 NATO S.W.S. (LE SYSTEM)



.MA25679

Shop Order: SW5679



.ABSW5679

Start Date: 9/3/2004

Finish Date: 10/15/2004

0520

Goff Blast Barrel & Rec Assembly,

78ROT01



0003770797

0540

Flat Black Powder Coat, Barrel and

01PC001



0003770799

0560

Reassemble Action.

89SWS1



0003770800

0690

Pack Rifle & Stencil SWS Container

89SWS1



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410218

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RTL
600	PROOF		1-4-05	RL
607	CHECK HEADSPACE	MAGNA - FLUX	1-4-05	RL
610	DIS-ASSEMBLE GUN	INSPECTED	1-4-05	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 04 2005 OPERATOR BS		
615	ROLLMARK CALIBER		1-5-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRLW
620	APPLY COATINGS (BARREL ACTION)		1-4-05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-78-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-18-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER			
	D) OIL FIRING PIN ASSEMBLY		2-1-05	RL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3-21-05	TRLW

OP # OPERATION NAME		READINGS			DATE	INITIAL			
625	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>6 lbs</u>	<u>6 lbs</u>	<u>6 lbs</u>	3-21-05	Ac		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>2 lbs</u>	<u>2 lbs</u>	<u>2 lbs</u>	3-21-05	Ac		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>.026</u>	<u>.026</u>	<u>.026</u>	3-21-05	Ac		
	J) ASSEMBLE STOCK					2-1-05	RTL		
	K) ASSEMBLE SWIVEL STUDS					3-21-05	Ac		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					2-1-05	RTL		
	M) IRON SIGHT ALIGNMENT					2-1-05	RTL		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					2-1-05	RTL		
640	GALLERY TEST AND TARGET		PASS FAIL			2-4-05	TRLW		
	MALFUNCTION <u>BAC</u>		CORRECTION			2-16-05	TRLW		
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
645	INSPECT FOR LIVE AMMO					2-4-05	TRLW		
655	FINAL INSPECTION A) HEADSPACE					3-21-05	Ac		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.56</u>	<u>2.77</u>	<u>2.62</u>	<u>2.46</u>	<u>2.64</u>	3-21-05	TRLW
	C) FUNCTION					3-21-05	Ac		
660	PACK					3/24/05	RA		

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)

SERIAL NO.

DATE 1-19-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.13	2.25		2.08	
PULL #2	2.22	2.05		2.20	
PULL #3	2.56	2.45		2.27	
PULL #4	2.59	2.25		2.46	
PULL #5	2.52	2.24		2.23	
TOTAL	12.02	11.24		11.24	
AVERAGE	2.40	2.24		2.24	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.11		
PULL #2	3.33	3.26		
PULL #3	3.28	3.21		
PULL #4	3.27	3.11		
PULL #5	3.27	3.19		
TOTAL	16.51	15.88		
AVERAGE	3.30	3.17		

	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	4.34	4.15		4.50
PULL #2	4.32	4.14		4.45
PULL #3	4.35	4.09		4.31
PULL #4	4.32	3.86		4.43
PULL #5	4.15	4.15		4.36
TOTAL	21.48	20.39		22.05
AVERAGE	4.29	4.07		4.41

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410218.___0
FILE DATE AND TIME: 02/04/2005 07:43

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.140
The Average Y Centroid of the Five Target Set:	-0.063
The Average Point of Impact of the Five Target Set:	0.154
The Average Mean Radius of the Five Target Set:	0.838
The Distance from POA to Centroid Target #1:	0.139
The Distance from Centroid Target #2 to Centroid Target #1:	0.092
The Distance from Centroid Target #3 to Centroid Target #1:	0.126
The Distance from Centroid Target #4 to Centroid Target #1:	0.155
The Distance from Centroid Target #5 to Centroid Target #1:	0.328

SERIAL NUMBER: G6410218. __0

TARGET NUMBER: 1

FILE DATE: 02/04/2005

FILE TIME: 07:43

POINT#	X	Y
1:	0.878	-0.930
2:	0.500	-0.688
3:	0.831	-0.506
4:	1.030	-0.367
5:	0.393	0.085
6:	-0.038	0.528
7:	-0.744	0.234
8:	-0.676	-0.236
9:	-1.218	0.362
10:	-1.808	0.415

X CENTROID: -0.085

Y CENTROID: -0.110

POA TO CENTROID: 0.139

HORZ SPREAD: 2.838

VERT SPREAD: 1.458

GROUP SPREAD: 3.004

MIN RADIUS: 0.517

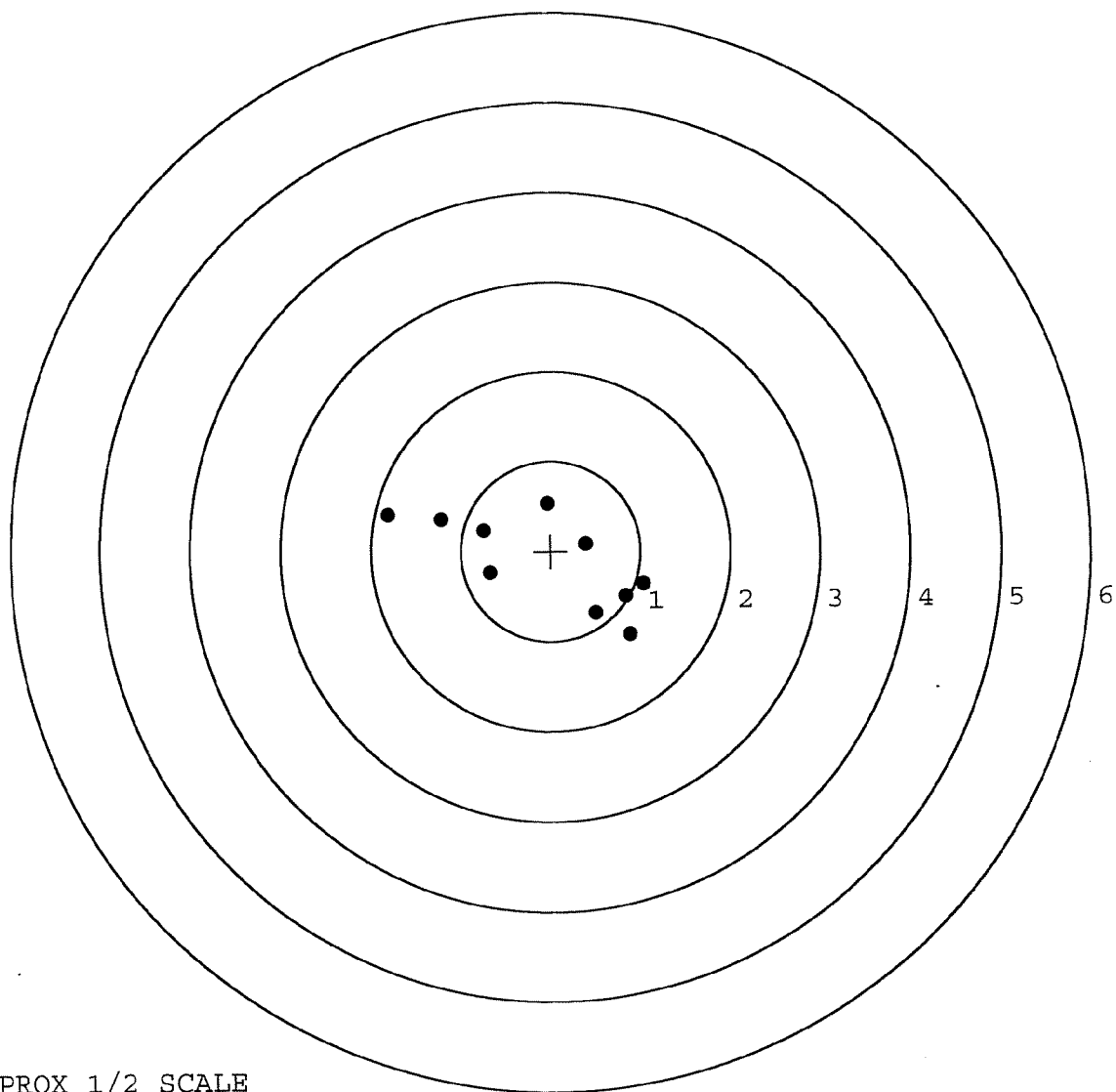
MAX RADIUS: 1.801

MEAN RADIUS: 0.976

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410218. __0

TARGET NUMBER: 2

FILE DATE: 02/04/2005

FILE TIME: 07:43

POINT#	X	Y
1:	1.558	0.182
2:	0.558	-0.010
3:	-0.700	-0.438
4:	-0.610	-0.359
5:	-0.752	-0.202
6:	-0.965	-0.260
7:	-0.028	-0.041
8:	-0.185	0.046
9:	-0.208	0.252
10:	-0.183	0.362

X CENTROID: -0.152

Y CENTROID: -0.047

POA TO CENTROID: 0.159

HORZ SPREAD: 2.523

VERT SPREAD: 0.800

GROUP SPREAD: 2.561

MIN RADIUS: 0.099

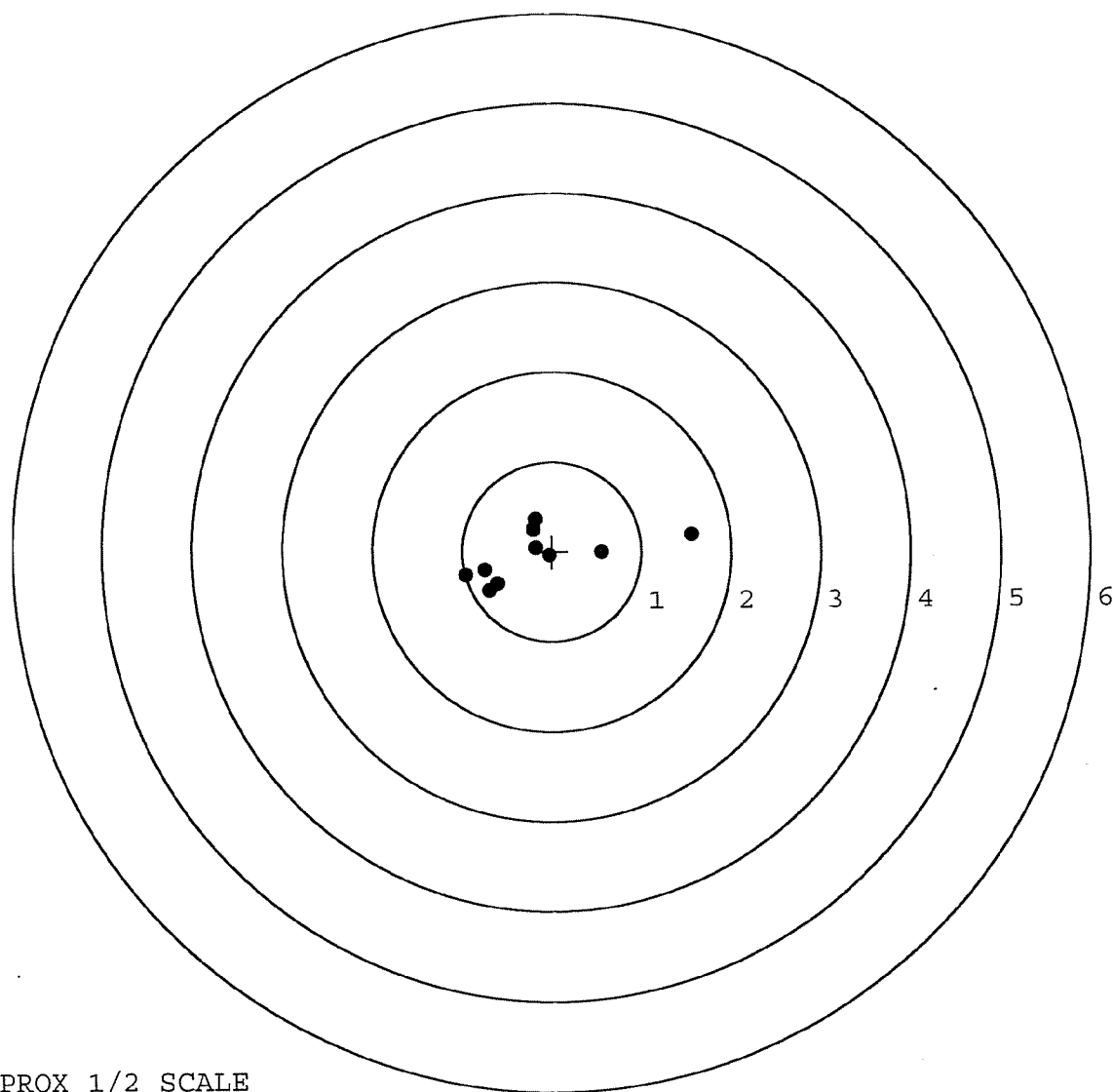
MAX RADIUS: 1.725

MEAN RADIUS: 0.606

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0148766

SERIAL NUMBER: G6410218. __0

TARGET NUMBER: 3

FILE DATE: 02/04/2005

FILE TIME: 07:43

POINT#	X	Y
1:	0.943	0.686
2:	0.735	0.403
3:	0.812	-0.022
4:	0.531	-0.201
5:	-0.048	-0.508
6:	-0.309	-0.225
7:	-0.491	0.174
8:	-0.174	0.510
9:	-1.025	-0.101
10:	-1.927	-0.565

X CENTROID: -0.095

Y CENTROID: 0.015

POA TO CENTROID: 0.096

HORZ SPREAD: 2.870

VERT SPREAD: 1.251

GROUP SPREAD: 3.131

MIN RADIUS: 0.321

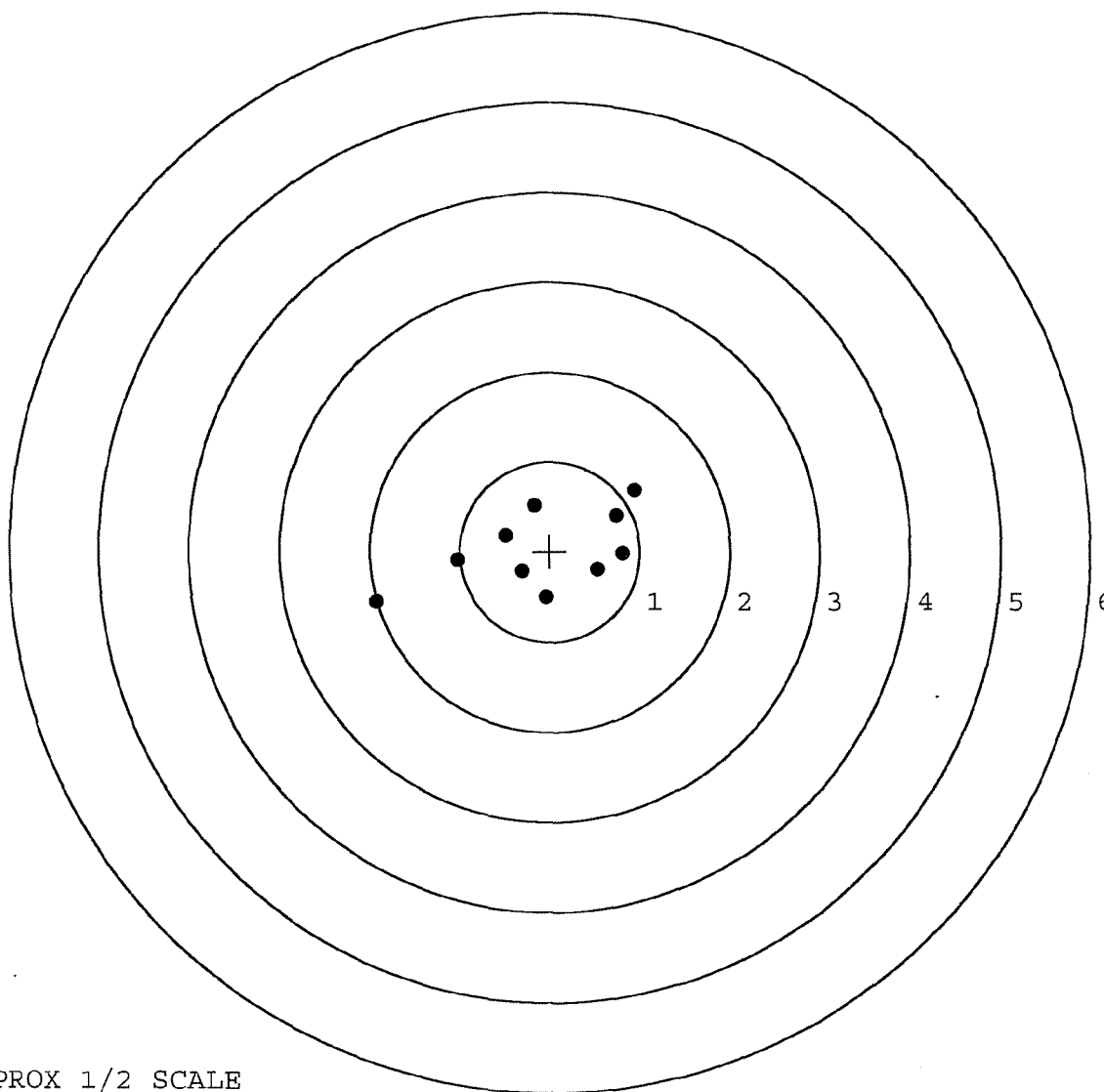
MAX RADIUS: 1.921

MEAN RADIUS: 0.836

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410218. __ 0

TARGET NUMBER: 4

FILE DATE: 02/04/2005

FILE TIME: 07:43

POINT#	X	Y
1:	1.846	0.469
2:	1.381	0.171
3:	0.817	-0.137
4:	0.298	-0.225
5:	-0.614	-0.603
6:	-0.854	-0.887
7:	-2.047	0.404
8:	-0.301	0.313
9:	-0.165	0.074
10:	0.061	0.205

X CENTROID: 0.042

Y CENTROID: -0.022

POA TO CENTROID: 0.047

HORZ SPREAD: 3.893

VERT SPREAD: 1.356

GROUP SPREAD: 3.894

MIN RADIUS: 0.227

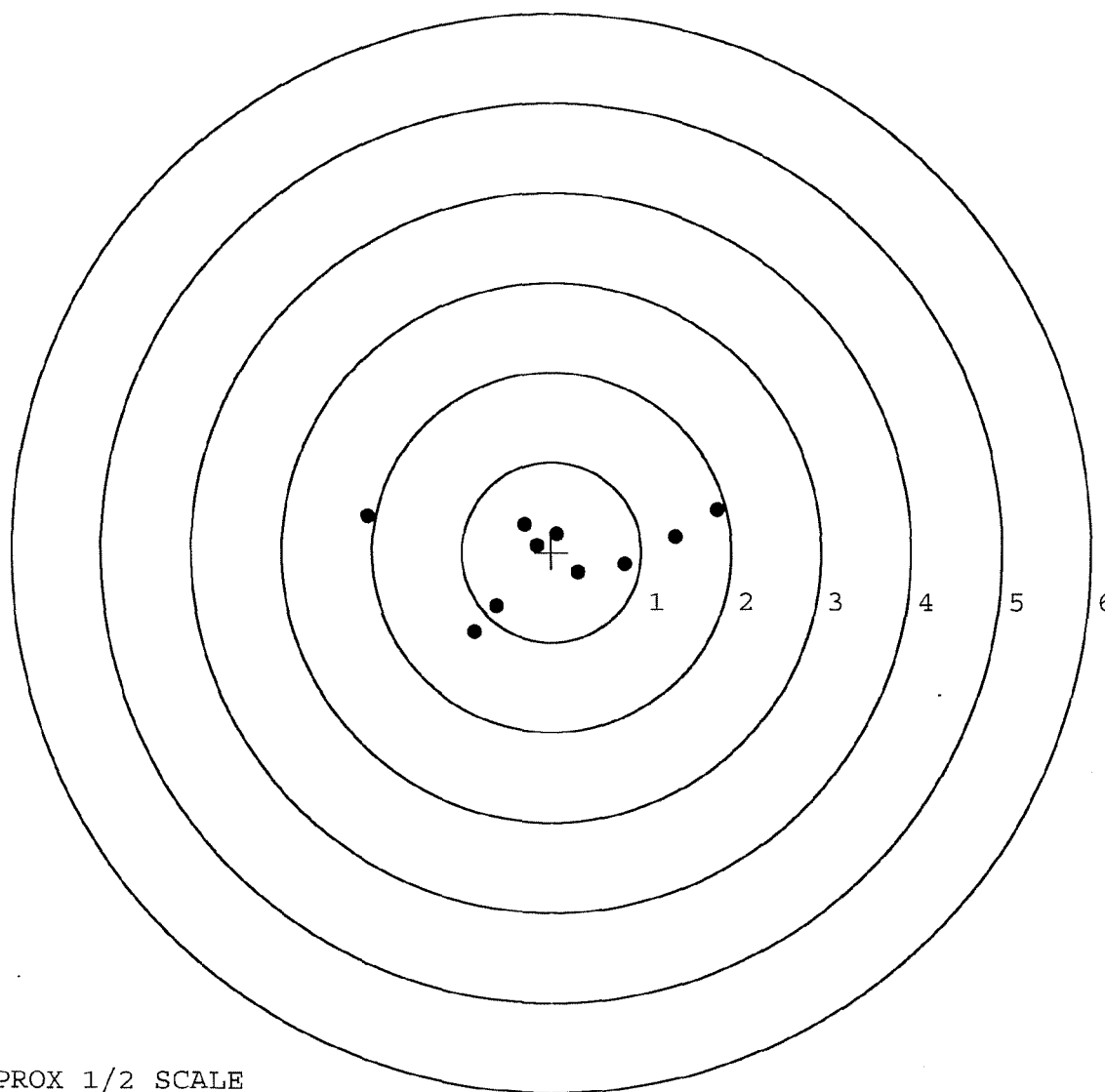
MAX RADIUS: 2.132

MEAN RADIUS: 0.952

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410218. __0

TARGET NUMBER: 5

FILE DATE: 02/04/2005

FILE TIME: 07:43

POINT#	X	Y
1:	1.142	-0.070
2:	0.703	0.091
3:	0.063	0.565
4:	0.046	-0.330
5:	-0.372	-0.400
6:	-2.342	0.066
7:	-0.802	-0.109
8:	-0.739	-0.304
9:	-0.774	-0.465
10:	-1.036	-0.543

X CENTROID: -0.411

Y CENTROID: -0.150

POA TO CENTROID: 0.438

HORZ SPREAD: 3.484

VERT SPREAD: 1.108

GROUP SPREAD: 3.487

MIN RADIUS: 0.253

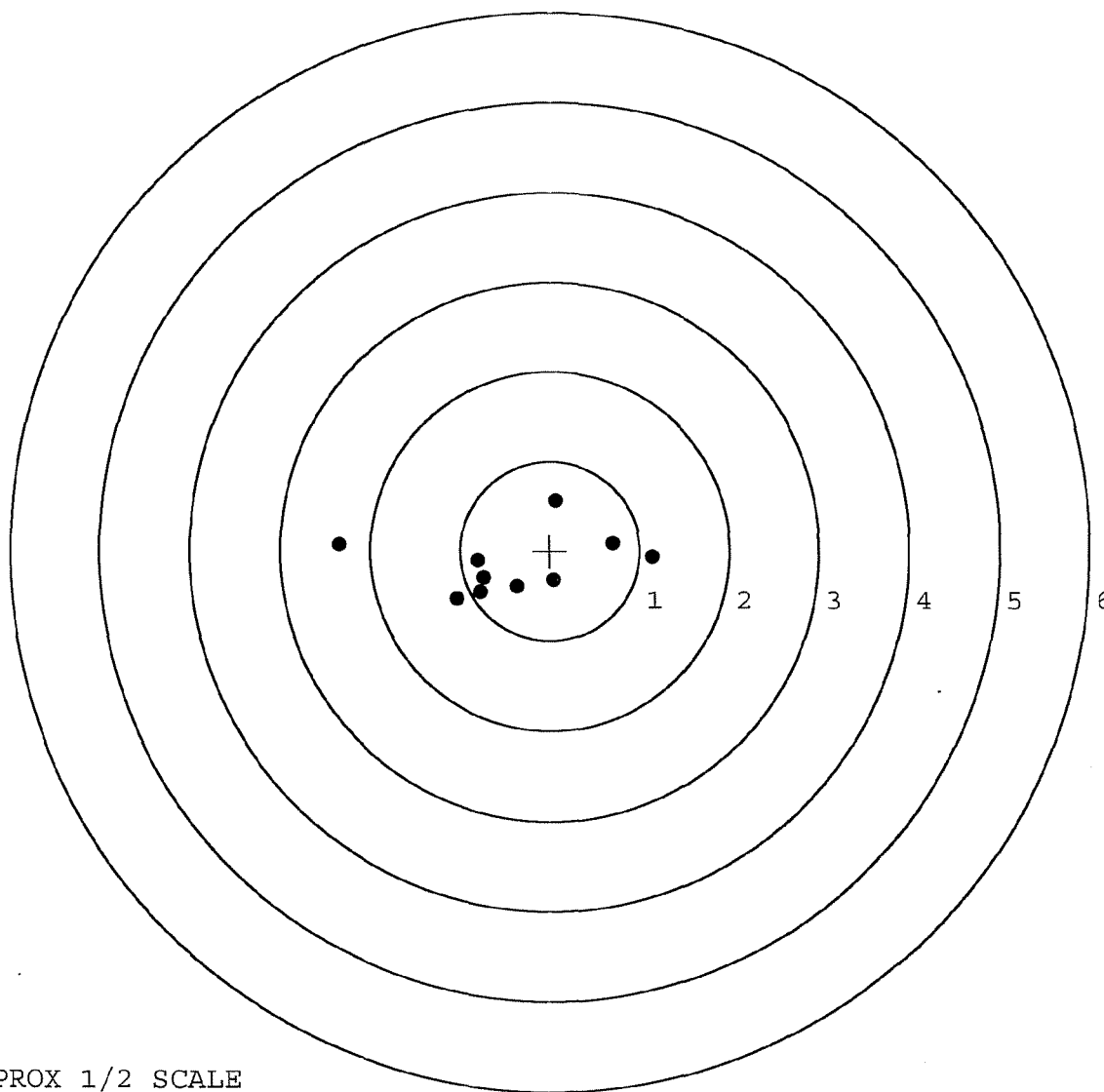
MAX RADIUS: 1.943

MEAN RADIUS: 0.821

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE