

G653 4977

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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SERIAL NO.

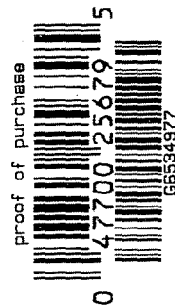


66534977

**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

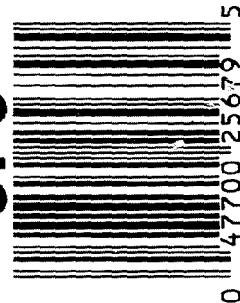
DD FORM 96253



ORDER NO.	25679
BARREL LENGTH	24"
CAPACITY	6

G6534977

UPC



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 653 4977

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		2-27-06	RTZ
440	PROOF		2/27/06	MPD
460	CHECK HEADSPACE	MAGNA-FLUX	2/27/06	MPD
470	DIS-ASSEMBLE ACTION	INSPECTED	2-28-06	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OP # 480 MAR 6 1 2006 OPERATOR CPD	3-1-06	APD
500	ROLLMARK CALIBER		3-1-06	CW
510	DRILL AND TAP SIGHT HOLES		2-28-06	TRL
520	GOFF BLAST BBL / REC		3-2-06	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		3/10	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3/20/06	MPD
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3/20/06	MPD
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3/20/06	MPD
	D) OIL FIRING PIN ASSEMBLY		3-21-06	A
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		4-20-06	mm

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>7lbs</u> <u>7lbs</u> <u>7lbs</u>	4-20-06	mm
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3lbs</u> <u>3lbs</u> <u>3lbs</u>	4-20-06	mm
	H) TRIGGER PULL TEST AND RETAINABILITY		4-20-06	mm
	I) FIRING PIN INDENT .020 MIN	<u>.032</u> <u>.032</u> <u>.022</u>	4-20-06	mm
	J) ASSEMBLE STOCK		3-21-06	Ac
	K) ASSEMBLE SWIVEL STUDS		4-20-06	L.P.D.
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-21-06	Ac
	M) IRON SIGHT ALIGNMENT		3-21-06	Ac
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-21-06	Ac
640 &	FUNCTION TEST AND	<u>PASS</u> FAIL		
650	TARGET	<u>PASS</u> FAIL	4-6-06	mm
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		4-06-06	L.P.D.
670	FINAL INSPECTION A) HEADSPACE		4-20-06	mm
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.25</u> <u>2.65</u> <u>2.65</u> <u>2.63</u> <u>2.63</u>	4-18-06	Ac
	C) FUNCTION		4-20-06	mm
690	PACK		4-24-06	RA

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 3-21-06

TESTER R.P

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.50	2.61		2.52	
PULL #2	2.57	2.52		2.53	
PULL #3	2.57	2.52		2.48	
PULL #4	2.59	2.52		2.43	
PULL #5	2.57	2.44		2.43	
TOTAL	12.80	12.61		12.39	
AVERAGE	2.56	2.52		2.47	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.09	3.08		
PULL #2	3.00	3.21		
PULL #3	3.01	3.06		
PULL #4	3.04	3.24		
PULL #5	2.90	3.18		
TOTAL	15.04	15.77		
AVERAGE	3.00	3.15		

	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	4.26	4.15		4.19
PULL #2	4.22	4.20		4.25
PULL #3	4.25	4.17		4.01
PULL #4	4.25	4.13		4.02
PULL #5	4.12	4.29		4.00
TOTAL	21.10	20.94		20.47
AVERAGE	4.22	4.18		4.09

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6534977.___0
FILE DATE AND TIME: 04/06/2006 17:03

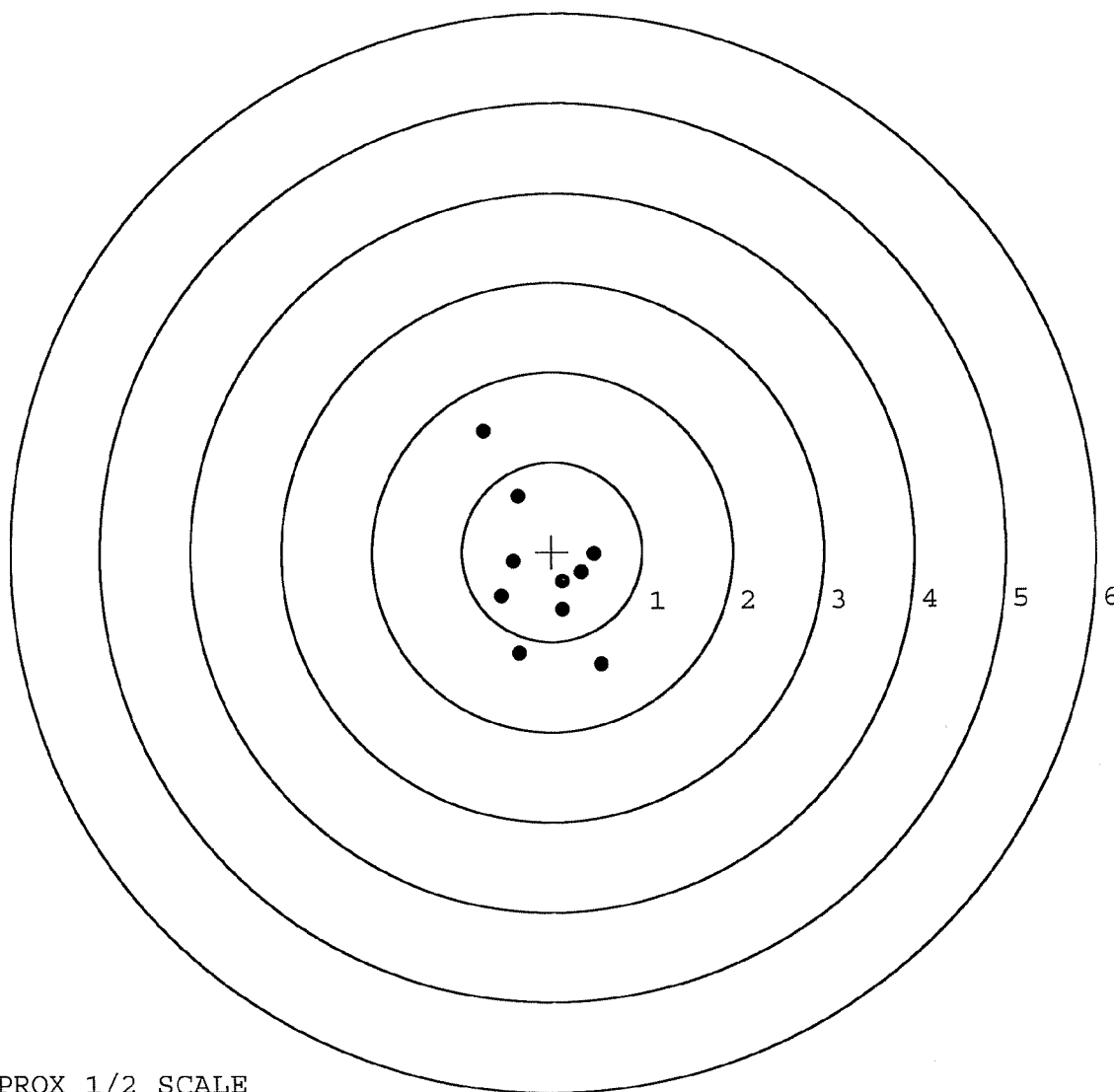
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.196
The Average Y Centroid of the Five Target Set:	0.063
The Average Point of Impact of the Five Target Set:	0.206
The Average Mean Radius of the Five Target Set:	0.741
The Distance from POA to Centroid Target #1:	0.246
The Distance from Centroid Target #2 to Centroid Target #1:	0.417
The Distance from Centroid Target #3 to Centroid Target #1:	0.139
The Distance from Centroid Target #4 to Centroid Target #1:	0.614
The Distance from Centroid Target #5 to Centroid Target #1:	0.502

SERIAL NUMBER: G6534977. __0
TARGET NUMBER: 1
FILE DATE: 04/06/2006
FILE TIME: 17:03

X CENTROID: -0.093
Y CENTROID: -0.228
POA TO CENTROID: 0.246
HORZ SPREAD: 1.302
VERT SPREAD: 2.613
GROUP SPREAD: 2.919
MIN RADIUS: 0.234
MAX RADIUS: 1.713
MEAN RADIUS: 0.740
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.542	-1.263
2:	-0.368	-1.136
3:	-0.561	-0.495
4:	-0.432	-0.107
5:	0.115	-0.653
6:	0.114	-0.337
7:	0.469	-0.030
8:	-0.379	0.625
9:	-0.760	1.350
10:	0.328	-0.235

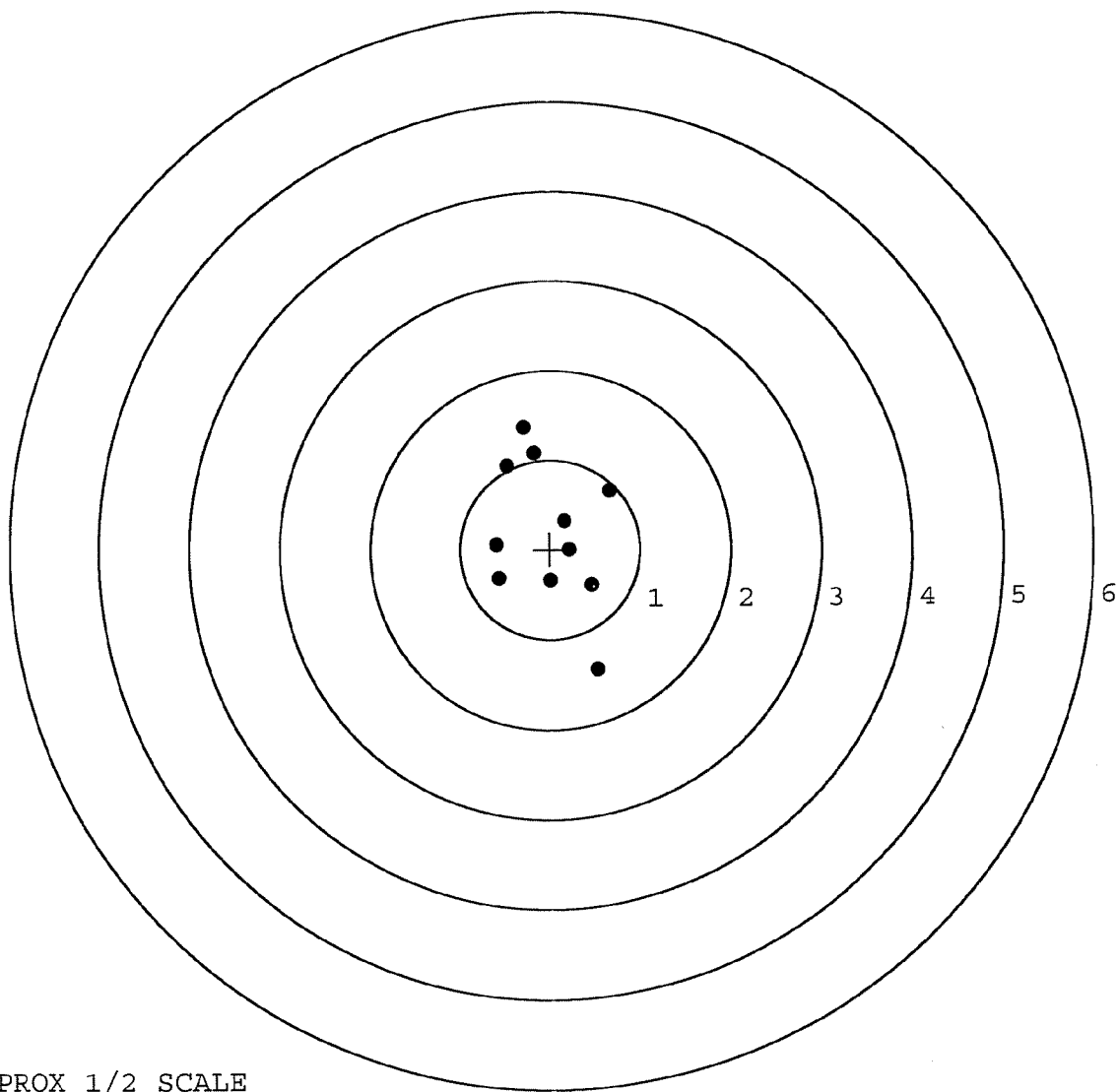


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6534977. __0
TARGET NUMBER: 2
FILE DATE: 04/06/2006
FILE TIME: 17:03

X CENTROID: -0.006
Y CENTROID: 0.180
POA TO CENTROID: 0.180
HORZ SPREAD: 1.260
VERT SPREAD: 2.696
GROUP SPREAD: 2.815
MIN RADIUS: 0.218
MAX RADIUS: 1.605
MEAN RADIUS: 0.781
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.163	0.317
2:	0.521	-1.336
3:	0.462	-0.405
4:	0.003	-0.347
5:	0.218	-0.007
6:	0.664	0.650
7:	-0.596	0.056
8:	-0.568	-0.326
9:	-0.474	0.937
10:	-0.174	1.079
11:	-0.289	1.360

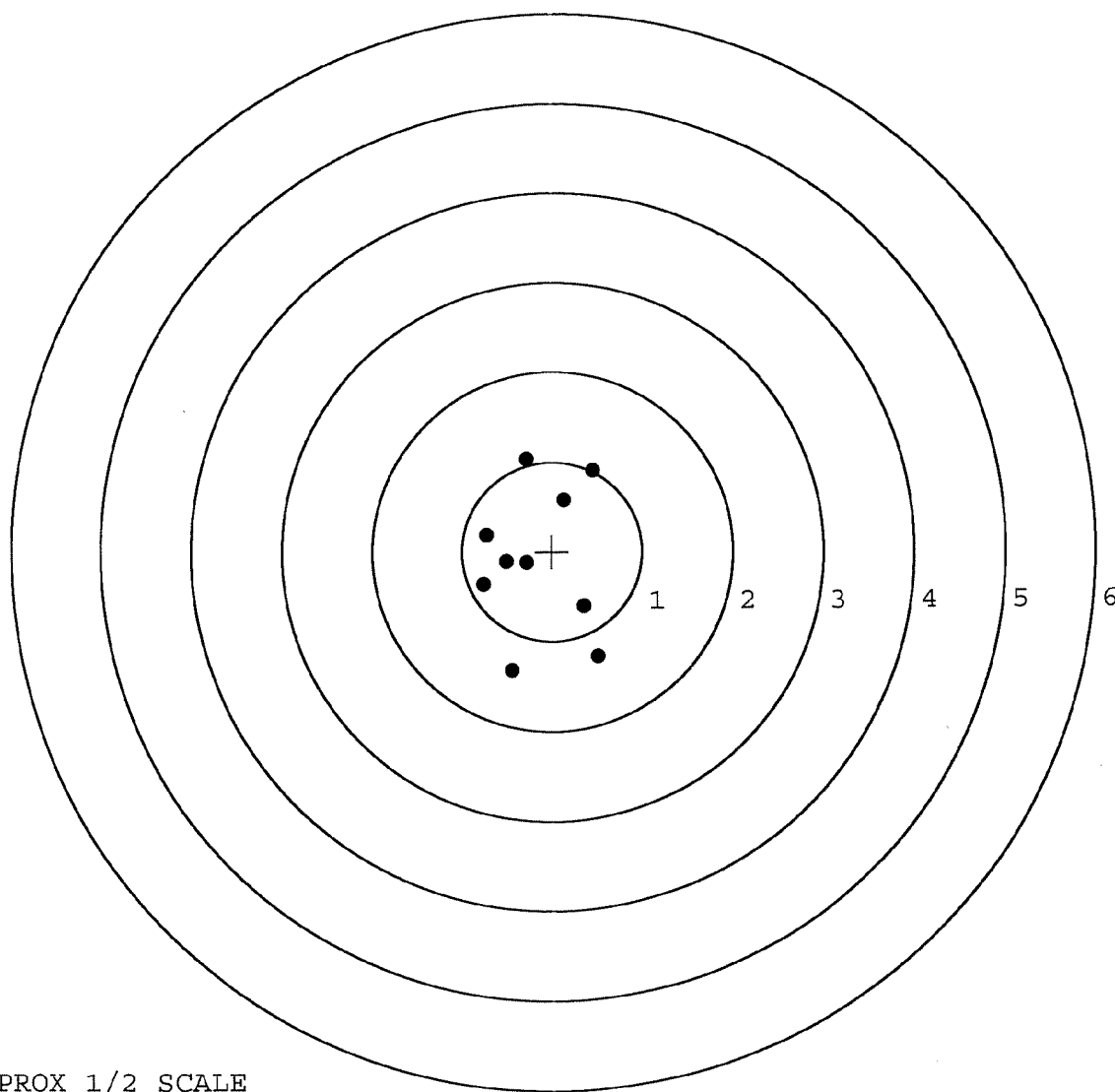


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6534977. __0
TARGET NUMBER: 3
FILE DATE: 04/06/2006
FILE TIME: 17:03

X CENTROID: -0.157
Y CENTROID: -0.104
POA TO CENTROID: 0.188
HORZ SPREAD: 1.267
VERT SPREAD: 2.360
GROUP SPREAD: 2.345
MIN RADIUS: 0.131
MAX RADIUS: 1.262
MEAN RADIUS: 0.810
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.507	-1.177
2:	0.355	-0.617
3:	-0.451	-1.329
4:	-0.285	-0.131
5:	-0.760	-0.372
6:	-0.732	0.192
7:	0.134	0.574
8:	0.455	0.905
9:	-0.283	1.031
10:	-0.508	-0.116

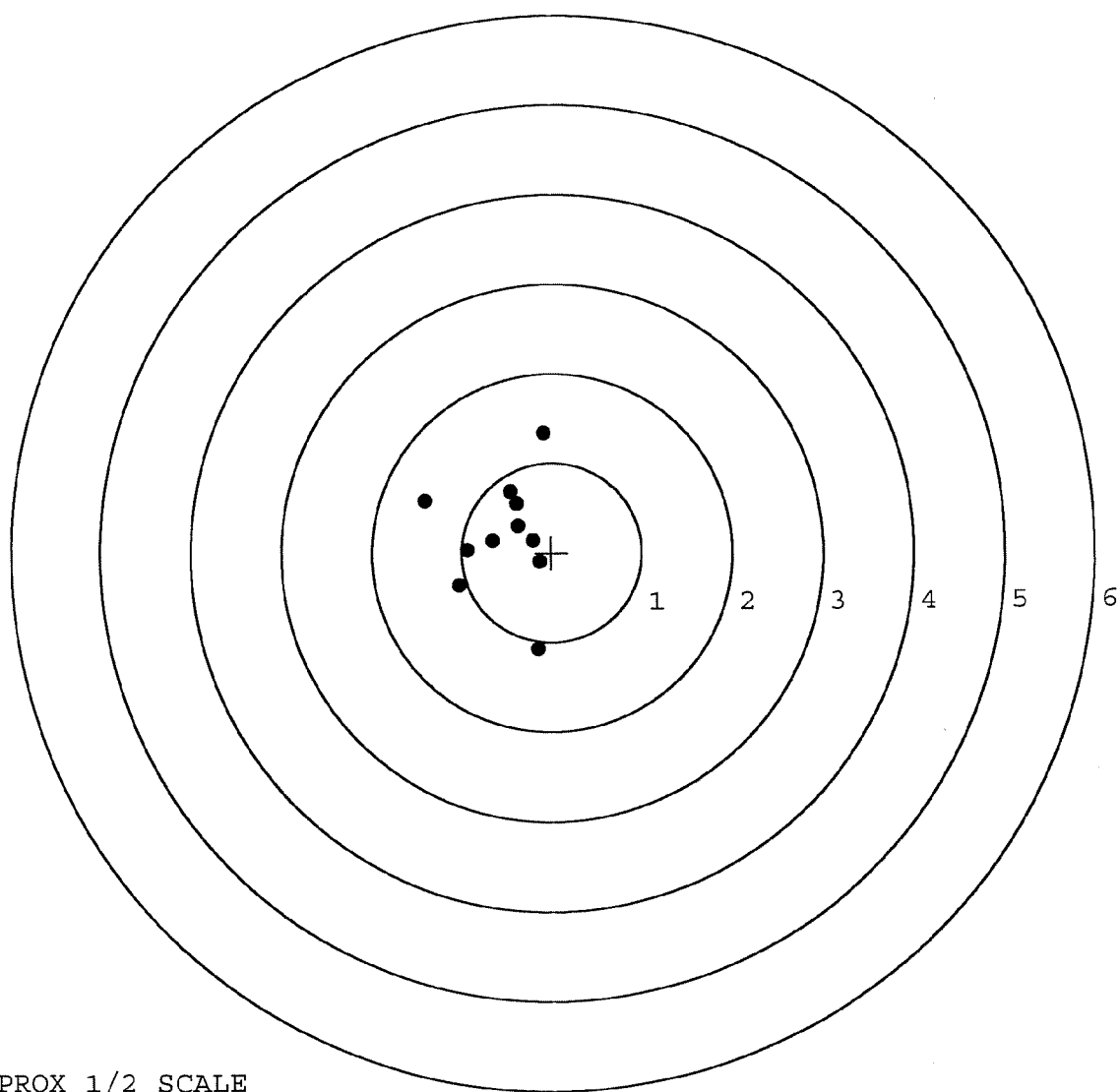


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6534977. __0
TARGET NUMBER: 4
FILE DATE: 04/06/2006
FILE TIME: 17:03

X CENTROID: -0.531
Y CENTROID: 0.202
POA TO CENTROID: 0.568
HORZ SPREAD: 1.413
VERT SPREAD: 2.410
GROUP SPREAD: 2.411
MIN RADIUS: 0.139
MAX RADIUS: 1.336
MEAN RADIUS: 0.610
IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 11

POINT#	X	Y
1:	-0.655	0.137
2:	-0.088	1.330
3:	-0.455	0.683
4:	-1.413	0.588
5:	-0.935	0.036
6:	-1.029	-0.364
7:	-0.155	-1.080
8:	-0.135	-0.105
9:	-0.210	0.138
10:	-0.380	0.303
11:	-0.391	0.551



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6534977. __ 0

TARGET NUMBER: 5

FILE DATE: 04/06/2006

FILE TIME: 17:03

X CENTROID: -0.194

Y CENTROID: 0.264

POA TO CENTROID: 0.327

HORZ SPREAD: 2.232

VERT SPREAD: 2.000

GROUP SPREAD: 2.948

MIN RADIUS: 0.172

MAX RADIUS: 1.756

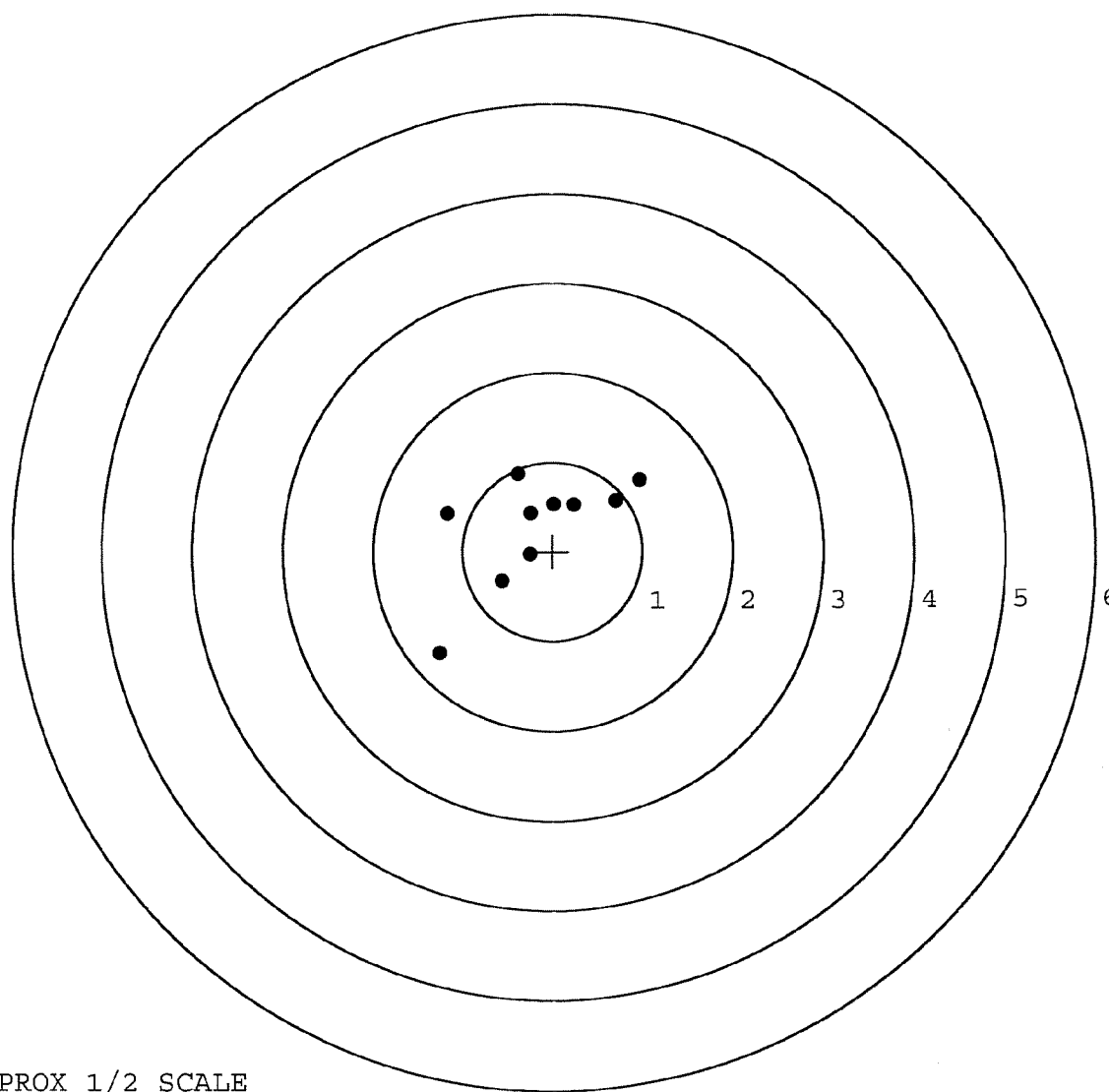
MEAN RADIUS: 0.763

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-1.172	0.434
2:	-0.383	0.868
3:	-0.246	0.427
4:	0.245	0.521
5:	0.703	0.565
6:	0.972	0.794
7:	-0.252	-0.039
8:	-0.560	-0.331
9:	-1.260	-1.132
10:	0.014	0.529



TARGET APPROX 1/2 SCALE