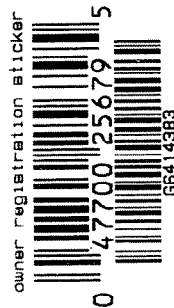


G 641 4385

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

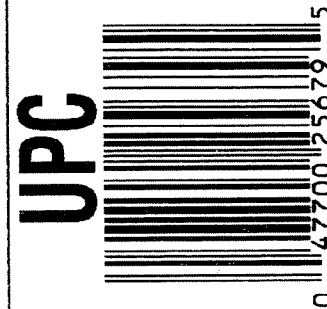


ORDER NO. **25679**

BARREL LENGTH **24"**

CAPACITY **6**

G6414383



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

Crib

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

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 # G6414383

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RTL
600	PROOF		1-4-05	A
607	CHECK HEADSPACE	MAGNA - FLUX	1-4-05	A
610	DIS-ASSEMBLE GUN	INSPECTED	1-4-05	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 3 + 2005 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)		1/16/05	HP
	(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	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>6 lbs</u>	<u>6 lbs</u>	<u>6 lbs</u>	2-16-05	Ac		
CONT.								
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u>	<u>2 lbs</u>	<u>2 lbs</u>	2-16-05	Ac		
	H) TRIGGER PULL TEST AND RETAINABILITY							
	I) FIRING PIN INDENT .020 MIN	<u>.023</u>	<u>.023</u>	<u>.023</u>	2-16-05	Ac		
	J) ASSEMBLE STOCK				2-1-05	RT		
	K) ASSEMBLE SWIVEL STUDS				2-18-05	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			2-4-05	Ac		
	MALFUNCTION	CORRECTION			NA			
	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>2.24</u>	<u>2.03</u>	<u>2.32</u>	<u>2.24</u>	<u>2.53</u>	2-17-05	TRW
	C) FUNCTION				2-16-05	Ac		
660	PACK				3/18/05	DA		

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

BARBER - M24 0151401

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 1-19-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.51	2.60		2.21	
PULL #2	2.71	2.57		2.06	
PULL #3	2.70	2.45		2.00	
PULL #4	2.52	2.37		2.05	
PULL #5	2.41	2.32		2.12	
TOTAL	12.85	12.31		10.44	
AVERAGE	2.57	2.46		2.08	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.48		
PULL #2	3.51	3.21		
PULL #3	3.39	3.18		
PULL #4	3.22	3.16		
PULL #5	3.24	3.16		
TOTAL	16.84	16.19		
AVERAGE	3.36	3.23		

	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	4.25	4.56		4.44
PULL #2	4.12	4.31		4.31
PULL #3	4.14	4.22		4.35
PULL #4	4.16	4.11		4.38
PULL #5	4.20	4.07		4.35
TOTAL	20.87	21.27		21.83
AVERAGE	4.17	4.25		4.36

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414383. __0
FILE DATE AND TIME: 02/04/2005 07:48

