

G-641 4340

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

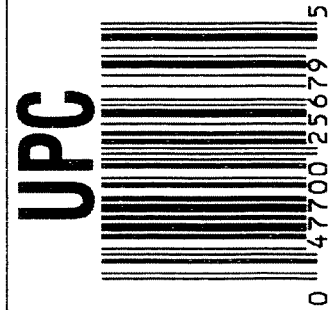


ORDER NO. **25679**

BARREL LENGTH **24"**

CAPACITY **6**

G6414340



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



0 47700 25679 5

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



0 47700 25679 5

SERIAL NO.



66414340

3/11/2005 9:25:01 AM

Original
LL
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 # G6414340

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		10-19-04	RTL
600	PROOF		10-20-04	AC
607	CHECK HEADSPACE		10-20-04	AK
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		10/27/04	AB
617	DRILL AND TAP SIGHT HOLES		10-22-04	TRW
620	APPLY COATINGS (BARREL ACTION)		10/30	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-8-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-8-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-8-04	RTL
	D) OIL FIRING PIN ASSEMBLY		11-8-04	RTL
	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	7 lbs	7 lbs	7 lbs	2-16-05 AC			
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	3 lbs	3 lbs	3 lbs	2-16-05 AC			
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.023	.023	.023	2-16-05 AC			
	J) ASSEMBLE STOCK				11-8-04	RTL			
	K) ASSEMBLE SWIVEL STUDS				2-18-05	A			
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				2-7-05	RTL			
	M) IRON SIGHT ALIGNMENT				2-7-05	RTL			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				2-7-05	RTL			
640	GALLERY TEST AND TARGET		PASS	FAIL	12-15-04	TRLW			
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
645	INSPECT FOR LIVE AMMO				12-15-04	TRLW			
655	FINAL INSPECTION A) HEADSPACE				2-16-05	AC			
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.94	2.90	2.86	2.88	2.82	2-18-05	TRLW
	C) FUNCTION					2-16-05	AC		
660	PACK					3/19/05	DA		

AVERAGE PULL FORCE BETWEEN
INITIAL & AFTER 50 CYCLES
BARBER - M24 0150593

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 6-17-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.56	2.74		2.80	
PULL #2	2.44	2.67		2.82	
PULL #3	2.56	2.65		2.82	
PULL #4	2.59	2.72		2.83	
PULL #5	2.61	2.73		2.79	
TOTAL	12.76	13.51		14.06	
AVERAGE	2.55	2.70		2.81	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.16		
PULL #2	3.13	3.05		
PULL #3	3.14	3.06		
PULL #4	3.15	2.96		
PULL #5	3.11	3.03		
TOTAL	15.87	15.26		
AVERAGE	3.17	3.05		

	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	4.15	4.10		4.20
PULL #2	4.25	4.08		4.18
PULL #3	4.32	4.14		3.91
PULL #4	4.10	4.19		4.04
PULL #5	4.12	4.22		4.17
TOTAL	20.94	20.73		20.50
AVERAGE	4.18	4.14		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414340.__0
FILE DATE AND TIME: 12/15/2004 08:03

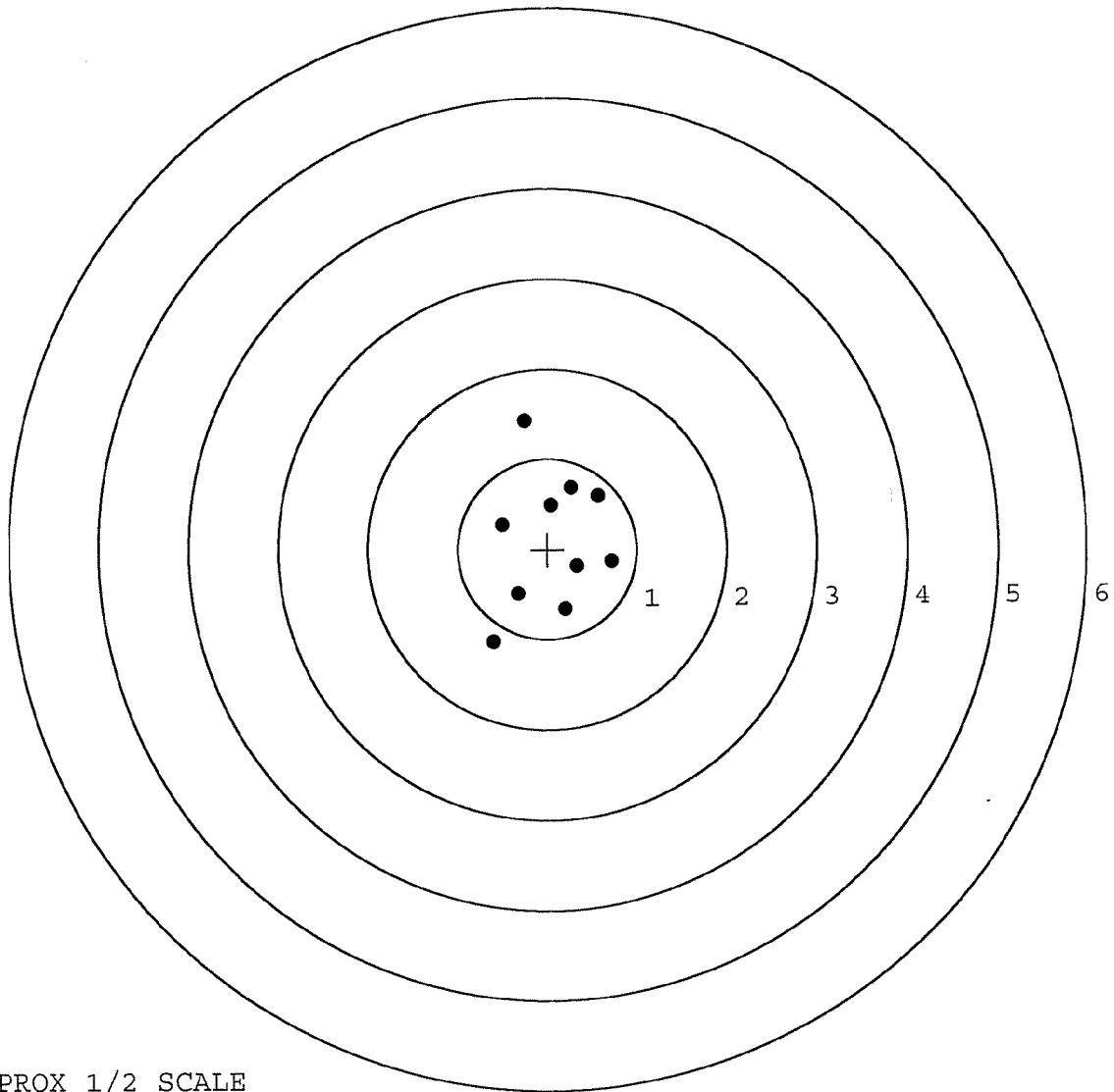
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.006
The Average Y Centroid of the Five Target Set:	-0.084
The Average Point of Impact of the Five Target Set:	0.084
The Average Mean Radius of the Five Target Set:	0.660
The Distance from POA to Centroid Target #1:	0.103
The Distance from Centroid Target #2 to Centroid Target #1:	0.230
The Distance from Centroid Target #3 to Centroid Target #1:	0.337
The Distance from Centroid Target #4 to Centroid Target #1:	0.210
The Distance from Centroid Target #5 to Centroid Target #1:	0.230

SERIAL NUMBER: G6414340. __0
 TARGET NUMBER: 1
 FILE DATE: 12/15/2004
 FILE TIME: 08:03

X CENTROID: 0.042
 Y CENTROID: 0.094
 POA TO CENTROID: 0.103
 HORZ SPREAD: 1.334
 VERT SPREAD: 2.458
 GROUP SPREAD: 2.485
 MIN RADIUS: 0.394
 MAX RADIUS: 1.364
 MEAN RADIUS: 0.759
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.716	-0.140
2:	0.333	-0.187
3:	0.194	-0.668
4:	-0.336	-0.495
5:	-0.618	-1.032
6:	0.572	0.588
7:	0.273	0.682
8:	0.046	0.488
9:	-0.508	0.275
10:	-0.252	1.426

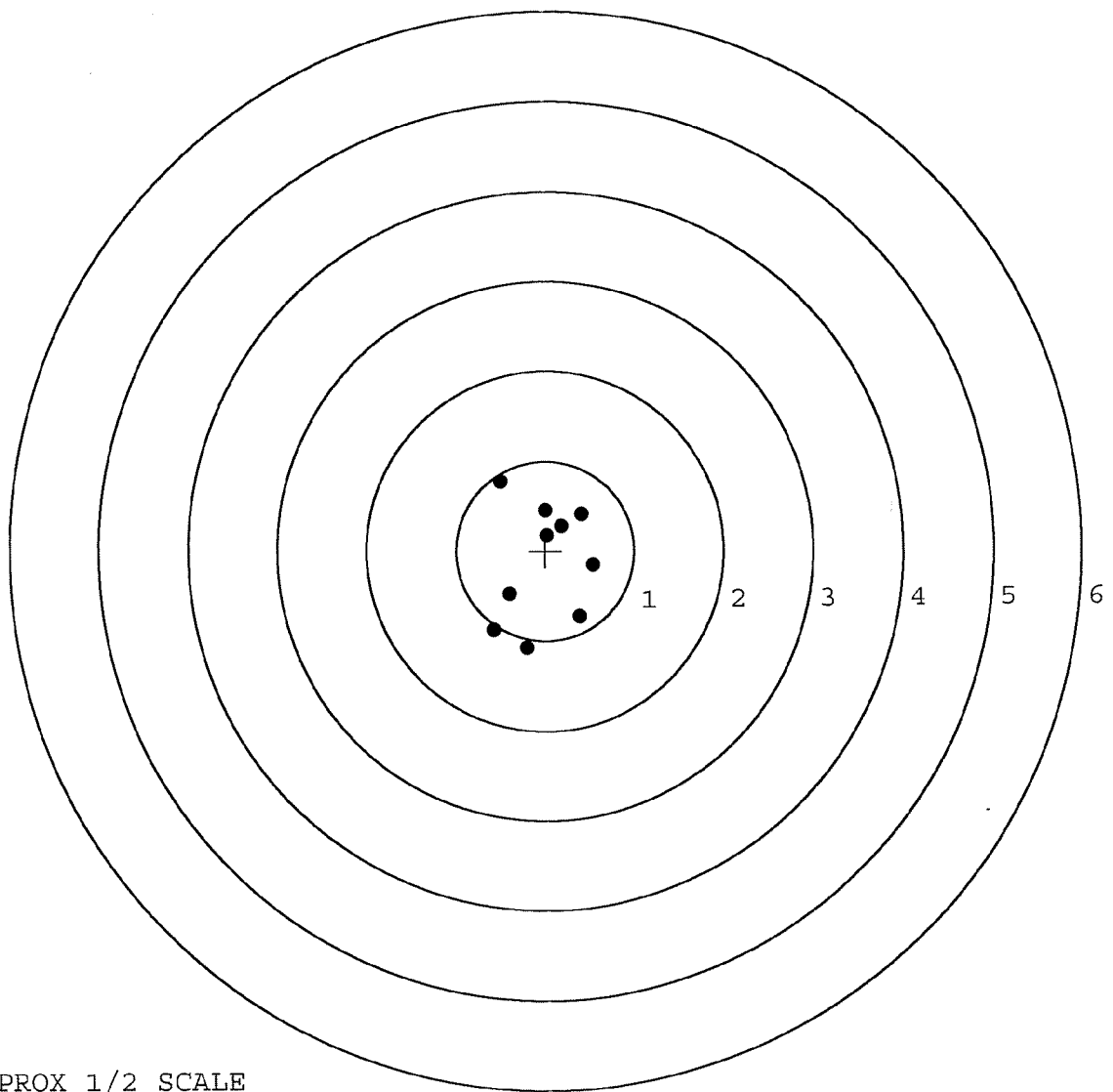


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414340. 0
 TARGET NUMBER: 2
 FILE DATE: 12/15/2004
 FILE TIME: 08:03

POINT#	X	Y
1:	0.386	-0.737
2:	0.536	-0.162
3:	-0.219	-1.085
4:	-0.591	-0.884
5:	-0.412	-0.486
6:	-0.506	0.775
7:	0.407	0.412
8:	0.185	0.277
9:	0.015	0.168
10:	0.003	0.448

X CENTROID: -0.020
 Y CENTROID: -0.127
 POA TO CENTROID: 0.129
 HORZ SPREAD: 1.127
 VERT SPREAD: 1.860
 GROUP SPREAD: 1.882
 MIN RADIUS: 0.297
 MAX RADIUS: 1.025
 MEAN RADIUS: 0.679
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

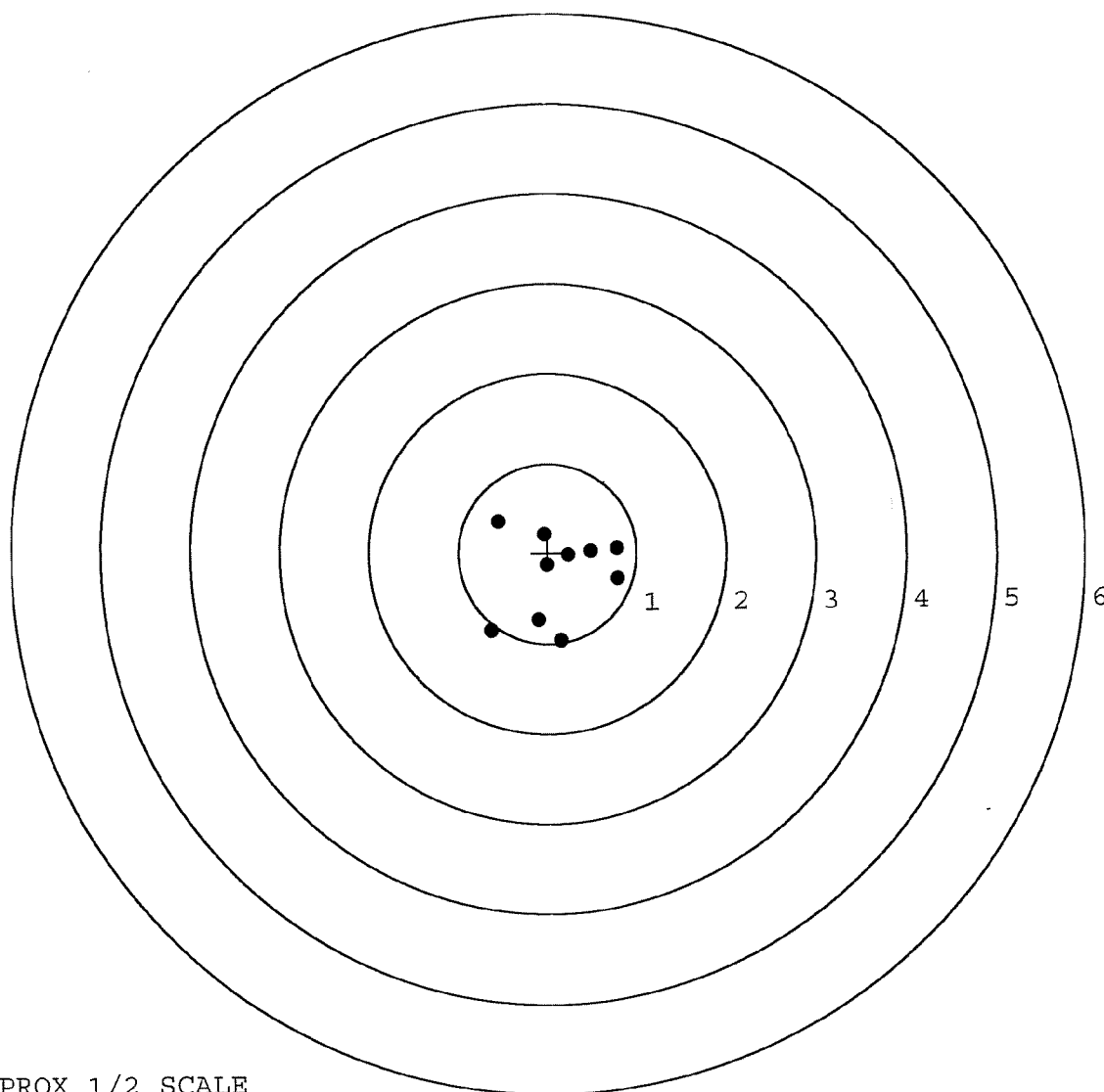


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414340. 0
 TARGET NUMBER: 3
 FILE DATE: 12/15/2004
 FILE TIME: 08:03

POINT#	X	Y
1:	0.145	-0.968
2:	-0.113	-0.745
3:	-0.641	-0.856
4:	0.783	-0.287
5:	-0.559	0.354
6:	0.780	0.051
7:	0.485	0.024
8:	0.229	-0.023
9:	-0.015	-0.137
10:	-0.045	0.211

X CENTROID: 0.105
 Y CENTROID: -0.238
 POA TO CENTROID: 0.260
 HORZ SPREAD: 1.424
 VERT SPREAD: 1.322
 GROUP SPREAD: 1.686
 MIN RADIUS: 0.157
 MAX RADIUS: 0.969
 MEAN RADIUS: 0.589
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



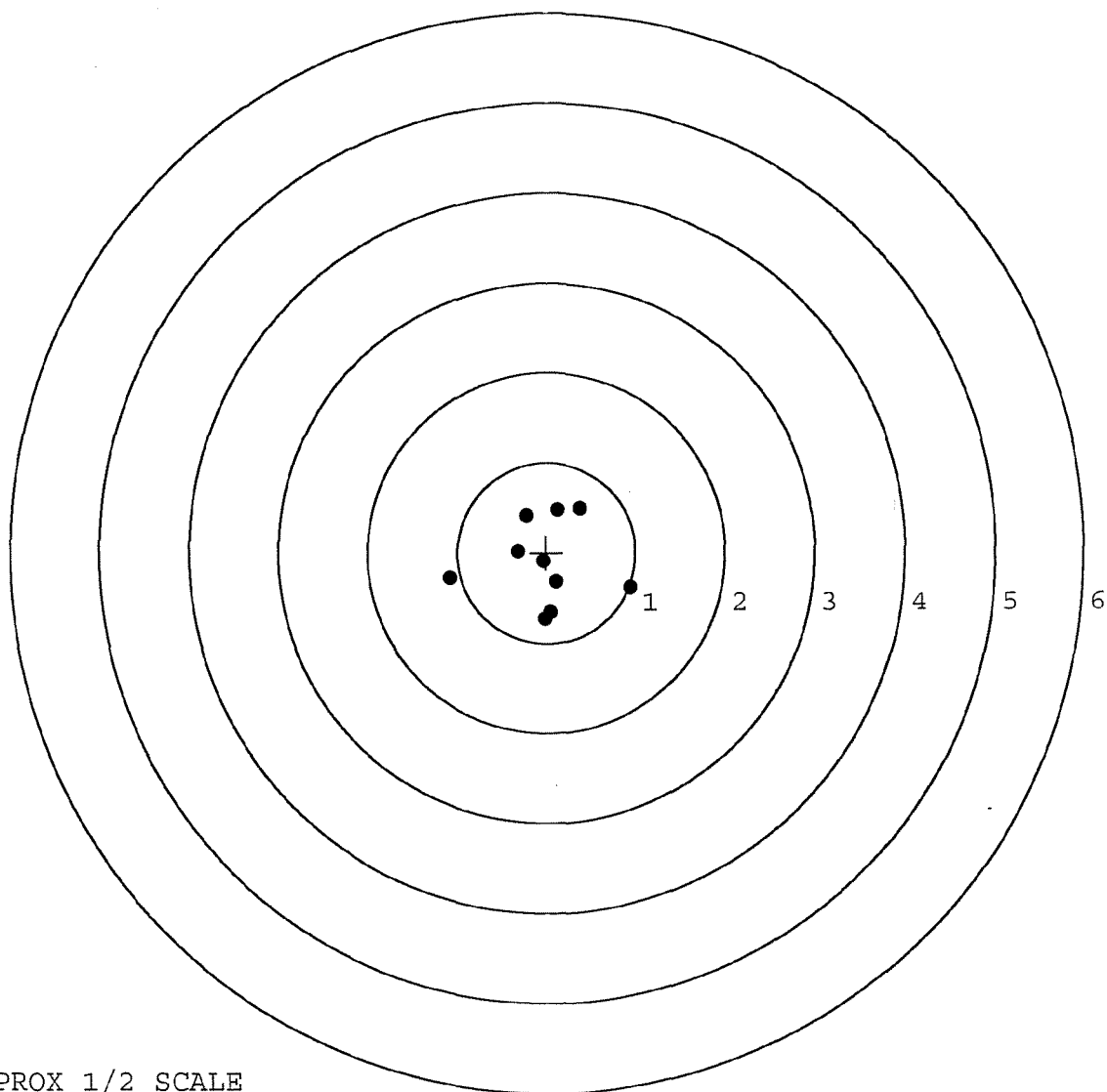
TARGET APPROX 1/2 SCALE

BARBER - M24 0150598

SERIAL NUMBER: G6414340. __0
 TARGET NUMBER: 4
 FILE DATE: 12/15/2004
 FILE TIME: 08:03

POINT#	X	Y
1:	0.945	-0.391
2:	0.044	-0.665
3:	-1.086	-0.283
4:	0.376	0.499
5:	0.125	0.478
6:	-0.232	0.407
7:	-0.322	0.015
8:	-0.035	-0.098
9:	0.112	-0.323
10:	-0.024	-0.737

X CENTROID: -0.010
 Y CENTROID: -0.110
 POA TO CENTROID: 0.110
 HORZ SPREAD: 2.031
 VERT SPREAD: 1.236
 GROUP SPREAD: 2.034
 MIN RADIUS: 0.028
 MAX RADIUS: 1.090
 MEAN RADIUS: 0.577
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



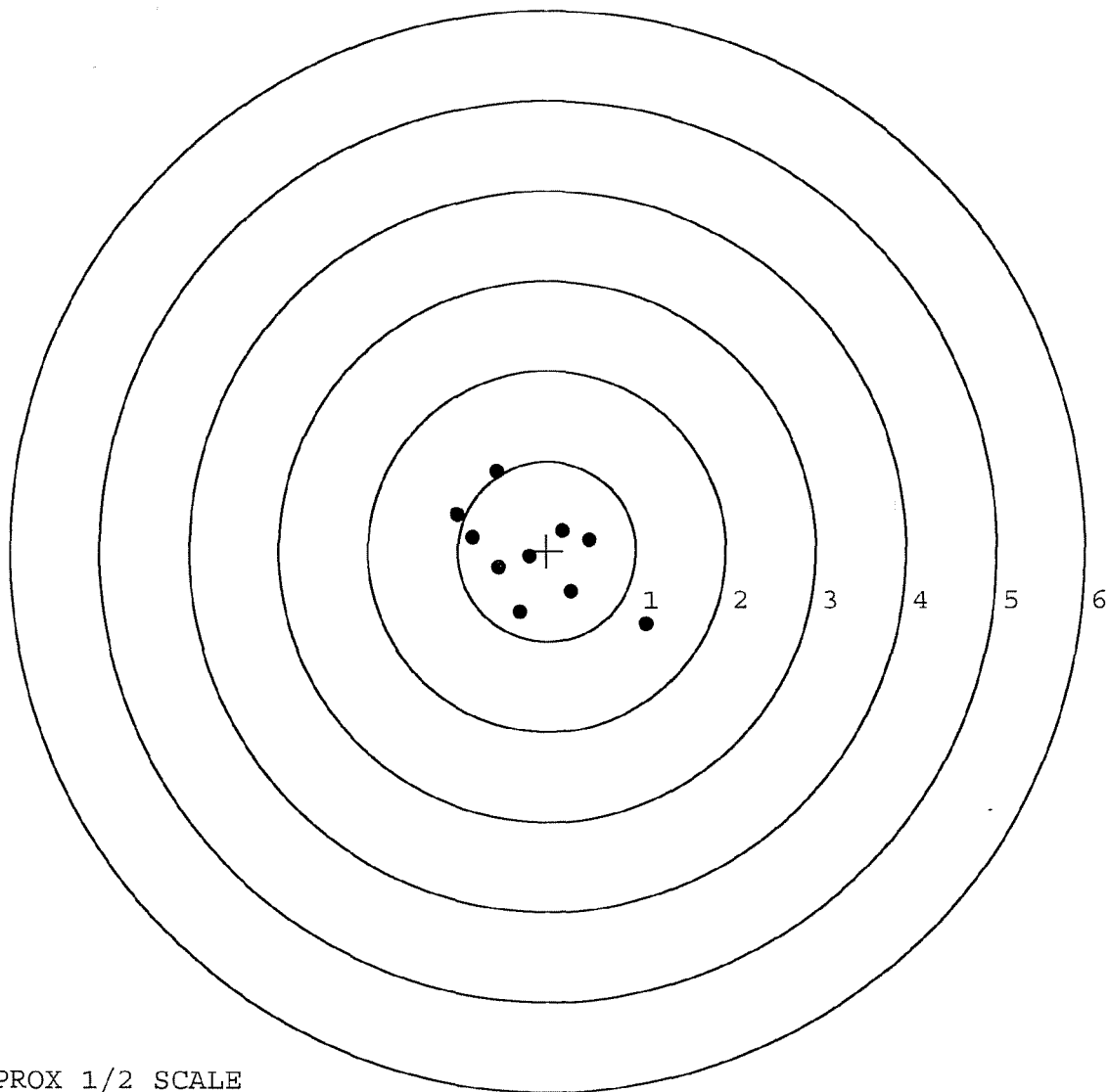
TARGET APPROX 1/2 SCALE

BARBER - M24 0150599

SERIAL NUMBER: G6414340. 0
 TARGET NUMBER: 5
 FILE DATE: 12/15/2004
 FILE TIME: 08:03

POINT#	X	Y
1:	1.107	-0.814
2:	0.267	-0.448
3:	0.467	0.129
4:	0.169	0.224
5:	-0.197	-0.066
6:	-0.312	-0.686
7:	-0.540	-0.184
8:	-0.571	0.888
9:	-1.010	0.410
10:	-0.838	0.159

X CENTROID: -0.146
 Y CENTROID: -0.039
 POA TO CENTROID: 0.151
 HORZ SPREAD: 2.117
 VERT SPREAD: 1.702
 GROUP SPREAD: 2.445
 MIN RADIUS: 0.058
 MAX RADIUS: 1.473
 MEAN RADIUS: 0.696
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE