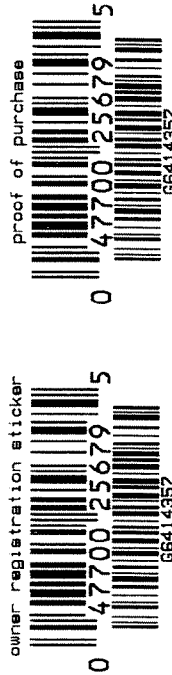


G641 4357

**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**

G6414357



ORDER — 25679

M/24 7.62 NATO S.W.S.

UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



SERIAL NO.



3/11/2005 9:25:01 AM

Chb

2

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 # G 641 4357

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-27-04	RTL
600	PROOF		12-28-04	K
607	CHECK HEADSPACE	MAGNA - FLUX INSPECTED	12-28-04	K
610	DIS-ASSEMBLE GUN	JAN 7 2005	12-28-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR 		
615	ROLLMARK CALIBER		12/29/04	K3
617	DRILL AND TAP SIGHT HOLES		12-28-04	TRW
620	APPLY COATINGS (BARREL ACTION)		1/5/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-10-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-10-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER			
	D) OIL FIRING PIN ASSEMBLY		1-11-05	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	<u>7 1/2s</u>	<u>7 1/2s</u>	<u>7 1/2s</u>	2-16-05	AC		
CONT.								
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 1/2s</u>	<u>3 1/2s</u>	<u>3 1/2s</u>	2-16-05	AC		
	H) TRIGGER PULL TEST AND RETAINABILITY							
	I) FIRING PIN INDENT .020 MIN	<u>.022</u>	<u>.022</u>	<u>.022</u>	2-16-05	AC		
	J) ASSEMBLE STOCK				1-11-05	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				2-4-05	RTZ		
640	GALLERY TEST AND TARGET	PASS FAIL			2-3-05	TRW		
	MALFUNCTION	CORRECTION						
	MALFUNCTION	CORRECTION						
	MALFUNCTION	CORRECTION						
	MALFUNCTION	CORRECTION						
645	INSPECT FOR LIVE AMMO				2-3-05	TRW		
655	FINAL INSPECTION A) HEADSPACE				2-16-05	AC		
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.59</u>	<u>2.45</u>	<u>2.45</u>	<u>2.48</u>	<u>2.42</u>	2-17-05	TRW
	C) FUNCTION				2-16-05	AC		
660	PACK				3/18/05	DA		

AVERAGE PULL FORCE BETWEEN
 INITIAL & BARBER - M24-0150845
 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 12-27-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS	COMMENTS
PULL #1	2.37	2.87	2.90	
PULL #2	2.59	2.85	2.78	
PULL #3	2.55	2.74	2.78	
PULL #4	2.62	2.71	2.74	
PULL #5	2.62	2.68	2.77	
TOTAL	12.75	13.85	13.97	
AVERAGE	2.55	2.77	2.79	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES	COMMENTS
PULL #1	3.24	3.37	
PULL #2	3.24	3.25	
PULL #3	3.15	3.26	
PULL #4	3.24	3.19	
PULL #5	3.14	3.18	
TOTAL	16.01	16.25	
AVERAGE	3.20	3.25	

	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	4.01		4.23
PULL #2	4.06	4.08		4.21
PULL #3	4.05	3.94		4.25
PULL #4	4.04	3.88		4.26
PULL #5	4.04	3.85		4.24
TOTAL	20.34	19.76		21.19
AVERAGE	4.06	3.95		4.23

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414357.___0
FILE DATE AND TIME: 02/03/2005 09:18

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.036
The Average Y Centroid of the Five Target Set:	-0.063
The Average Point of Impact of the Five Target Set:	0.072
The Average Mean Radius of the Five Target Set:	0.903
The Distance from POA to Centroid Target #1:	0.305
The Distance from Centroid Target #2 to Centroid Target #1:	0.234
The Distance from Centroid Target #3 to Centroid Target #1:	0.379
The Distance from Centroid Target #4 to Centroid Target #1:	0.396
The Distance from Centroid Target #5 to Centroid Target #1:	0.161

SERIAL NUMBER: G6414357. 0

TARGET NUMBER: 1

FILE DATE: 02/03/2005

FILE TIME: 09:18

X CENTROID: -0.146

Y CENTROID: -0.267

POA TO CENTROID: 0.305

HORZ SPREAD: 1.779

VERT SPREAD: 3.940

GROUP SPREAD: 3.988

MIN RADIUS: 0.379

MAX RADIUS: 2.117

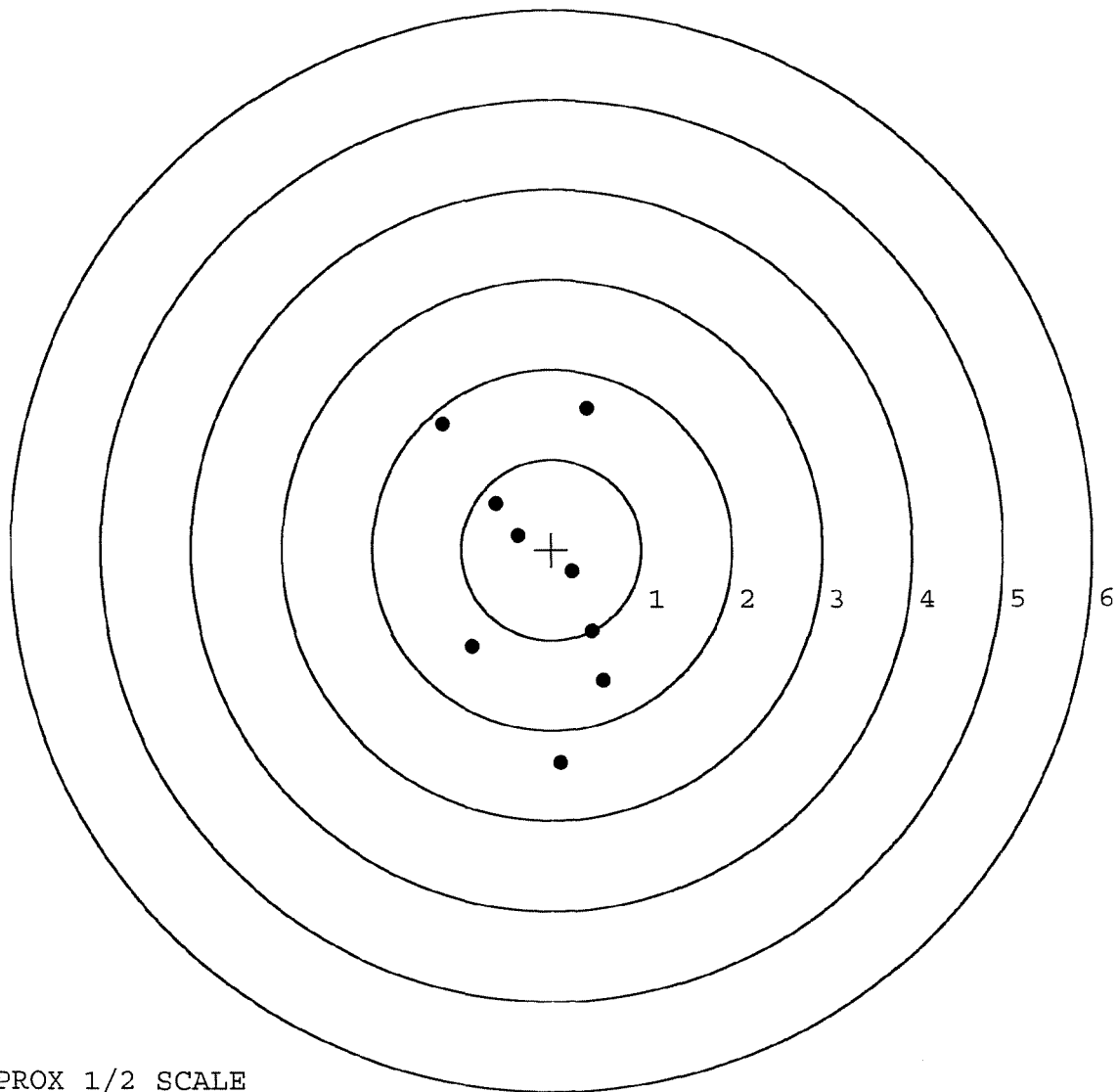
MEAN RADIUS: 1.236

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 6

POINT#	X	Y
1:	0.106	-2.369
2:	-0.880	-1.071
3:	0.574	-1.457
4:	0.452	-0.903
5:	0.232	-0.242
6:	-0.373	0.159
7:	-0.617	0.509
8:	0.394	1.571
9:	-1.205	1.397



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414357. 0

TARGET NUMBER: 2

FILE DATE: 02/03/2005

FILE TIME: 09:18

X CENTROID: -0.005

Y CENTROID: -0.081

POA TO CENTROID: 0.081

HORZ SPREAD: 1.767

VERT SPREAD: 2.601

GROUP SPREAD: 2.708

MIN RADIUS: 0.213

MAX RADIUS: 1.490

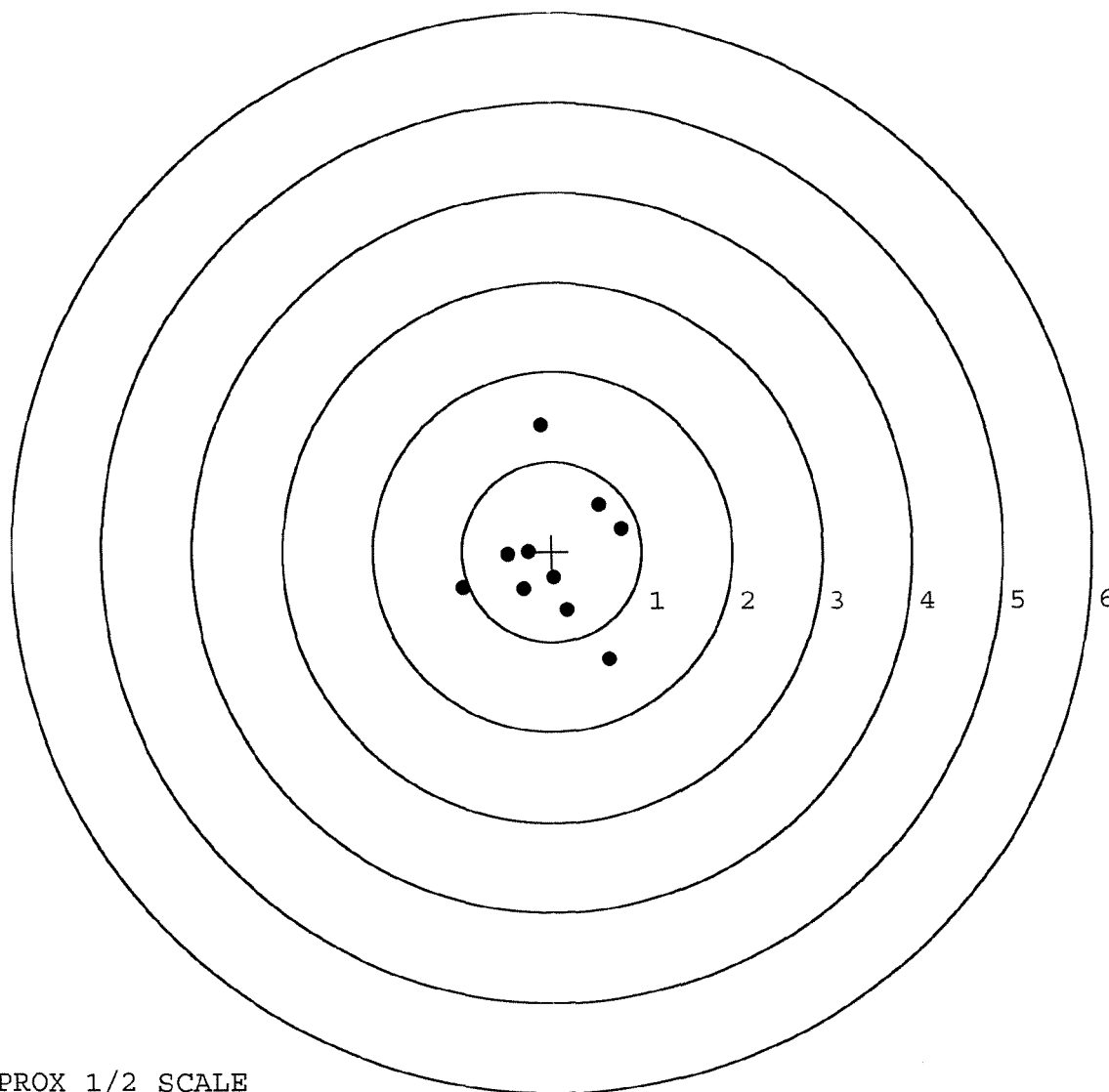
MEAN RADIUS: 0.749

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.636	-1.196
2:	0.173	-0.652
3:	-0.995	-0.406
4:	0.772	0.259
5:	0.522	0.523
6:	-0.117	1.405
7:	-0.489	-0.033
8:	-0.261	-0.003
9:	0.025	-0.292
10:	-0.317	-0.415



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414357. __0

TARGET NUMBER: 3

FILE DATE: 02/03/2005

FILE TIME: 09:18

X CENTROID: 0.017

Y CENTROID: 0.075

POA TO CENTROID: 0.077

HORZ SPREAD: 1.076

VERT SPREAD: 3.038

GROUP SPREAD: 3.047

MIN RADIUS: 0.068

MAX RADIUS: 1.952

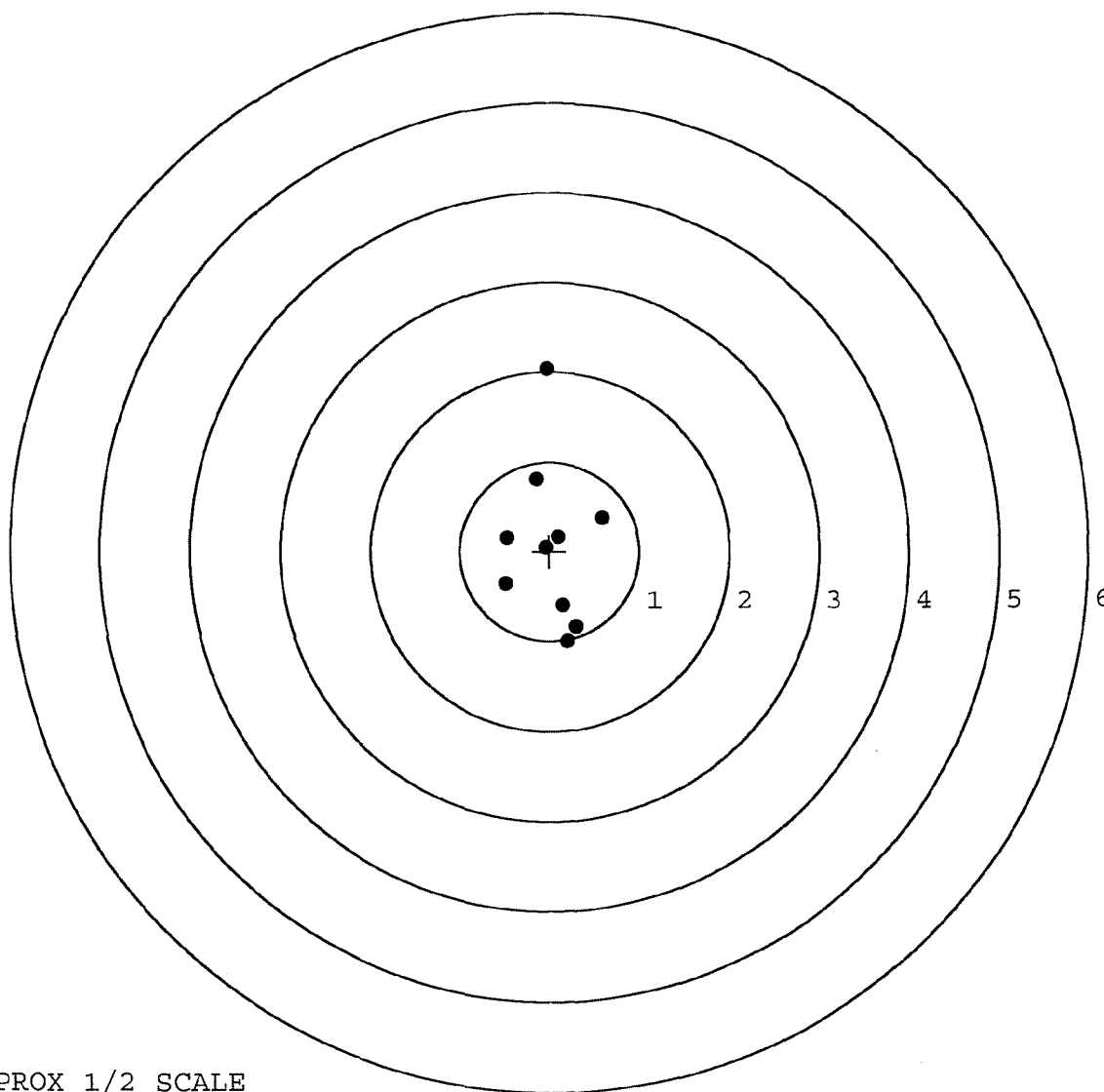
MEAN RADIUS: 0.746

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.206	-1.011
2:	0.294	-0.841
3:	0.147	-0.613
4:	0.588	0.379
5:	-0.141	0.808
6:	-0.470	0.156
7:	-0.488	-0.360
8:	-0.043	0.044
9:	0.103	0.161
10:	-0.025	2.027



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414357. __0

TARGET NUMBER: 4

FILE DATE: 02/03/2005

FILE TIME: 09:18

X CENTROID: 0.052

Y CENTROID: 0.075

POA TO CENTROID: 0.091

HORZ SPREAD: 1.619

VERT SPREAD: 2.583

GROUP SPREAD: 2.652

MIN RADIUS: 0.287

MAX RADIUS: 1.559

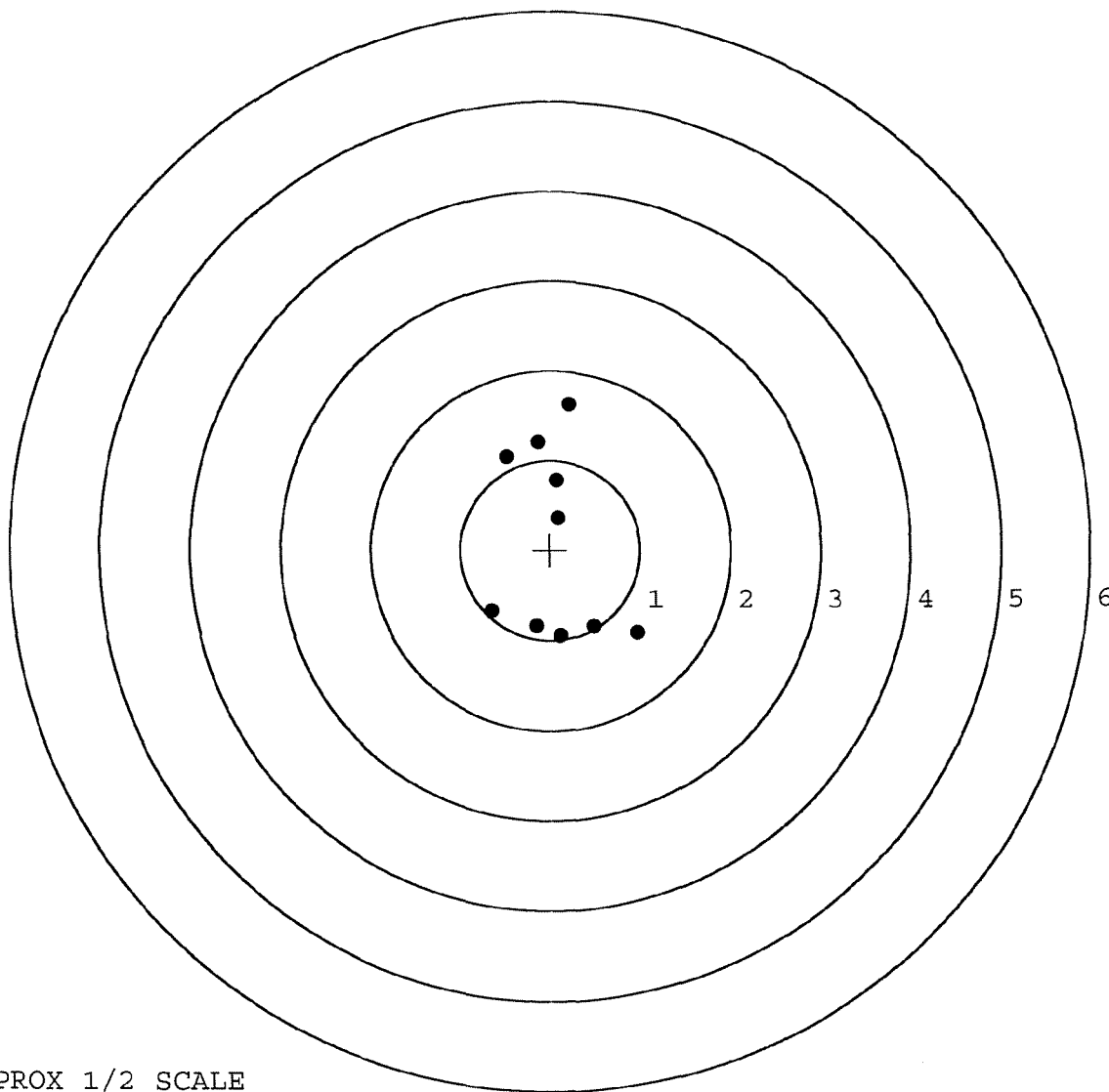
MEAN RADIUS: 1.018

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.963	-0.921
2:	0.483	-0.851
3:	0.118	-0.958
4:	-0.158	-0.849
5:	-0.656	-0.678
6:	0.087	0.360
7:	0.076	0.774
8:	-0.128	1.202
9:	-0.481	1.045
10:	0.219	1.625



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414357. 0

TARGET NUMBER: 5

FILE DATE: 02/03/2005

FILE TIME: 09:18

X CENTROID: -0.096

Y CENTROID: -0.114

POA TO CENTROID: 0.149

HORZ SPREAD: 1.693

VERT SPREAD: 2.355

GROUP SPREAD: 2.626

MIN RADIUS: 0.375

MAX RADIUS: 1.338

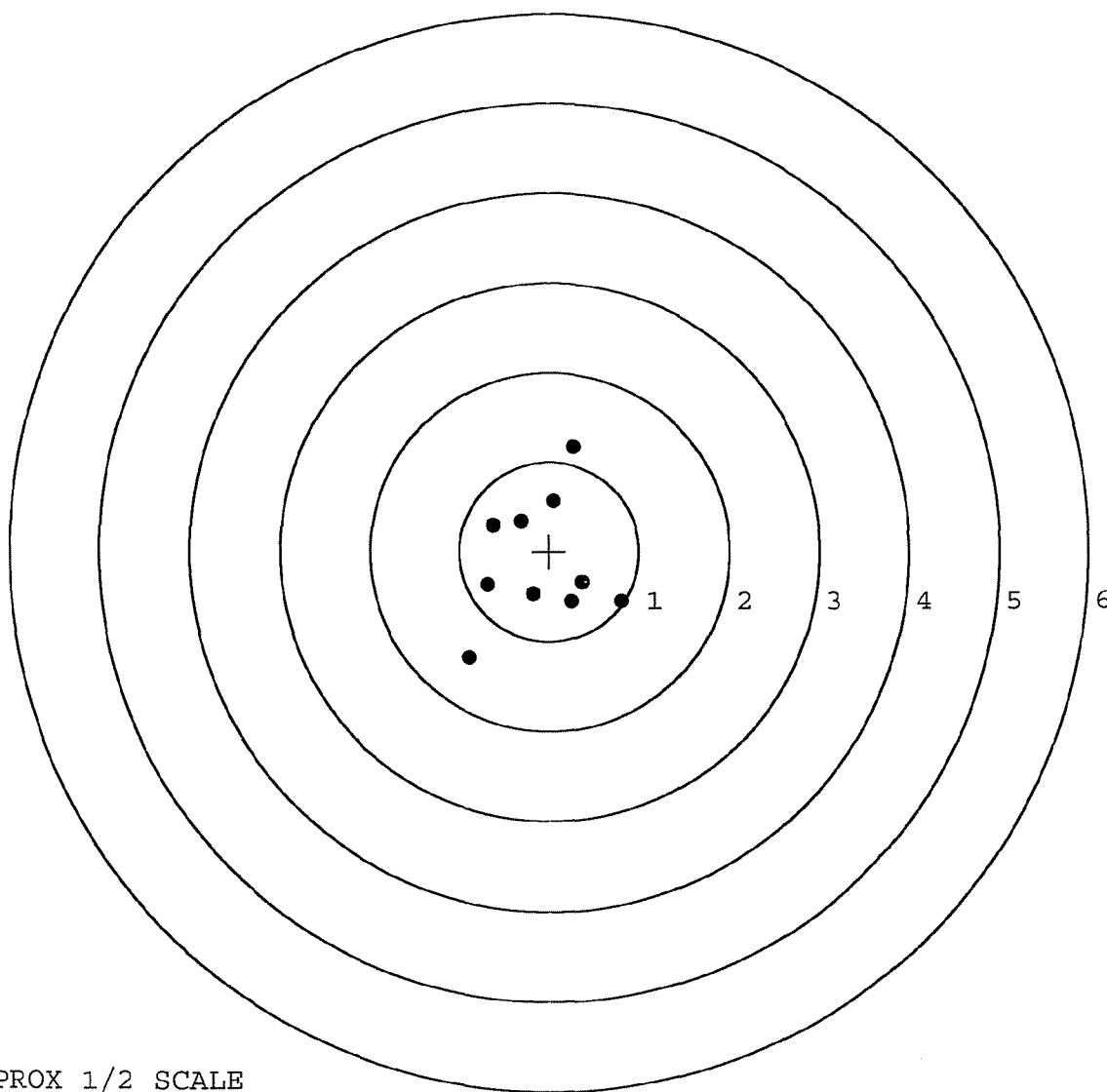
MEAN RADIUS: 0.764

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.806	-0.559
2:	-0.887	-1.183
3:	-0.690	-0.367
4:	-0.183	-0.479
5:	0.251	-0.565
6:	0.367	-0.346
7:	0.051	0.554
8:	-0.314	0.334
9:	0.274	1.172
10:	-0.631	0.297



TARGET APPROX 1/2 SCALE