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

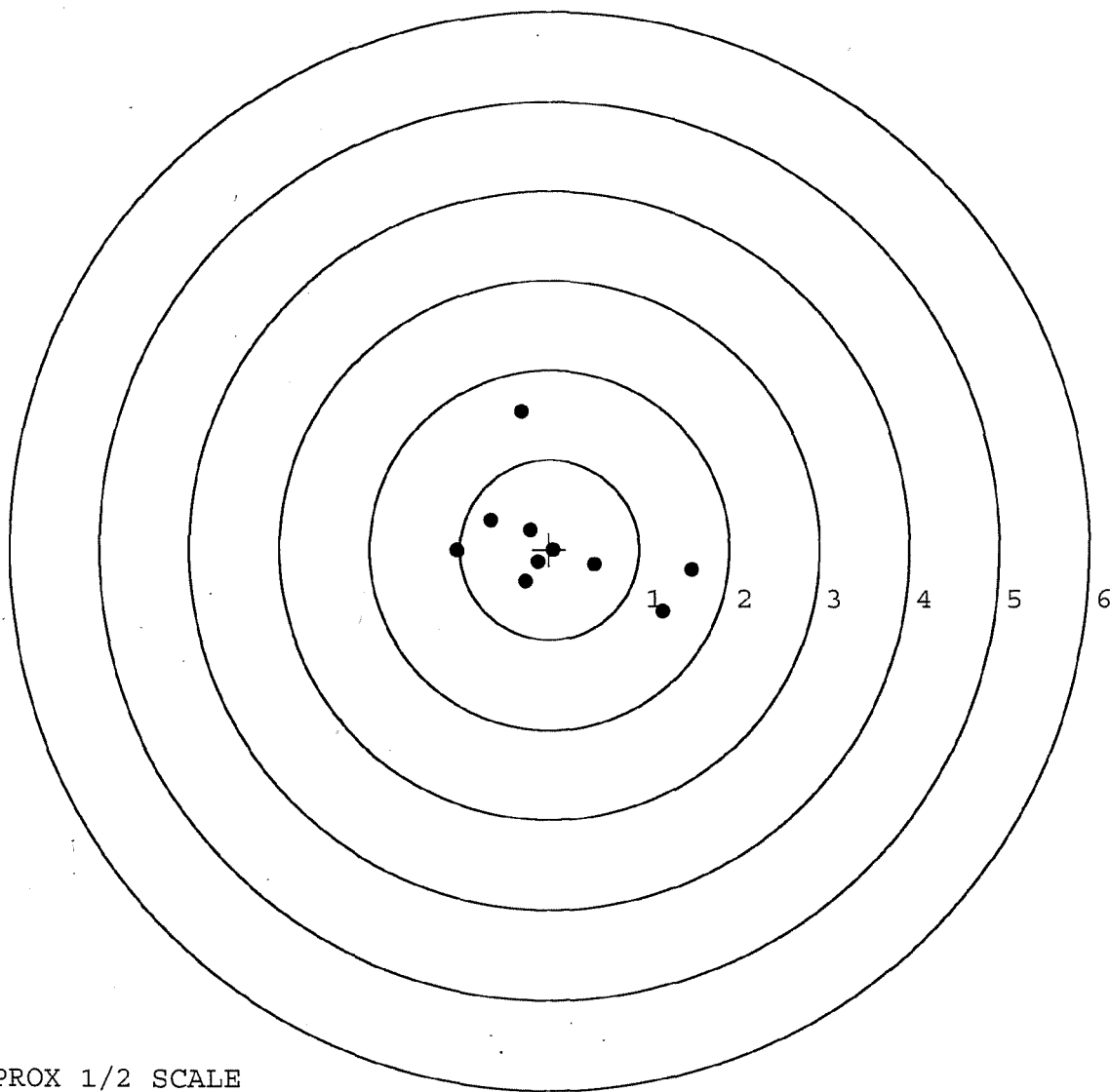
The Average X Centroid of the Five Target Set:	0.044
The Average Y Centroid of the Five Target Set:	-0.038
The Average Point of Impact of the Five Target Set:	0.058
The Average Mean Radius of the Five Target Set:	1.149
The Distance from POA to Centroid Target #1:	0.089
The Distance from Centroid Target #2 to Centroid Target #1:	0.464
The Distance from Centroid Target #3 to Centroid Target #1:	0.578
The Distance from Centroid Target #4 to Centroid Target #1:	0.250
The Distance from Centroid Target #5 to Centroid Target #1:	0.483

BARBER - M24 0151403

SERIAL NUMBER: G6414383: 0
 TARGET NUMBER: 1
 FILE DATE: 02/04/2005
 FILE TIME: 07:48

POINT#	X	Y
1:	1.259	-0.699
2:	1.581	-0.228
3:	0.500	-0.167
4:	-0.314	1.537
5:	-1.027	-0.018
6:	-0.655	0.330
7:	-0.216	0.217
8:	0.042	-0.010
9:	-0.127	-0.145
10:	-0.272	-0.363

X CENTROID: 0.077
 Y CENTROID: 0.045
 POA TO CENTROID: 0.089
 HORZ SPREAD: 2.608
 VERT SPREAD: 2.236
 GROUP SPREAD: 2.734
 MIN RADIUS: 0.066
 MAX RADIUS: 1.542
 MEAN RADIUS: 0.805
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

BARBER - M24 0151404

SERIAL NUMBER: G6414383: 0

TARGET NUMBER: 2

FILE DATE: 02/04/2005

FILE TIME: 07:48

POINT#	X	Y
1:	-0.036	-2.663
2:	0.110	-2.490
3:	0.247	-1.138
4:	0.331	-0.678
5:	0.782	0.920
6:	-0.760	1.182
7:	0.226	0.325
8:	0.010	0.215
9:	-0.240	0.128
10:	-0.468	0.045

X CENTROID: 0.020

Y CENTROID: -0.415

POA TO CENTROID: 0.416

HORZ SPREAD: 1.542

VERT SPREAD: 3.845

GROUP SPREAD: 3.913

MIN RADIUS: 0.407

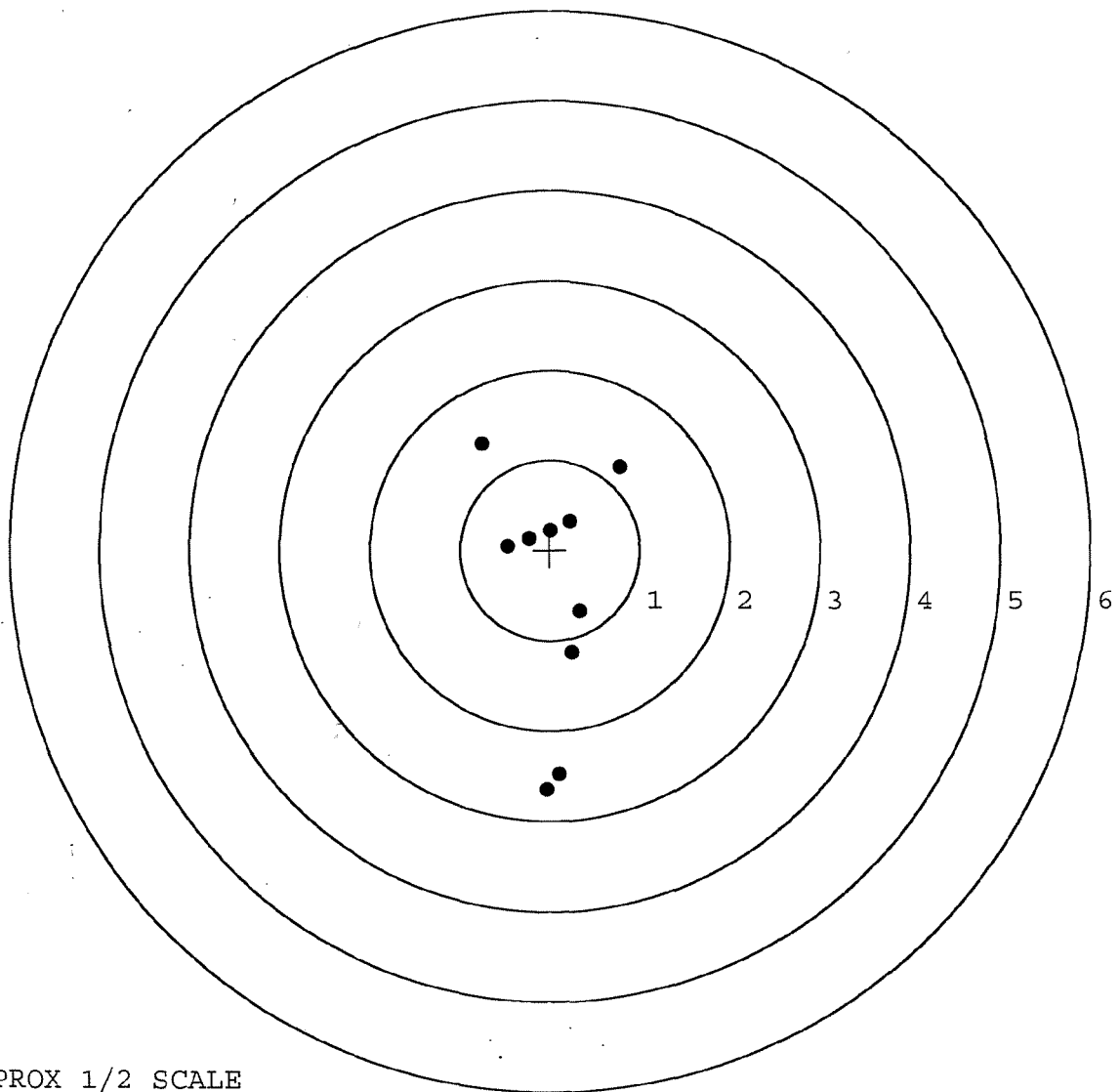
MAX RADIUS: 2.248

MEAN RADIUS: 1.148

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

BARBER - M24 0151405

SERIAL NUMBER: G6414383: 0

TARGET NUMBER: 3

FILE DATE: 02/04/2005

FILE TIME: 07:48

POINT#	X	Y
1:	2.053	-0.367
2:	1.262	-0.698
3:	0.981	-0.373
4:	0.490	-2.069
5:	0.218	-2.570
6:	-0.528	-2.364
7:	-0.471	-0.285
8:	-0.225	0.357
9:	-0.184	1.501
10:	-0.819	1.896

X CENTROID: 0.278

Y CENTROID: -0.497

POA TO CENTROID: 0.569

HORZ SPREAD: 2.872

VERT SPREAD: 4.466

GROUP SPREAD: 4.585

MIN RADIUS: 0.714

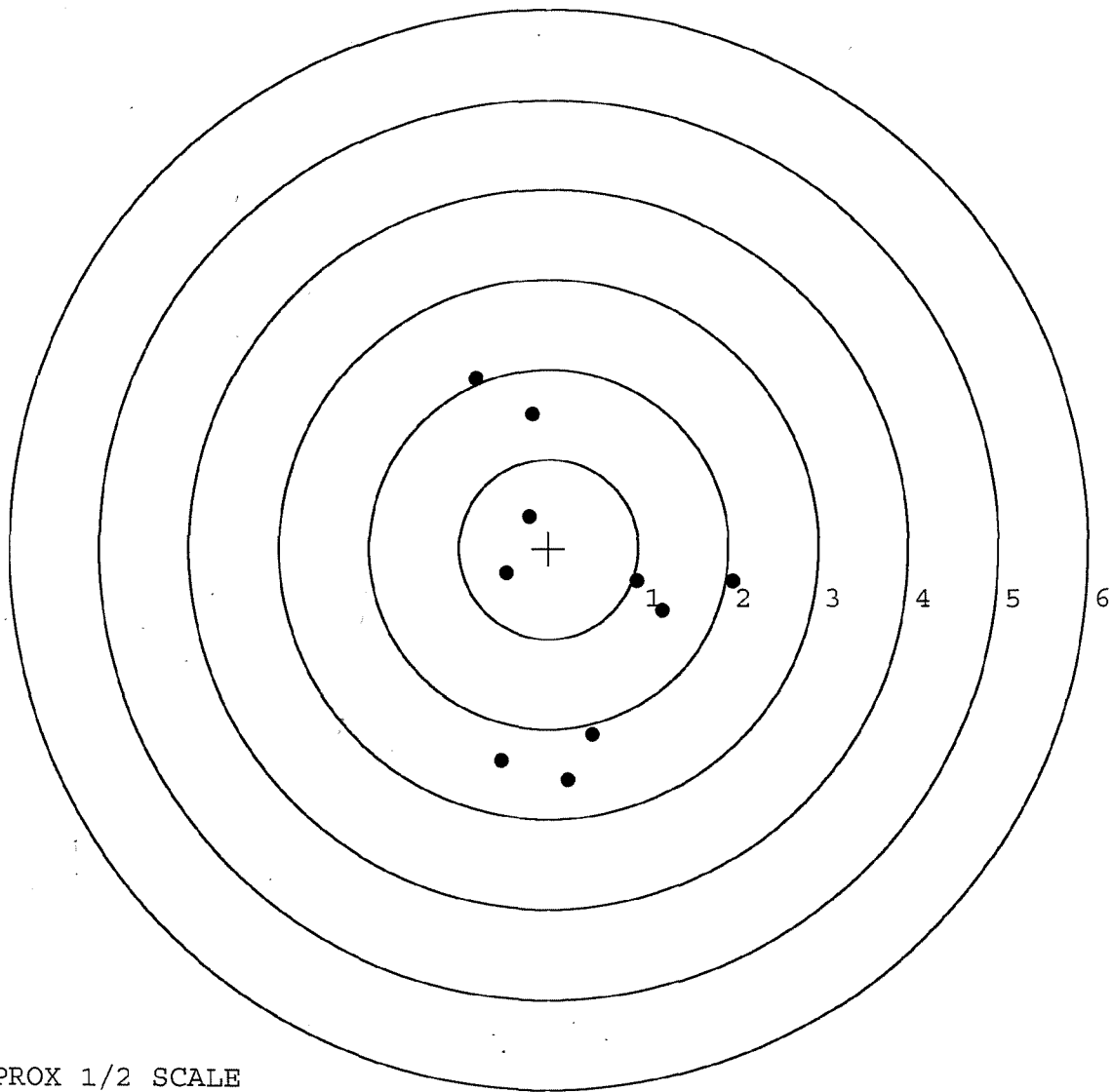
MAX RADIUS: 2.633

MEAN RADIUS: 1.564

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 4



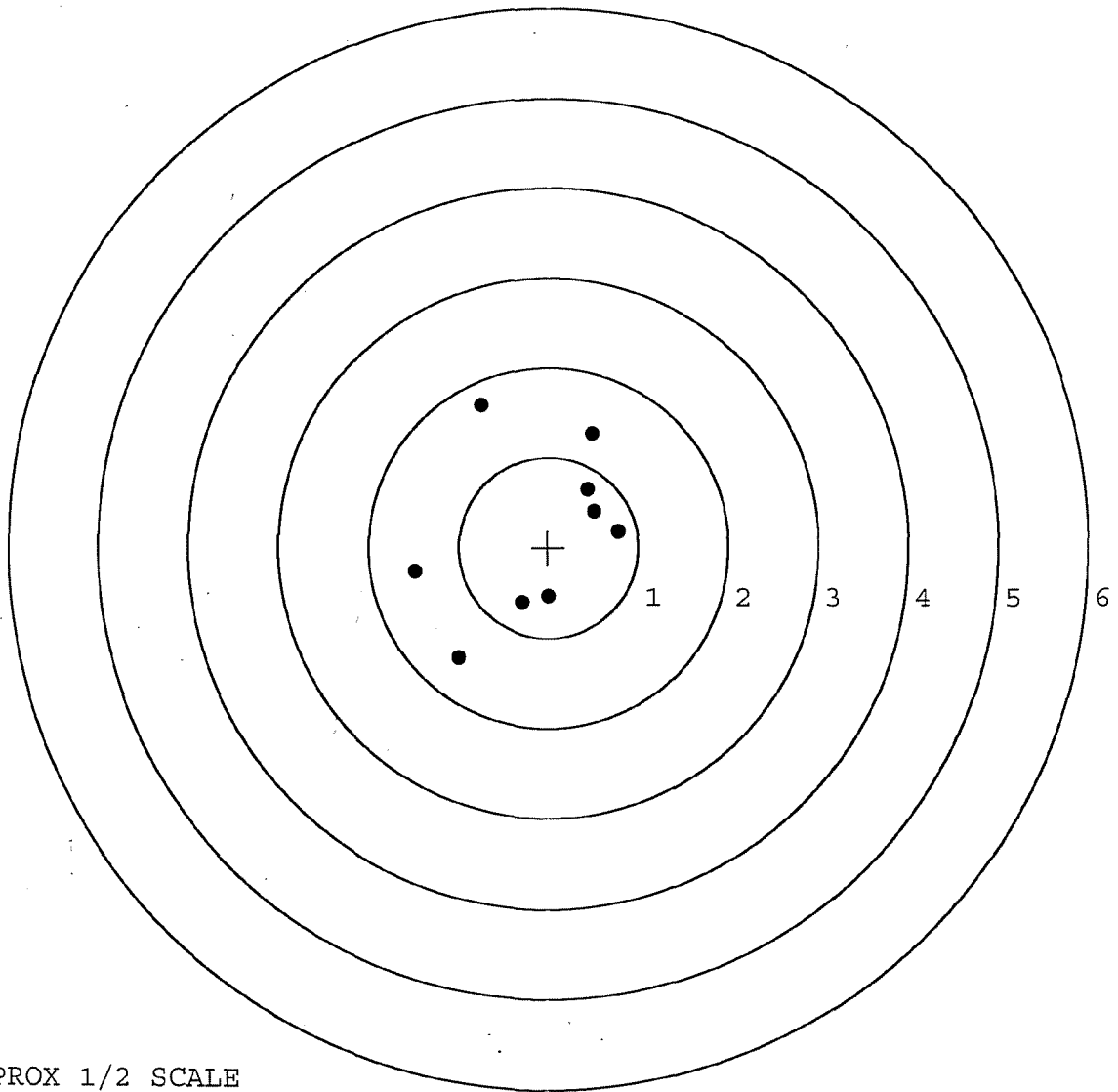
TARGET APPROX 1/2 SCALE

BARBER - M24 0151406

SERIAL NUMBER: G6414383' 0
 TARGET NUMBER: 4
 FILE DATE: 02/04/2005
 FILE TIME: 07:48

POINT#	X	Y
1:	0.777	0.178
2:	0.513	0.398
3:	0.439	0.643
4:	0.000	-0.544
5:	-0.299	-0.609
6:	-1.002	-1.225
7:	-1.483	-0.272
8:	0.493	1.265
9:	-0.753	1.579

X CENTROID: -0.146
 Y CENTROID: 0.157
 POA TO CENTROID: 0.214
 HORZ SPREAD: 2.260
 VERT SPREAD: 2.804
 GROUP SPREAD: 2.904
 MIN RADIUS: 0.702
 MAX RADIUS: 1.626
 MEAN RADIUS: 1.082
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 5
 # in 3 IN DIAMETER: 7



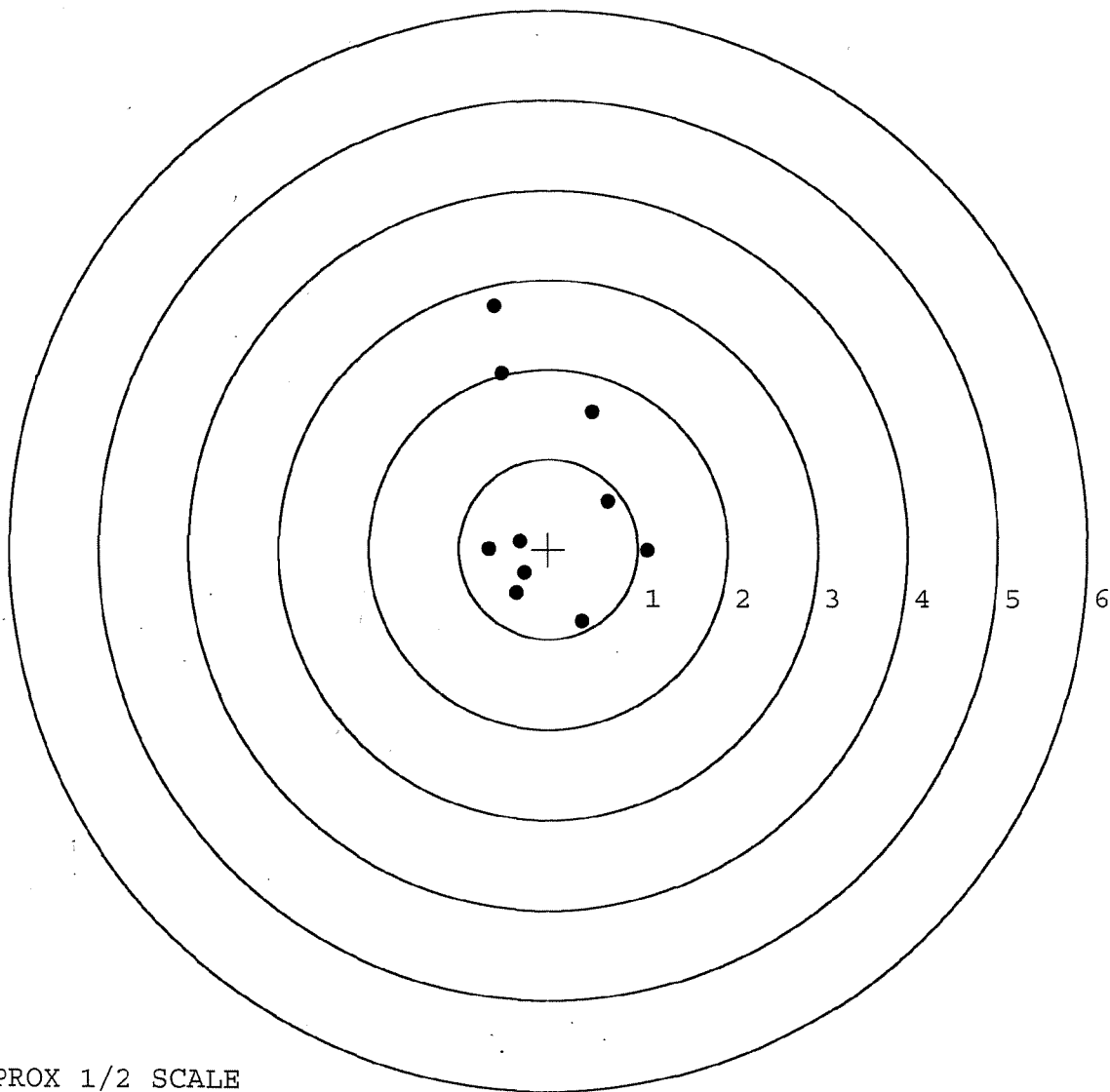
TARGET APPROX 1/2 SCALE

BARBER - M24 0151407

SERIAL NUMBER: G6414383: 0
 TARGET NUMBER: 5
 FILE DATE: 02/04/2005
 FILE TIME: 07:48

POINT#	X	Y
1:	0.375	-0.812
2:	1.105	-0.023
3:	0.666	0.530
4:	-0.267	-0.262
5:	-0.357	-0.495
6:	-0.317	0.091
7:	-0.662	-0.001
8:	0.493	1.523
9:	-0.530	1.949
10:	-0.611	2.705

X CENTROID: -0.011
 Y CENTROID: 0.521
 POA TO CENTROID: 0.521
 HORZ SPREAD: 1.767
 VERT SPREAD: 3.517
 GROUP SPREAD: 3.653
 MIN RADIUS: 0.528
 MAX RADIUS: 2.266
 MEAN RADIUS: 1.147
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE