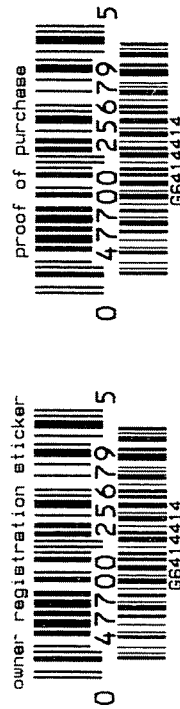


66414414

**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

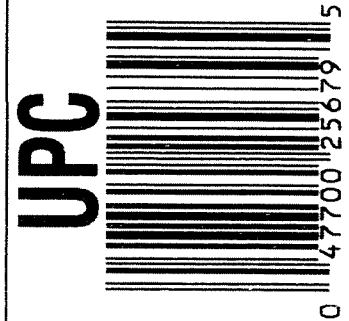


ORDER NO. **25679**

BARREL LENGTH 24"

CAPACITY 6

G6414414



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.



G6414414

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 #

~~G6414410~~ G6414414

TRW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RTZ
600	PROOF		1-4-05	Ac
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-4-05	Ac
610	DIS-ASSEMBLE GUN		1-4-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	07 2005 OPERATOR 		
615	ROLLMARK CALIBER		1-7-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1-14-05	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		2-9-05	RTZ
	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>8 lbs</u> <u>8 lbs</u> <u>8 lbs</u>	3-21-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	3-21-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	3-21-05	Ac
	J) ASSEMBLE STOCK		2-9-05	RTL
	K) ASSEMBLE SWIVEL STUDS		3-21-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-9-05	RTL
	M) IRON SIGHT ALIGNMENT		2-9-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-9-05	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	2-11-05	TRLW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-11-05	Ac
655	FINAL INSPECTION A) HEADSPACE		3-21-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.20</u> <u>2.47</u> <u>2.53</u> <u>2.47</u> <u>2.46</u>	3-21-05	TRLW
	C) FUNCTION		3-21-05	Ac
660	PACK		3/27/05	DA

AVER BARBER - M24 0151973
 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.

DATE

2-1-05

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.13	2.57		2.44	
PULL #2	2.39	2.60		2.68	
PULL #3	2.58	2.41		2.60	
PULL #4	2.90	2.21		2.68	
PULL #5	2.75	2.45		2.59	
TOTAL	12.75	12.24		12.99	
AVERAGE	2.55	2.44		2.59	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.07		
PULL #2	3.12	3.43		
PULL #3	3.09	3.36		
PULL #4	3.32	3.38		
PULL #5	3.25	3.37		
TOTAL	16.07	16.61		
AVERAGE	3.21	3.32		

	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	4.46	4.27		4.19
PULL #2	4.41	4.24		4.24
PULL #3	4.51	4.32		4.30
PULL #4	4.54	4.24		4.34
PULL #5	4.51	4.28		4.34
TOTAL	22.43	21.35		21.41
AVERAGE	4.48	4.27		4.28

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414414.___0
FILE DATE AND TIME: 02/11/2005 09:24

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.068
The Average Y Centroid of the Five Target Set:	-0.021
The Average Point of Impact of the Five Target Set:	0.071
The Average Mean Radius of the Five Target Set:	0.959
The Distance from POA to Centroid Target #1:	0.317
The Distance from Centroid Target #2 to Centroid Target #1:	0.598
The Distance from Centroid Target #3 to Centroid Target #1:	0.340
The Distance from Centroid Target #4 to Centroid Target #1:	0.210
The Distance from Centroid Target #5 to Centroid Target #1:	0.252

SERIAL NUMBER: G6414414. 0

TARGET NUMBER: 1

FILE DATE: 02/11/2005

FILE TIME: 09:24

POINT#	X	Y
1:	0.427	-0.474
2:	-0.248	-0.492
3:	-0.657	-0.870
4:	-0.452	-1.689
5:	-0.151	0.335
6:	-1.607	0.628
7:	-1.921	-1.295
8:	0.398	1.639
9:	1.425	1.745
10:	-0.331	-0.107

X CENTROID: -0.312

Y CENTROID: -0.058

POA TO CENTROID: 0.317

HORZ SPREAD: 3.346

VERT SPREAD: 3.434

GROUP SPREAD: 4.521

MIN RADIUS: 0.053

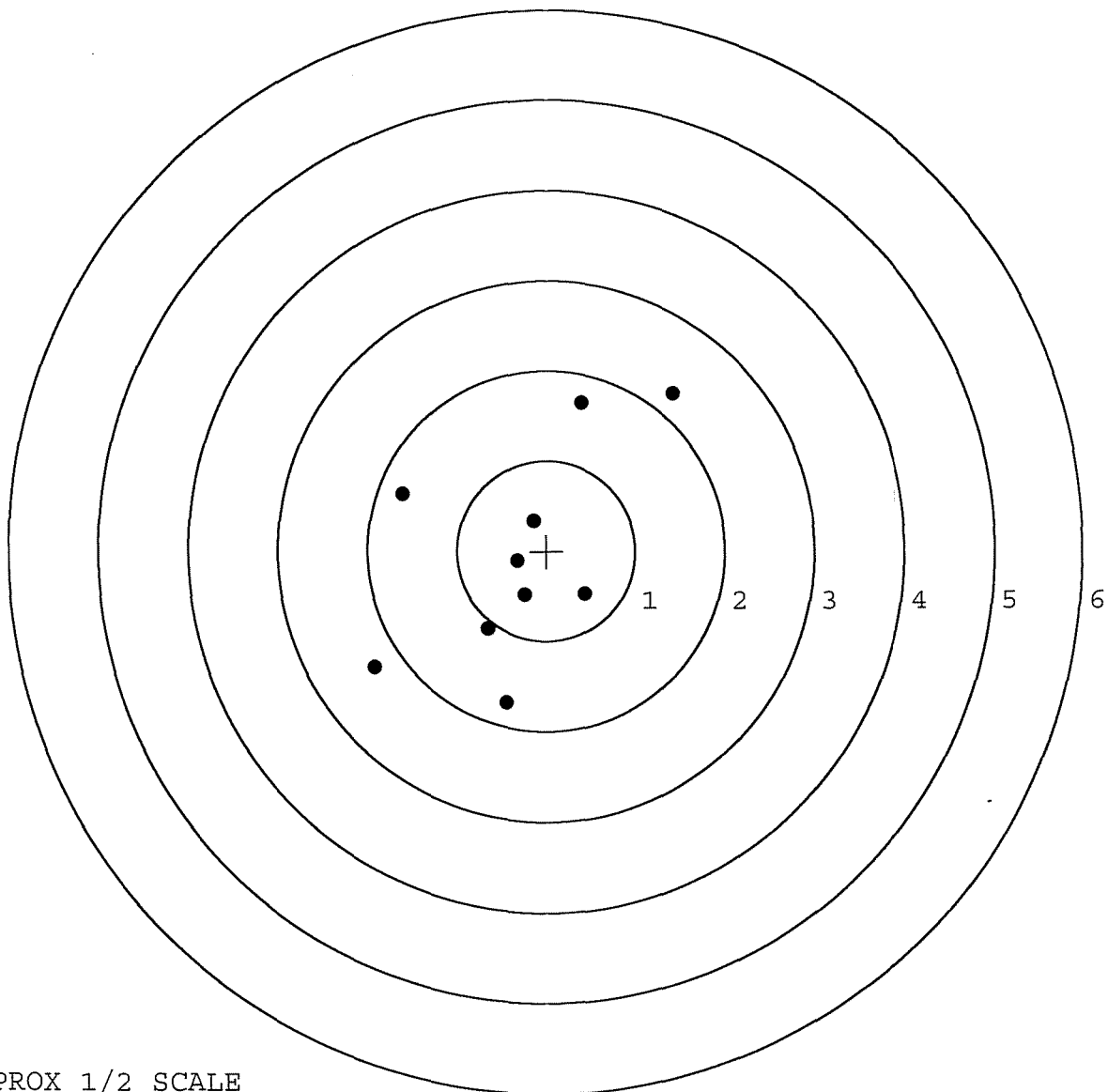
MAX RADIUS: 2.503

MEAN RADIUS: 1.212

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 6

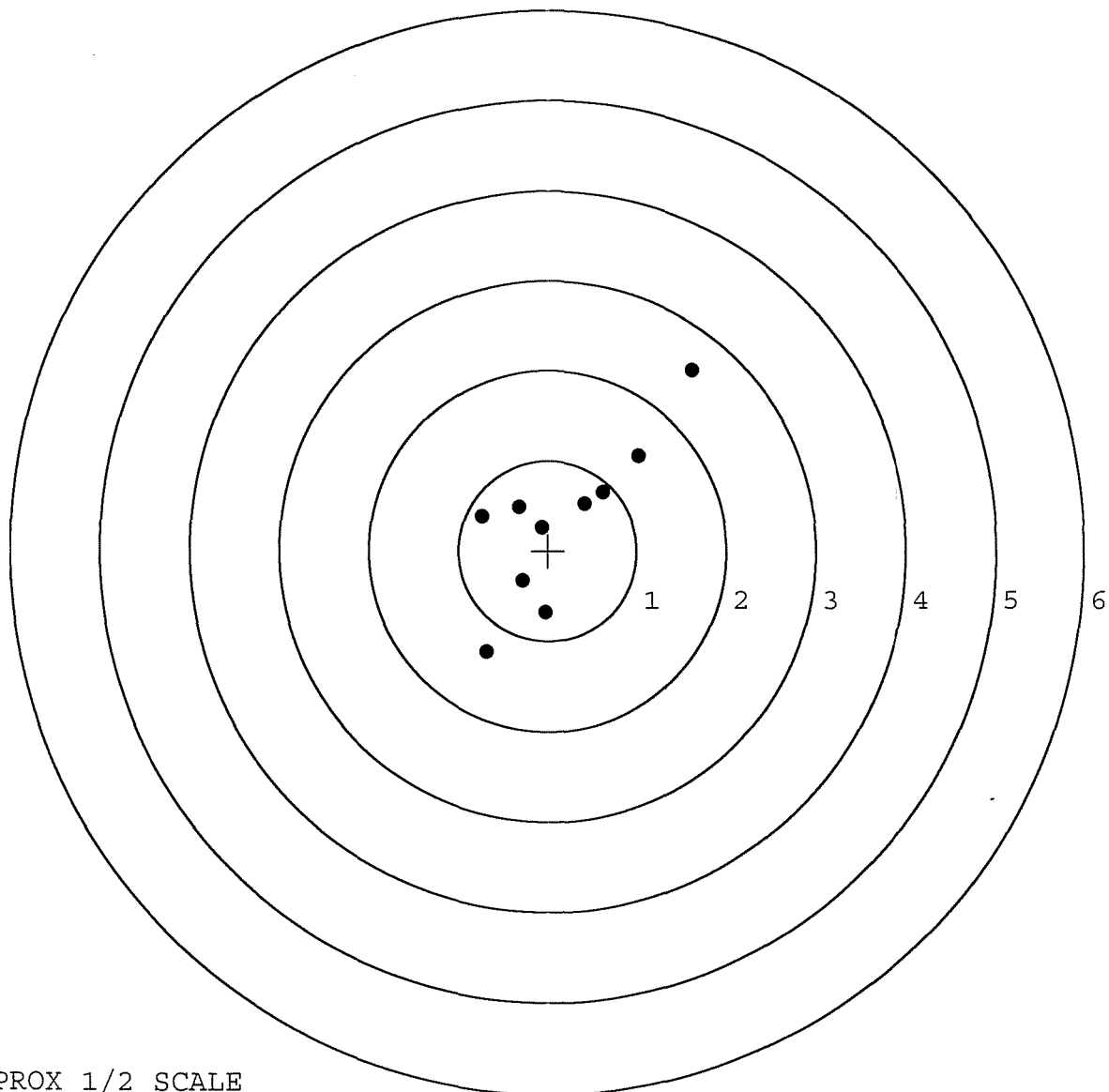


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414414. __0
 TARGET NUMBER: 2
 FILE DATE: 02/11/2005
 FILE TIME: 09:24

POINT#	X	Y
1:	1.025	1.051
2:	0.619	0.651
3:	0.407	0.521
4:	-0.040	-0.687
5:	-0.291	-0.334
6:	-0.690	-1.124
7:	-0.067	0.256
8:	-0.328	0.485
9:	-0.743	0.381
10:	1.626	2.000

X CENTROID: 0.152
 Y CENTROID: 0.320
 POA TO CENTROID: 0.354
 HORZ SPREAD: 2.369
 VERT SPREAD: 3.124
 GROUP SPREAD: 3.889
 MIN RADIUS: 0.228
 MAX RADIUS: 2.235
 MEAN RADIUS: 0.939
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414414. __0

TARGET NUMBER: 3

FILE DATE: 02/11/2005

FILE TIME: 09:24

POINT#	X	Y
1:	1.037	-0.811
2:	0.211	-0.739
3:	-0.219	-0.962
4:	-1.291	-0.376
5:	-1.425	0.010
6:	0.225	0.797
7:	0.026	0.210
8:	0.409	0.150
9:	0.441	-0.081
10:	0.592	-0.119

X CENTROID: 0.001

Y CENTROID: -0.192

POA TO CENTROID: 0.192

HORZ SPREAD: 2.462

VERT SPREAD: 1.759

GROUP SPREAD: 2.595

MIN RADIUS: 0.403

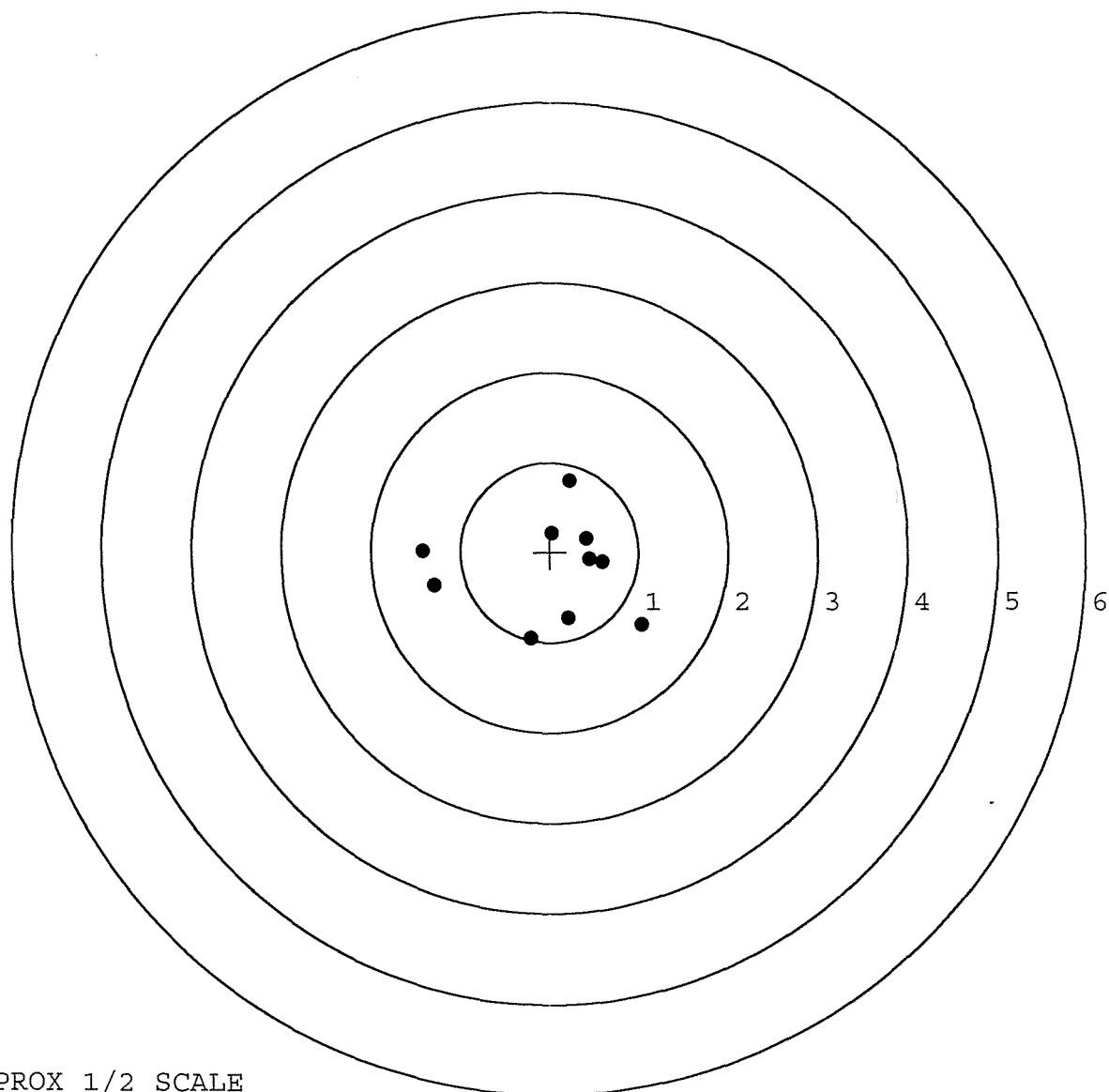
MAX RADIUS: 1.440

MEAN RADIUS: 0.834

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

<u>POINT#</u>	<u>X</u>	<u>Y</u>
---------------	----------	----------

TARGET NUMBER: 4

FILE DATE: 02/11/2005

FILE TIME: 09:24

```
X  CENTROID:      -0.119
```

Y CENTROID: -0.140

POA TO CENTROID: 0.184

HORZ SPREAD: 2.237

VERT SPREAD: 1.988

GROUP SPREAD: 2.505

MIN RADIUS: 0.386

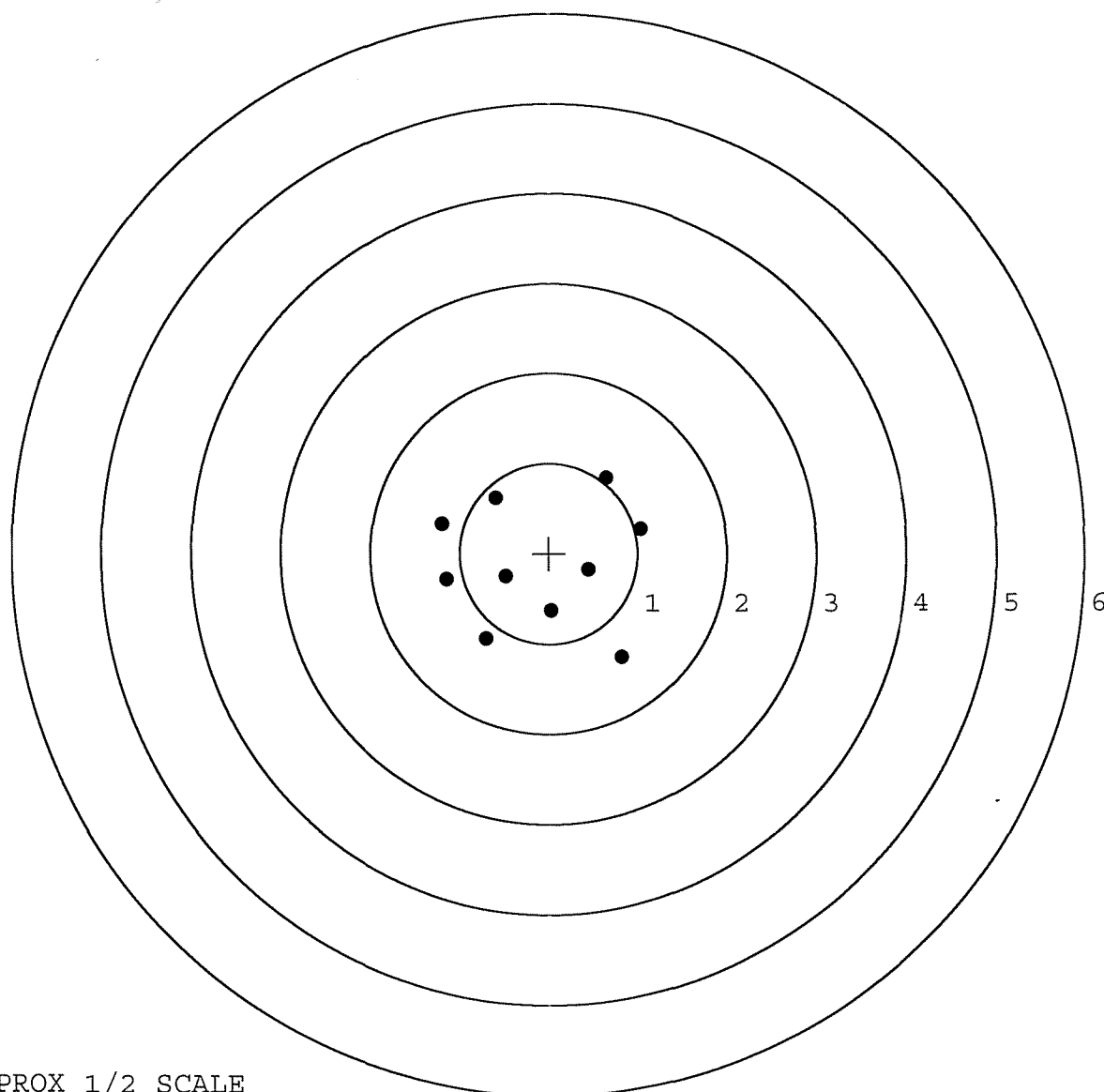
MAX RADIUS: 1.379

MEAN RADIUS: 0.943

```
# IN 1 IN DIAMETER:      1
```

IN 2 IN DIAMETER: 5

```
# in 3 IN DIAMETER:      10
```



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414414. __0

TARGET NUMBER: 5

FILE DATE: 02/11/2005

FILE TIME: 09:24

POINT#	X	Y
1:	0.430	0.633
2:	-0.524	0.914
3:	-0.717	0.289
4:	-2.005	0.068
5:	1.045	-0.231
6:	0.699	-0.170
7:	0.440	-0.146
8:	0.181	-0.573
9:	0.047	-0.751
10:	-0.198	-0.401

X CENTROID: -0.060

Y CENTROID: -0.037

POA TO CENTROID: 0.071

HORZ SPREAD: 3.050

VERT SPREAD: 1.665

GROUP SPREAD: 3.065

MIN RADIUS: 0.389

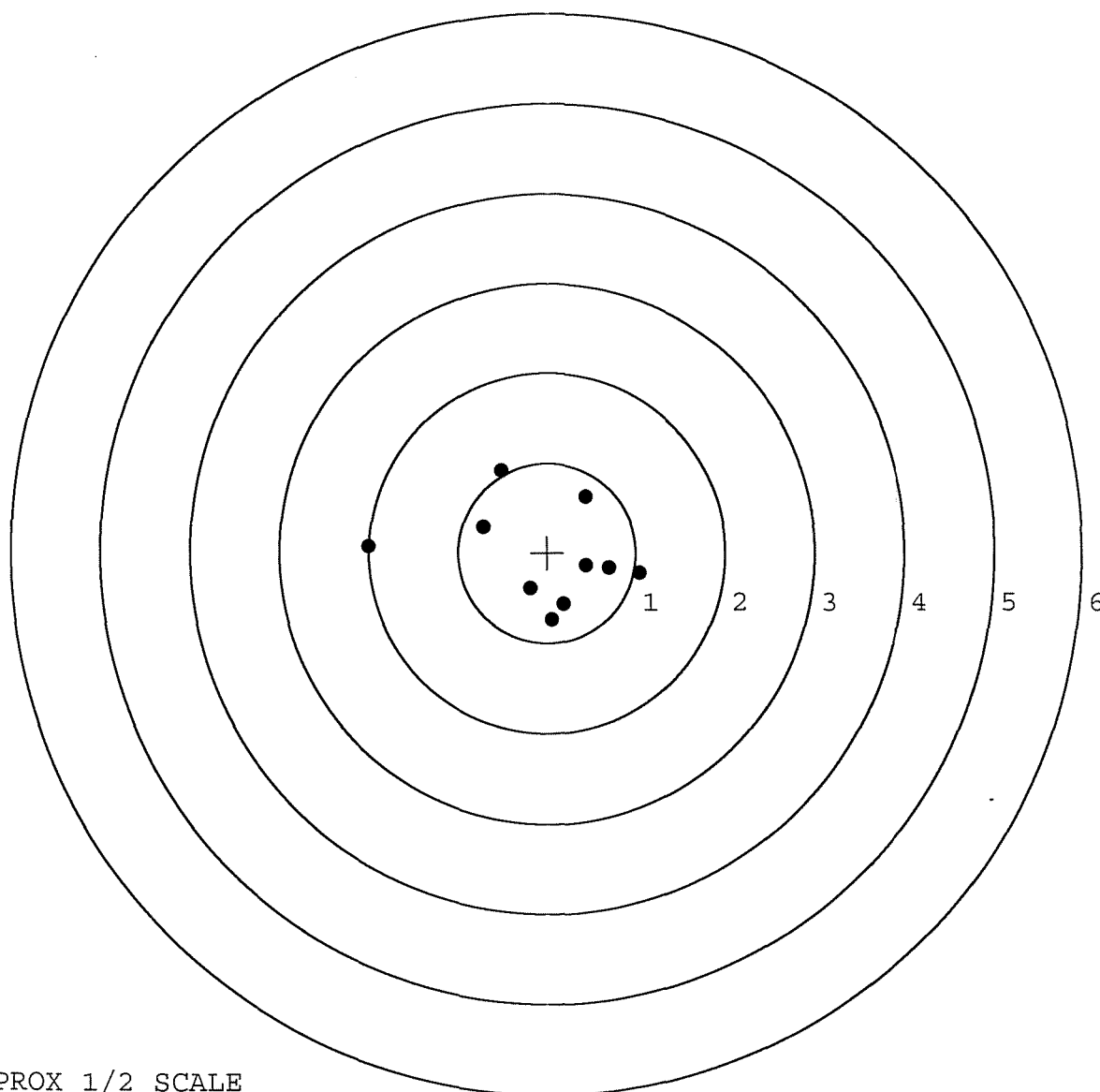
MAX RADIUS: 1.948

MEAN RADIUS: 0.867

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE