

G6360990

**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

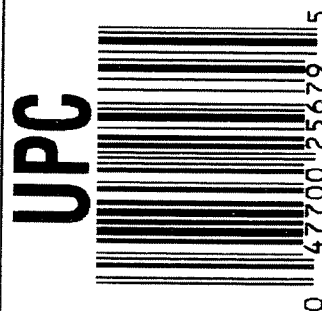


ORDER NO. 25679

BARREL LENGTH 24"

CAPACITY 6

G6360990



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



SERIAL NO.



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

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6360990

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-29-04	RTL
600	PROOF		12-29-04	RTZ
607	CHECK HEADSPACE		12-29-04	RTZ
610	DIS-ASSEMBLE GUN		12-30-04	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		12-30-04	RTZ
615	ROLLMARK CALIBER		1-3-05	CW
617	DRILL AND TAP SIGHT HOLES		12-30-04	TRLW
620	APPLY COATINGS (BARREL ACTION)		1/5/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-12-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-12-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-21-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-21-05	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>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	1-27-05	Ac
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	1-27-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-27-05	Ac
	J) ASSEMBLE STOCK		1-21-05	RT
	K) ASSEMBLE SWIVEL STUDS		1-27-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-7-05	RT
	M) IRON SIGHT ALIGNMENT		2-7-05	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-7-05	RT
640	GALLERY TEST AND TARGET	PASS FAIL	2-9-05 TRW 1-25-05	Ac
	MALFUNCTION <i>Feeds hard</i>	CORRECTION <i>OK</i>	1-25-05	Ac
	MALFUNCTION <i>MCW</i>	CORRECTION <i>OK</i>	1-25-05	Ac
	MALFUNCTION	CORRECTION	NA	
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-25-05	Ac
655	FINAL INSPECTION A) HEADSPACE		1-27-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.86</u> <u>2.75</u> <u>2.64</u> <u>2.76</u> <u>2.91</u>	1-27-05	Ac
	C) FUNCTION		1-27-05	Ac
660	PACK		3/18/05	NA

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. ~~66360990~~

DATE

11-30-04 G6360990

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.65	2.86		2.28	
PULL #2	2.44	2.70		2.32	
PULL #3	2.75	2.68		2.20	
PULL #4	2.71	2.68		2.35	
PULL #5	2.73	2.65		2.31	
TOTAL	13.28	13.57		11.46	
AVERAGE	2.65	2.71		2.29	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.17		
PULL #2	3.37	3.28		
PULL #3	3.31	3.22		
PULL #4	3.28	3.20		
PULL #5	3.49	3.15		
TOTAL	16.85	16.02		
AVERAGE	3.37	3.20		

	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	4.18	4.12		4.35
PULL #2	4.02	4.12		4.36
PULL #3	4.22	4.13		4.22
PULL #4	4.26	4.09		4.30
PULL #5	4.11	4.08		4.16
TOTAL	20.79	20.54		21.39
AVERAGE	4.15	4.10		4.27

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360990.__1
FILE DATE AND TIME: 02/09/2005 07:37

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.092
The Average Y Centroid of the Five Target Set:	0.048
The Average Point of Impact of the Five Target Set:	0.104
The Average Mean Radius of the Five Target Set:	0.900
The Distance from POA to Centroid Target #1:	0.289
The Distance from Centroid Target #2 to Centroid Target #1:	0.286
The Distance from Centroid Target #3 to Centroid Target #1:	0.381
The Distance from Centroid Target #4 to Centroid Target #1:	0.196
The Distance from Centroid Target #5 to Centroid Target #1:	0.195

SERIAL NUMBER: G6360990. 1

TARGET NUMBER: 1

FILE DATE: 02/09/2005

FILE TIME: 07:37

POINT#	X	Y
1:	0.847	-1.010
2:	0.238	-1.098
3:	-0.558	-0.792
4:	1.531	0.017
5:	1.143	0.235
6:	-0.091	0.667
7:	-0.513	1.067
8:	-0.475	1.972
9:	-1.125	0.455
10:	-2.894	0.666

X CENTROID: -0.190

Y CENTROID: 0.218

POA TO CENTROID: 0.289

HORZ SPREAD: 4.425

VERT SPREAD: 3.070

GROUP SPREAD: 4.472

MIN RADIUS: 0.460

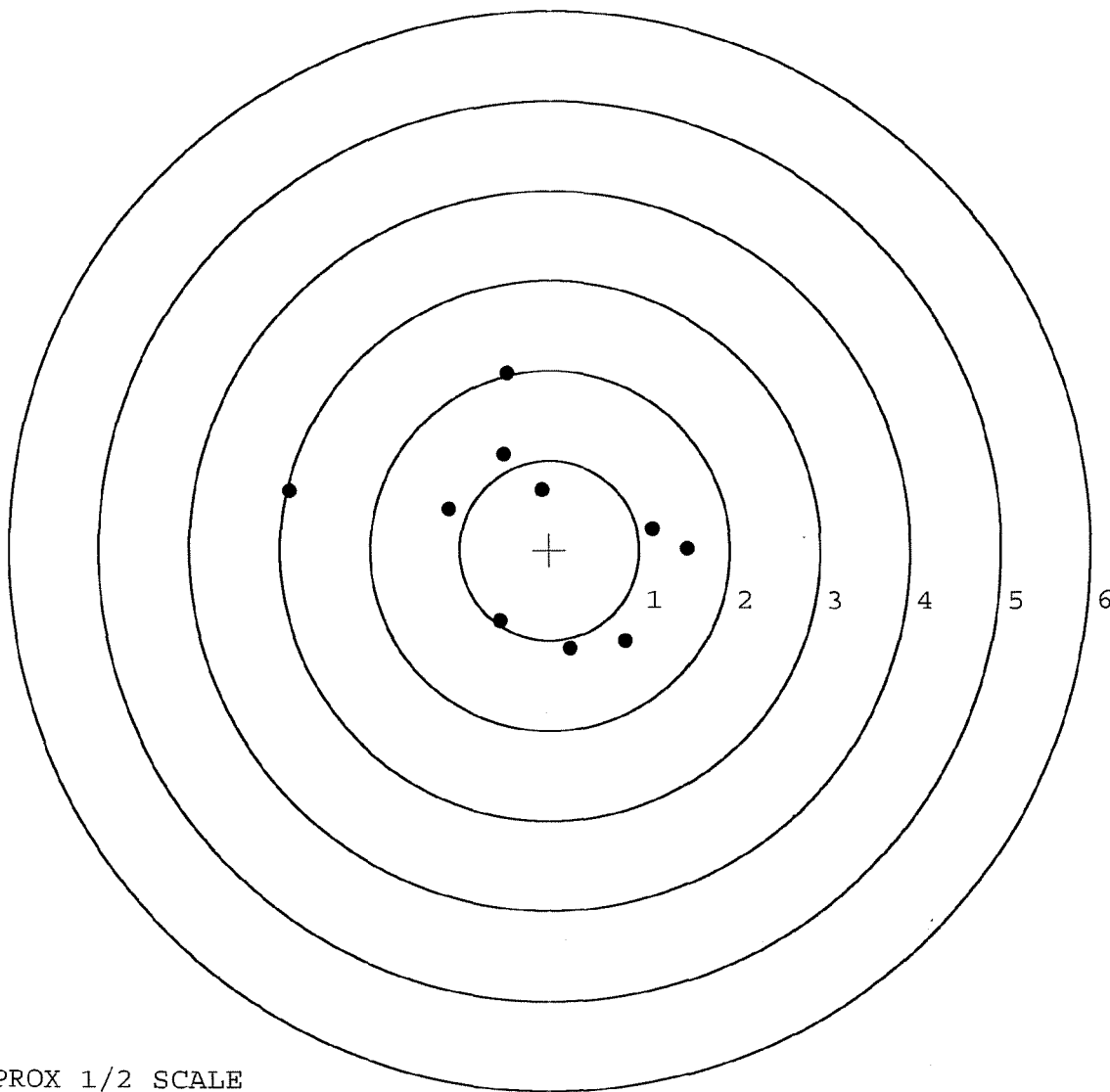
MAX RADIUS: 2.741

MEAN RADIUS: 1.398

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360990. __1

TARGET NUMBER: 2

FILE DATE: 02/09/2005

FILE TIME: 07:37

POINT#	X	Y
1:	0.144	-1.441
2:	1.149	-0.631
3:	0.741	0.442
4:	0.527	0.314
5:	0.105	0.645
6:	-0.015	0.320
7:	0.011	-0.105
8:	-0.597	0.392
9:	-0.875	-0.063
10:	-1.565	-0.121

X CENTROID: -0.038

Y CENTROID: -0.025

POA TO CENTROID: 0.045

HORZ SPREAD: 2.714

VERT SPREAD: 2.086

GROUP SPREAD: 2.762

MIN RADIUS: 0.094

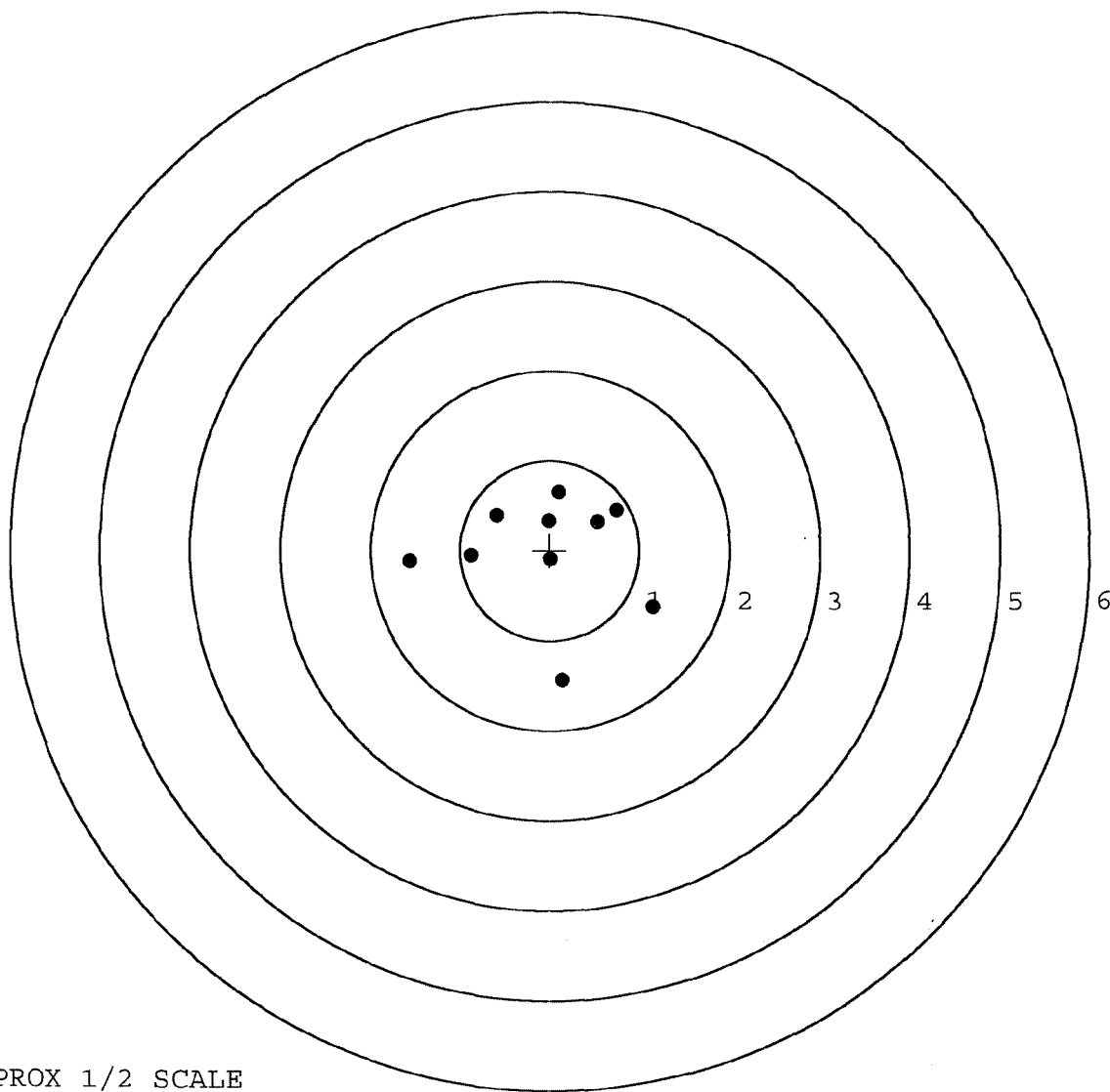
MAX RADIUS: 1.531

MEAN RADIUS: 0.852

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360990. __1

TARGET NUMBER: 3

FILE DATE: 02/09/2005

FILE TIME: 07:37

POINT#	X	Y
1:	1.146	-0.932
2:	0.043	-1.001
3:	0.831	0.548
4:	0.062	0.199
5:	-0.025	-0.363
6:	-0.246	-0.291
7:	-0.912	-0.433
8:	-0.273	0.918
9:	-0.693	0.569
10:	0.120	-0.304

X CENTROID: 0.005

Y CENTROID: -0.109

POA TO CENTROID: 0.109

HORZ SPREAD: 2.058

VERT SPREAD: 1.919

GROUP SPREAD: 2.374

MIN RADIUS: 0.226

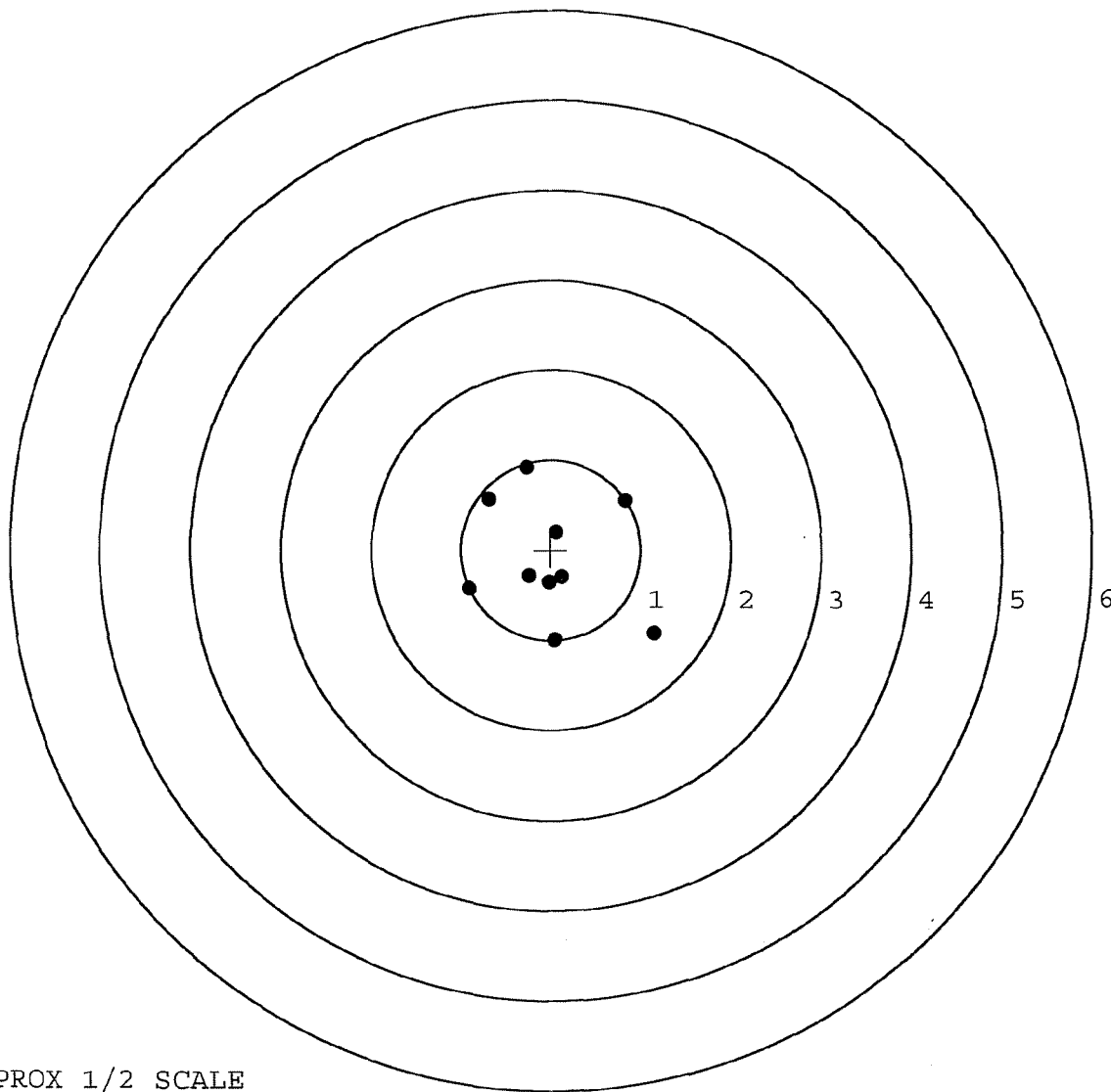
MAX RADIUS: 1.407

MEAN RADIUS: 0.747

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360990. __1

TARGET NUMBER: 4

FILE DATE: 02/09/2005

FILE TIME: 07:37

POINT#	X	Y
1:	0.474	-0.971
2:	0.007	-0.540
3:	-0.314	-1.084
4:	0.072	-0.093
5:	-0.104	-0.117
6:	0.837	0.941
7:	0.108	0.753
8:	-0.116	1.017
9:	-0.388	0.756
10:	-0.706	0.658

X CENTROID: -0.013

Y CENTROID: 0.132

POA TO CENTROID: 0.133

HORZ SPREAD: 1.543

VERT SPREAD: 2.101

GROUP SPREAD: 2.329

MIN RADIUS: 0.241

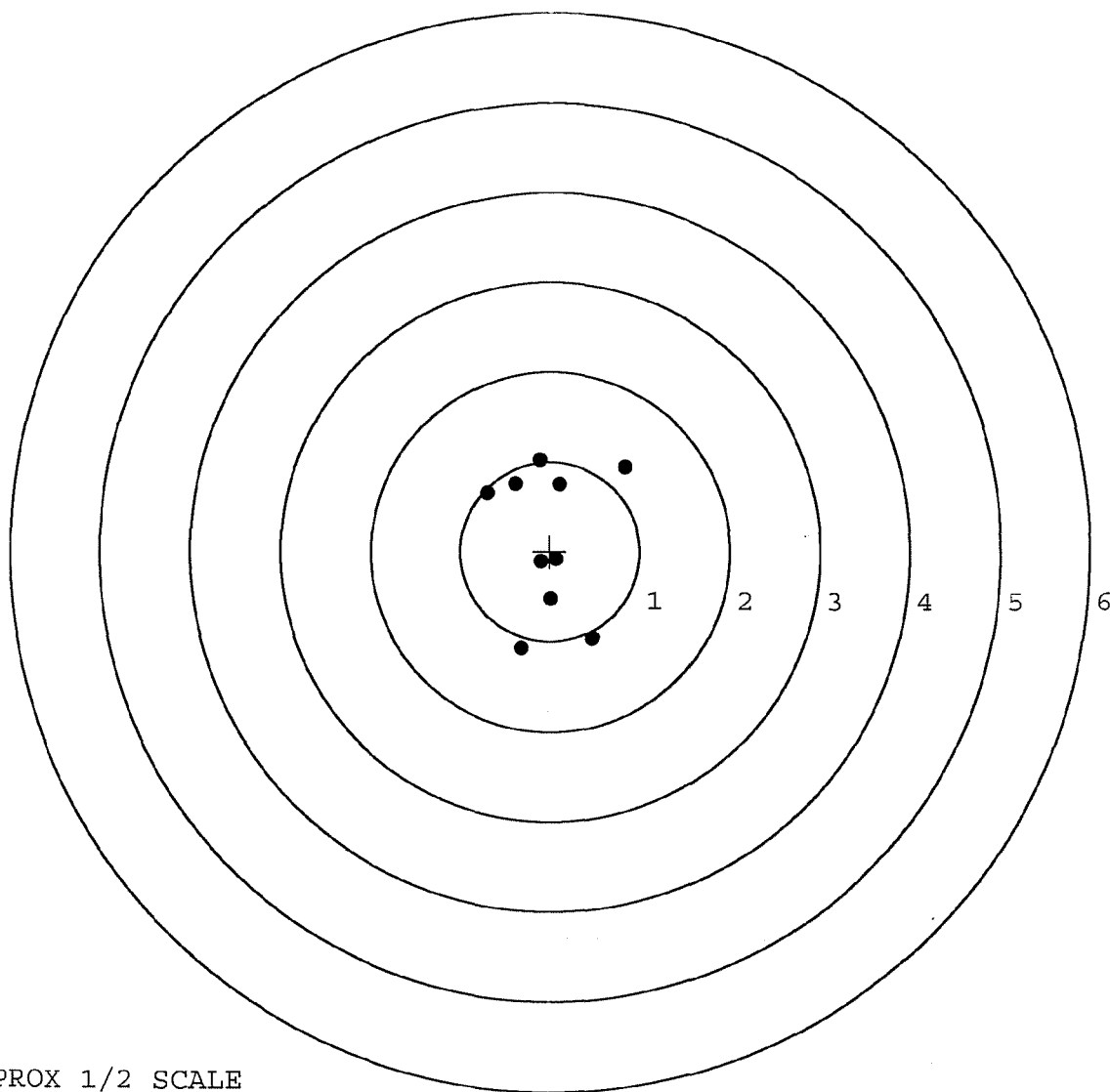
MAX RADIUS: 1.253

MEAN RADIUS: 0.793

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360990. __1

TARGET NUMBER: 5

FILE DATE: 02/09/2005

FILE TIME: 07:37

X CENTROID: -0.223

Y CENTROID: 0.025

POA TO CENTROID: 0.224

HORZ SPREAD: 2.627

VERT SPREAD: 1.404

GROUP SPREAD: 2.765

MIN RADIUS: 0.060

MAX RADIUS: 1.708

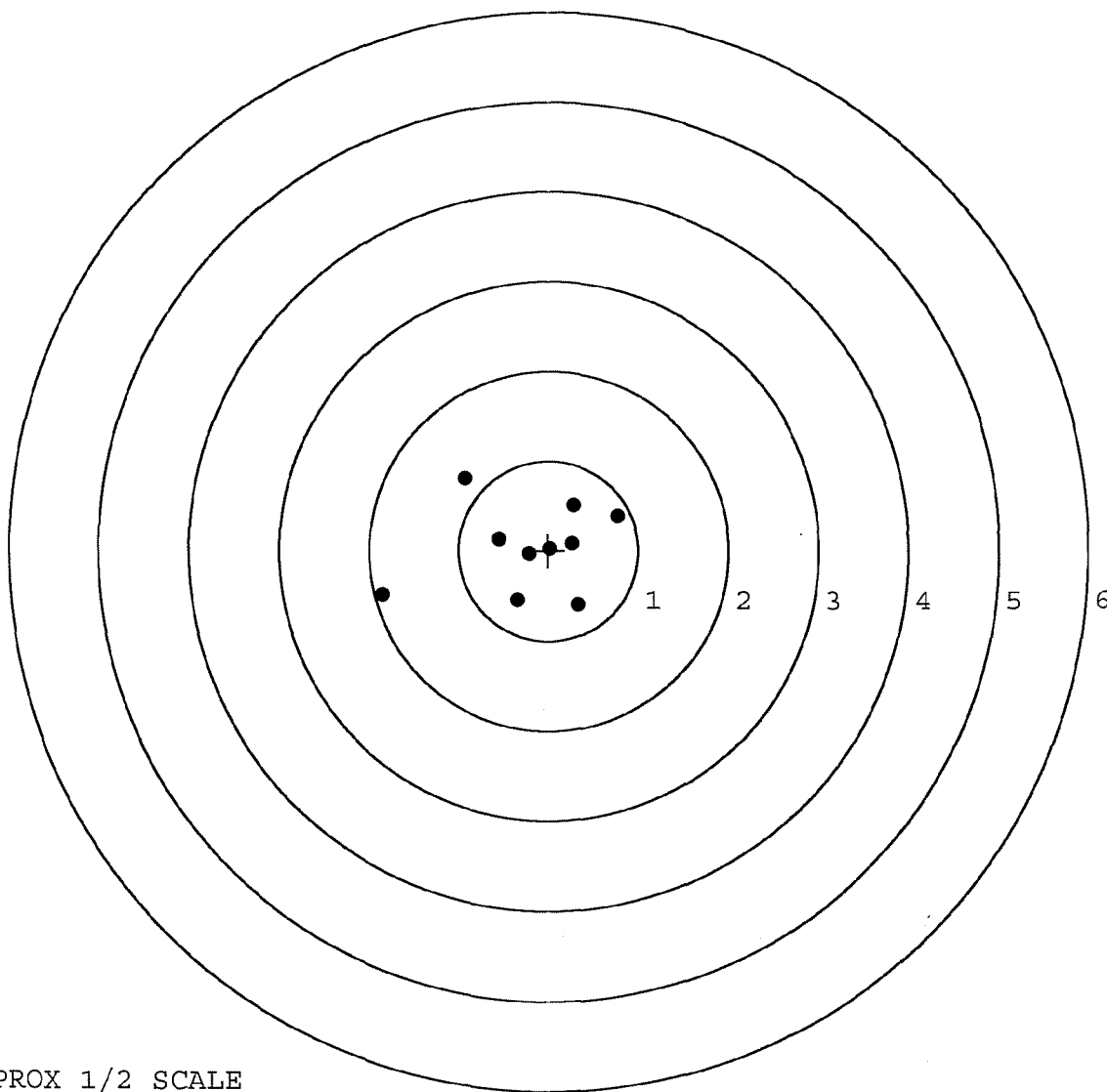
MEAN RADIUS: 0.708

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.773	0.382
2:	0.332	-0.603
3:	0.269	0.079
4:	0.286	0.506
5:	0.014	0.025
6:	-0.215	-0.034
7:	-0.350	-0.549
8:	-0.553	0.127
9:	-1.854	-0.481
10:	-0.932	0.801



TARGET APPROX 1/2 SCALE