

G6414407

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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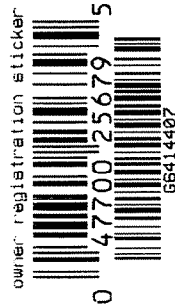
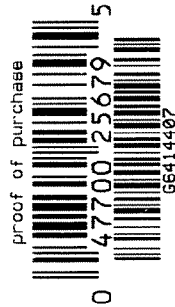
SERIAL NO.



**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

46 FORM 96253

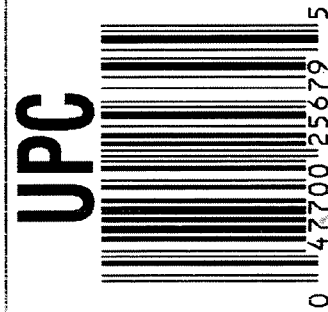


ORDER NO. **25679**

BARREL LENGTH **24"**

CAPACITY **6**

G6414407



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414407

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-29-04	RTZ
600	PROOF		12-29-04	A
607	CHECK HEADSPACE		12-29-04	A
610	DIS-ASSEMBLE GUN		12-30-04	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		1-3-05	CW
617	DRILL AND TAP SIGHT HOLES		12-30-04	TRL
620	APPLY COATINGS (BARREL ACTION)		1/8/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-12-05	RTA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-12-05	RTA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-13-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-13-05	RTZ
	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>5.5</u>	<u>6.2</u>	<u>5.5</u>	1-17-05	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u>	<u>2.5</u>	<u>2.2</u>	1-17-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT .020 MIN	<u>1.023</u>	<u>1.021</u>	<u>1.022</u>	1-17-05	DA
	J) ASSEMBLE STOCK				1-13-05	RTW
	K) ASSEMBLE SWIVEL STUDS				1-17-05	RTW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					
	M) IRON SIGHT ALIGNMENT			N.A		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					
640	GALLERY TEST AND TARGET			<u>PASS</u> FAIL	1-13-05	TRW
	MALFUNCTION			CORRECTION		
	MALFUNCTION			CORRECTION		
	MALFUNCTION			CORRECTION		
	MALFUNCTION			CORRECTION		
645	INSPECT FOR LIVE AMMO				1-13-05	TRW
655	FINAL INSPECTION A) HEADSPACE				1-17-05	RTW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.88</u>	<u>2.71</u>	<u>2.63</u> <u>2.49</u> <u>2.73</u>	1-17-05	DA
	C) FUNCTION				1-17-05	RTW
660	PACK				1-19-05	D.A.

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414407.__1
FILE DATE AND TIME: 09/21/2005 11:16

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.114
The Average Y Centroid of the Five Target Set:	0.073
The Average Point of Impact of the Five Target Set:	0.135
The Average Mean Radius of the Five Target Set:	0.750
The Distance from POA to Centroid Target #1:	0.229
The Distance from Centroid Target #2 to Centroid Target #1:	0.308
The Distance from Centroid Target #3 to Centroid Target #1:	0.167
The Distance from Centroid Target #4 to Centroid Target #1:	0.142
The Distance from Centroid Target #5 to Centroid Target #1:	0.190

SERIAL NUMBER: G6414407. 1

TARGET NUMBER: 1

FILE DATE: 09/21/2005

FILE TIME: 11:16

X CENTROID: -0.110

Y CENTROID: 0.201

POA TO CENTROID: 0.229

HORZ SPREAD: 2.274

VERT SPREAD: 2.331

GROUP SPREAD: 2.490

MIN RADIUS: 0.222

MAX RADIUS: 1.541

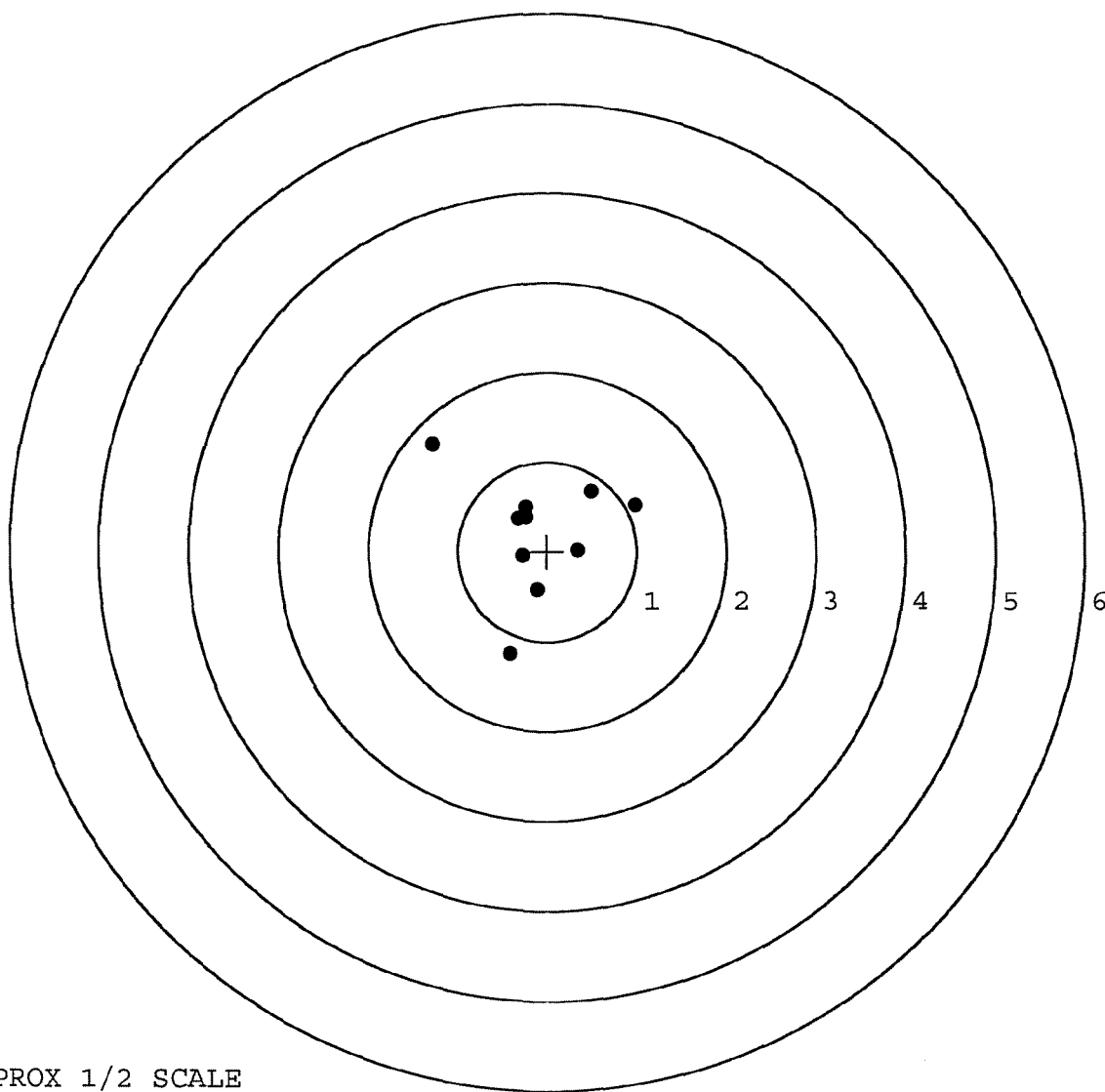
MEAN RADIUS: 0.705

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.982	0.520
2:	0.490	0.669
3:	0.341	0.020
4:	-0.114	-0.430
5:	-0.280	-0.053
6:	-0.417	-1.141
7:	-0.330	0.362
8:	-0.241	0.493
9:	-0.241	0.380
10:	-1.292	1.190



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414407. __1

TARGET NUMBER: 2

FILE DATE: 09/21/2005

FILE TIME: 11:16

X CENTROID: -0.034

Y CENTROID: -0.098

POA TO CENTROID: 0.104

HORZ SPREAD: 1.546

VERT SPREAD: 1.777

GROUP SPREAD: 1.855

MIN RADIUS: 0.014

MAX RADIUS: 1.122

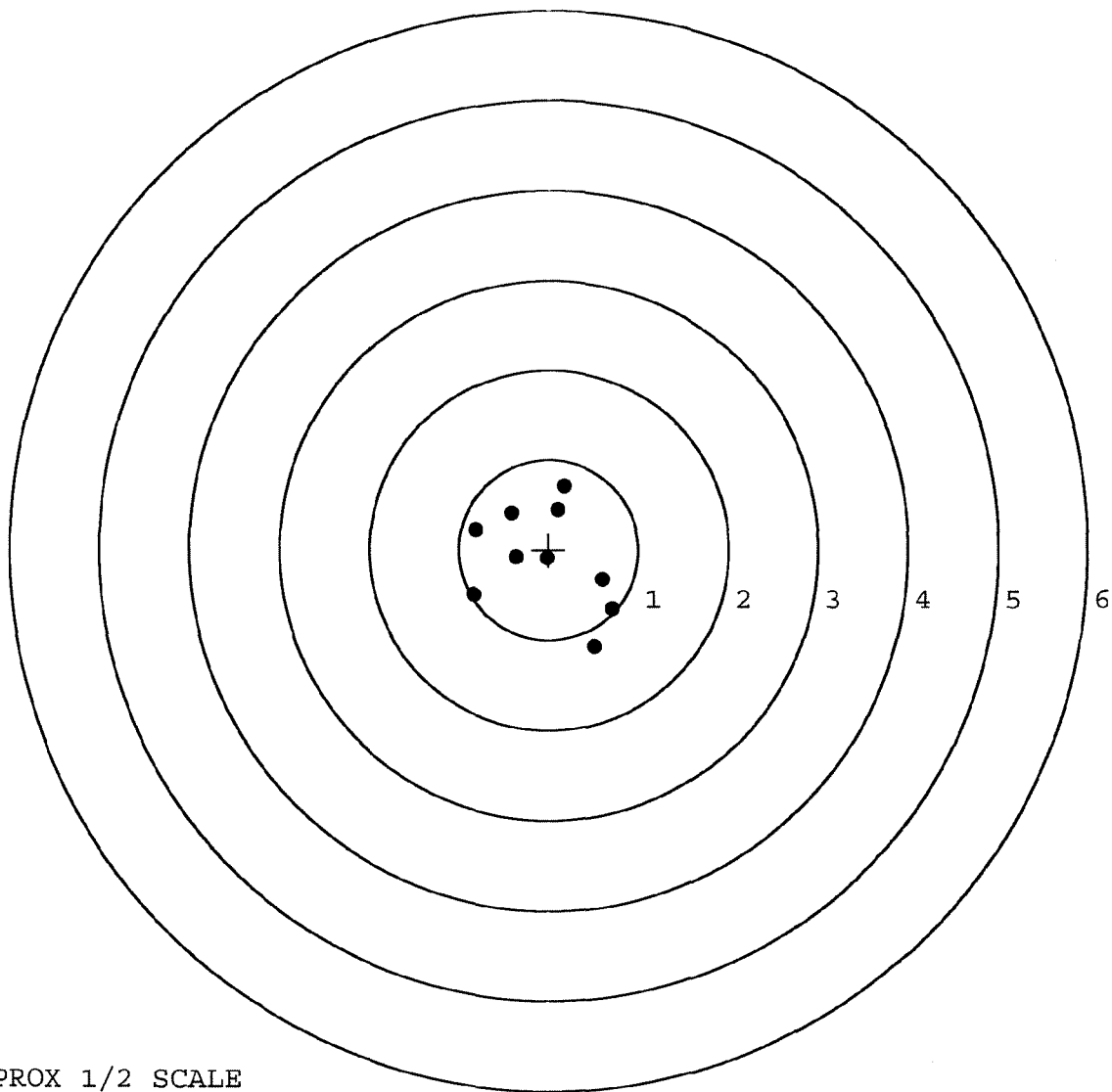
MEAN RADIUS: 0.684

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.515	-1.076
2:	0.709	-0.656
3:	0.605	-0.332
4:	0.178	0.701
5:	0.105	0.441
6:	-0.020	-0.099
7:	-0.363	-0.081
8:	-0.837	-0.506
9:	-0.813	0.219
10:	-0.419	0.410



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414407. __1

TARGET NUMBER: 3

FILE DATE: 09/21/2005

FILE TIME: 11:16

X CENTROID: -0.175

Y CENTROID: 0.048

POA TO CENTROID: 0.182

HORZ SPREAD: 2.051

VERT SPREAD: 3.139

GROUP SPREAD: 3.683

MIN RADIUS: 0.250

MAX RADIUS: 2.413

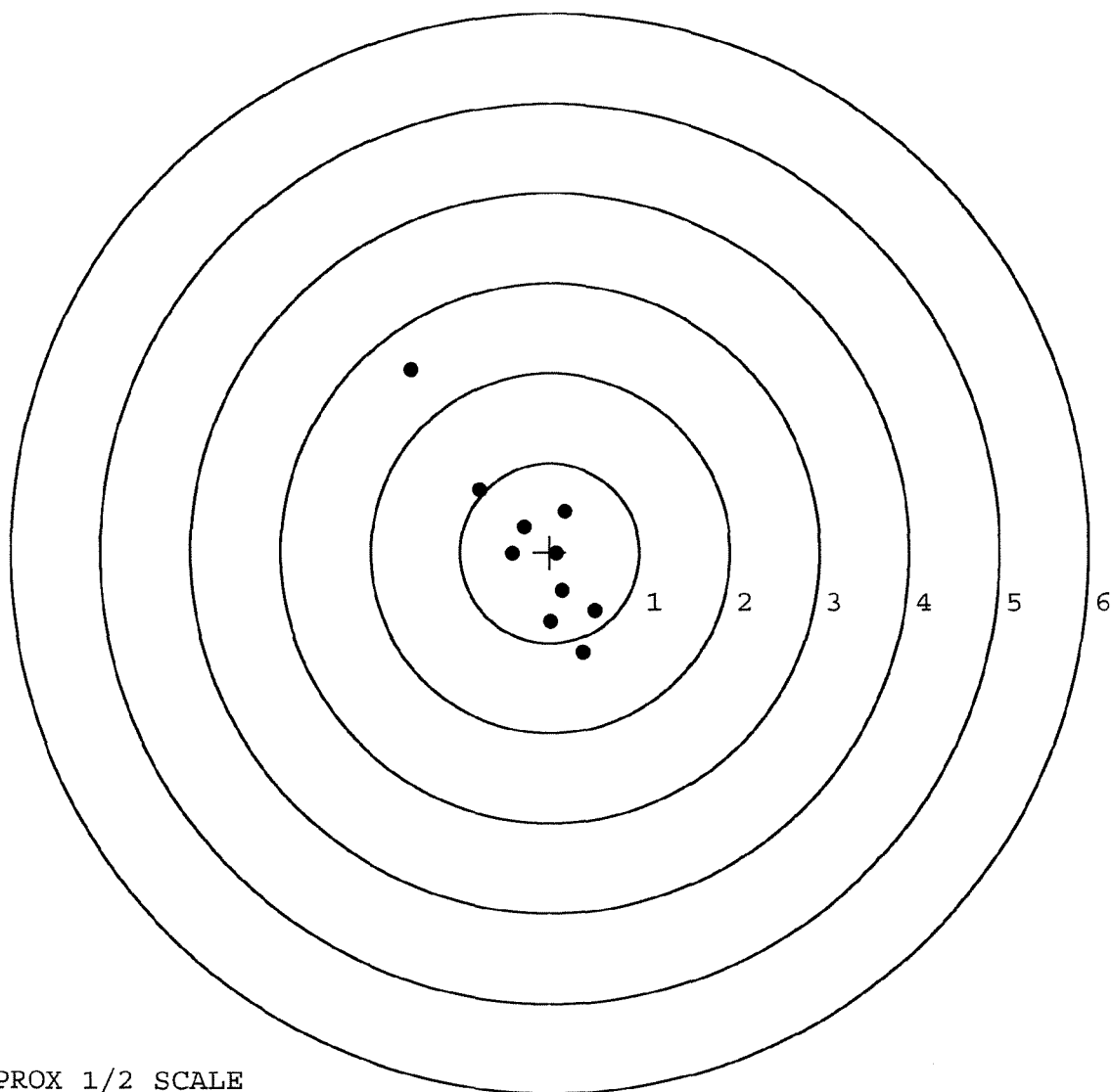
MEAN RADIUS: 0.827

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.378	-1.108
2:	0.502	-0.644
3:	0.008	-0.773
4:	0.146	-0.429
5:	0.079	-0.020
6:	0.170	0.455
7:	-0.291	0.281
8:	-0.417	-0.015
9:	-0.780	0.698
10:	-1.549	2.031



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414407. 1

TARGET NUMBER: 4

FILE DATE: 09/21/2005

FILE TIME: 11:16

X CENTROID: -0.249

Y CENTROID: 0.168

POA TO CENTROID: 0.300

HORZ SPREAD: 1.915

VERT SPREAD: 2.242

GROUP SPREAD: 2.740

MIN RADIUS: 0.272

MAX RADIUS: 1.539

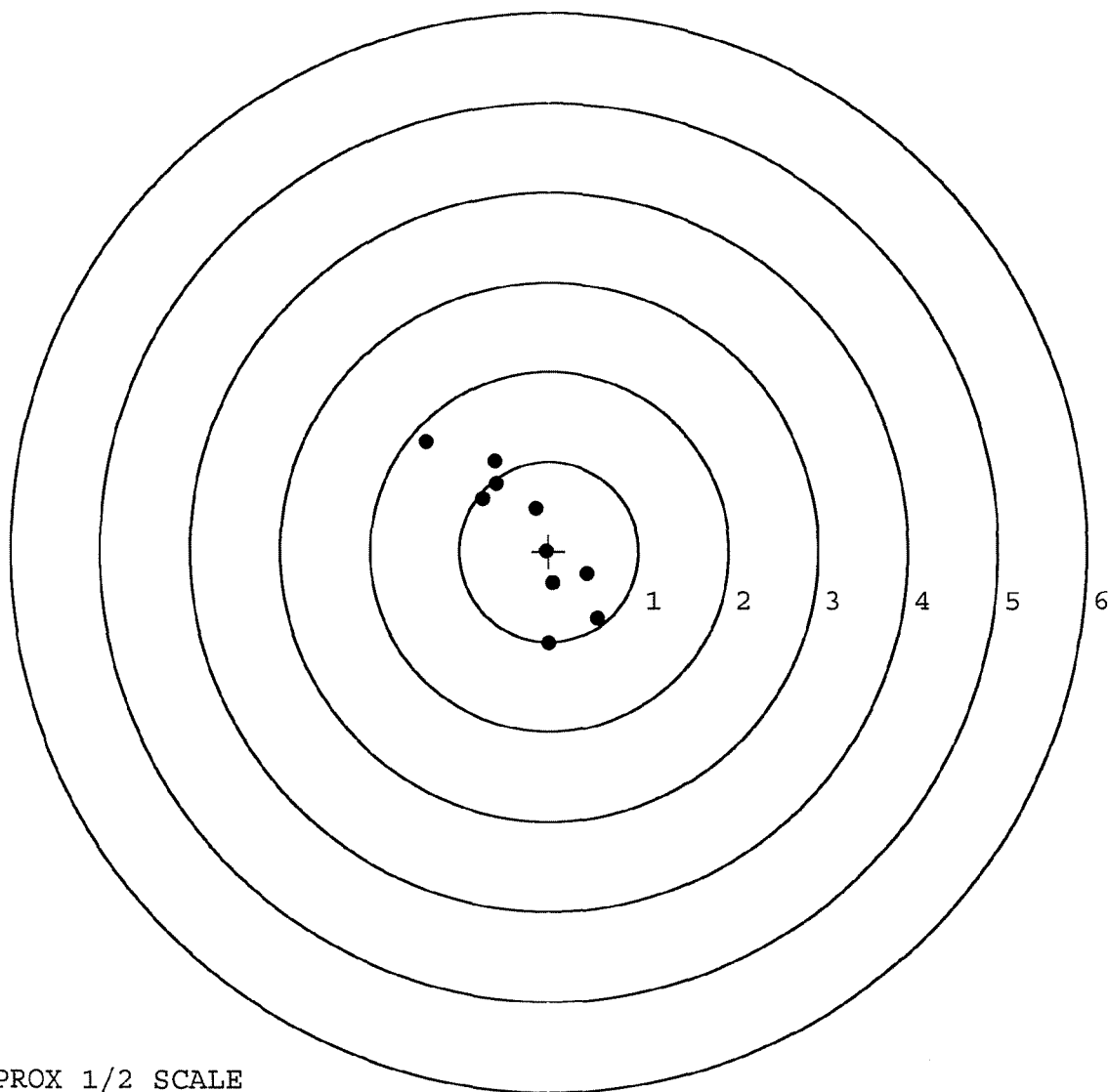
MEAN RADIUS: 0.819

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.542	-0.740
2:	-0.002	-1.023
3:	0.429	-0.249
4:	0.041	-0.355
5:	-0.033	0.003
6:	-0.152	0.480
7:	-0.745	0.587
8:	-0.590	0.755
9:	-0.603	1.005
10:	-1.373	1.219



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414407. __1

TARGET NUMBER: 5

FILE DATE: 09/21/2005

FILE TIME: 11:16

POINT#	X	Y
1:	0.930	0.355
2:	0.836	0.008
3:	-0.212	1.197
4:	0.289	0.059
5:	-0.044	-0.093
6:	-0.370	0.199
7:	-1.018	0.162
8:	-0.225	-0.448
9:	-0.684	-1.072
10:	0.461	0.074

X CENTROID: -0.004

Y CENTROID: 0.044

POA TO CENTROID: 0.044

HORZ SPREAD: 1.948

VERT SPREAD: 2.269

GROUP SPREAD: 2.318

MIN RADIUS: 0.143

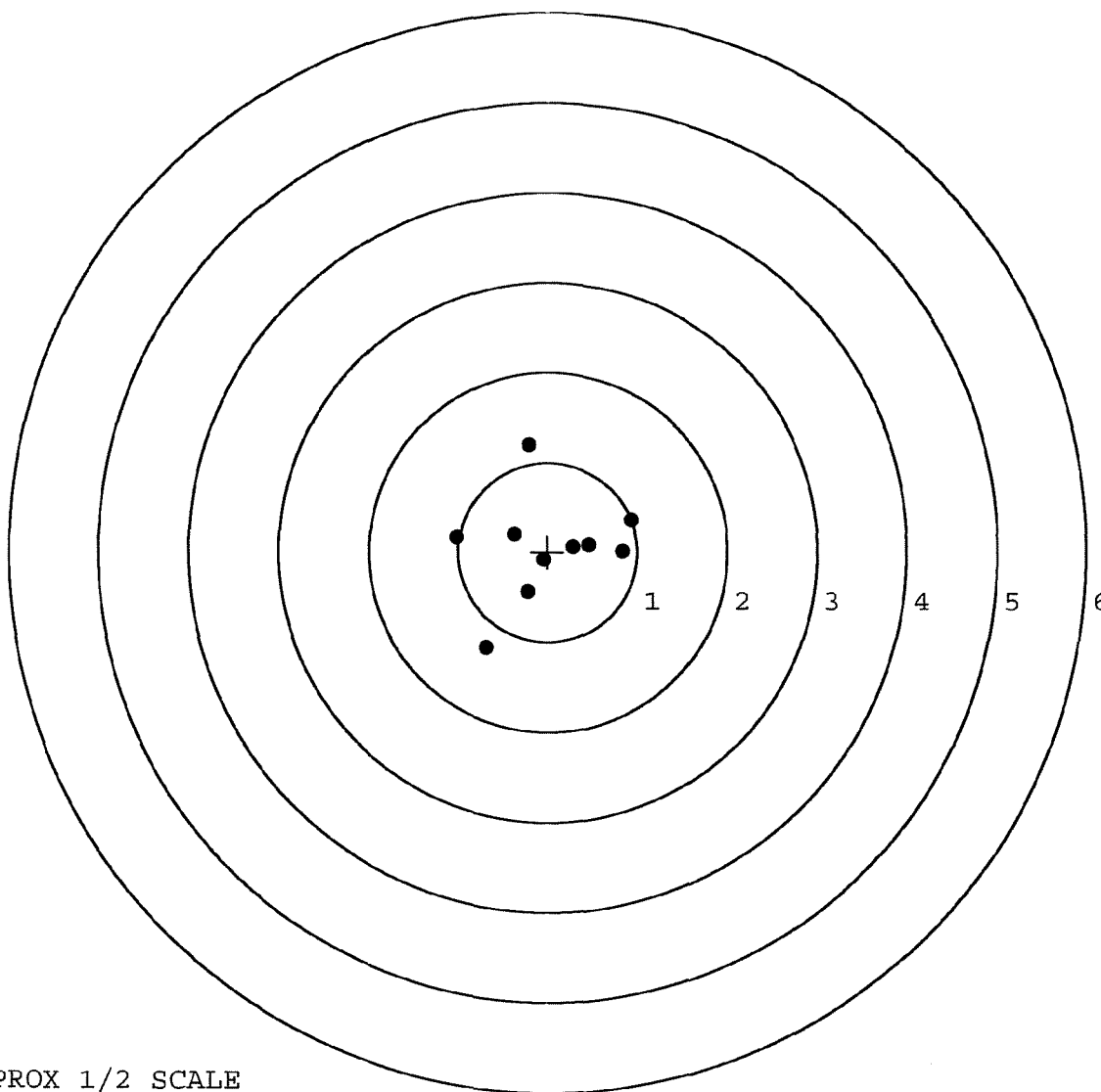
MAX RADIUS: 1.307

MEAN RADIUS: 0.716

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

AVERAGE PULL FORCE BETWEEN
 INITIAL **BARBER-M240151793**
 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 11-10-04

TESTER TRL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.35	2.50		2.01	
PULL #2	2.29	2.64		2.09	
PULL #3	2.34	2.53		2.03	
PULL #4	2.33	2.46		2.08	
PULL #5	2.52	2.34		2.07	
TOTAL	11.83	12.47		10.28	
AVERAGE	2.36	2.49		2.05	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.42	3.42		
PULL #2	3.37	3.30		
PULL #3	3.49	3.41		
PULL #4	3.49	3.25		
PULL #5	3.53	3.16		
TOTAL	17.30	16.54		
AVERAGE	3.46	3.30		

	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	4.14	4.12		4.28
PULL #2	4.13	3.96		4.53
PULL #3	4.09	3.95		4.24
PULL #4	4.01	4.02		4.19
PULL #5	3.95	3.93		4.05
TOTAL	20.32	19.98		21.29
AVERAGE	4.06	3.99		4.25