

66414410 Z

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



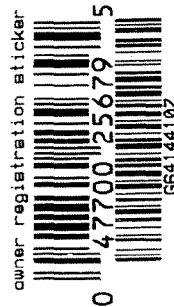
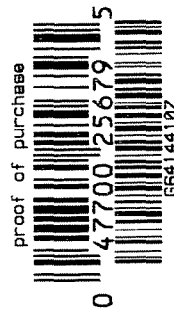
SERIAL NO.



**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 BIPOD ASSB

DD FORM 96253

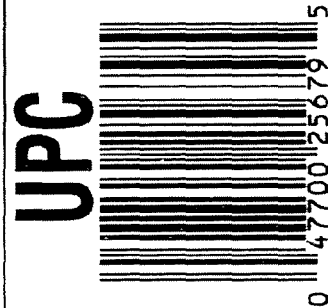


ORDER NO. **25679**

BARREL LENGTH **24"**

CAPACITY **6**

G6414410Z



3/11/2006 9:25:01 AM

Original
5
Chib

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 # G6414410 Z

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RTZ
600	PROOF		1-4-05	A
607	CHECK HEADSPACE	MAGNA - FLUX	1-4-05	K
610	DIS-ASSEMBLE GUN	INSPECTED	1-4-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 3 2005 OPERATOR BS		
615	ROLLMARK CALIBER		1-5-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1-4-05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-15-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-15-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-15-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-31-05	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	8 lbs	8 lbs	8.16s	2-16-05	Ac
CONT.							
	G) SAFETY OFF FORCE	2 LBS MIN	2 lbs	2 lbs	2 lbs	2-16-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY						
	I) FIRING PIN INDENT	.020 MIN	.022	.022	.022	2-16-05	Ac
	J) ASSEMBLE STOCK					1-31-05	RTZ
	K) ASSEMBLE SWIVEL STUDS					2-18-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					1-31-05	RTZ
	M) IRON SIGHT ALIGNMENT					1-31-05	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					1-31-05	RTZ
640	GALLERY TEST AND TARGET		PASS FAIL			2-3-05	Ac
	MALFUNCTION Bolt Rel. sticks		CORRECTION OK			2-16-05	Ac
	MALFUNCTION		CORRECTION				
	MALFUNCTION		CORRECTION				
	MALFUNCTION		CORRECTION				
645	INSPECT FOR LIVE AMMO					2-3-05	Ac
655	FINAL INSPECTION A) HEADSPACE					2-16-05	Ac
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.79	2.88	2.95 2.96 2.91	2-16-05	TRW
	C) FUNCTION					2-16-05	Ac
660	PACK						

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

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.

G 441 4410 Z

DATE

1-18-05

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.58	2.65		2.54	
PULL #2	2.50	2.63		2.60	
PULL #3	2.41	2.74		2.71	
PULL #4	2.69	2.68		2.65	
PULL #5	2.65	2.67		2.62	
TOTAL	12.83	13.37		13.12	
AVERAGE	2.56	2.67		2.62	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.14		
PULL #2	3.10	3.06		
PULL #3	3.26	3.08		
PULL #4	3.28	3.23		
PULL #5	3.27	3.09		
TOTAL	16.14	15.60		
AVERAGE	3.22	3.12		

	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	4.22	4.21		4.40
PULL #2	4.45	4.14		4.18
PULL #3	4.48	4.36		4.20
PULL #4	4.22	4.22		4.25
PULL #5	4.35	4.27		4.07
TOTAL	21.72	21.20		21.10
AVERAGE	4.34	4.24		4.22

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414410 Z 0
FILE DATE AND TIME: 02/03/2005 09:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.018
The Average Y Centroid of the Five Target Set:	-0.033
The Average Point of Impact of the Five Target Set:	0.037
The Average Mean Radius of the Five Target Set:	0.576
The Distance from POA to Centroid Target #1:	0.064
The Distance from Centroid Target #2 to Centroid Target #1:	0.110
The Distance from Centroid Target #3 to Centroid Target #1:	0.074
The Distance from Centroid Target #4 to Centroid Target #1:	0.099
The Distance from Centroid Target #5 to Centroid Target #1:	0.043

SERIAL NUMBER: G6414410. __0

TARGET NUMBER: 1

FILE DATE: 02/03/2005

FILE TIME: 09:22

POINT#	X	Y
1:	1.207	-0.724
2:	0.813	-0.548
3:	0.755	-0.011
4:	0.257	0.211
5:	-0.071	-0.063
6:	-0.733	-0.380
7:	-0.942	0.120
8:	-0.290	0.435
9:	-0.604	0.420
10:	0.046	0.072

X CENTROID: 0.044

Y CENTROID: -0.047

POA TO CENTROID: 0.064

HORZ SPREAD: 2.149

VERT SPREAD: 1.159

GROUP SPREAD: 2.309

MIN RADIUS: 0.116

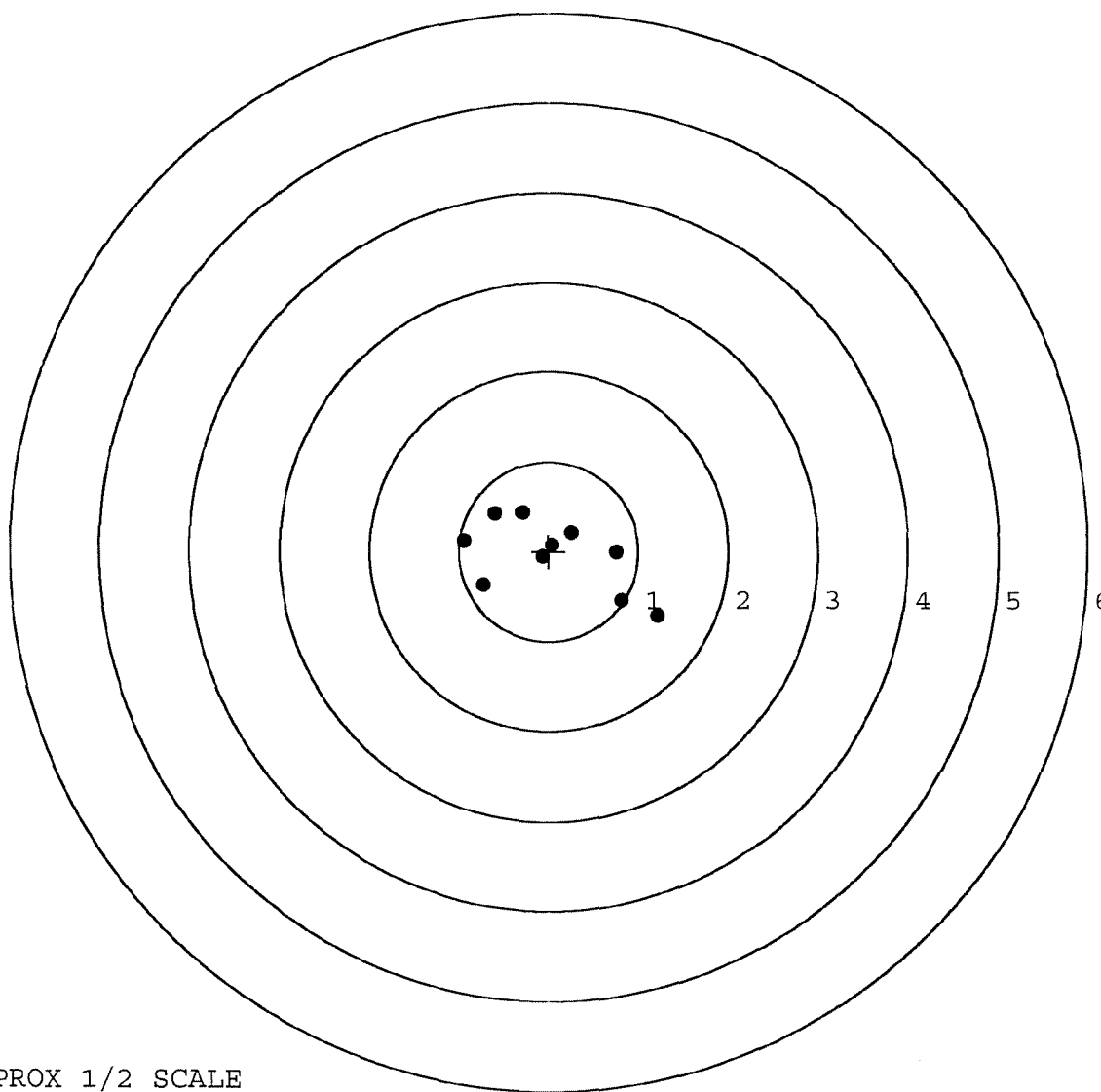
MAX RADIUS: 1.346

MEAN RADIUS: 0.678

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414410. __ 0

TARGET NUMBER: 2

FILE DATE: 02/03/2005

FILE TIME: 09:22

POINT#	X	Y
1:	0.383	-0.592
2:	0.202	-0.335
3:	-0.245	-0.503
4:	-0.658	-0.188
5:	-0.330	-0.021
6:	-0.075	-0.066
7:	0.409	0.172
8:	-0.025	0.393
9:	-0.133	1.012
10:	-0.185	-0.264

X CENTROID: -0.066

Y CENTROID: -0.039

POA TO CENTROID: 0.077

HORZ SPREAD: 1.067

VERT SPREAD: 1.604

GROUP SPREAD: 1.685

MIN RADIUS: 0.028

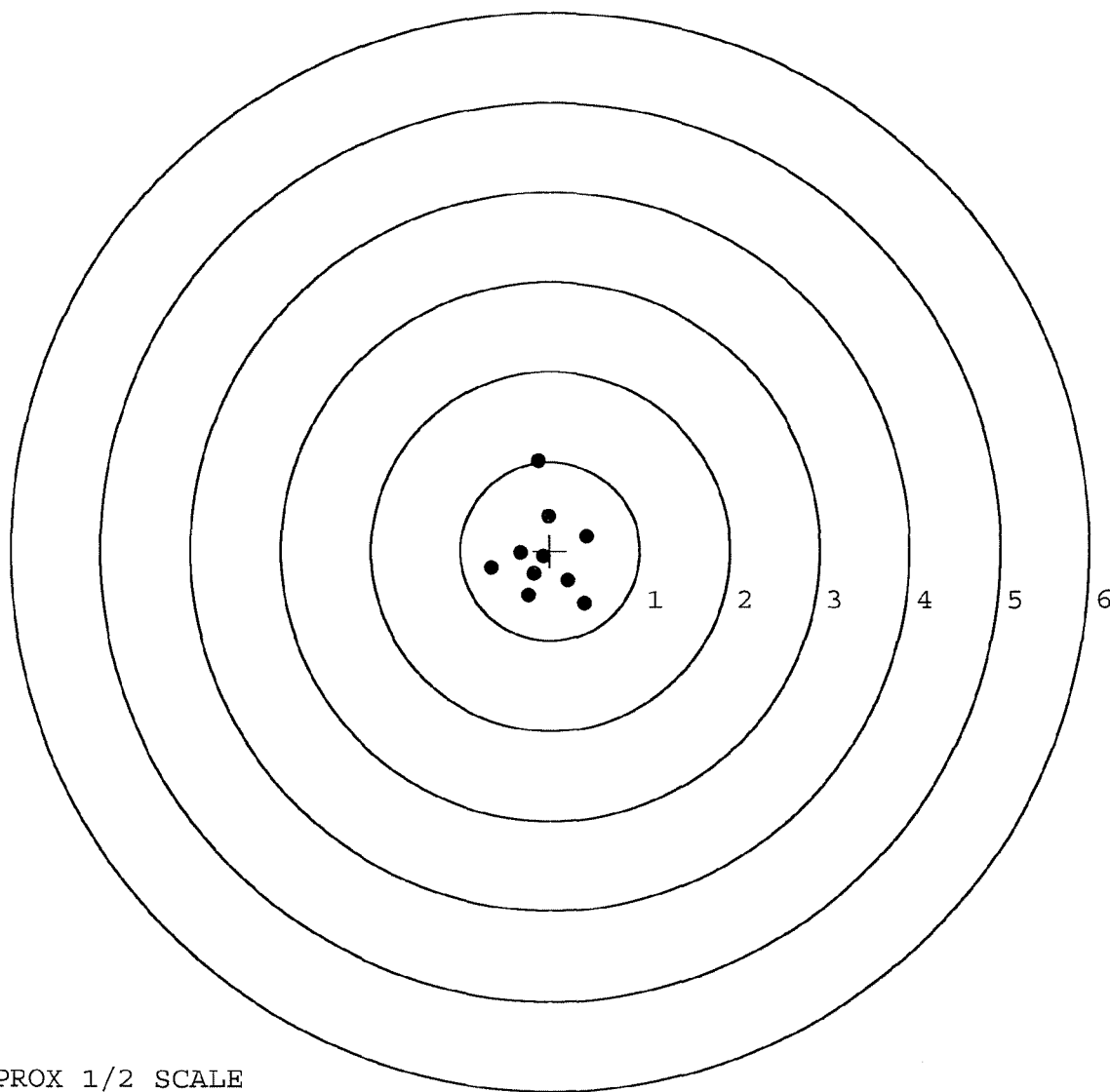
MAX RADIUS: 1.053

MEAN RADIUS: 0.477

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

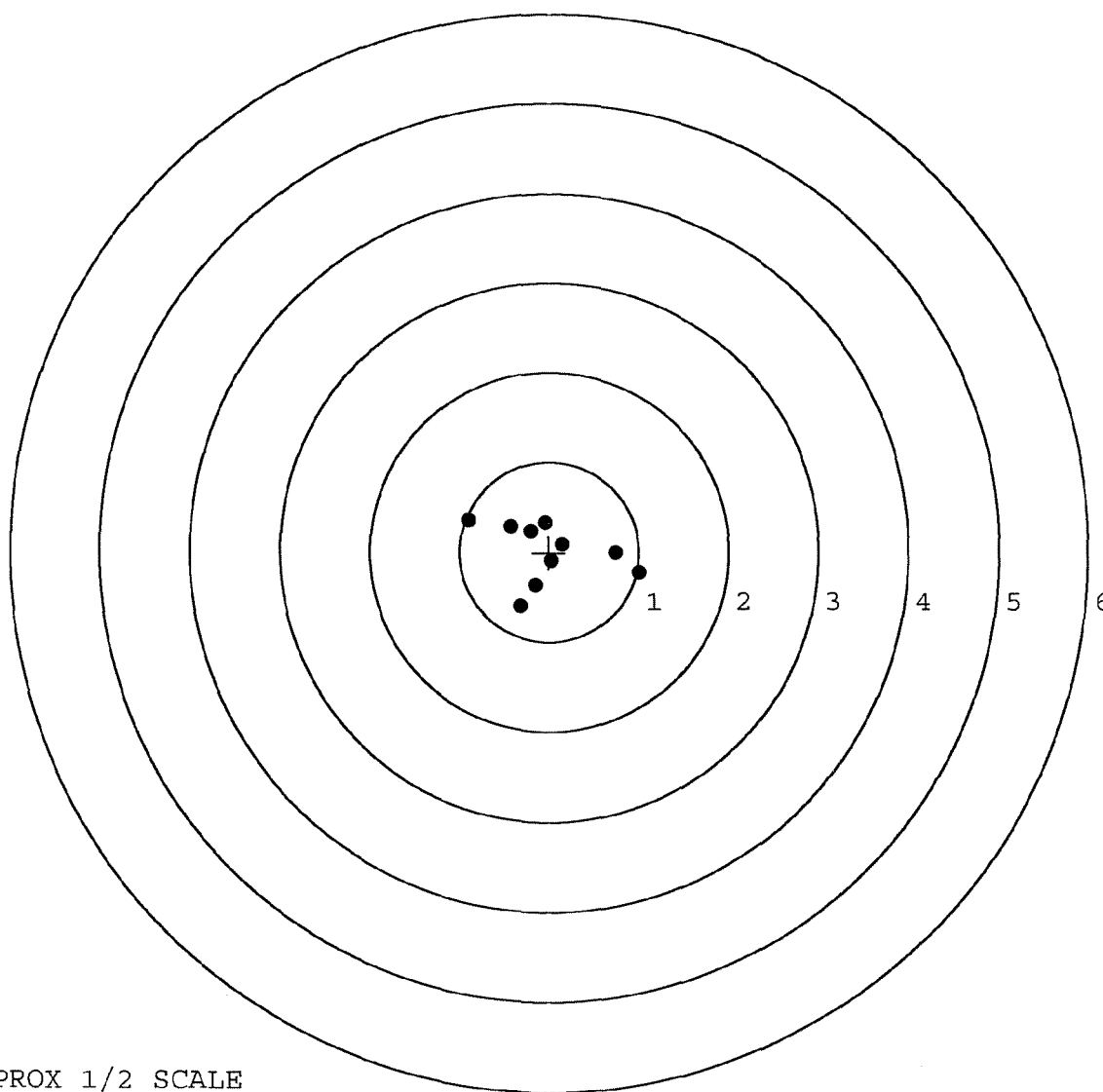


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414410. __0
 TARGET NUMBER: 3
 FILE DATE: 02/03/2005
 FILE TIME: 09:22

POINT#	X	Y
1:	1.006	-0.227
2:	0.744	-0.010
3:	-0.325	-0.608
4:	-0.156	-0.369
5:	-0.902	0.354
6:	0.029	-0.096
7:	0.148	0.087
8:	-0.051	0.333
9:	-0.210	0.238
10:	-0.431	0.285

X CENTROID: -0.015
 Y CENTROID: -0.001
 POA TO CENTROID: 0.015
 HORZ SPREAD: 1.908
 VERT SPREAD: 0.962
 GROUP SPREAD: 1.994
 MIN RADIUS: 0.104
 MAX RADIUS: 1.045
 MEAN RADIUS: 0.528
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414410. __ 0

TARGET NUMBER: 4

FILE DATE: 02/03/2005

FILE TIME: 09:22

POINT#	X	Y
1:	0.363	-0.910
2:	0.140	-0.595
3:	-0.402	-0.731
4:	-0.822	-0.470
5:	0.523	0.811
6:	0.054	-0.106
7:	0.180	0.090
8:	0.089	0.556
9:	-0.149	0.621
10:	-0.503	0.475

X CENTROID: -0.053

Y CENTROID: -0.026

POA TO CENTROID: 0.059

HORZ SPREAD: 1.345

VERT SPREAD: 1.721

GROUP SPREAD: 1.857

MIN RADIUS: 0.133

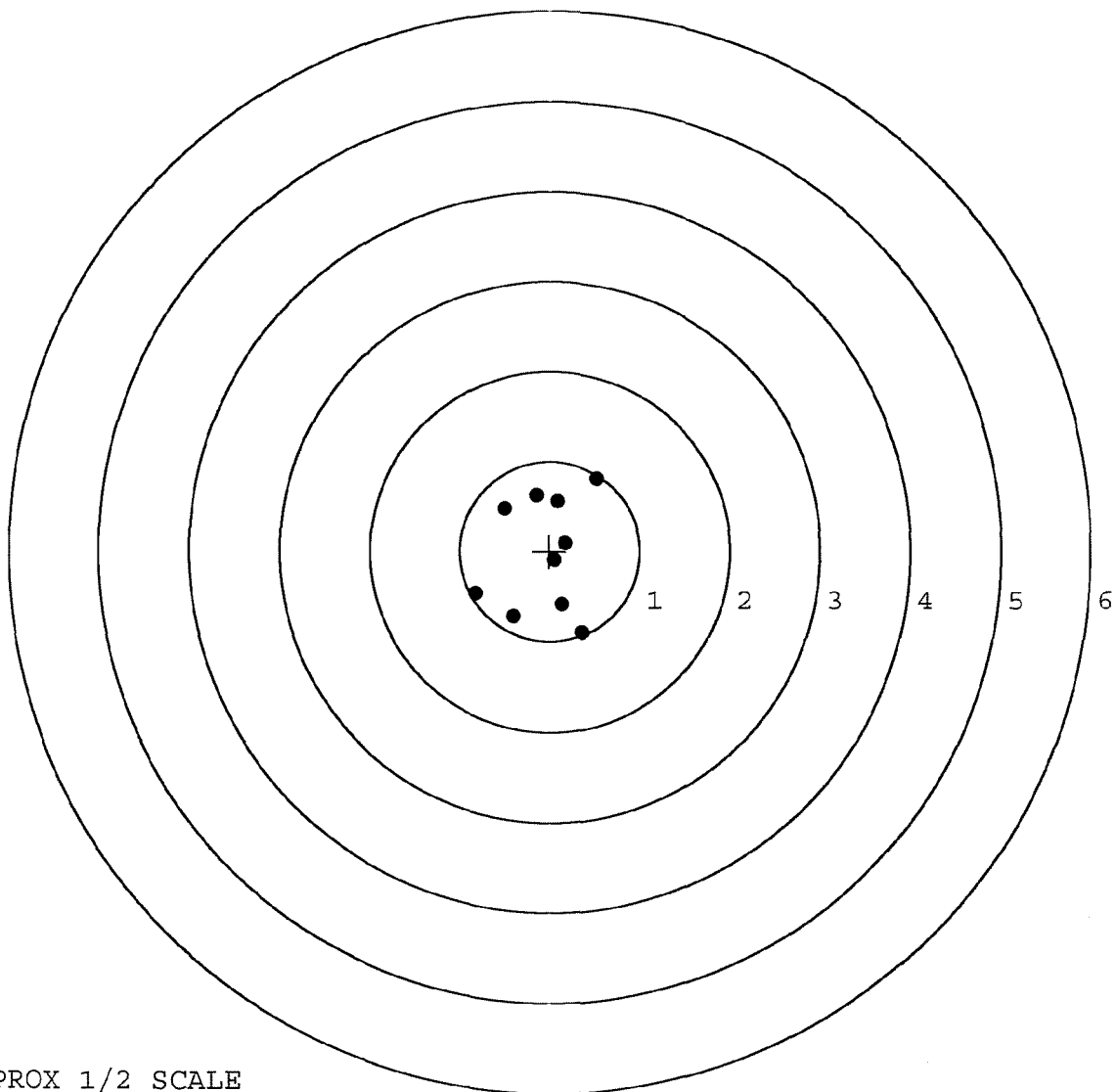
MAX RADIUS: 1.016

MEAN RADIUS: 0.659

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414410. 0

TARGET NUMBER: 5

FILE DATE: 02/03/2005

FILE TIME: 09:22

X CENTROID: 0.001

Y CENTROID: -0.051

POA TO CENTROID: 0.051

HORZ SPREAD: 1.662

VERT SPREAD: 1.135

GROUP SPREAD: 1.760

MIN RADIUS: 0.136

MAX RADIUS: 0.925

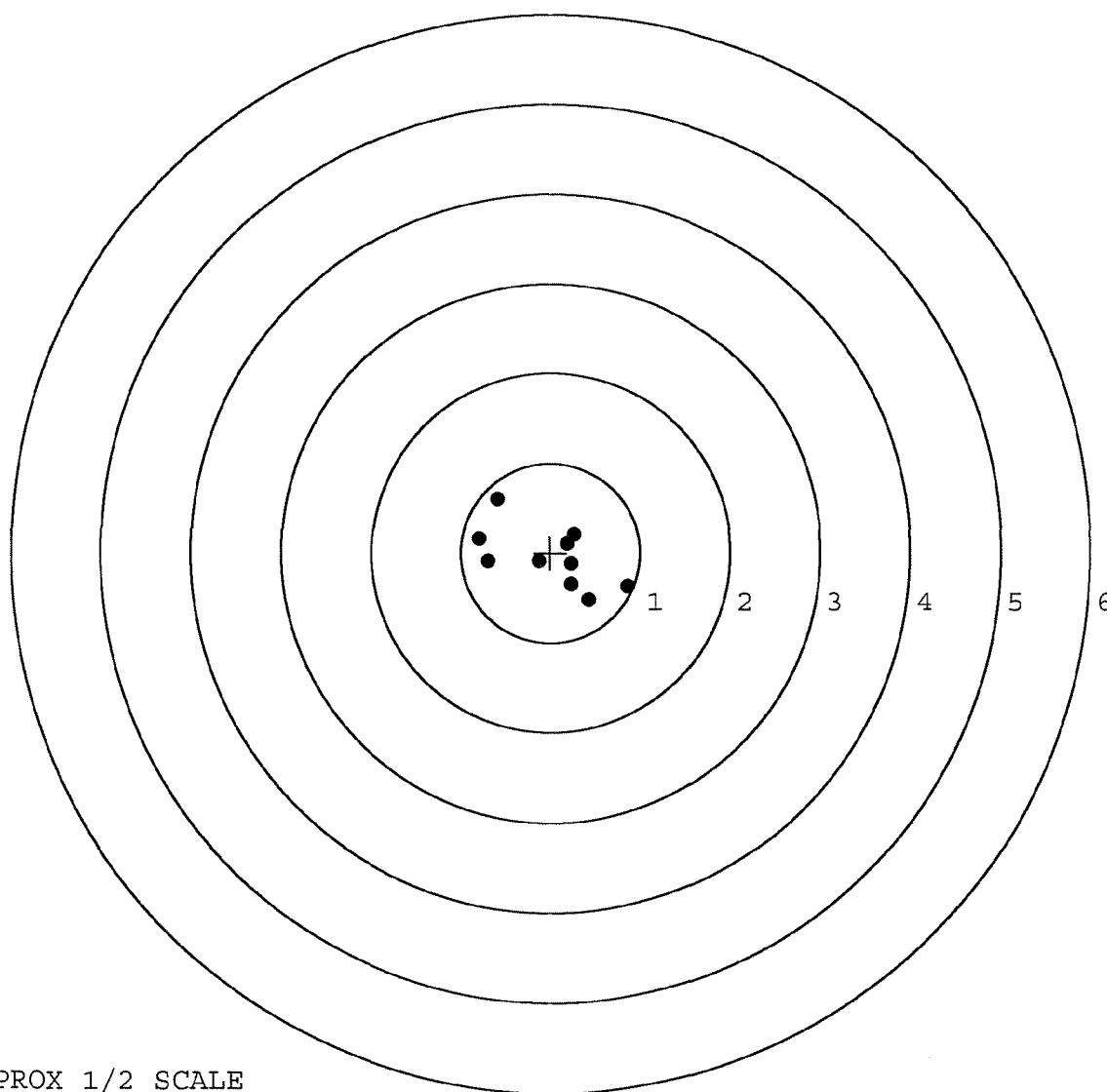
MEAN RADIUS: 0.537

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.864	-0.383
2:	-0.695	-0.096
3:	-0.798	0.163
4:	-0.595	0.602
5:	0.269	0.213
6:	0.187	0.104
7:	-0.128	-0.094
8:	0.238	-0.357
9:	0.430	-0.533
10:	0.235	-0.124



TARGET APPROX 1/2 SCALE