

G652 1290

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.

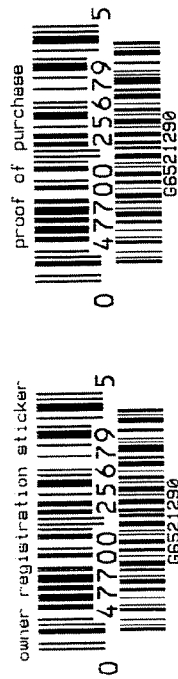


66521296

**M/24 7.62 NATO S.W.S.
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO
COMPLETE SYSTEM - LE/EXPORT**

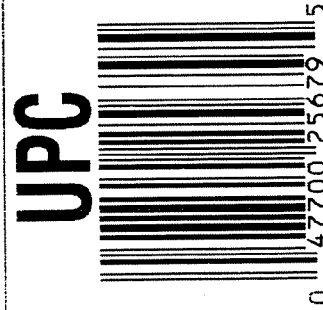
98606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB

46 FORM 96253



ORDER NO.	25679
BARREL LENGTH	24"
CAPACITY	6

G6521290



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6521290

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		10-3-05	RTZ
440	PROOF		10-3-05	RTZ
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	10-3-05	RTZ
470	DIS-ASSEMBLE ACTION		10-4-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	2750 OPERATE RE und	10/7/05	und
500	ROLLMARK CALIBER		10-7-05	CW
510	DRILL AND TAP SIGHT HOLES		10-6-05	TRW
520	GOFF BLAST BBL / REC		10/10/05	und
530 & 540	APPLY COATINGS (BARREL ACTION)		10/14/05	RB
	(BOLT)		10/14/05	RB
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-17-05	RA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-17-05	RA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-17-05	RA
	D) OIL FIRING PIN ASSEMBLY		10-24-05	RE
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE	2.50 LBS +/- .5 LBS		
REV-8405				

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6 lb</u> <u>6 lb</u> <u>6 lb</u>	10-31-05	BC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lb</u> <u>3 lb</u> <u>3 lb</u>	10-31-05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.025</u> <u>.025</u>	10-31-05	BC
	J) ASSEMBLE STOCK		10-24-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-31-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-31-05	BC
	M) IRON SIGHT ALIGNMENT		10-31-05	BC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-31-05	BC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10-25-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10-25-05	JK
670	FINAL INSPECTION A) HEADSPACE		10-31-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.91</u> <u>2.53</u> <u>2.41</u> <u>2.65</u> <u>2.82</u>	10-28-05	BC
	C) FUNCTION		10-31-05	BC
690	PACK		11-1-05	RA

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 10-24-05

TESTER R.P.

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.62	2.34		2.37	
PULL #2	2.51	2.43		2.54	
PULL #3	2.70	2.39		2.41	
PULL #4	2.69	2.39		2.42	
PULL #5	2.66	2.54		2.37	
TOTAL	13.18	12.09		12.11	
AVERAGE	2.63	2.41		2.42	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.07		
PULL #2	3.05	3.04		
PULL #3	3.21	3.04		
PULL #4	3.10	3.06		
PULL #5	3.04	2.98		
TOTAL	15.60	15.19		
AVERAGE	3.12	3.03		

	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	4.08	3.96		4.01
PULL #2	3.96	3.96		4.15
PULL #3	3.93	4.09		4.07
PULL #4	4.01	3.97		3.98
PULL #5	4.02	4.15		4.14
TOTAL	20.00	20.13		20.35
AVERAGE	4.00	4.02		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6521290.__0
FILE DATE AND TIME: 10/25/2005 09:44

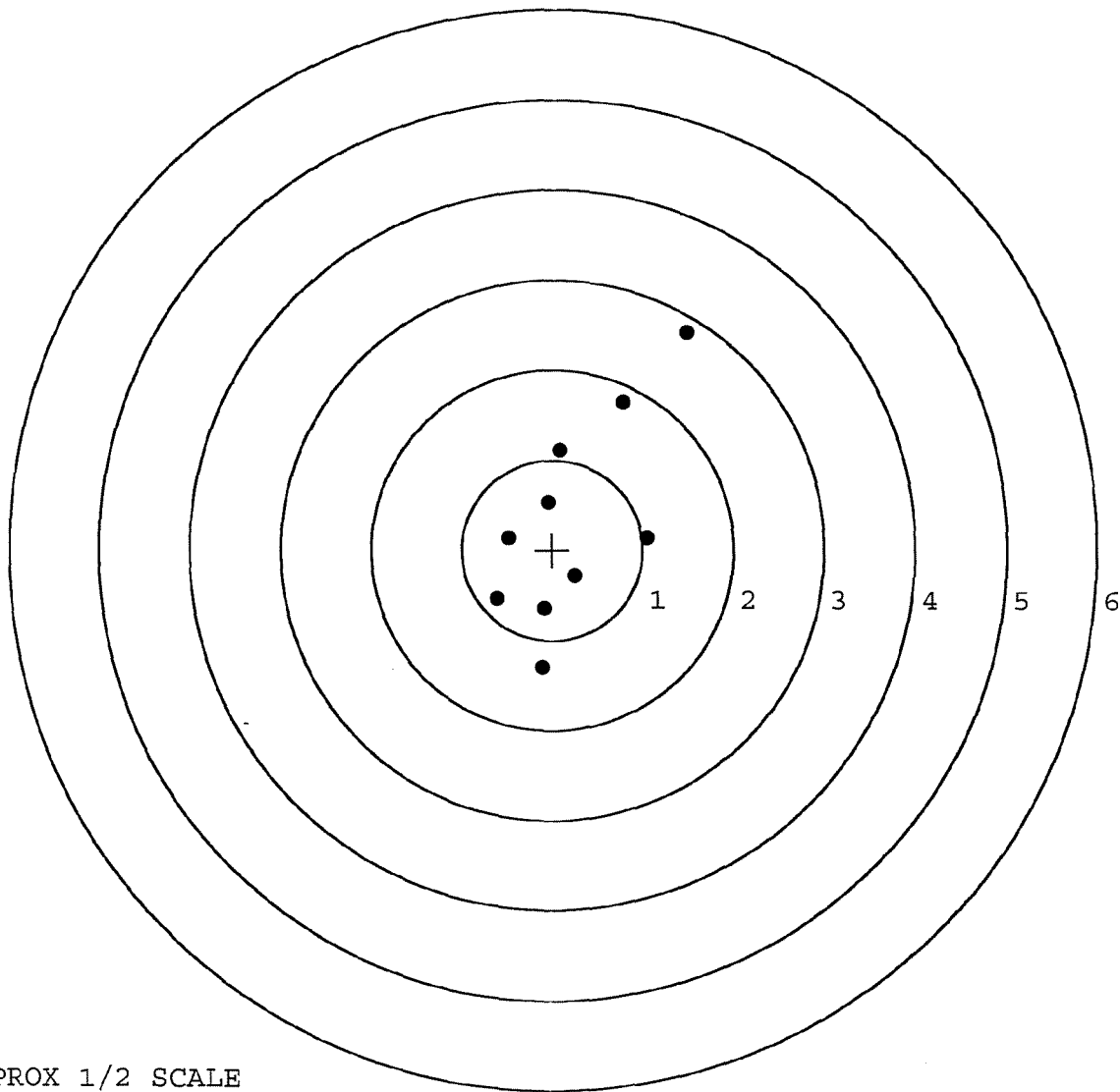
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.094
The Average Y Centroid of the Five Target Set:	-0.024
The Average Point of Impact of the Five Target Set:	0.097
The Average Mean Radius of the Five Target Set:	0.884
The Distance from POA to Centroid Target #1:	0.392
The Distance from Centroid Target #2 to Centroid Target #1:	0.435
The Distance from Centroid Target #3 to Centroid Target #1:	0.545
The Distance from Centroid Target #4 to Centroid Target #1:	0.434
The Distance from Centroid Target #5 to Centroid Target #1:	0.546

SERIAL NUMBER: G6521290. __0
TARGET NUMBER: 1
FILE DATE: 10/25/2005
FILE TIME: 09:44

X CENTROID: 0.230
Y CENTROID: 0.318
POA TO CENTROID: 0.392
HORZ SPREAD: 2.081
VERT SPREAD: 3.721
GROUP SPREAD: 4.041
MIN RADIUS: 0.351
MAX RADIUS: 2.441
MEAN RADIUS: 1.108
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	-0.106	-1.301
2:	-0.088	-0.648
3:	0.256	-0.287
4:	-0.610	-0.546
5:	1.052	0.137
6:	-0.052	0.527
7:	0.084	1.109
8:	0.774	1.639
9:	1.471	2.420
10:	-0.482	0.127



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521290. __0

TARGET NUMBER: 2

FILE DATE: 10/25/2005

FILE TIME: 09:44

POINT#	X	Y
1:	1.048	-0.786
2:	0.475	-0.712
3:	0.524	-0.383
4:	-0.561	-0.779
5:	-0.011	-0.056
6:	-0.174	0.428
7:	-0.422	0.309
8:	-0.907	0.581
9:	-0.759	1.577
10:	-0.195	0.141

X CENTROID: -0.098

Y CENTROID: 0.032

POA TO CENTROID: 0.103

HORZ SPREAD: 1.955

VERT SPREAD: 2.363

GROUP SPREAD: 2.975

MIN RADIUS: 0.124

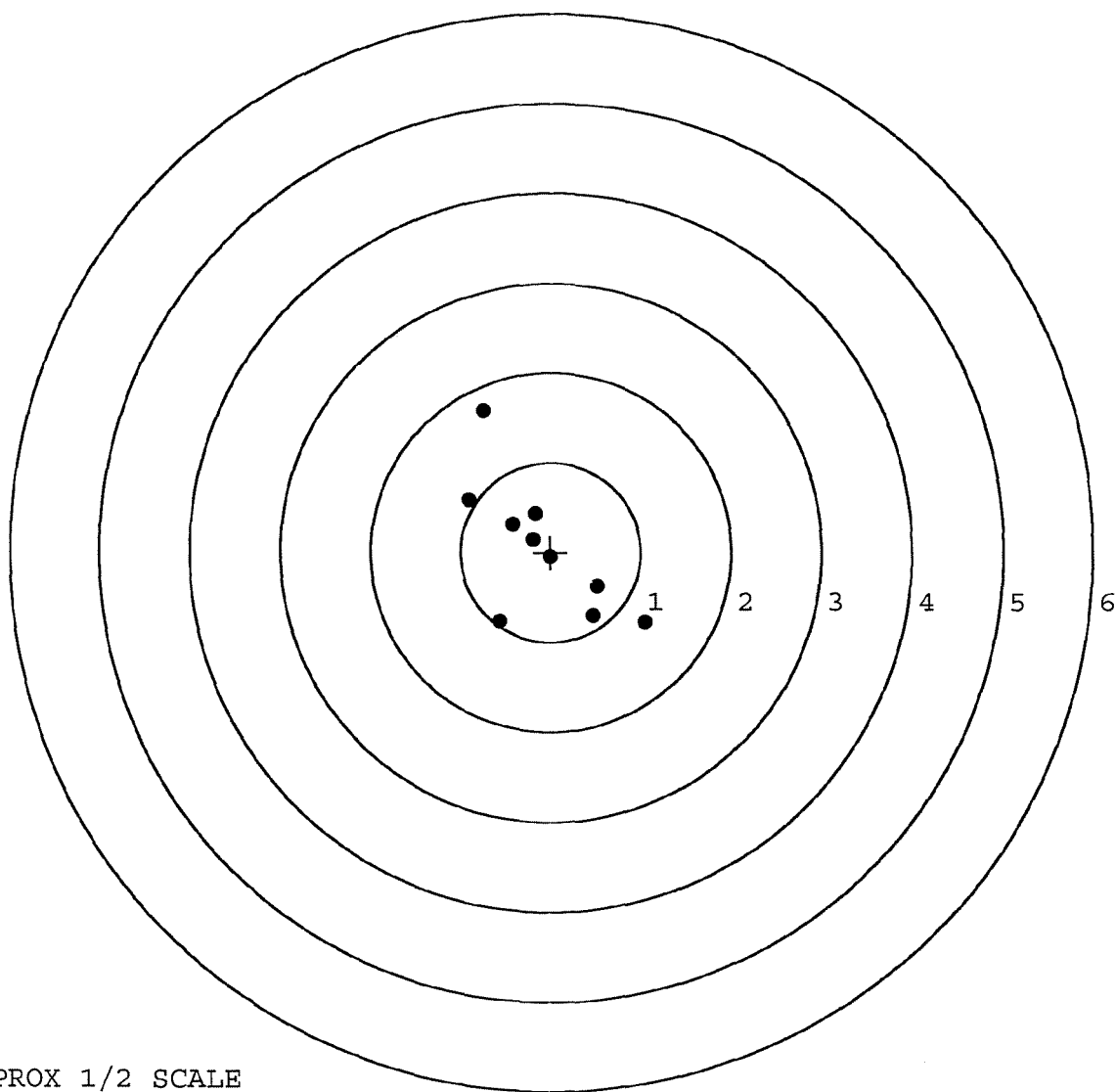
MAX RADIUS: 1.680

MEAN RADIUS: 0.779

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9

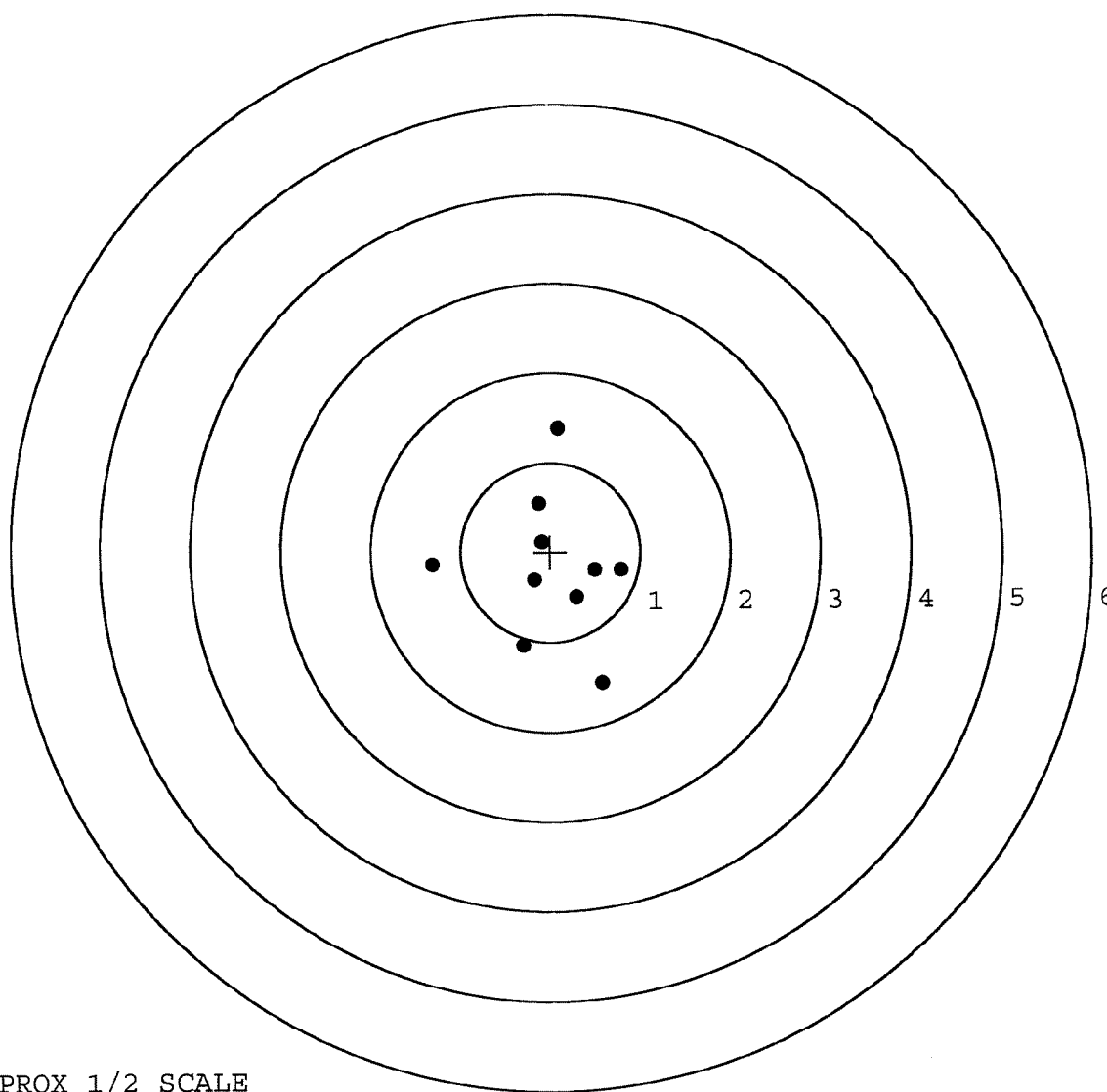


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521290. __0
TARGET NUMBER: 3
FILE DATE: 10/25/2005
FILE TIME: 09:44

POINT#	X	Y
1:	0.568	-1.463
2:	-0.312	-1.041
3:	-1.319	-0.134
4:	-0.184	-0.317
5:	-0.098	0.107
6:	-0.129	0.543
7:	0.094	1.383
8:	0.786	-0.213
9:	0.495	-0.211
10:	0.288	-0.507

X CENTROID: 0.019
Y CENTROID: -0.185
POA TO CENTROID: 0.186
HORZ SPREAD: 2.105
VERT SPREAD: 2.846
GROUP SPREAD: 2.885
MIN RADIUS: 0.242
MAX RADIUS: 1.570
MEAN RADIUS: 0.818
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

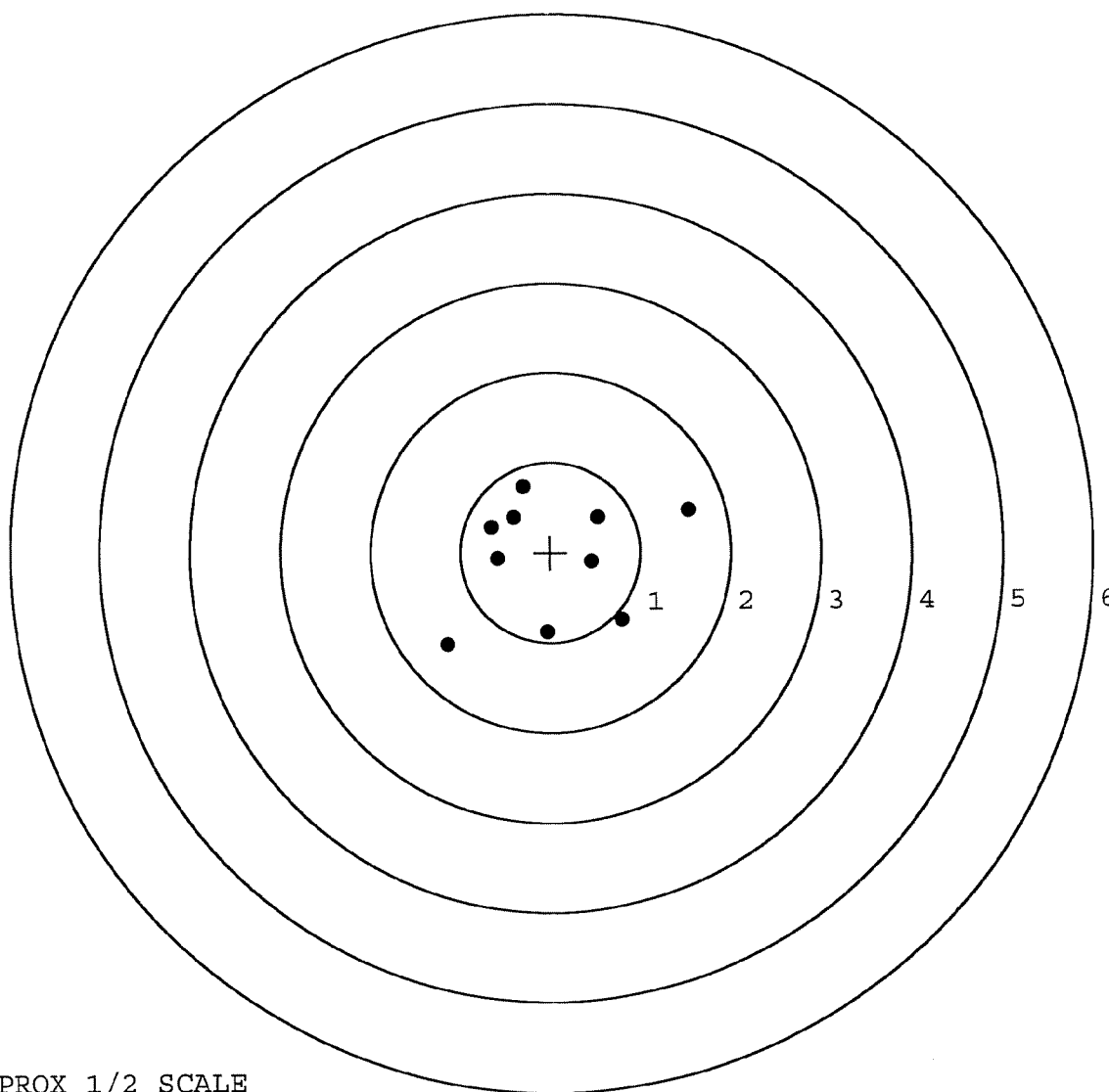


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521290. 0
TARGET NUMBER: 4
FILE DATE: 10/25/2005
FILE TIME: 09:44

POINT#	X	Y
1:	0.790	-0.759
2:	-0.045	-0.893
3:	-1.153	-1.022
4:	1.527	0.464
5:	0.533	0.393
6:	0.454	-0.105
7:	-0.306	0.730
8:	-0.407	0.391
9:	-0.655	0.286
10:	-0.590	-0.073

X CENTROID: 0.015
Y CENTROID: -0.059
POA TO CENTROID: 0.061
HORZ SPREAD: 2.680
VERT SPREAD: 1.752
GROUP SPREAD: 3.064
MIN RADIUS: 0.442
MAX RADIUS: 1.600
MEAN RADIUS: 0.895
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6521290. __0

TARGET NUMBER: 5

FILE DATE: 10/25/2005

FILE TIME: 09:44

POINT#	X	Y
1:	1.548	-0.647
2:	1.403	-0.669
3:	0.011	-1.130
4:	0.607	-0.358
5:	-0.144	-0.556
6:	-0.718	-0.359
7:	0.254	-0.019
8:	-0.275	0.147
9:	-0.111	0.609
10:	0.452	0.750

X CENTROID: 0.303

Y CENTROID: -0.223

POA TO CENTROID: 0.376

HORZ SPREAD: 2.266

VERT SPREAD: 1.880

GROUP SPREAD: 2.284

MIN RADIUS: 0.210

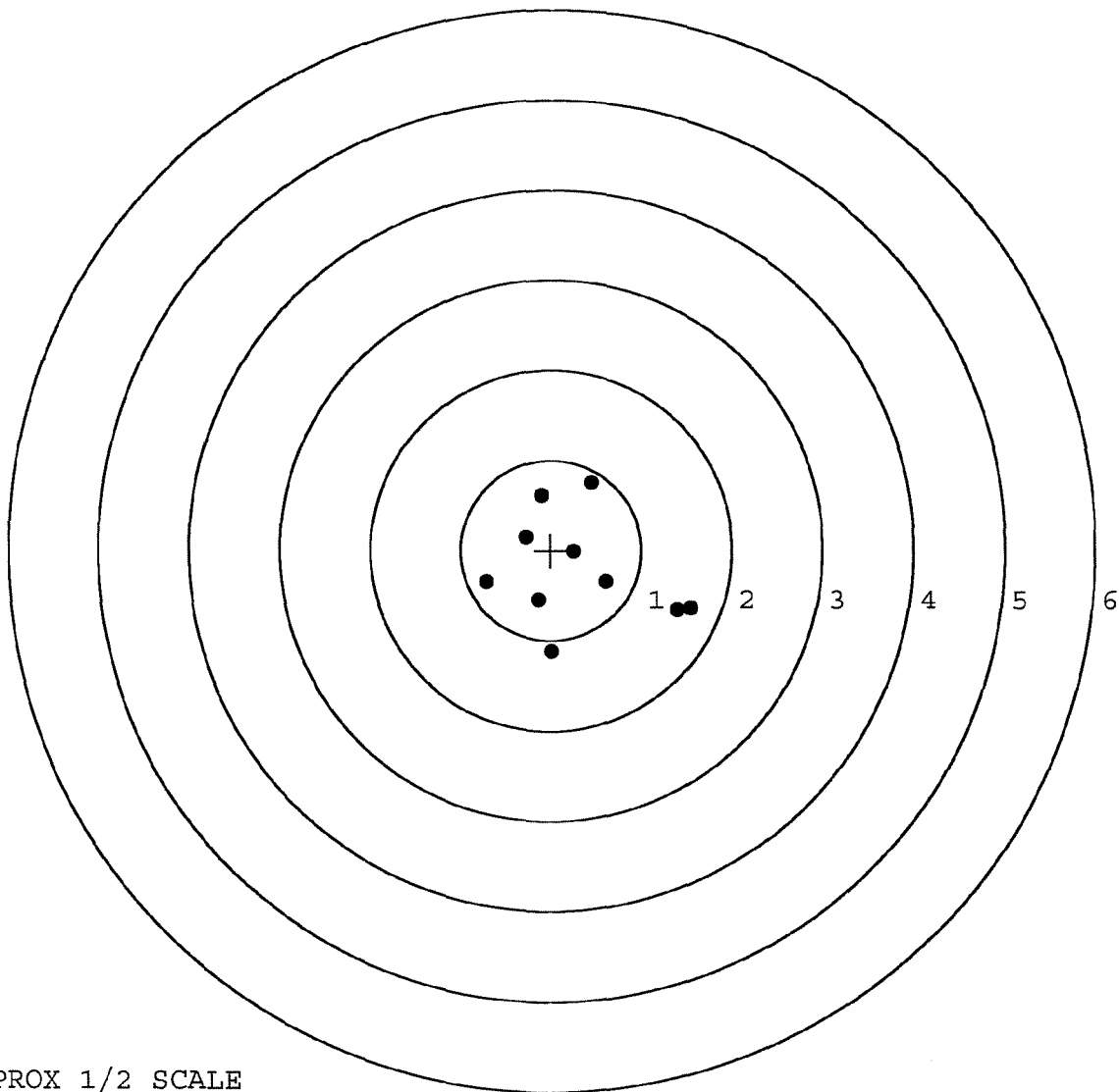
MAX RADIUS: 1.315

MEAN RADIUS: 0.818

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE