

G673 1477

**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

BM FORM 96253

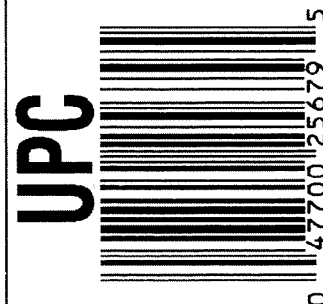


ORDER NO. 25679

BARREL LENGTH 24"

CAPACITY 6

G6731477



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66731477

OP #	OPERATION NAME	READINGS	DATE	INITIAL
410	SERIALIZE BOLT HANDLE		4-2-08	L.P.D.
420	ASSEMBLE ACTION		4-2-08	L.P.D.
430	ASSEMBLE TO STOCK		4-2-08	TRW
440	PROOF	MAGNA - FLUX	4-2-08	TRW
460	CHECK HEADSPACE	APR 04 2008	4-2-08	TRW
470	DIS-ASSEMBLE ACTION		4-3-08	L.P.D.
480	MAGNAFLUX BBL ACTION	OPERATOR <u>mm</u>	4/4/08	mm
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		4-3-08	CW
510	DRILL AND TAP SIGHT HOLES		4-3-08	Fm
520	GOFF BLAST BBL / REC		4-7-08	DG
530 & 540	APPLY COATINGS (BARREL ACTION)		4-11-08	LM
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-14-08	L.P.D.
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-14-08	L.P.D.
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-14-08	L.P.D.
	D) OIL FIRING PIN ASSEMBLY		4-17-08	L.P.D.
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>8.0</u> <u>8.0</u> <u>7.5</u>	4-23-08	TRW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.75</u> <u>2.5</u> <u>3.0</u>	4-23-08	TRW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023^S</u> <u>.023^S</u> <u>.023^S</u>	4-23-08	TRW
	J) ASSEMBLE STOCK		4-17-08	J.P.D.
	K) ASSEMBLE SWIVEL STUDS		4-23-08	TRW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-23-08	J.P.D.
	M) IRON SIGHT ALIGNMENT		4-23-08	J.P.D.
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-23-08	J.P.D.
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	4-21-08	J.P.D.
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-21-08	SD
670	FINAL INSPECTION A) HEADSPACE		4-23-08	TRW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.42</u> <u>2.42</u> <u>2.43</u> <u>2.42</u>	4-23-08	TRW
	C) FUNCTION		4-23-08	TRW
690	PACK		5-2-08	Fm

F004 REV 5/2006

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)

DATE 1-10-08

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.30	2.36		2.11	
PULL #2	2.33	2.17		2.29	
PULL #3	2.44	2.28		2.31	
PULL #4	2.48	2.24		2.44	
PULL #5	2.40	2.34		2.44	
TOTAL	11.95	11.39		11.59	
AVERAGE	2.39	2.27		2.31	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.11		
PULL #2	3.08	3.09		
PULL #3	3.22	3.03		
PULL #4	3.22	2.98		
PULL #5	3.05	3.00		
TOTAL	15.70	15.21		
AVERAGE	3.14	3.04		

	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	4.54	4.11		4.78
PULL #2	4.50	4.03		4.51
PULL #3	4.48	3.99		4.51
PULL #4	4.57	3.98		4.56
PULL #5	4.51	4.07		4.51
TOTAL	22.60	20.18		22.87 ^{TRW}
AVERAGE	4.52	4.03		4.57

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6731477.__0
FILE DATE AND TIME: 04/22/2008 05:09

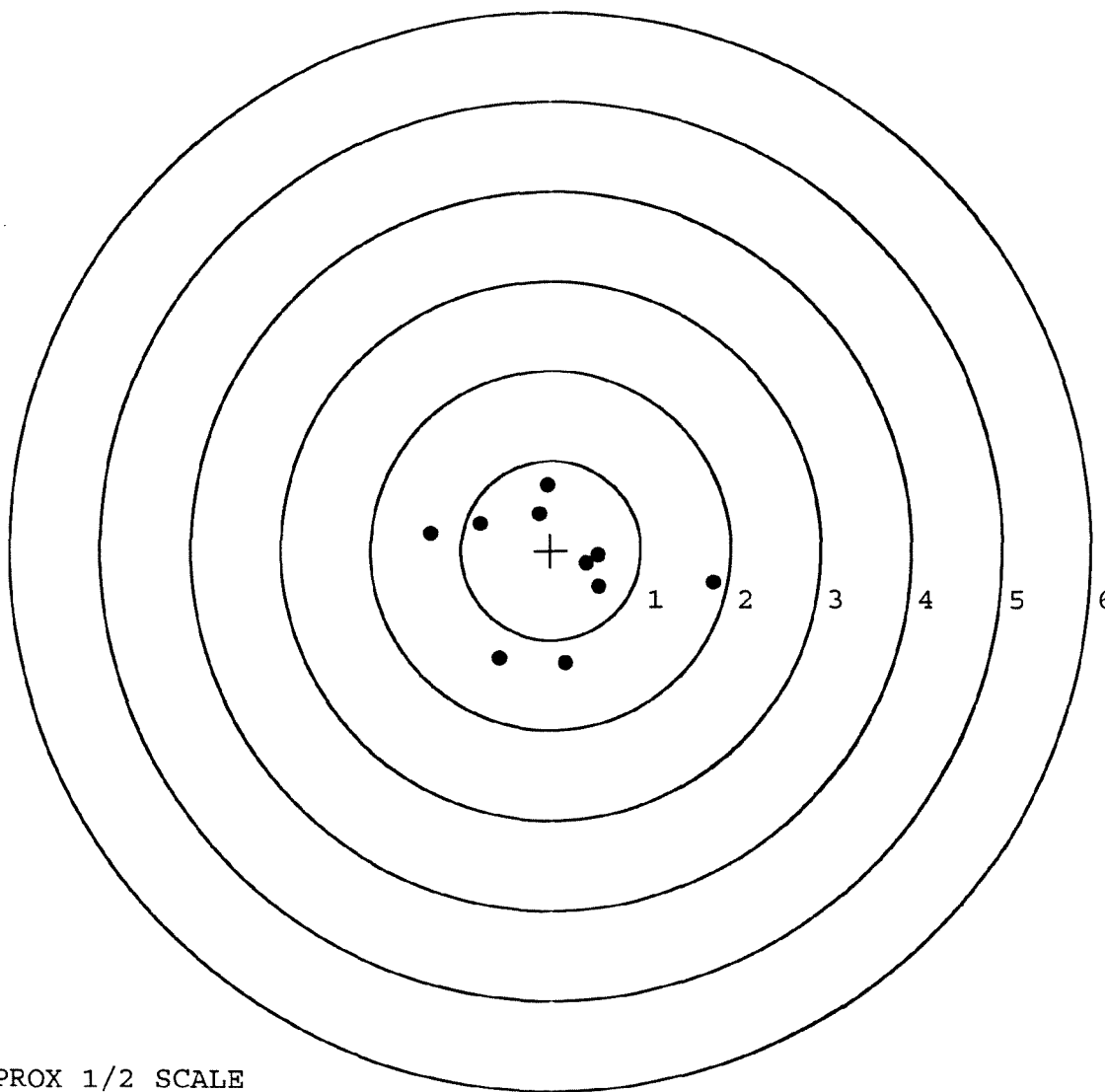
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.014
The Average Y Centroid of the Five Target Set:	0.009
The Average Point of Impact of the Five Target Set:	0.016
The Average Mean Radius of the Five Target Set:	0.840
The Distance from POA to Centroid Target #1:	0.191
The Distance from Centroid Target #2 to Centroid Target #1:	0.307
The Distance from Centroid Target #3 to Centroid Target #1:	0.439
The Distance from Centroid Target #4 to Centroid Target #1:	0.196
The Distance from Centroid Target #5 to Centroid Target #1:	0.318

SERIAL NUMBER: G6731477. __0
TARGET NUMBER: 1
FILE DATE: 04/22/2008
FILE TIME: 05:09

X CENTROID: 0.055
Y CENTROID: -0.182
POA TO CENTROID: 0.191
HORZ SPREAD: 3.143
VERT SPREAD: 1.995
GROUP SPREAD: 3.191
MIN RADIUS: 0.342
MAX RADIUS: 1.763
MEAN RADIUS: 0.937
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.809	-0.364
2:	0.163	-1.262
3:	-0.576	-1.212
4:	-0.043	0.733
5:	-0.137	0.413
6:	-0.790	0.295
7:	-1.334	0.190
8:	0.528	-0.058
9:	0.395	-0.150
10:	0.534	-0.410

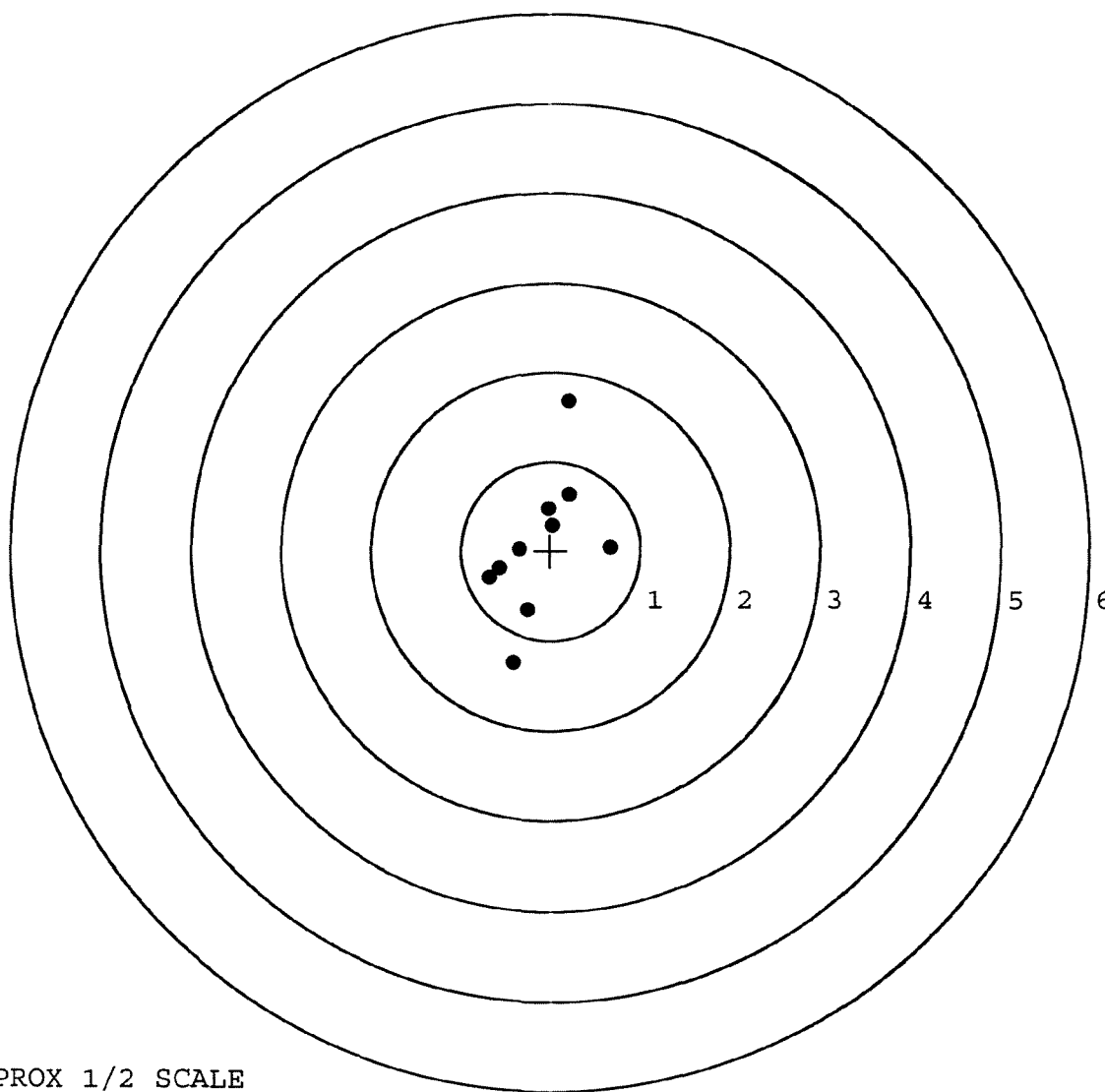


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6731477. __0
TARGET NUMBER: 2
FILE DATE: 04/22/2008
FILE TIME: 05:09

X CENTROID: -0.121
Y CENTROID: 0.069
POA TO CENTROID: 0.139
HORZ SPREAD: 1.355
VERT SPREAD: 2.920
GROUP SPREAD: 2.988
MIN RADIUS: 0.235
MAX RADIUS: 1.638
MEAN RADIUS: 0.728
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.210	1.673
2:	0.673	0.039
3:	-0.265	-0.661
4:	-0.422	-1.247
5:	-0.682	-0.311
6:	-0.568	-0.201
7:	-0.350	0.017
8:	0.016	0.283
9:	-0.033	0.470
10:	0.213	0.627



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6731477. 0

TARGET NUMBER: 3

FILE DATE: 04/22/2008

FILE TIME: 05:09

X CENTROID: 0.356

Y CENTROID: 0.137

POA TO CENTROID: 0.382

HORZ SPREAD: 3.004

VERT SPREAD: 2.136

GROUP SPREAD: 3.203

MIN RADIUS: 0.715

MAX RADIUS: 1.906

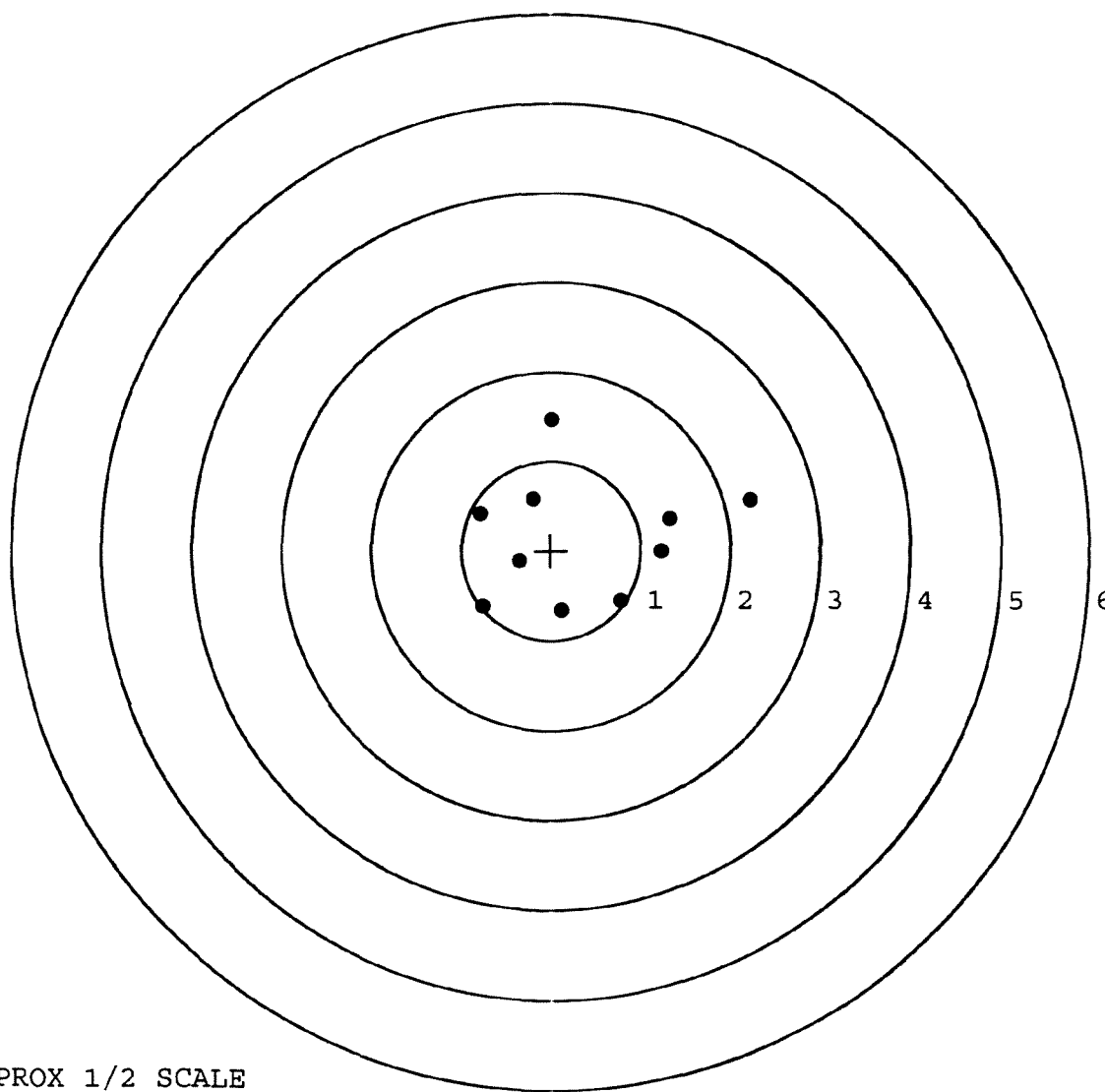
MEAN RADIUS: 1.082

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	2.214	0.564
2:	1.323	0.350
3:	1.234	-0.019
4:	0.778	-0.563
5:	0.118	-0.672
6:	-0.761	-0.623
7:	-0.356	-0.121
8:	-0.790	0.413
9:	-0.206	0.579
10:	0.009	1.464



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6731477. __0

TARGET NUMBER: 4

FILE DATE: 04/22/2008

FILE TIME: 05:09

POINT#	X	Y
1:	1.224	0.236
2:	0.796	0.225
3:	-0.777	1.012
4:	-1.123	-0.627
5:	-0.437	-0.317
6:	-0.006	0.246
7:	-0.324	0.233
8:	0.173	-0.156
9:	0.163	-0.474
10:	-0.141	-0.514

X CENTROID: -0.045

Y CENTROID: -0.014

POA TO CENTROID: 0.047

HORZ SPREAD: 2.347

VERT SPREAD: 1.639

GROUP SPREAD: 2.501

MIN RADIUS: 0.261

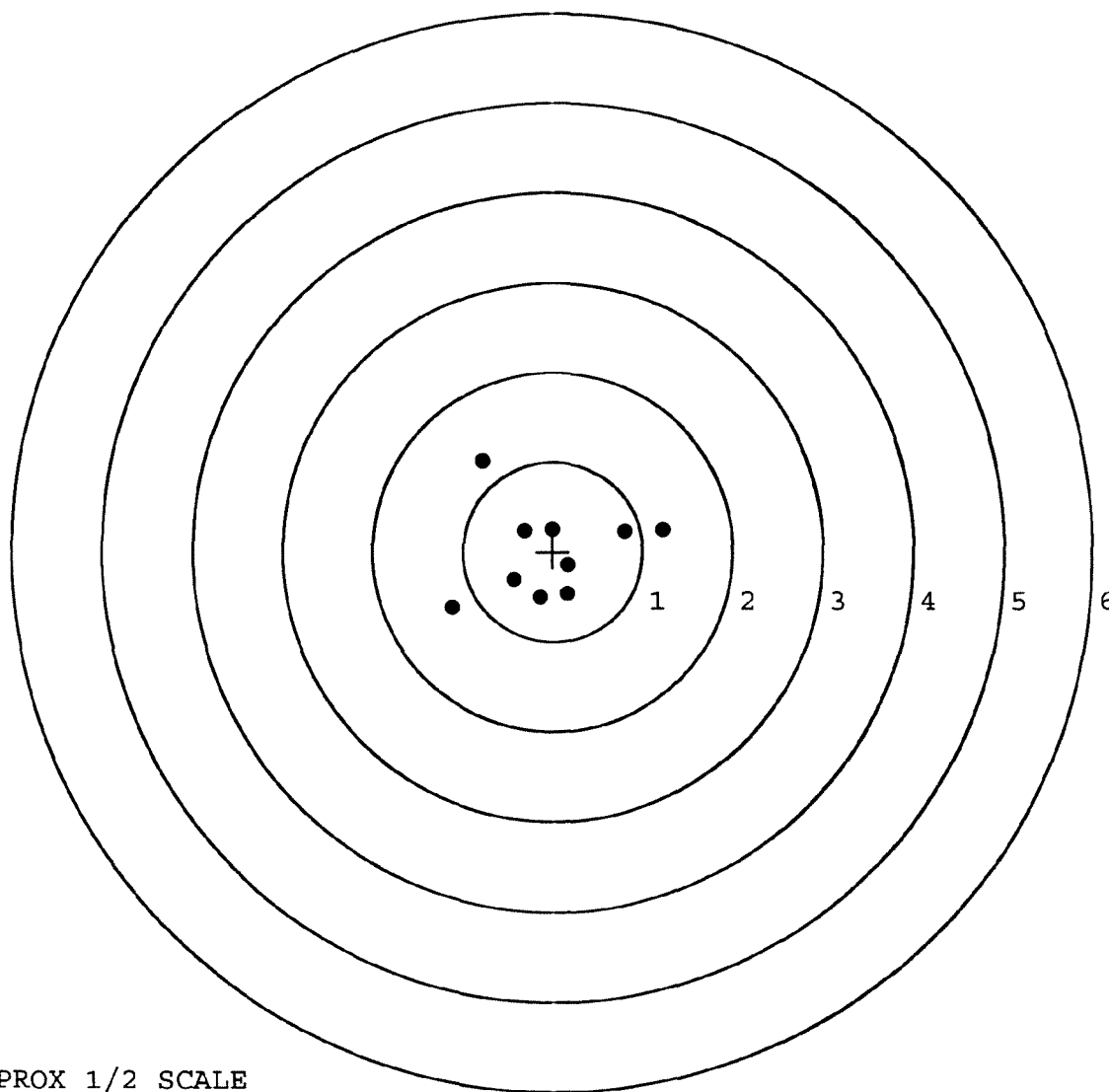
MAX RADIUS: 1.294

MEAN RADIUS: 0.707

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6731477. __0

TARGET NUMBER: 5

FILE DATE: 04/22/2008

FILE TIME: 05:09

POINT#	X	Y
1:	0.345	-0.775
2:	-0.094	-1.053
3:	0.648	0.242
4:	0.134	0.887
5:	-0.124	0.325
6:	0.085	-0.111
7:	-0.466	-0.057
8:	-0.740	-0.357
9:	-1.484	0.578
10:	-0.077	0.667

X CENTROID: -0.177

Y CENTROID: 0.035

POA TO CENTROID: 0.181

HORZ SPREAD: 2.132

VERT SPREAD: 1.940

GROUP SPREAD: 2.275

MIN RADIUS: 0.295

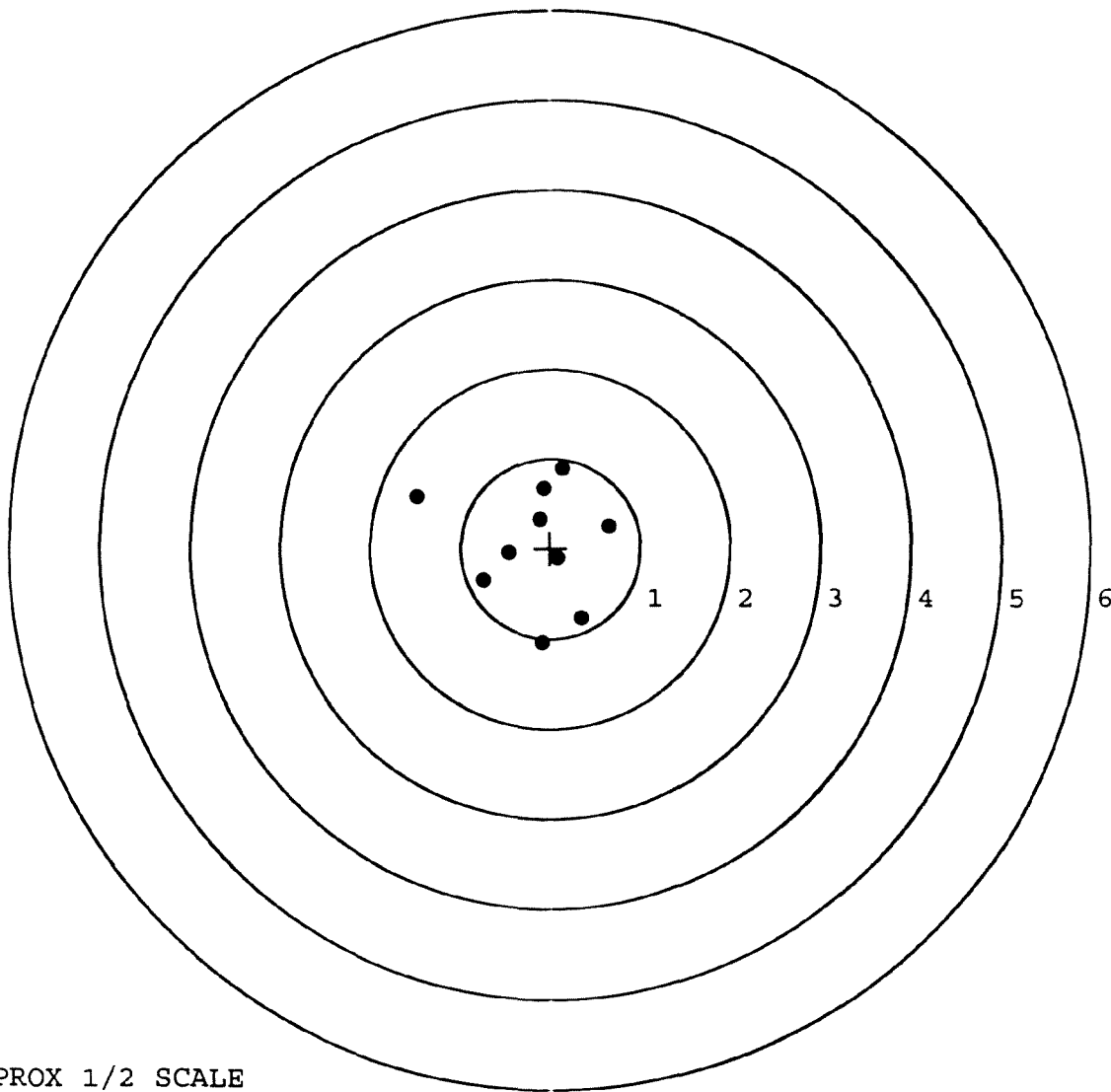
MAX RADIUS: 1.415

MEAN RADIUS: 0.745

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE