

G-6410226

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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UPC



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

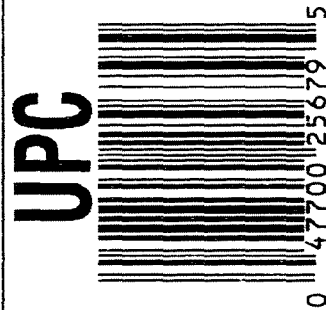


ORDER NO. **25679**

BARREL LENGTH 24"

CAPACITY 6

G6410226



Original
18
3/11/2005 9:25:01 AM
Crib

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 # G6410226

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RTL
600	PROOF		1-4-05	K
607	CHECK HEADSPACE		1-4-05	K
610	DIS-ASSEMBLE GUN	MAGNA-FLUX INSPECTED	1-4-05	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 3 2005 OPERATOR BS		
615	ROLLMARK CALIBER		1-5-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRL
620	APPLY COATINGS (BARREL ACTION)		1-14-05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-15-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-15-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-4-05	ER
	D) OIL FIRING PIN ASSEMBLY		2-4-05	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3-21-05	TRL

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>.025</u>	<u>.025</u>	<u>.025</u>	3-21-05	Ac		
	J) ASSEMBLE STOCK				2-1-05	RT		
	K) ASSEMBLE SWIVEL STUDS				3-21-05	Ac		
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				2-1-05	RT		
	M) IRON SIGHT ALIGNMENT				2-1-05	RT		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				2-1-05	RT		
640	GALLERY TEST AND TARGET	PASS FAIL			2-3-05	Ac		
	MALFUNCTION <u>73 AC</u>	CORRECTION	<u>2-16-05 OK</u>		2-3-05	Ac		
	MALFUNCTION	CORRECTION						
	MALFUNCTION	CORRECTION	<u>N/A</u>					
	MALFUNCTION	CORRECTION						
	MALFUNCTION	CORRECTION						
645	INSPECT FOR LIVE AMMO				2-3-05	Ac		
655	FINAL INSPECTION A) HEADSPACE				3-21-05	Ac		
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.55</u>	<u>2.79</u>	<u>2.38</u>	<u>2.55</u>	<u>2.38</u>	3-21-05	TRW
	C) FUNCTION				3-21-05	Ac		
660	PACK				3/23/05	DA		

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 1-18-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.31	2.35		2.71	
PULL #2	2.53	2.43		2.19	
PULL #3	2.63	2.42		2.23	
PULL #4	2.77	2.36		2.21	
PULL #5	2.78	2.38		2.19	
TOTAL	13.02	11.94		11.53	
AVERAGE	2.60	2.38		2.30	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.30		
PULL #2	3.50	3.26		
PULL #3	3.38	3.25		
PULL #4	3.29	3.26		
PULL #5	3.35	3.26		
TOTAL	17.00	16.33		
AVERAGE	3.40	3.26		

	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	4.10	4.10		4.13
PULL #2	4.47	3.92		3.97
PULL #3	4.20	4.04		4.15
PULL #4	4.24	4.06		4.17
PULL #5	4.26	4.06		3.93
TOTAL	21.27	20.18		20.35
AVERAGE	4.25	4.03		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410226.___0
FILE DATE AND TIME: 02/03/2005 09:30

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.080
The Average Y Centroid of the Five Target Set:	-0.026
The Average Point of Impact of the Five Target Set:	0.084
The Average Mean Radius of the Five Target Set:	0.662
The Distance from POA to Centroid Target #1:	0.170
The Distance from Centroid Target #2 to Centroid Target #1:	0.121
The Distance from Centroid Target #3 to Centroid Target #1:	0.080
The Distance from Centroid Target #4 to Centroid Target #1:	0.183
The Distance from Centroid Target #5 to Centroid Target #1:	0.066

SERIAL NUMBER: G6410226. __0

TARGET NUMBER: 1

FILE DATE: 02/03/2005

FILE TIME: 09:30

POINT#	X	Y
1:	0.373	-0.551
2:	0.492	-0.405
3:	0.257	-0.325
4:	-0.687	-0.565
5:	-0.858	-0.290
6:	-0.707	0.097
7:	-0.222	0.449
8:	0.087	0.287
9:	0.426	0.836
10:	-0.658	-0.345

X CENTROID: -0.150

Y CENTROID: -0.081

POA TO CENTROID: 0.170

HORZ SPREAD: 1.350

VERT SPREAD: 1.401

GROUP SPREAD: 1.789

MIN RADIUS: 0.438

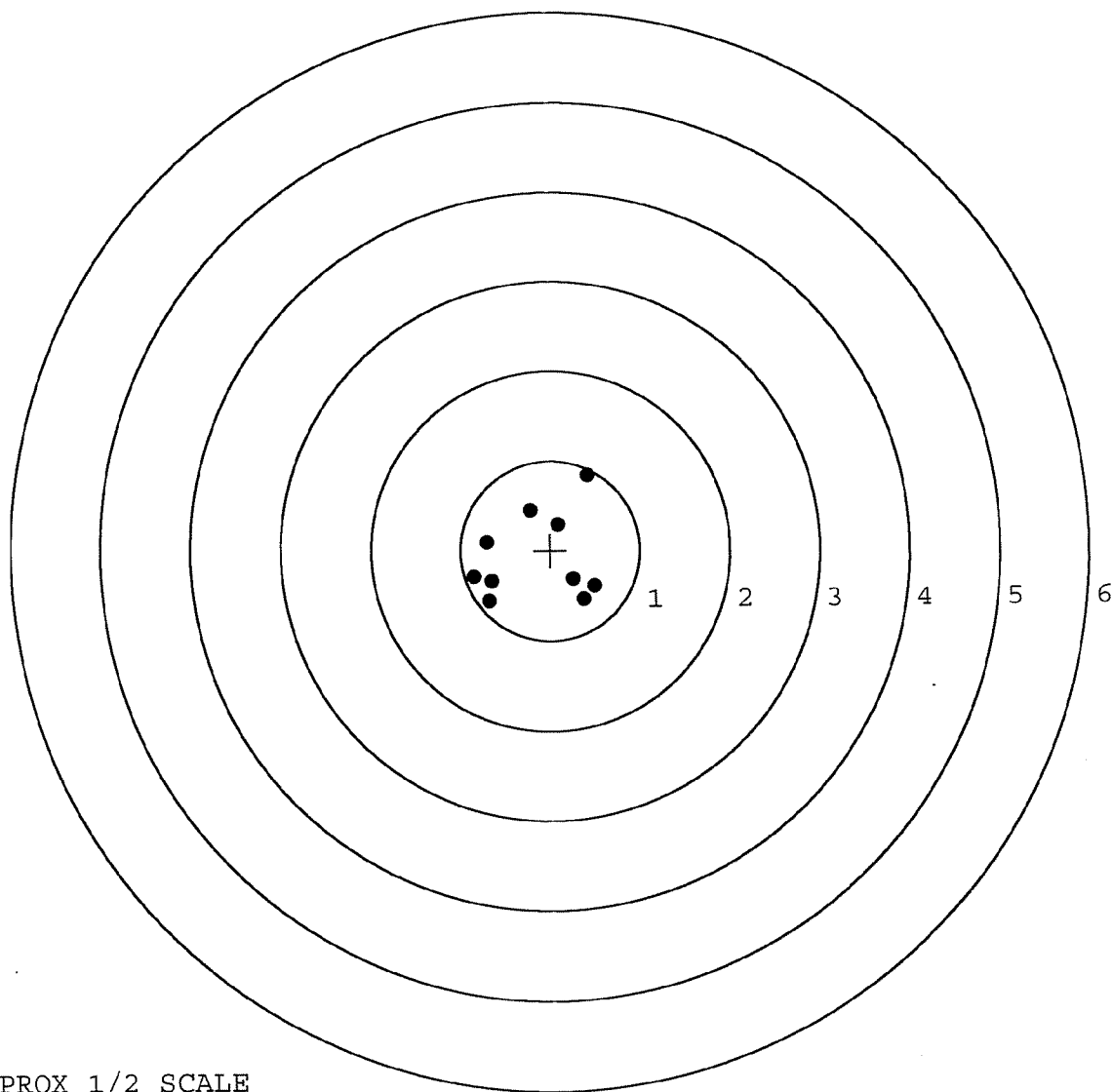
MAX RADIUS: 1.083

MEAN RADIUS: 0.657

IN 1 IN DIAMETER: 2

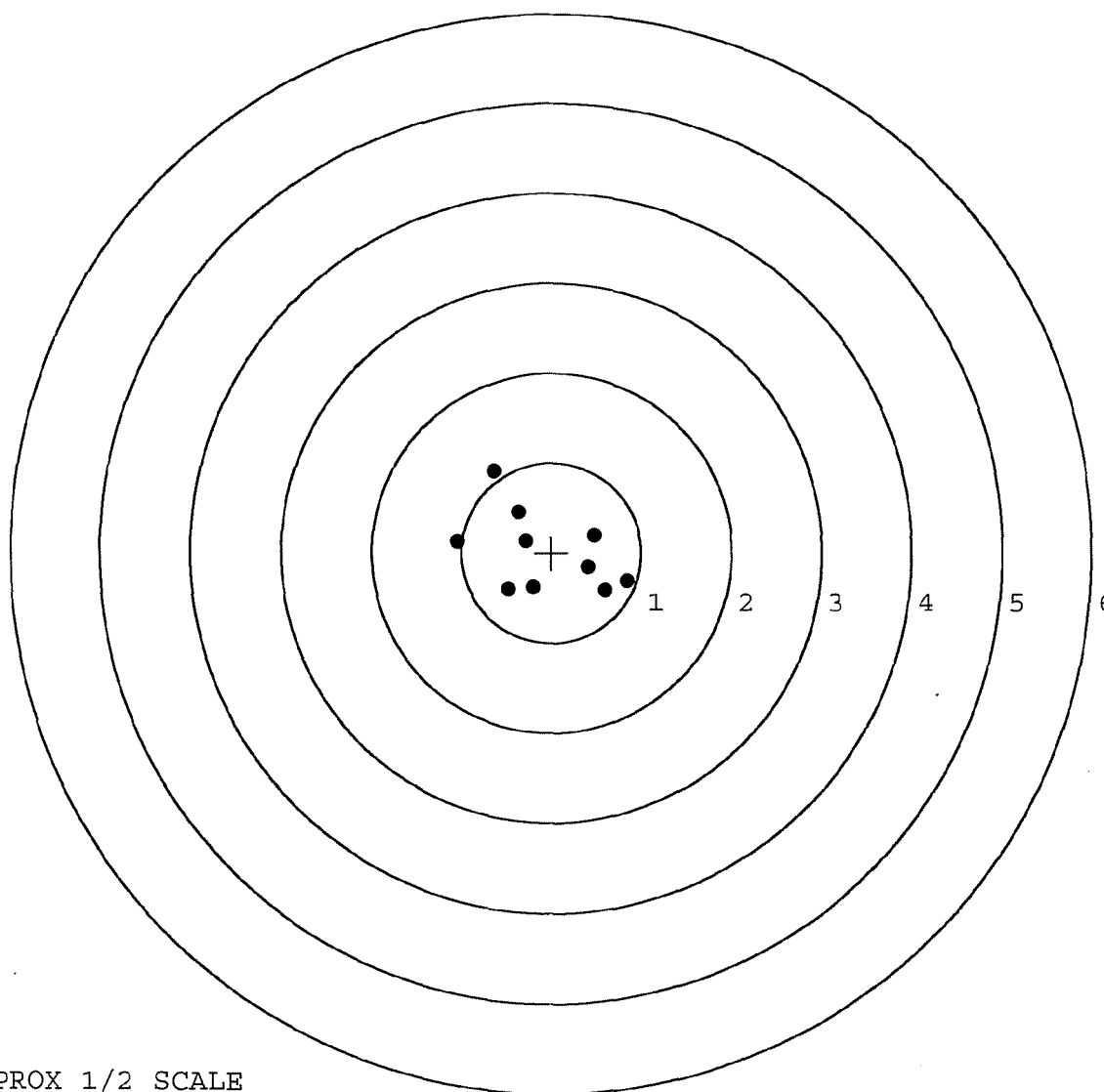
IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410226. __ 0	POINT#	X	Y
TARGET NUMBER: 2	1:	0.845	-0.319
FILE DATE: 02/03/2005	2:	0.599	-0.424
FILE TIME: 09:30	3:	0.407	-0.165
	4:	0.480	0.188
X CENTROID: -0.069	5:	-0.210	-0.391
Y CENTROID: 0.009	6:	-0.484	-0.410
POA TO CENTROID: 0.070	7:	-0.282	0.127
HORZ SPREAD: 1.888	8:	-0.367	0.453
VERT SPREAD: 1.331	9:	-1.043	0.126
GROUP SPREAD: 1.921	10:	-0.634	0.907
MIN RADIUS: 0.243			
MAX RADIUS: 1.061			
MEAN RADIUS: 0.669			
# IN 1 IN DIAMETER: 2			
# IN 2 IN DIAMETER: 9			
# in 3 IN DIAMETER: 10			

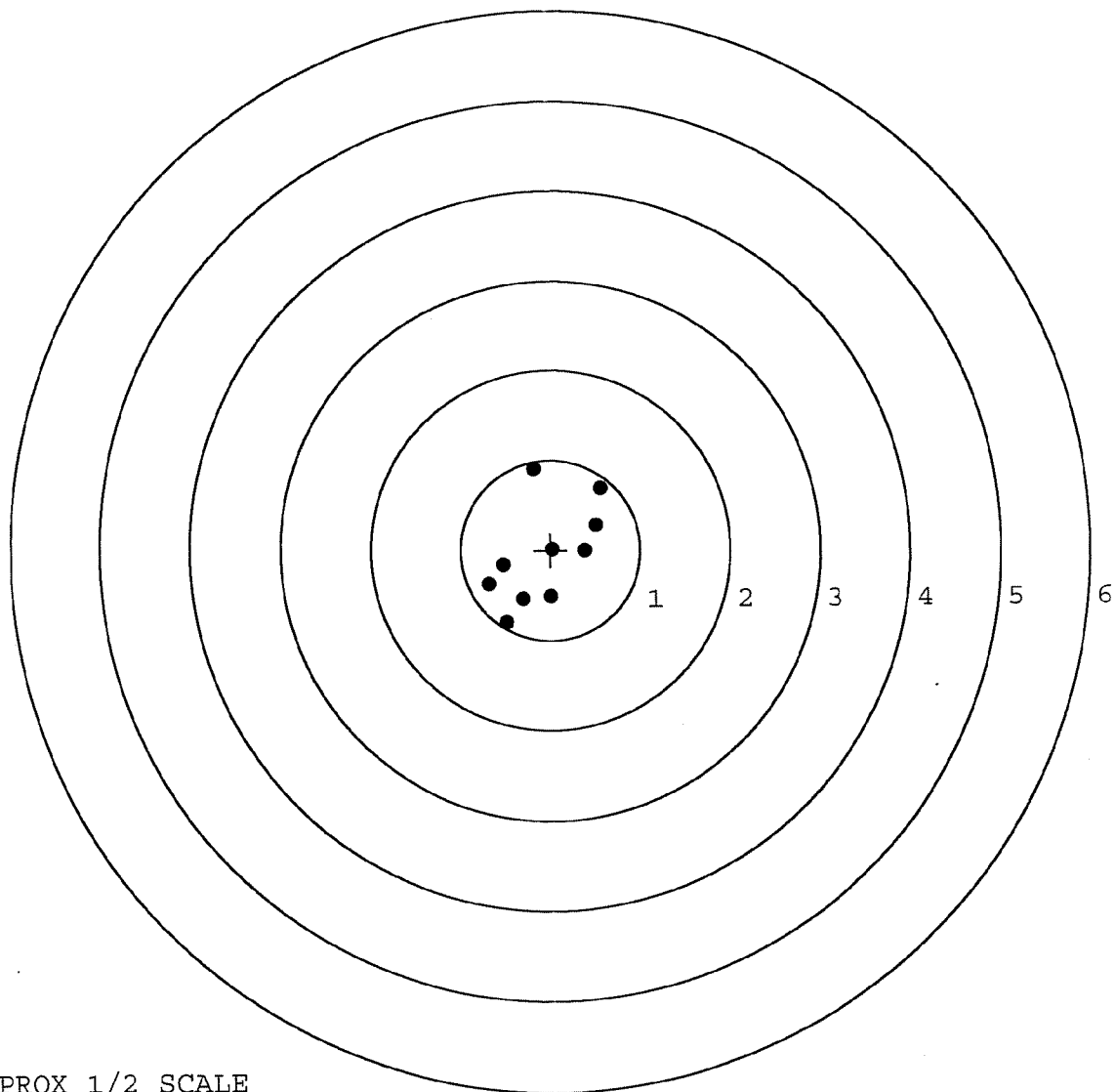


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410226. __0
 TARGET NUMBER: 3
 FILE DATE: 02/03/2005
 FILE TIME: 09:30

POINT#	X	Y
1:	-0.185	0.901
2:	0.563	0.683
3:	0.512	0.275
4:	0.380	-0.013
5:	0.021	0.010
6:	-0.529	-0.163
7:	-0.689	-0.377
8:	-0.004	-0.516
9:	-0.498	-0.804
10:	-0.309	-0.540

X CENTROID: -0.074
 Y CENTROID: -0.054
 POA TO CENTROID: 0.092
 HORZ SPREAD: 1.252
 VERT SPREAD: 1.705
 GROUP SPREAD: 1.827
 MIN RADIUS: 0.115
 MAX RADIUS: 0.974
 MEAN RADIUS: 0.621
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410226. __0

TARGET NUMBER: 4

FILE DATE: 02/03/2005

FILE TIME: 09:30

POINT#	X	Y
1:	0.674	-0.420
2:	0.712	-0.141
3:	-0.094	-0.934
4:	-0.162	-0.655
5:	0.562	0.455
6:	0.324	0.675
7:	-0.219	0.305
8:	-0.455	-0.020
9:	-0.558	0.408
10:	-0.873	0.681

X CENTROID: -0.009

Y CENTROID: 0.035

POA TO CENTROID: 0.037

HORZ SPREAD: 1.585

VERT SPREAD: 1.615

GROUP SPREAD: 1.899

MIN RADIUS: 0.342

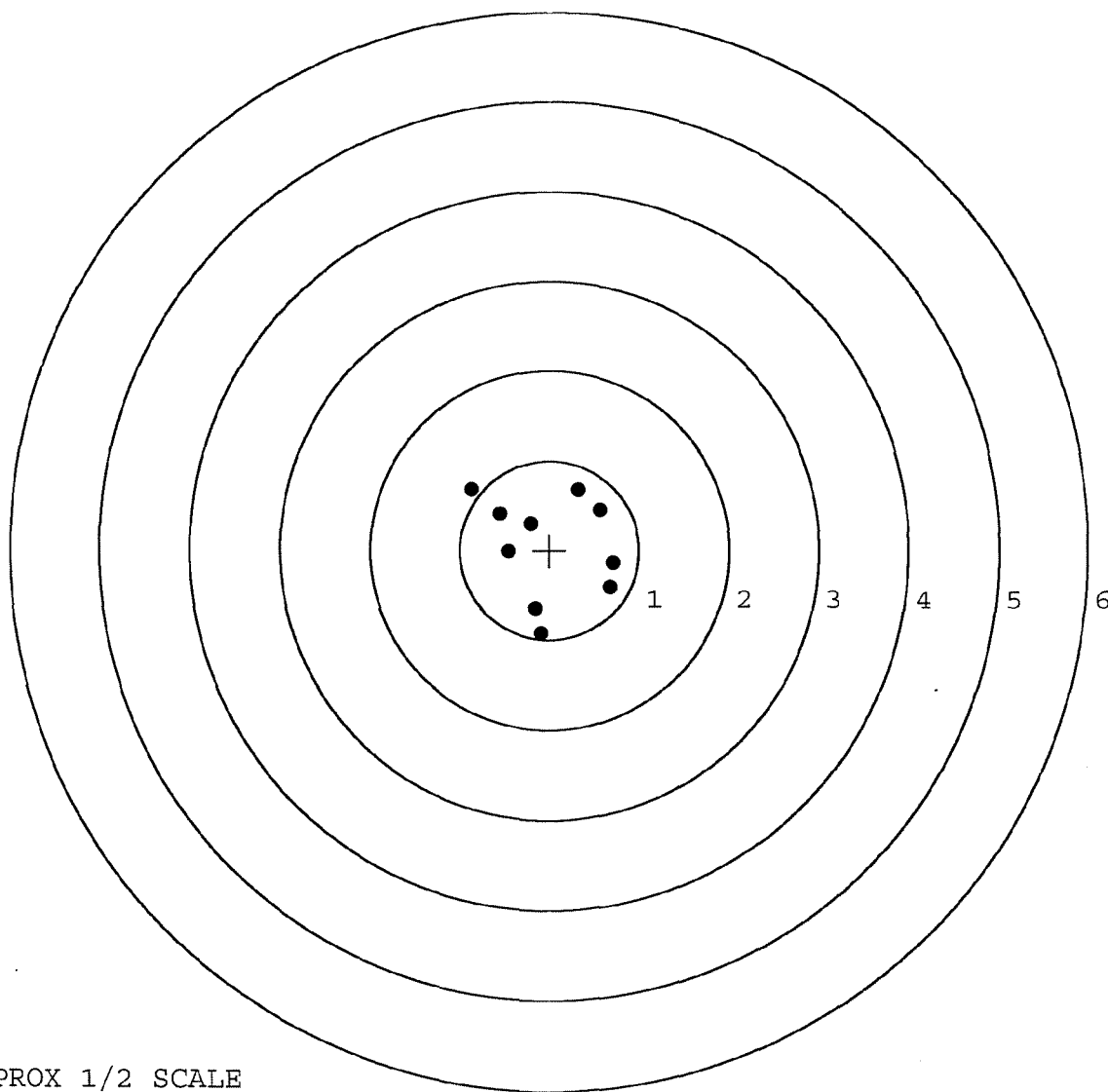
MAX RADIUS: 1.079

MEAN RADIUS: 0.721

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410226. 0

TARGET NUMBER: 5

FILE DATE: 02/03/2005

FILE TIME: 09:30

X CENTROID: -0.099

Y CENTROID: -0.039

POA TO CENTROID: 0.106

HORZ SPREAD: 1.691

VERT SPREAD: 1.695

GROUP SPREAD: 2.004

MIN RADIUS: 0.148

MAX RADIUS: 1.082

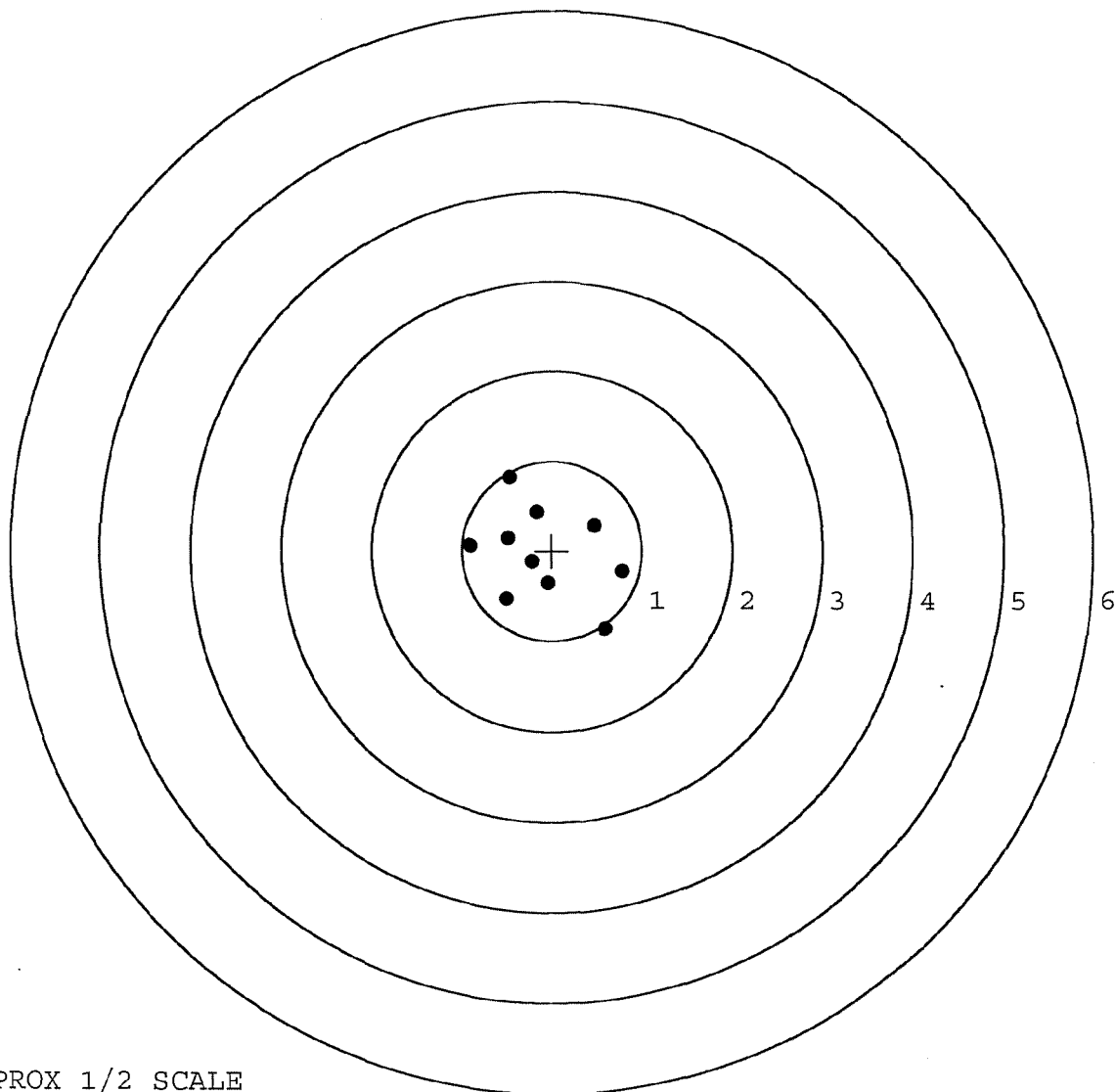
MEAN RADIUS: 0.642

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.591	-0.872
2:	0.781	-0.231
3:	0.467	0.286
4:	-0.047	-0.365
5:	-0.221	-0.123
6:	-0.510	-0.535
7:	-0.174	0.427
8:	-0.491	0.142
9:	-0.910	0.063
10:	-0.478	0.823



TARGET APPROX 1/2 SCALE