

56414385

**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**

G6414385



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.



66414385

3/11/2006 9:26:01 AM

Crib

22

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,



0003770797

78ROT01

0540

Flat Black Powder Coat, Barrel and



0003770799

01PC001

0560

Reassemble Action.



0003770800

89SWS1

0690

Pack Rifle & Stencil SWS Container



.OP0690

89SWS1

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G641 4385

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		10-19-04	RTT
600	PROOF		10-20-04	AC
607	CHECK HEADSPACE		10-20-04	AC
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)		11/30	HP
	(BOLT)			
625	FINAL ASSEMBLY		11-9-04	DA
	A) CLEAN INSIDE OF BOLT ASSEMBLY			
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-9-04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-9-04	DA
	D) OIL FIRING PIN ASSEMBLY		11-9-04	RTT
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3-21-05	TRW

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>	3-22-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>4 lbs</u> <u>4 lbs</u> <u>4 lbs</u>	3-22-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.026</u> <u>.026</u>	3-22-05	AC
	J) ASSEMBLE STOCK		11-9-04	RTL
	K) ASSEMBLE SWIVEL STUDS		3-22-05	AC
	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	11-10-04	AC
	MALFUNCTION <i>CH</i>	CORRECTION <i>OK</i>	11-12-04	TRW
	MALFUNCTION <i>MCW</i>	CORRECTION <i>OK</i>	12-3-04 11-12-04	TRW
	MALFUNCTION <i>RIC</i>	CORRECTION <i>OK</i>	12-3-04	TRW
	MALFUNCTION <i>SB</i>	CORRECTION <i>OK</i>	12-3-04	TRW
645	INSPECT FOR LIVE AMMO		11-10-04	AC
655	FINAL INSPECTION A) HEADSPACE		3-22-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.30</u> <u>2.38</u> <u>2.53</u> <u>2.80</u> <u>2.33</u>	3-21-05	TRW
	C) FUNCTION		3-22-05	AC
660	PACK		3/24/05	OA

INITIAL BARBER - M24 0151414
 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 7-1-04
 TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.21	2.81		2.74	
PULL #2	2.22	2.64		2.77	
PULL #3	2.46	2.65		2.64	
PULL #4	2.63	2.76		2.73	
PULL #5	2.72	2.69		2.77	
TOTAL	12.24	13.55		13.65	
AVERAGE	2.44	2.71		2.73	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.11		
PULL #2	3.09	3.23		
PULL #3	3.26	3.26		
PULL #4	3.12	3.14		
PULL #5	3.11	3.10		
TOTAL	15.76	15.84		
AVERAGE	3.15	3.16		

	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	4.07	4.12		4.33
PULL #2	4.14	3.85		3.94
PULL #3	4.13	4.24		4.36
PULL #4	4.13	4.24		4.34
PULL #5	4.12	4.29		4.43
TOTAL	20.59	20.74		21.40
AVERAGE	4.11	4.14		4.28

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414385.__1
FILE DATE AND TIME: 11/12/2004 09:00

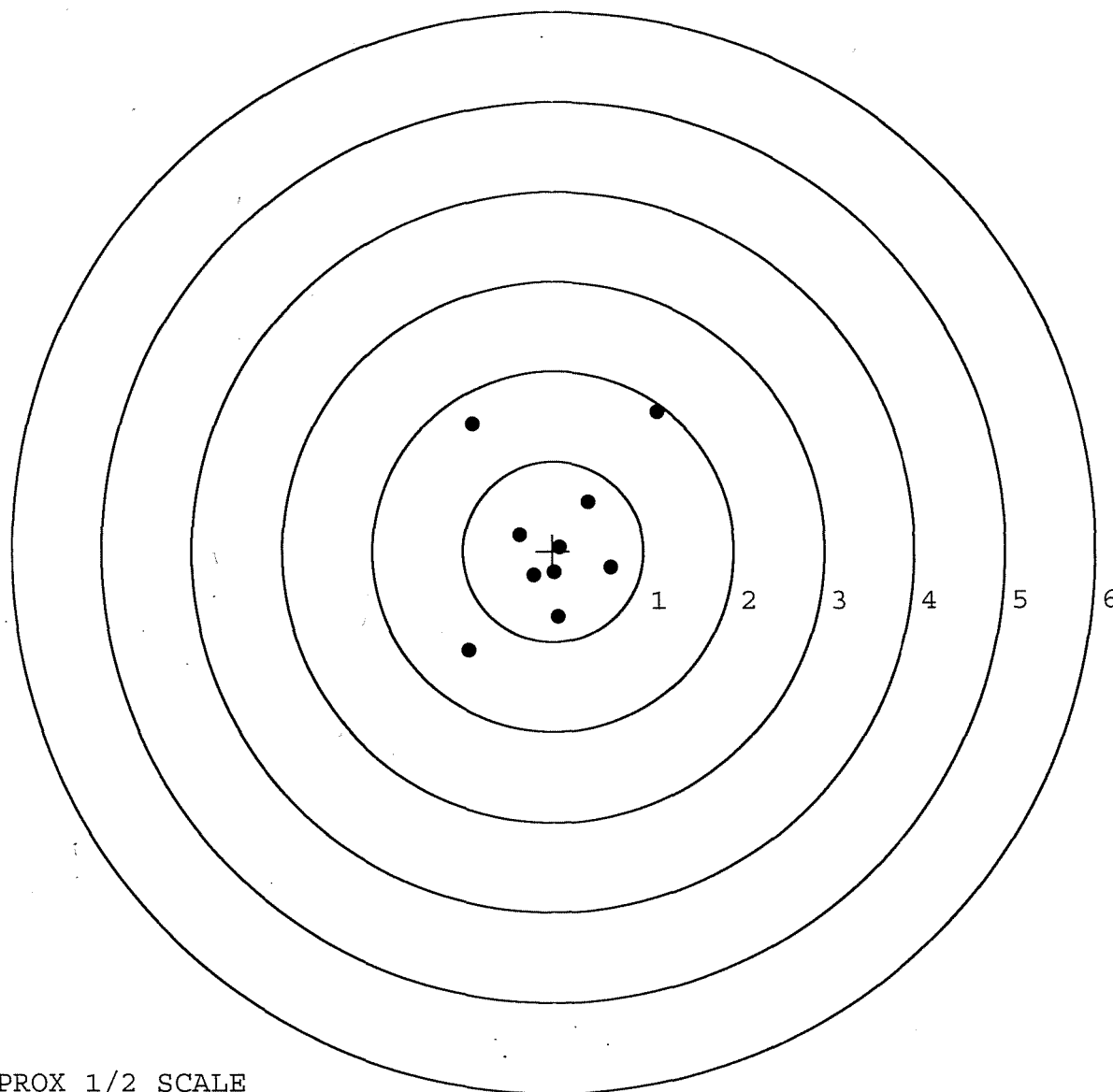
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.046
The Average Y Centroid of the Five Target Set:	0.013
The Average Point of Impact of the Five Target Set:	0.048
The Average Mean Radius of the Five Target Set:	0.802
The Distance from POA to Centroid Target #1:	0.121
The Distance from Centroid Target #2 to Centroid Target #1:	0.307
The Distance from Centroid Target #3 to Centroid Target #1:	0.215
The Distance from Centroid Target #4 to Centroid Target #1:	0.178
The Distance from Centroid Target #5 to Centroid Target #1:	0.063

SERIAL NUMBER: G6414385. 1
 TARGET NUMBER: 1
 FILE DATE: 11/12/2004
 FILE TIME: 09:00

X CENTROID: -0.010
 Y CENTROID: 0.121
 POA TO CENTROID: 0.121
 HORZ SPREAD: 2.089
 VERT SPREAD: 2.633
 GROUP SPREAD: 3.361
 MIN RADIUS: 0.114
 MAX RADIUS: 1.829
 MEAN RADIUS: 0.838
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.056	-0.730
2:	0.643	-0.184
3:	-0.938	-1.098
4:	-0.218	-0.271
5:	0.014	-0.237
6:	0.074	0.043
7:	0.390	0.548
8:	-0.371	0.182
9:	-0.897	1.420
10:	1.151	1.535

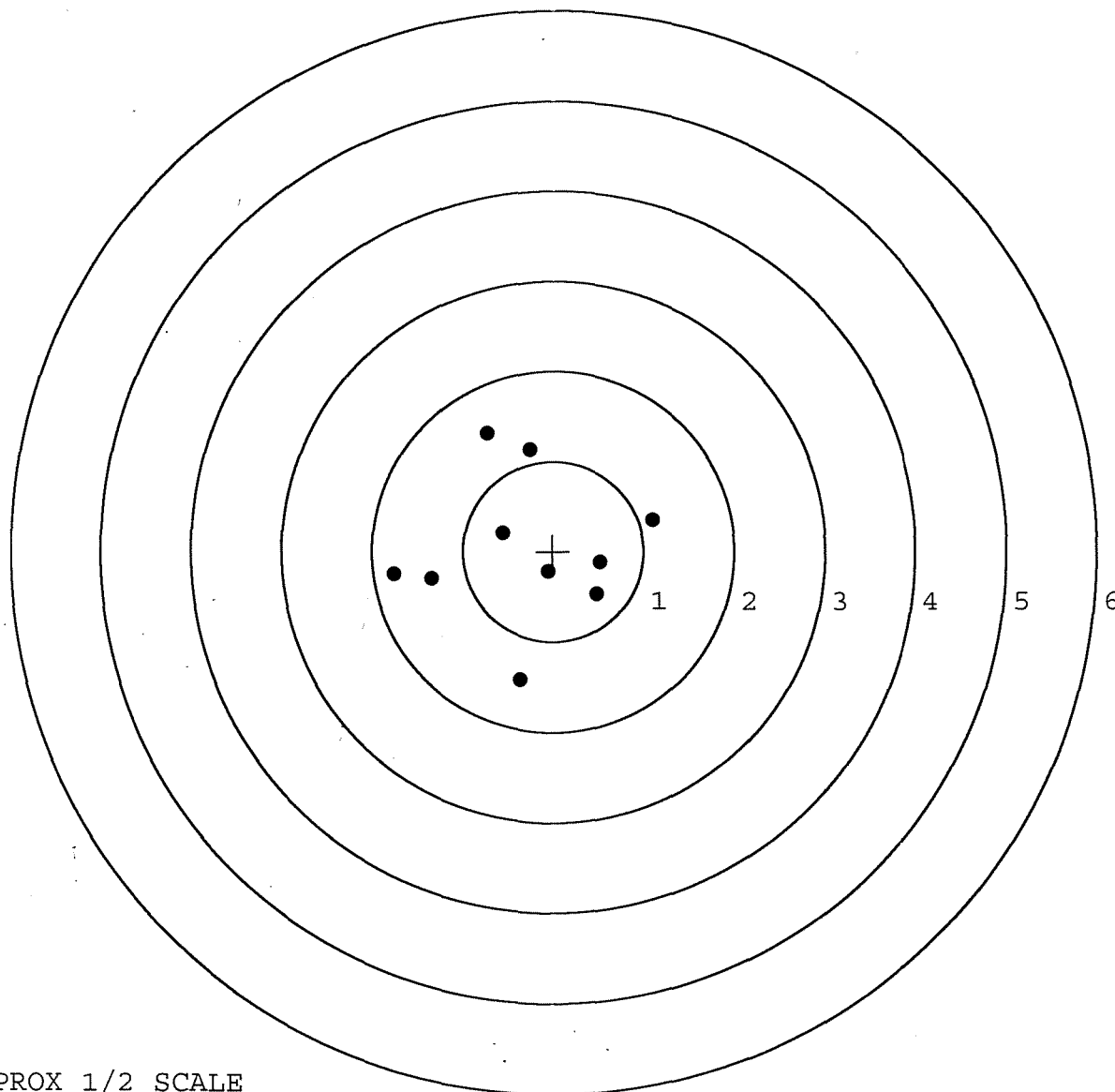


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414385: 1
 TARGET NUMBER: 2
 FILE DATE: 11/12/2004
 FILE TIME: 09:00

X CENTROID: -0.299
 Y CENTROID: 0.018
 POA TO CENTROID: 0.299
 HORZ SPREAD: 2.854
 VERT SPREAD: 2.734
 GROUP SPREAD: 2.918
 MIN RADIUS: 0.319
 MAX RADIUS: 1.485
 MEAN RADIUS: 1.036
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.373	-1.423
2:	0.481	-0.478
3:	0.524	-0.121
4:	1.096	0.353
5:	-0.057	-0.231
6:	-0.559	0.202
7:	-1.340	-0.309
8:	-1.758	-0.256
9:	-0.263	1.130
10:	-0.738	1.311

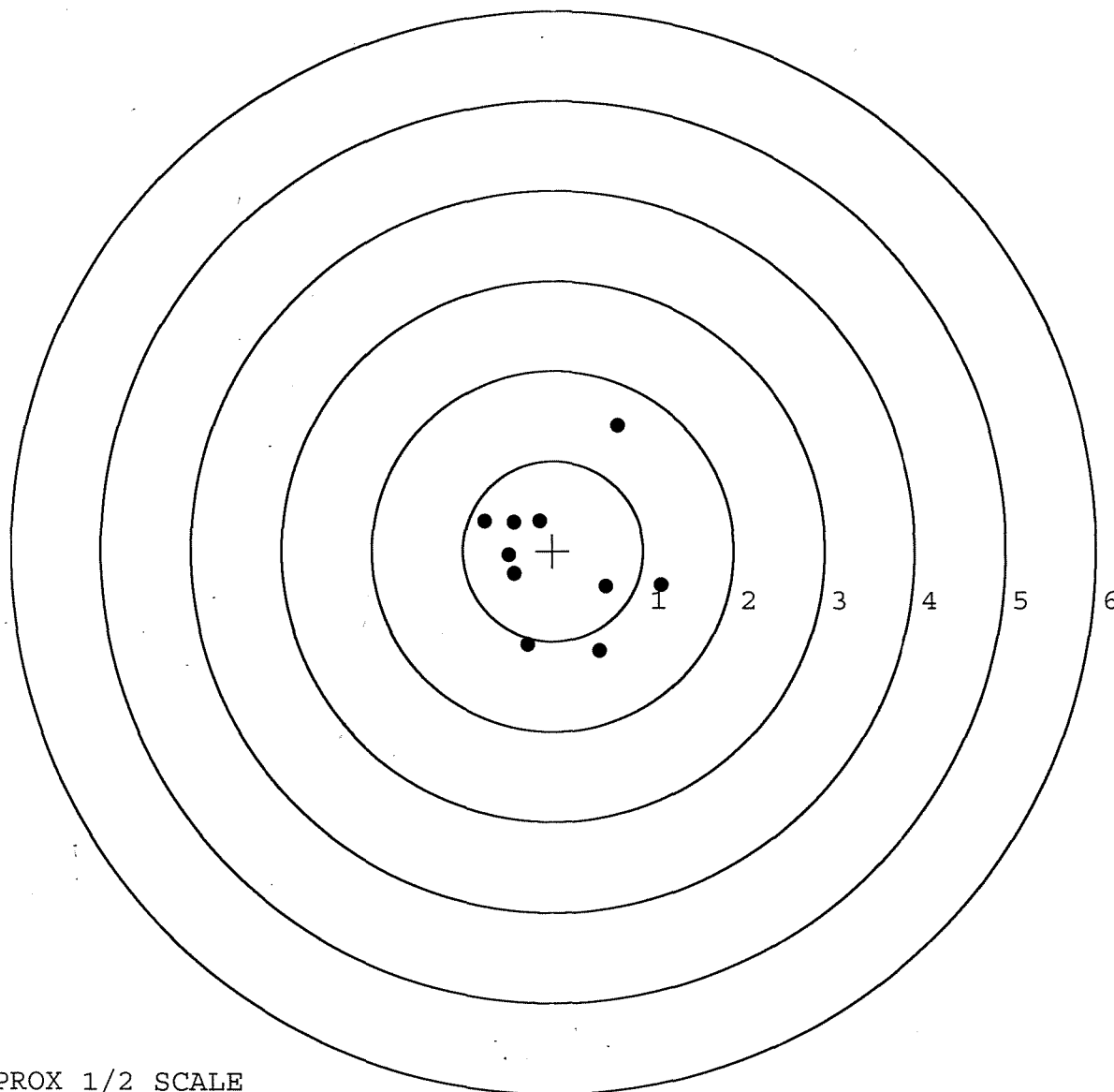


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414385: 1
 TARGET NUMBER: 3
 FILE DATE: 11/12/2004
 FILE TIME: 09:00

X CENTROID: 0.048
 Y CENTROID: -0.086
 POA TO CENTROID: 0.099
 HORZ SPREAD: 1.960
 VERT SPREAD: 2.494
 GROUP SPREAD: 2.624
 MIN RADIUS: 0.465
 MAX RADIUS: 1.618
 MEAN RADIUS: 0.862
 # IN 1 IN DIAMETER: 1
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.194	-0.382
2:	0.592	-0.394
3:	0.525	-1.107
4:	-0.276	-1.042
5:	-0.432	-0.255
6:	-0.488	-0.050
7:	-0.153	0.333
8:	-0.766	0.330
9:	-0.435	0.317
10:	0.717	1.387

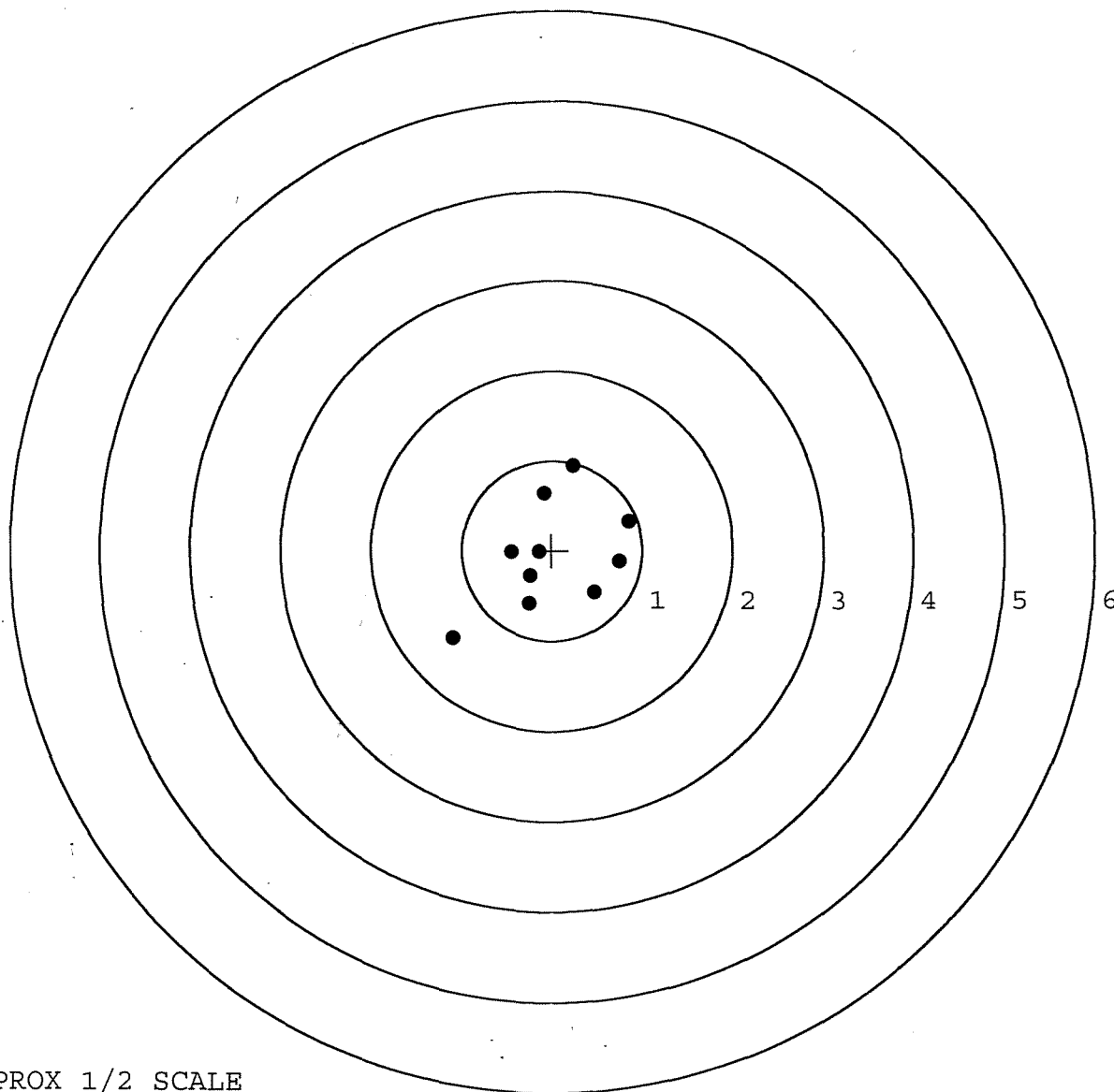


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414385: __1
 TARGET NUMBER: 4
 FILE DATE: 11/12/2004
 FILE TIME: 09:00

X CENTROID: 0.004
 Y CENTROID: -0.057
 POA TO CENTROID: 0.057
 HORZ SPREAD: 1.943
 VERT SPREAD: 1.914
 GROUP SPREAD: 2.336
 MIN RADIUS: 0.149
 MAX RADIUS: 1.431
 MEAN RADIUS: 0.698
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.848	0.324
2:	0.752	-0.125
3:	0.473	-0.463
4:	-0.255	-0.589
5:	-1.095	-0.973
6:	0.240	0.941
7:	-0.088	0.637
8:	-0.140	-0.018
9:	-0.452	-0.020
10:	-0.240	-0.281



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414385: 1

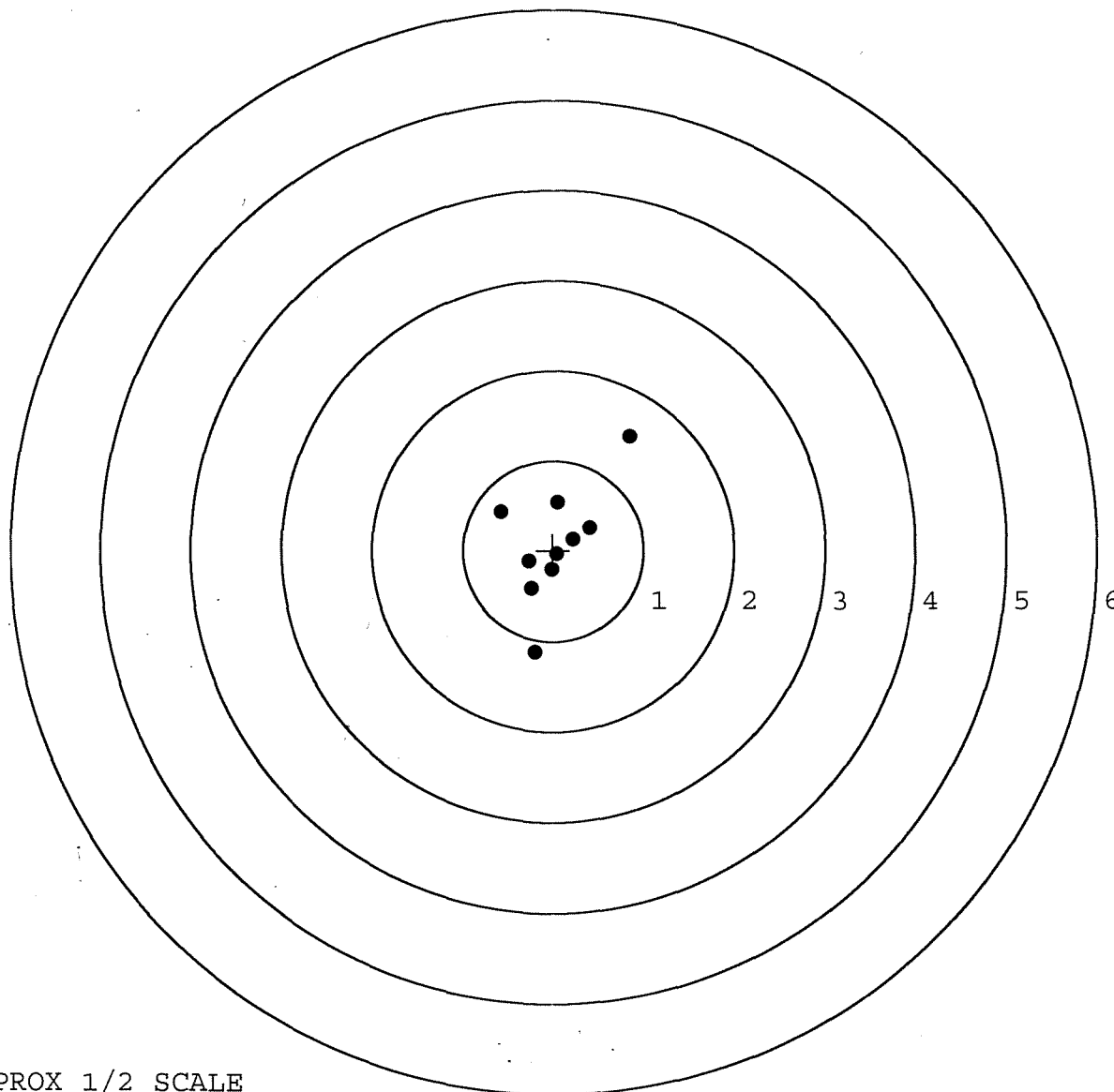
TARGET NUMBER: 5

FILE DATE: 11/12/2004

FILE TIME: 09:00

X CENTROID: 0.025
 Y CENTROID: 0.068
 POA TO CENTROID: 0.072
 HORZ SPREAD: 1.427
 VERT SPREAD: 2.397
 GROUP SPREAD: 2.617
 MIN RADIUS: 0.112
 MAX RADIUS: 1.458
 MEAN RADIUS: 0.578
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.206	-1.124
2:	0.845	1.273
3:	0.052	0.535
4:	-0.582	0.433
5:	0.401	0.247
6:	0.223	0.122
7:	0.046	-0.042
8:	-0.019	-0.217
9:	-0.242	-0.426
10:	-0.267	-0.123



TARGET APPROX 1/2 SCALE