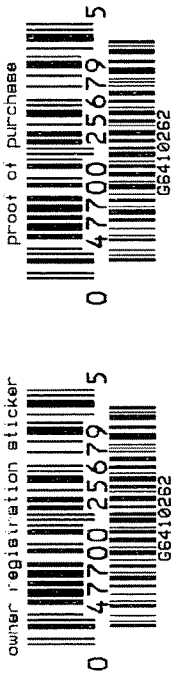


G6410262

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
G6410262	

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



SERIAL NO.



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

78ROT01

Goff Blast Barrel & Rec Assembly,



0003770797

0540

01PC001

Flat Black Powder Coat, Barrel and



0003770799

0560

89SWS1

Reassemble Action.



0003770800

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410262

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RR
600	PROOF		1-4-05	L
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-4-05	Ac
610	DIS-ASSEMBLE GUN		1-4-05	RR
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		1-5-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1-10-05	TR
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-18-05	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	RR
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6 16s</u> <u>6 16s</u> <u>6 16s</u>	2-16-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5 16s</u> <u>2.5 16s</u> <u>2.5 16s</u>	2-16-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	2-16-05	Ac
	J) ASSEMBLE STOCK		2-1-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		2-18-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-1-05	RTZ
	M) IRON SIGHT ALIGNMENT		2-1-05	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-1-05	RTZ
640	GALLERY TEST AND TARGET	<u>PASS</u> <u>FAIL</u>	2-4-05	Ac
	MALFUNCTION	CORRECTION	N/A	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-4-05	Ac
655	FINAL INSPECTION A) HEADSPACE		2-16-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.32</u> <u>2.75</u> <u>2.30</u> <u>2.72</u>	2-18-05	TRW
	C) FUNCTION		2-16-05	Ac
660	PACK		3/19/05	RTZ

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 1-18-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.11	2.57		2.58	
PULL #2	2.47	2.72		2.60	
PULL #3	2.60	2.66		2.58	
PULL #4	2.70	2.62		2.61	
PULL #5	2.91	2.70		2.48	
TOTAL	12.79	13.27		12.85	
AVERAGE	2.55	2.65		2.57	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.41	3.33		
PULL #2	3.50	3.42		
PULL #3	3.48	3.48		
PULL #4	3.56	3.45		
PULL #5	3.48	3.38		
TOTAL	17.43	17.06		
AVERAGE	3.48	3.41		

	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	4.16	4.05		4.37
PULL #2	4.30	4.16		4.08
PULL #3	4.27	4.04		4.14
PULL #4	4.11	4.17		4.20
PULL #5	4.15	4.11		4.19
TOTAL	20.99	20.53		20.98
AVERAGE	4.19	4.10		4.19

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410262.___0

FILE DATE AND TIME: 02/03/2005 09:37

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.067
The Average Y Centroid of the Five Target Set:	-0.036
The Average Point of Impact of the Five Target Set:	0.076
The Average Mean Radius of the Five Target Set:	0.779
The Distance from POA to Centroid Target #1:	0.237
The Distance from Centroid Target #2 to Centroid Target #1:	0.273
The Distance from Centroid Target #3 to Centroid Target #1:	0.290
The Distance from Centroid Target #4 to Centroid Target #1:	0.295
The Distance from Centroid Target #5 to Centroid Target #1:	0.408

SERIAL NUMBER: G6410262. 0

TARGET NUMBER: 1

FILE DATE: 02/03/2005

FILE TIME: 09:37

X CENTROID: -0.136

Y CENTROID: 0.194

POA TO CENTROID: 0.237

HORZ SPREAD: 2.095

VERT SPREAD: 2.413

GROUP SPREAD: 2.214

MIN RADIUS: 0.225

MAX RADIUS: 1.449

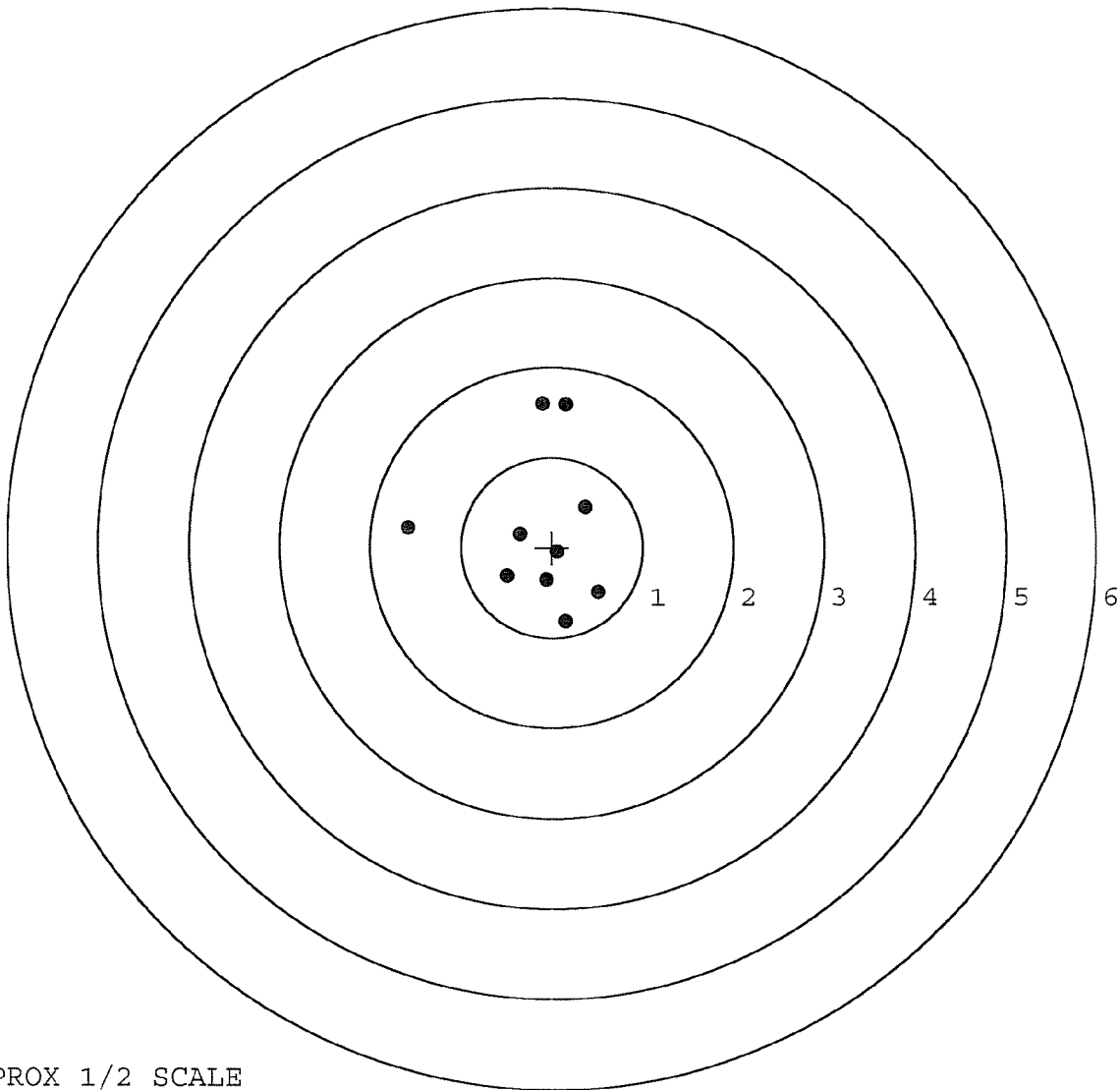
MEAN RADIUS: 0.855

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.154	1.581
2:	-0.102	1.587
3:	0.369	0.451
4:	-0.357	0.147
5:	0.056	-0.047
6:	-0.063	-0.360
7:	-0.494	-0.321
8:	-1.585	0.220
9:	0.510	-0.497
10:	0.148	-0.826



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410262. __0

TARGET NUMBER: 2

FILE DATE: 02/03/2005

FILE TIME: 09:37

POINT#	X	Y
1:	-0.357	1.263
2:	-0.761	-0.471
3:	-0.538	-0.996
4:	0.844	-0.352
5:	0.704	-0.167
6:	0.490	-0.461
7:	0.251	-0.411
8:	-0.098	0.166
9:	-0.230	0.355
10:	-0.514	0.534

X CENTROID: -0.021

Y CENTROID: -0.054

POA TO CENTROID: 0.058

HORZ SPREAD: 1.605

VERT SPREAD: 2.259

GROUP SPREAD: 2.266

MIN RADIUS: 0.233

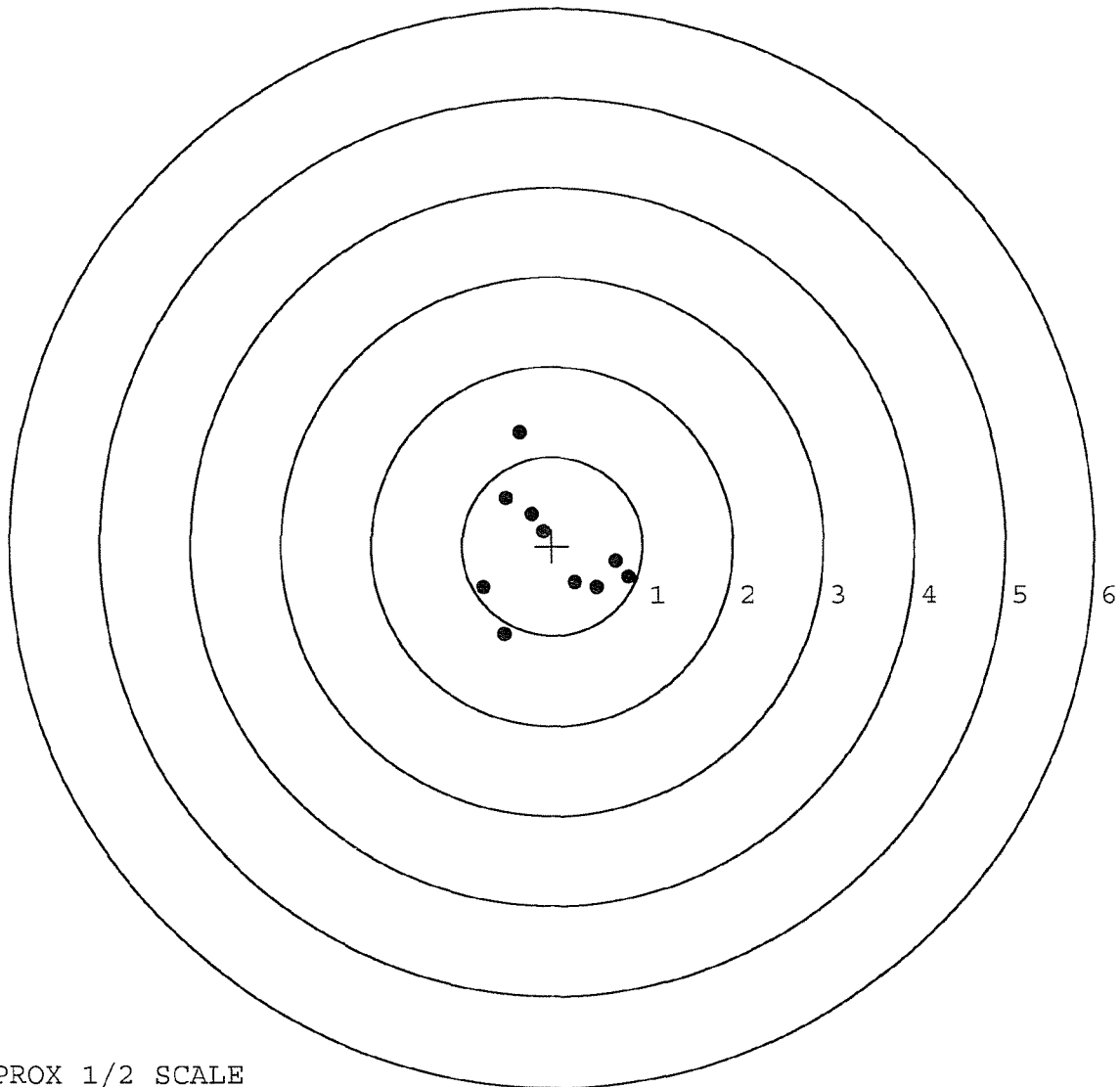
MAX RADIUS: 1.359

MEAN RADIUS: 0.749

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410262. __0

TARGET NUMBER: 3

FILE DATE: 02/03/2005

FILE TIME: 09:37

X CENTROID: 0.002

Y CENTROID: -0.061

POA TO CENTROID: 0.061

HORZ SPREAD: 2.091

VERT SPREAD: 1.568

GROUP SPREAD: 2.284

MIN RADIUS: 0.344

MAX RADIUS: 1.279

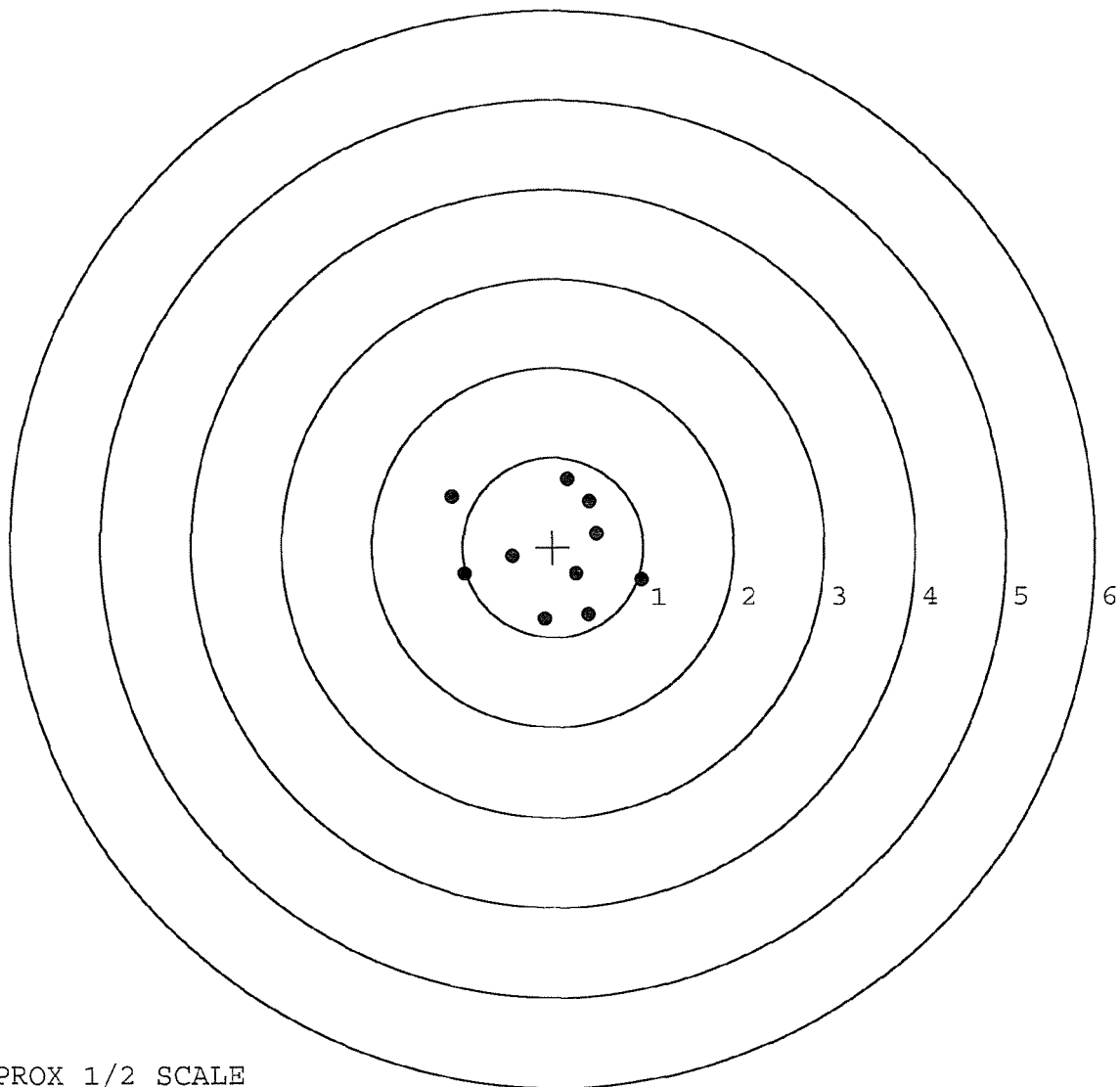
MEAN RADIUS: 0.771

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.974	-0.361
2:	0.388	-0.751
3:	0.257	-0.292
4:	-0.094	-0.803
5:	-0.452	-0.101
6:	-0.975	-0.297
7:	-1.117	0.558
8:	0.166	0.765
9:	0.403	0.517
10:	0.474	0.157

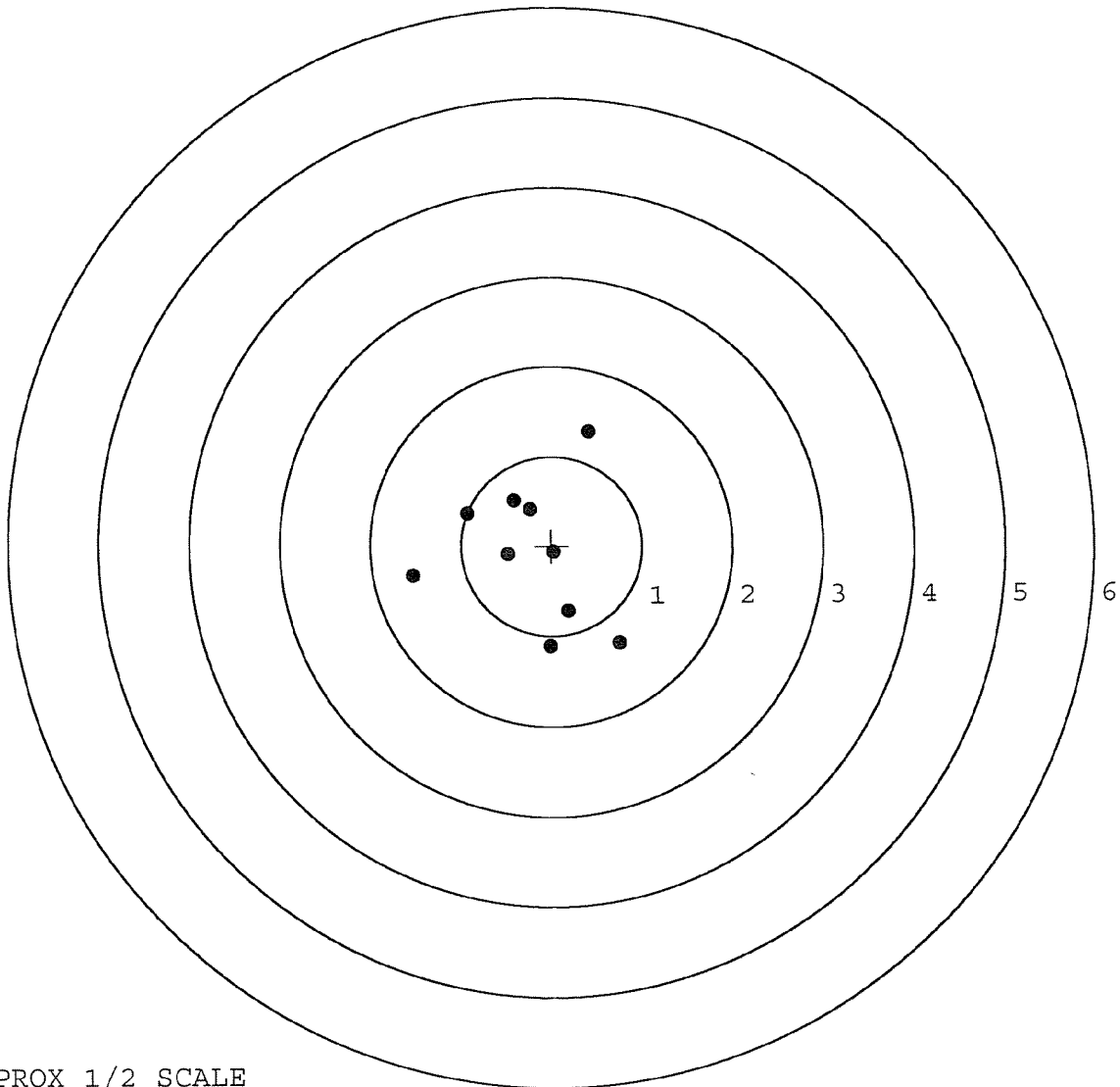


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410262.____0
 TARGET NUMBER: 4
 FILE DATE: 02/03/2005
 FILE TIME: 09:37

X CENTROID: -0.226
 Y CENTROID: -0.088
 POA TO CENTROID: 0.242
 HORZ SPREAD: 2.275
 VERT SPREAD: 2.402
 GROUP SPREAD: 2.530
 MIN RADIUS: 0.250
 MAX RADIUS: 1.510
 MEAN RADIUS: 0.852
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.746	-1.086
2:	0.180	-0.728
3:	-0.025	-1.124
4:	0.023	-0.067
5:	-0.486	-0.097
6:	-0.236	0.411
7:	-0.418	0.510
8:	-0.931	0.362
9:	-1.529	-0.336
10:	0.419	1.278

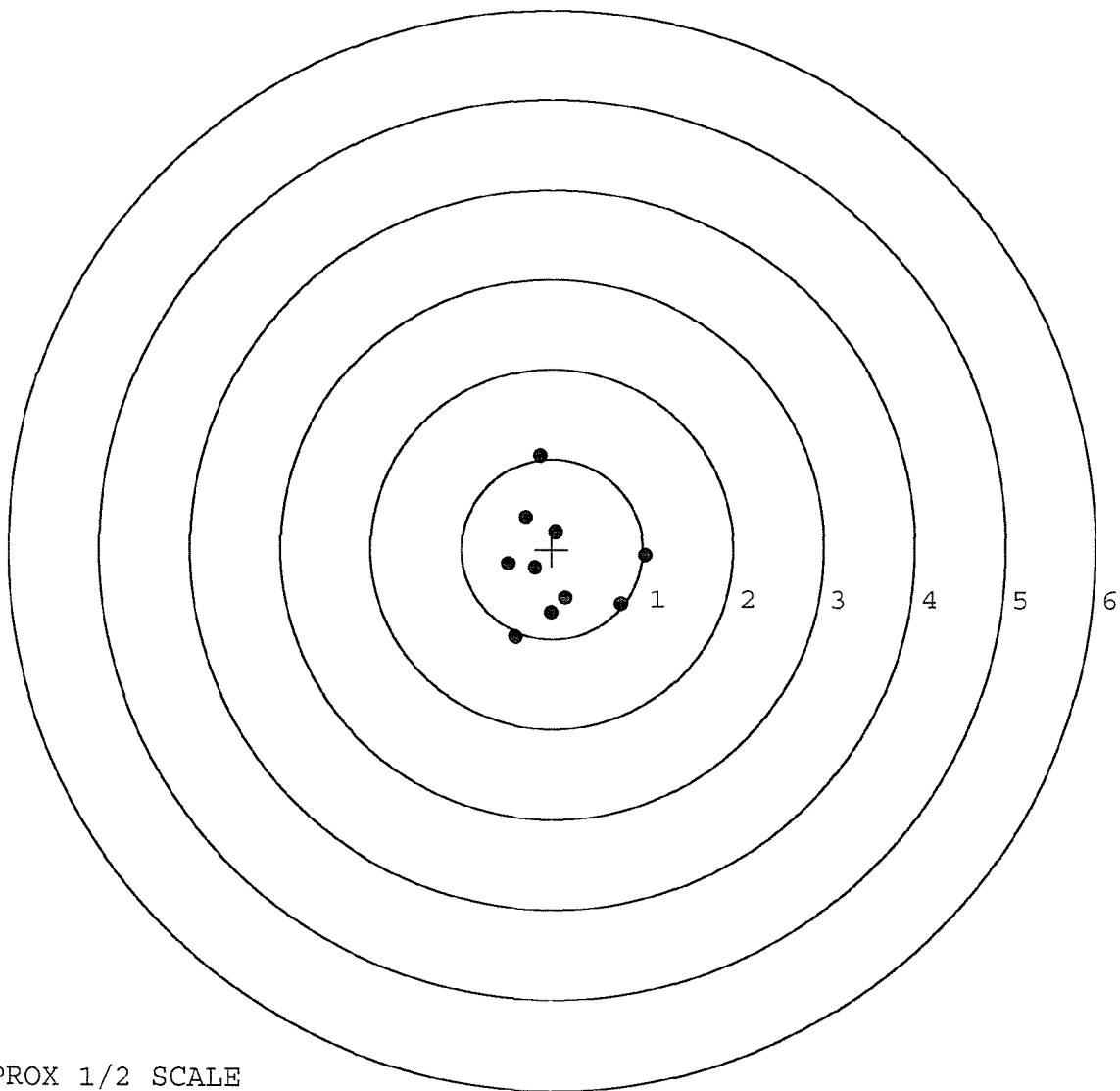


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410262. __0
 TARGET NUMBER: 5
 FILE DATE: 02/03/2005
 FILE TIME: 09:37

POINT#	X	Y
1:	1.031	-0.068
2:	0.761	-0.611
3:	0.148	-0.540
4:	-0.013	-0.712
5:	-0.406	-0.986
6:	-0.134	1.035
7:	0.042	0.190
8:	-0.297	0.357
9:	-0.485	-0.171
10:	-0.191	-0.209

X CENTROID: 0.046
 Y CENTROID: -0.172
 POA TO CENTROID: 0.177
 HORZ SPREAD: 1.516
 VERT SPREAD: 2.021
 GROUP SPREAD: 2.039
 MIN RADIUS: 0.240
 MAX RADIUS: 1.220
 MEAN RADIUS: 0.667
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE