

G-641 0247

ORDER 25679

M/24 7.62 NATO S.W.S.

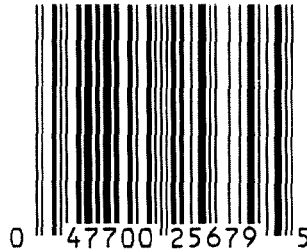
UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



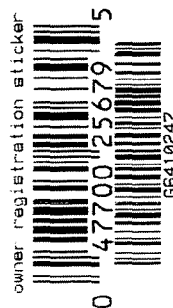
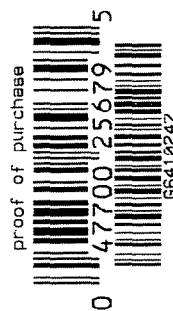
SERIAL NO.



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
96187 - TRS BI POD ASSB

46 FORM 96253

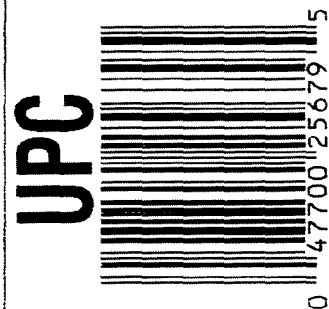


ORDER NO. **25679**

BARREL LENGTH 24"

CAPACITY 6

G6410247



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # GL440247

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-29-04	RTL
600	PROOF		12-29-04	RL
607	CHECK HEADSPACE		12-29-04	RL
610	DIS-ASSEMBLE GUN		12-30-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		12-30-04	RL
615	ROLLMARK CALIBER		1-3-05	CW
617	DRILL AND TAP SIGHT HOLES		12-30-04	TRW
620	APPLY COATINGS (BARREL ACTION)		1/8/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-12-05	RL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-12-05	RL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-12-05	RL
	D) OIL FIRING PIN ASSEMBLY		1-12-05	RL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	BARBER - M24 0149210	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>6.2</u> <u>5.5</u> <u>5.5</u>	1-22-05	DA
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>2.2</u> <u>2.2</u> <u>2.2</u>	1-22-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>1023</u> <u>1025</u> <u>1023</u>	1-22-05	DA
	J) ASSEMBLE STOCK			1-22-05	RT
	K) ASSEMBLE SWIVEL STUDS			1-24-05	RT
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				
	M) IRON SIGHT ALIGNMENT		N.A.		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				
640	GALLERY TEST AND TARGET		(PASS) FAIL	1-20-05	TRW
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
645	INSPECT FOR LIVE AMMO			1-20-05	TRW
655	FINAL INSPECTION A) HEADSPACE			1-24-05	RT
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u> <u>2.66</u> <u>2.46</u> <u>2.46</u> <u>2.22</u>	1-22-05	DA
	C) FUNCTION			1-24-05	RT
660	PACK			1-25-05	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & 50 CYCLES

BARBER - M24 0149211

SERIAL NO.

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

11.11.04

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.14	2.28		2.19	
PULL #2	2.41	2.64		2.27	
PULL #3	2.41	2.54		2.30	
PULL #4	2.53	2.44		2.20	
PULL #5	2.50	2.56		2.21	
TOTAL	11.99	12.46		11.17	
AVERAGE	2.39	2.49		2.23	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.08		
PULL #2	3.44	3.29		
PULL #3	3.35	3.27		
PULL #4	3.34	3.37		
PULL #5	3.55	3.44		
TOTAL	16.90	16.45		
AVERAGE	3.38	3.29		

	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	4.36	4.39		4.18
PULL #2	4.37	4.25		4.23
PULL #3	4.47	4.30		4.20
PULL #4	4.58	4.21		4.22
PULL #5	4.46	4.29		4.16
TOTAL	22.24	21.44		20.99
AVERAGE	4.44	4.28		4.19

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410247.___1
FILE DATE AND TIME: 09/27/2005 11:16

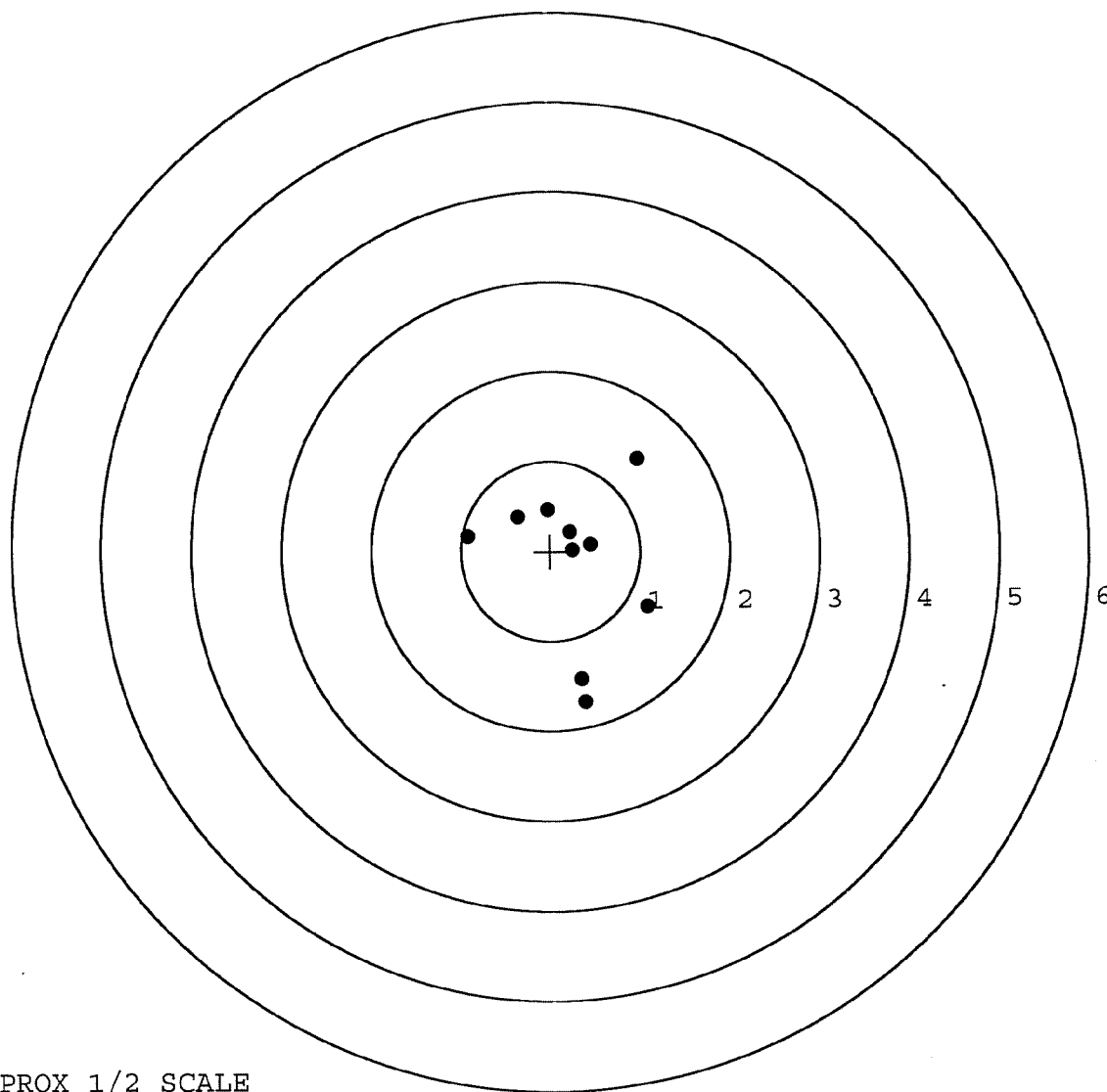
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.049
The Average Y Centroid of the Five Target Set:	-0.173
The Average Point of Impact of the Five Target Set:	0.180
The Average Mean Radius of the Five Target Set:	1.063
The Distance from POA to Centroid Target #1:	0.277
The Distance from Centroid Target #2 to Centroid Target #1:	0.481
The Distance from Centroid Target #3 to Centroid Target #1:	0.335
The Distance from Centroid Target #4 to Centroid Target #1:	0.341
The Distance from Centroid Target #5 to Centroid Target #1:	0.462

SERIAL NUMBER: G6410247. __1
 TARGET NUMBER: 1
 FILE DATE: 09/27/2005
 FILE TIME: 11:16

POINT#	X	Y
1:	0.383	-1.685
2:	0.342	-1.429
3:	1.080	-0.621
4:	0.453	0.074
5:	0.225	0.215
6:	0.974	1.014
7:	-0.032	0.461
8:	-0.362	0.383
9:	-0.925	0.177
10:	0.249	0.014

X CENTROID: 0.239
 Y CENTROID: -0.140
 POA TO CENTROID: 0.277
 HORZ SPREAD: 2.005
 VERT SPREAD: 2.699
 GROUP SPREAD: 2.763
 MIN RADIUS: 0.154
 MAX RADIUS: 1.552
 MEAN RADIUS: 0.866
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410247. __1

TARGET NUMBER: 2

FILE DATE: 09/27/2005

FILE TIME: 11:16

POINT#	X	Y
1:	1.318	0.120
2:	0.490	0.739
3:	-0.243	0.710
4:	-0.590	0.350
5:	0.063	-0.820
6:	-1.056	-0.378
7:	-1.510	-0.951
8:	0.041	-1.455
9:	0.275	-2.068
10:	1.317	-1.880

X CENTROID: 0.011

Y CENTROID: -0.563

POA TO CENTROID: 0.563

HORZ SPREAD: 2.828

VERT SPREAD: 2.807

GROUP SPREAD: 3.024

MIN RADIUS: 0.262

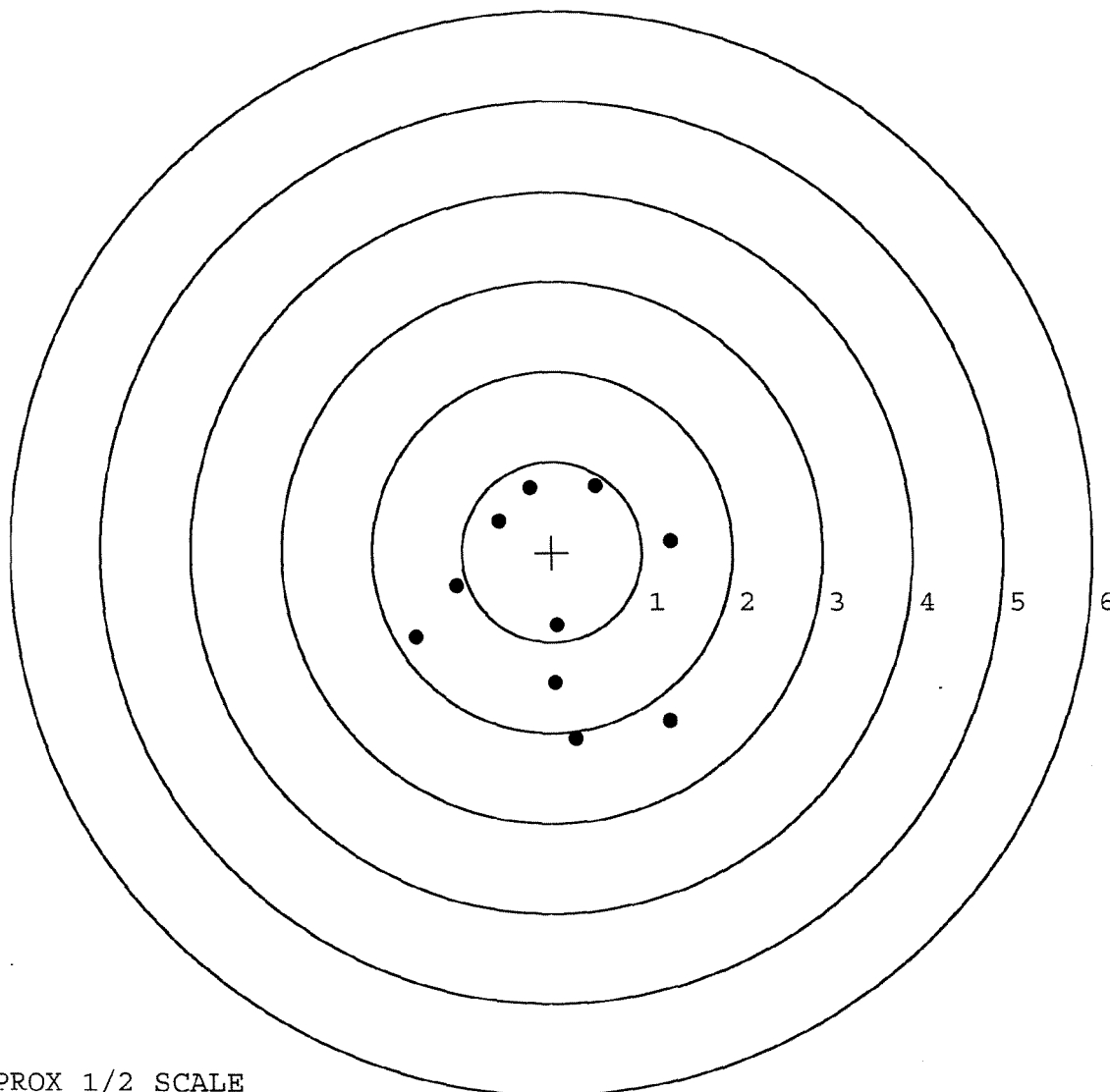
MAX RADIUS: 1.855

MEAN RADIUS: 1.244

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 2

in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410247. __1

TARGET NUMBER: 3

FILE DATE: 09/27/2005

FILE TIME: 11:16

POINT#	X	Y
1:	1.300	-0.136
2:	0.685	0.319
3:	-0.215	-0.319
4:	-0.359	0.123
5:	-0.582	0.225
6:	-0.369	0.606
7:	-1.653	0.682
8:	0.219	-1.644
9:	0.475	-1.881
10:	1.104	-2.211

X CENTROID: 0.060

Y CENTROID: -0.424

POA TO CENTROID: 0.428

HORZ SPREAD: 2.953

VERT SPREAD: 2.893

GROUP SPREAD: 3.996

MIN RADIUS: 0.295

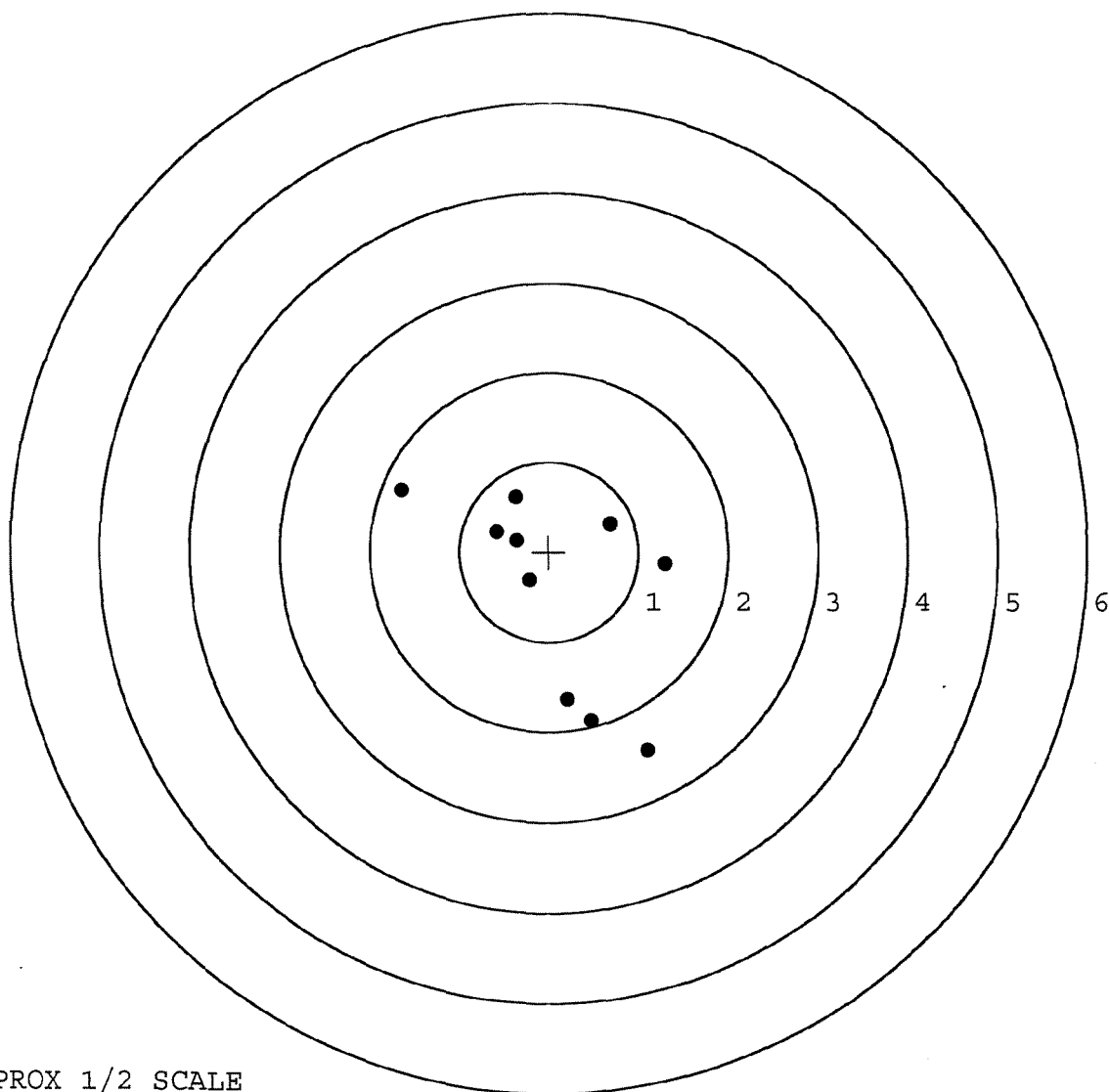
MAX RADIUS: 2.070

MEAN RADIUS: 1.211

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 7

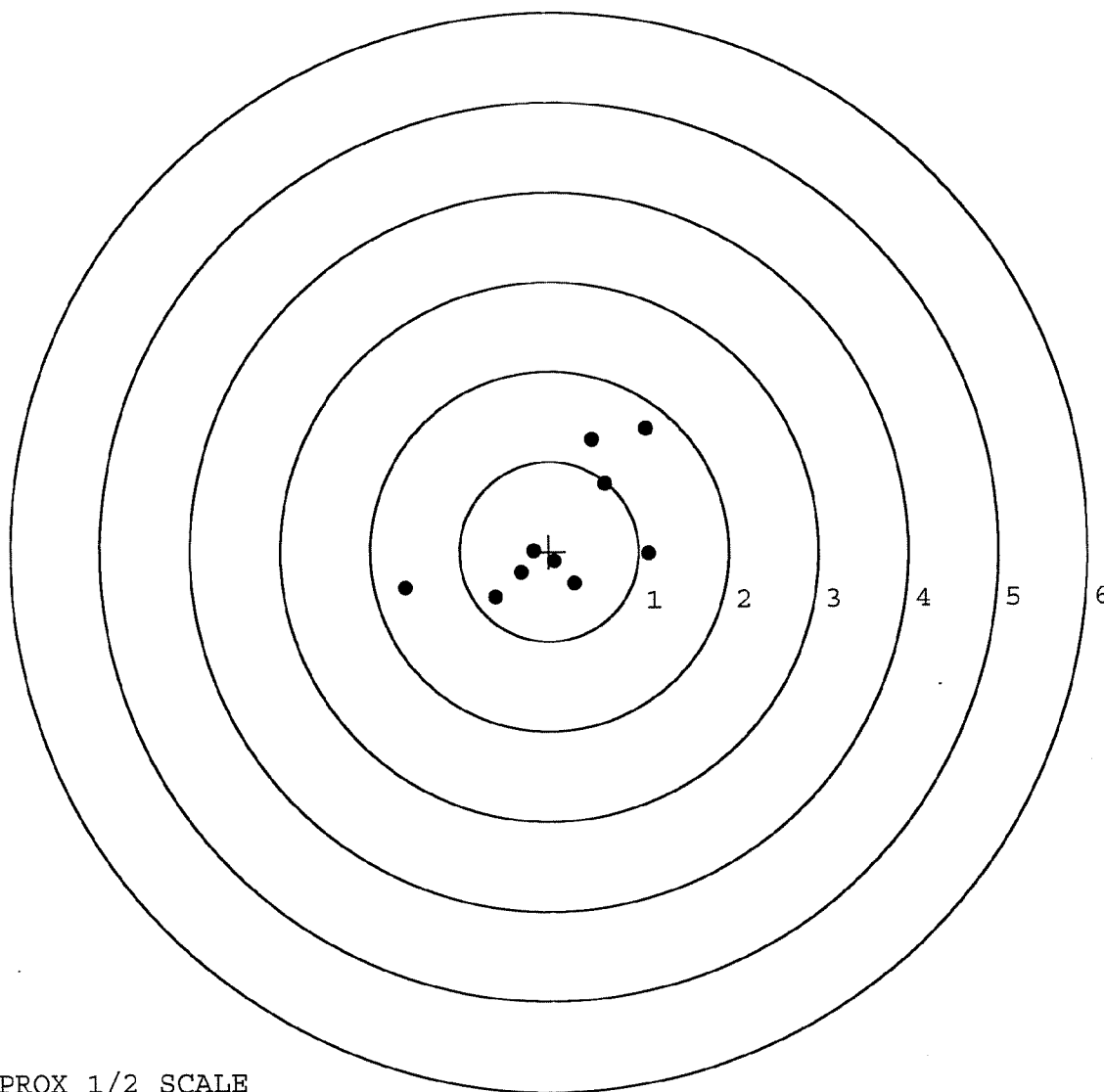


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410247. __1
 TARGET NUMBER: 4
 FILE DATE: 09/27/2005
 FILE TIME: 11:16

POINT#	X	Y
1:	1.110	-0.038
2:	0.627	0.748
3:	0.488	1.236
4:	1.089	1.350
5:	0.285	-0.364
6:	0.065	-0.109
7:	-0.175	0.012
8:	-0.317	-0.236
9:	-0.601	-0.508
10:	-1.612	-0.395

X CENTROID: 0.096
 Y CENTROID: 0.170
 POA TO CENTROID: 0.195
 HORZ SPREAD: 2.722
 VERT SPREAD: 1.858
 GROUP SPREAD: 3.216
 MIN RADIUS: 0.280
 MAX RADIUS: 1.799
 MEAN RADIUS: 0.901
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410247. __1

TARGET NUMBER: 5

FILE DATE: 09/27/2005

FILE TIME: 11:16

POINT#	X	Y
1:	1.118	-0.524
2:	0.906	0.058
3:	0.777	0.388
4:	0.258	0.054
5:	-0.323	0.067
6:	-0.879	0.086
7:	-0.535	0.709
8:	-0.142	-1.246
9:	-2.121	-0.682
10:	-0.680	1.990

X CENTROID: -0.162

Y CENTROID: 0.090

POA TO CENTROID: 0.185

HORZ SPREAD: 3.239

VERT SPREAD: 3.236

GROUP SPREAD: 3.243

MIN RADIUS: 0.163

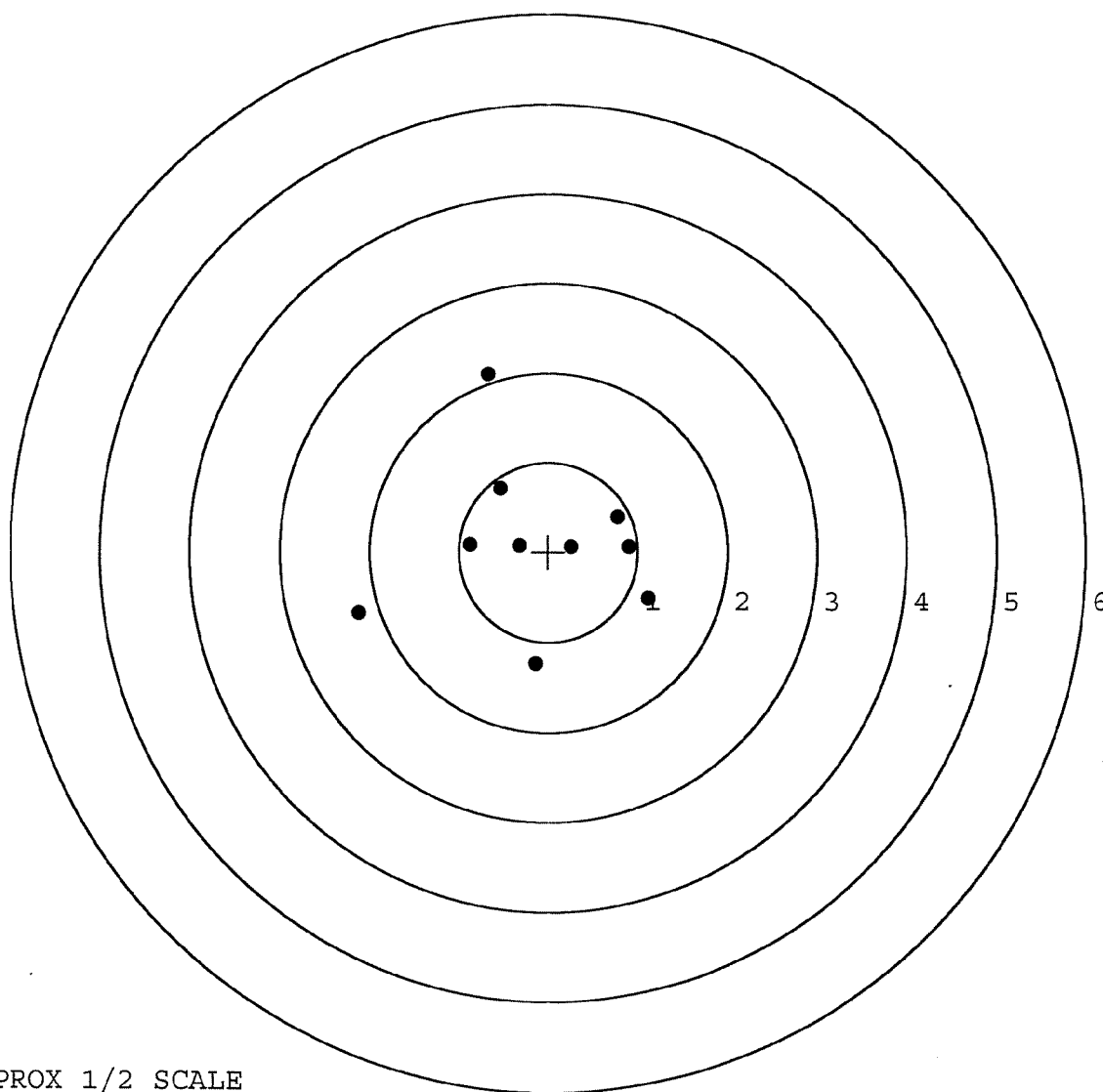
MAX RADIUS: 2.106

MEAN RADIUS: 1.091

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE