

G6410218

**ORDER 25679**

M/24 7.62 NATO S.W.S.

**UPC**



**ORDER 25679**

M/24 7.62 NATO S.W.S.

**UPC**



SERIAL NO.



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

93606 - M-24 OPERATORS MANUAL  
96229 - SWS SLING STRAP ASSEMBLY  
96117 - TRS BI POD ASSB

**DD FORM 96253**



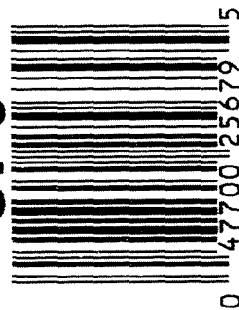
**ORDER NO. 25679**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6410218**

**UPC**



3/11/2005 9:25:01 AM

Chib

61

Original

**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

Goff Blast Barrel & Rec Assembly,

78ROT01



**0003770797**

0540

Flat Black Powder Coat, Barrel and

01PC001



**0003770799**

0560

Reassemble Action.

89SWS1



**0003770800**

0690

Pack Rifle & Stencil SWS Container

89SWS1



**.OP0690**

**M-24**  
**INSPECTION CHECKLIST-NEW GUNS**

GUN SERIAL # G6410218

| OP #      | OPERATION NAME                                                                                                                         | READINGS                   | DATE    | INITIAL |
|-----------|----------------------------------------------------------------------------------------------------------------------------------------|----------------------------|---------|---------|
| 575 & 580 | ASSEMBLE ACTION AND STOCK                                                                                                              |                            | 1-3-05  | RTL     |
| 600       | PROOF                                                                                                                                  |                            | 1-4-05  | RL      |
| 607       | CHECK HEADSPACE                                                                                                                        | MAGNA - FLUX               | 1-4-05  | RL      |
| 610       | DIS-ASSEMBLE GUN                                                                                                                       | INSPECTED                  | 1-4-05  | RTL     |
| 612       | MAGNAFLUX BBL ACTION<br>MAGNAFLUX BOLT                                                                                                 | JAN 04 2005<br>OPERATOR BS |         |         |
| 615       | ROLLMARK CALIBER                                                                                                                       |                            | 1-5-05  | CW      |
| 617       | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |                            | 1-4-05  | TRLW    |
| 620       | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |                            | 1-4-05  | HP      |
|           | (BOLT)                                                                                                                                 |                            |         |         |
| 625       | FINAL ASSEMBLY                                                                                                                         |                            |         |         |
|           | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |                            | 1-78-05 | DA      |
|           | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |                            | 1-18-05 | DA      |
|           | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |                            |         |         |
|           | D) OIL FIRING PIN ASSEMBLY                                                                                                             |                            | 2-1-05  | RT      |
|           | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE <span style="border: 1px solid black; padding: 2px;">2.50 LBS +/- .5 LBS</span> |                            | 3-21-05 | TRLW    |

| OP #  | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|-------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 625   | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>6 lbs</u> <u>6 lbs</u> <u>6 lbs</u>                      | 3-21-05 | AC      |
| CONT. | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>                      | 3-21-05 | AC      |
|       | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|       | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.026</u> <u>.026</u> <u>.026</u>                         | 3-21-05 | AC      |
|       | J) ASSEMBLE STOCK                                                        |                                                             | 2-1-05  | RTL     |
|       | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 3-21-05 | AC      |
|       | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 |                                                             | 2-1-05  | RTL     |
|       | M) IRON SIGHT<br>ALIGNMENT                                               |                                                             | 2-1-05  | RTL     |
|       | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                             | 2-1-05  | RTL     |
| 640   | GALLERY TEST AND<br>TARGET                                               | <span>PASS</span> FAIL                                      | 2-4-05  | TRL     |
|       | MALFUNCTION <u>BAC</u>                                                   | CORRECTION                                                  | 2-16-05 | TRL     |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 645   | INSPECT FOR LIVE AMMO                                                    |                                                             | 2-4-05  | TRL     |
| 655   | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 3-21-05 | AC      |
|       | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.56</u> <u>2.77</u> <u>2.62</u> <u>2.46</u> <u>2.64</u> | 3-21-05 | TRL     |
|       | C) FUNCTION                                                              |                                                             | 3-21-05 | AC      |
| 660   | PACK                                                                     |                                                             | 3/24/05 | 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)

SERIAL NO. \_\_\_\_\_

DATE 1-19-05

TESTER TRW

|         | 2.50 LBS<br>INITIAL | 2.50 LBS AFTER<br>50 CYCLES | FINAL TEST & TO RESET<br>2.50 LBS |       | COMMENTS |
|---------|---------------------|-----------------------------|-----------------------------------|-------|----------|
| PULL #1 | 2.13                | 2.25                        |                                   | 2.08  |          |
| PULL #2 | 2.22                | 2.05                        |                                   | 2.20  |          |
| PULL #3 | 2.56                | 2.45                        |                                   | 2.27  |          |
| PULL #4 | 2.59                | 2.25                        |                                   | 2.46  |          |
| PULL #5 | 2.52                | 2.24                        |                                   | 2.23  |          |
| TOTAL   | 12.02               | 11.24                       |                                   | 11.24 |          |
| AVERAGE | 2.40                | 2.24                        |                                   | 2.24  |          |

|         | 3.00 LBS<br>INITIAL | 3.00 LBS AFTER<br>20 CYCLES |  | COMMENTS |
|---------|---------------------|-----------------------------|--|----------|
| PULL #1 | 3.36                | 3.11                        |  |          |
| PULL #2 | 3.33                | 3.26                        |  |          |
| PULL #3 | 3.28                | 3.21                        |  |          |
| PULL #4 | 3.27                | 3.11                        |  |          |
| PULL #5 | 3.27                | 3.19                        |  |          |
| TOTAL   | 16.51               | 15.88                       |  |          |
| AVERAGE | 3.30                | 3.17                        |  |          |

|         | 4.00 LBS<br>INITIAL | 4.00 LBS AFTER<br>20 CYCLES | MAX SETTING GREATER<br>THAN 4 LBS | RESET TO 4 LBS FOR<br>TARGET & ACCURACY |
|---------|---------------------|-----------------------------|-----------------------------------|-----------------------------------------|
| PULL #1 | 4.34                | 4.15                        |                                   | 4.50                                    |
| PULL #2 | 4.32                | 4.14                        |                                   | 4.45                                    |
| PULL #3 | 4.35                | 4.09                        |                                   | 4.31                                    |
| PULL #4 | 4.32                | 3.86                        |                                   | 4.43                                    |
| PULL #5 | 4.15                | 4.15                        |                                   | 4.36                                    |
| TOTAL   | 21.48               | 20.39                       |                                   | 22.05                                   |
| AVERAGE | 4.29                | 4.07                        |                                   | 4.41                                    |

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410218.\_\_\_0  
FILE DATE AND TIME: 02/04/2005 07:43

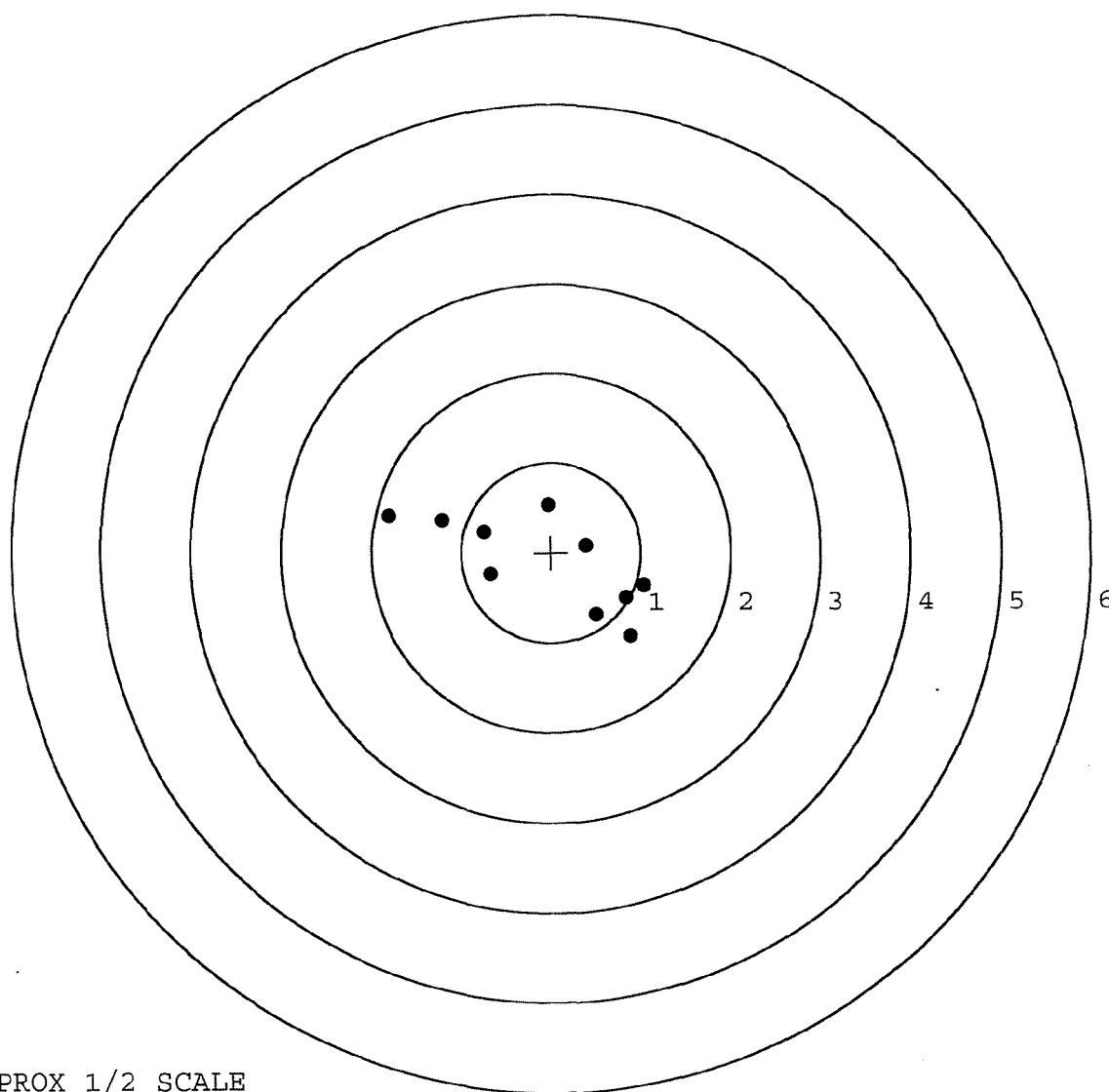
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | -0.140 |
| The Average Y Centroid of the Five Target Set:              | -0.063 |
| The Average Point of Impact of the Five Target Set:         | 0.154  |
| The Average Mean Radius of the Five Target Set:             | 0.838  |
| The Distance from POA to Centroid Target #1:                | 0.139  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.092  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.126  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.155  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.328  |

SERIAL NUMBER: G6410218.\_\_\_0  
TARGET NUMBER: 1  
FILE DATE: 02/04/2005  
FILE TIME: 07:43

X CENTROID: -0.085  
Y CENTROID: -0.110  
POA TO CENTROID: 0.139  
HORZ SPREAD: 2.838  
VERT SPREAD: 1.458  
GROUP SPREAD: 3.004  
MIN RADIUS: 0.517  
MAX RADIUS: 1.801  
MEAN RADIUS: 0.976  
# IN 1 IN DIAMETER: 0  
# IN 2 IN DIAMETER: 6  
# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.878  | -0.930 |
| 2:     | 0.500  | -0.688 |
| 3:     | 0.831  | -0.506 |
| 4:     | 1.030  | -0.367 |
| 5:     | 0.393  | 0.085  |
| 6:     | -0.038 | 0.528  |
| 7:     | -0.744 | 0.234  |
| 8:     | -0.676 | -0.236 |
| 9:     | -1.218 | 0.362  |
| 10:    | -1.808 | 0.415  |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410218. \_\_0

TARGET NUMBER: 2

FILE DATE: 02/04/2005

FILE TIME: 07:43

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.558  | 0.182  |
| 2:     | 0.558  | -0.010 |
| 3:     | -0.700 | -0.438 |
| 4:     | -0.610 | -0.359 |
| 5:     | -0.752 | -0.202 |
| 6:     | -0.965 | -0.260 |
| 7:     | -0.028 | -0.041 |
| 8:     | -0.185 | 0.046  |
| 9:     | -0.208 | 0.252  |
| 10:    | -0.183 | 0.362  |

X CENTROID: -0.152

Y CENTROID: -0.047

POA TO CENTROID: 0.159

HORZ SPREAD: 2.523

VERT SPREAD: 0.800

GROUP SPREAD: 2.561

MIN RADIUS: 0.099

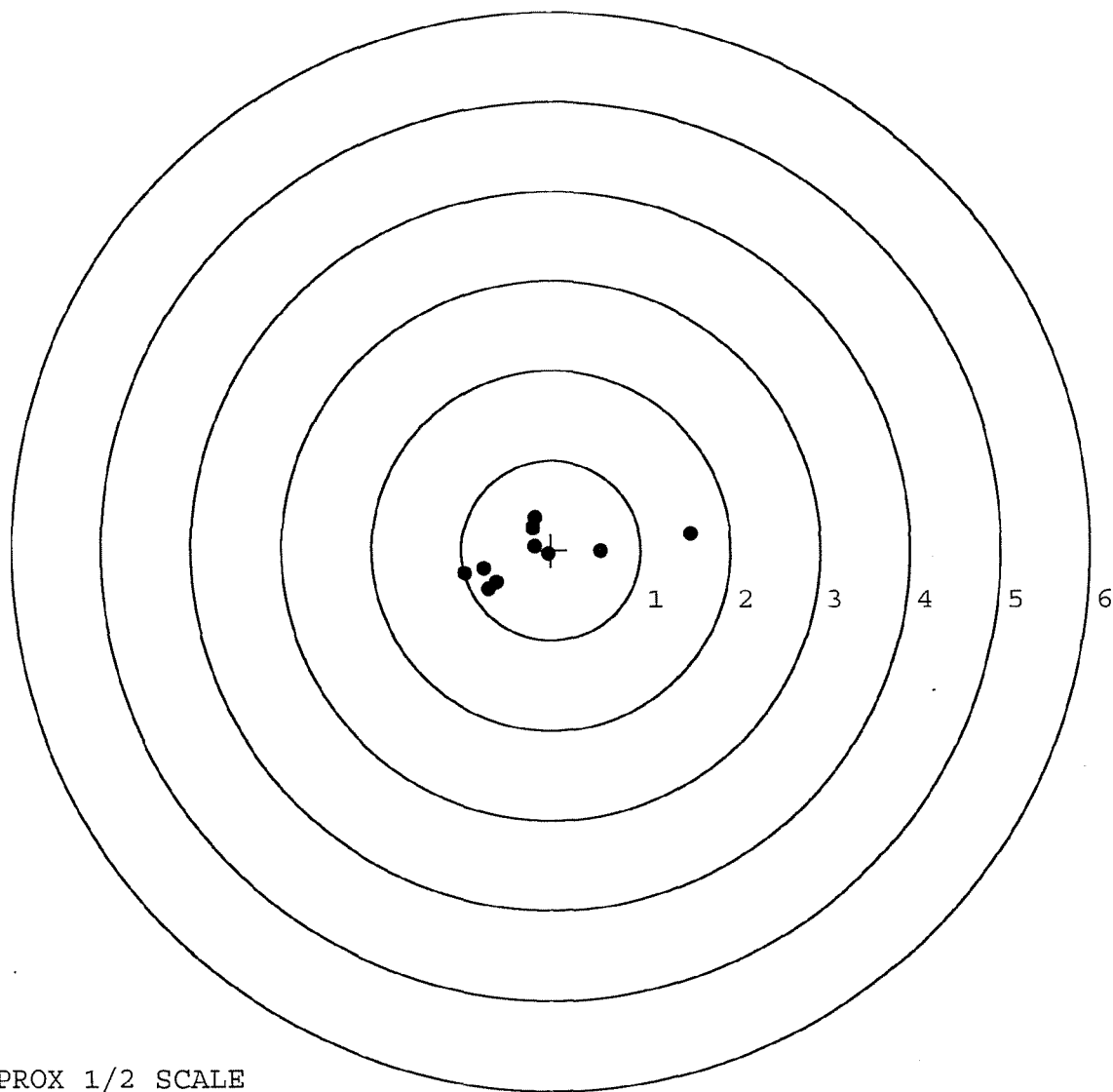
MAX RADIUS: 1.725

MEAN RADIUS: 0.606

# IN 1 IN DIAMETER: 4

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 9

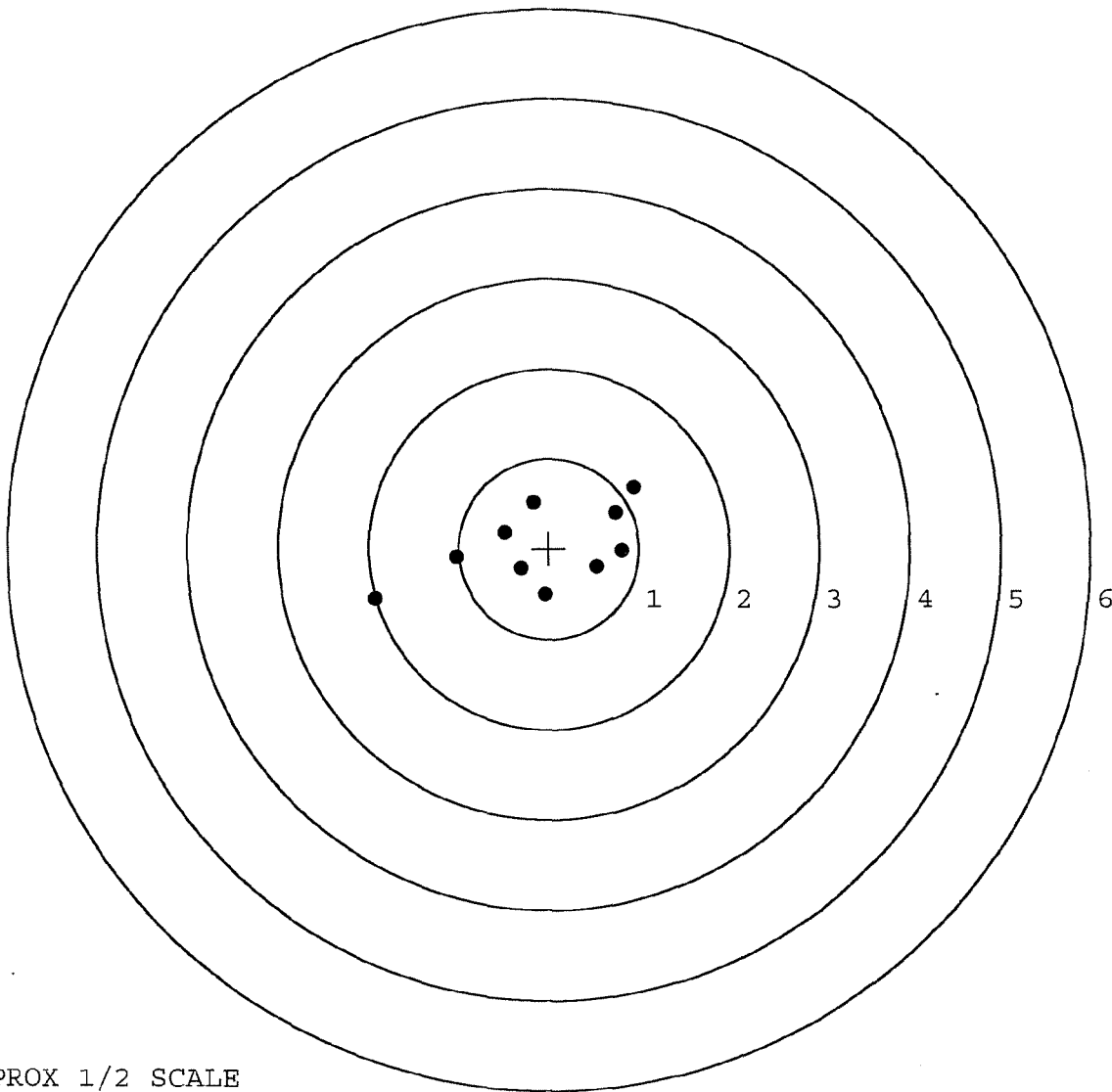


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410218. \_\_0  
TARGET NUMBER: 3  
FILE DATE: 02/04/2005  
FILE TIME: 07:43

X CENTROID: -0.095  
Y CENTROID: 0.015  
POA TO CENTROID: 0.096  
HORZ SPREAD: 2.870  
VERT SPREAD: 1.251  
GROUP SPREAD: 3.131  
MIN RADIUS: 0.321  
MAX RADIUS: 1.921  
MEAN RADIUS: 0.836  
# IN 1 IN DIAMETER: 2  
# IN 2 IN DIAMETER: 8  
# in 3 IN DIAMETER: 9

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.943  | 0.686  |
| 2:     | 0.735  | 0.403  |
| 3:     | 0.812  | -0.022 |
| 4:     | 0.531  | -0.201 |
| 5:     | -0.048 | -0.508 |
| 6:     | -0.309 | -0.225 |
| 7:     | -0.491 | 0.174  |
| 8:     | -0.174 | 0.510  |
| 9:     | -1.025 | -0.101 |
| 10:    | -1.927 | -0.565 |

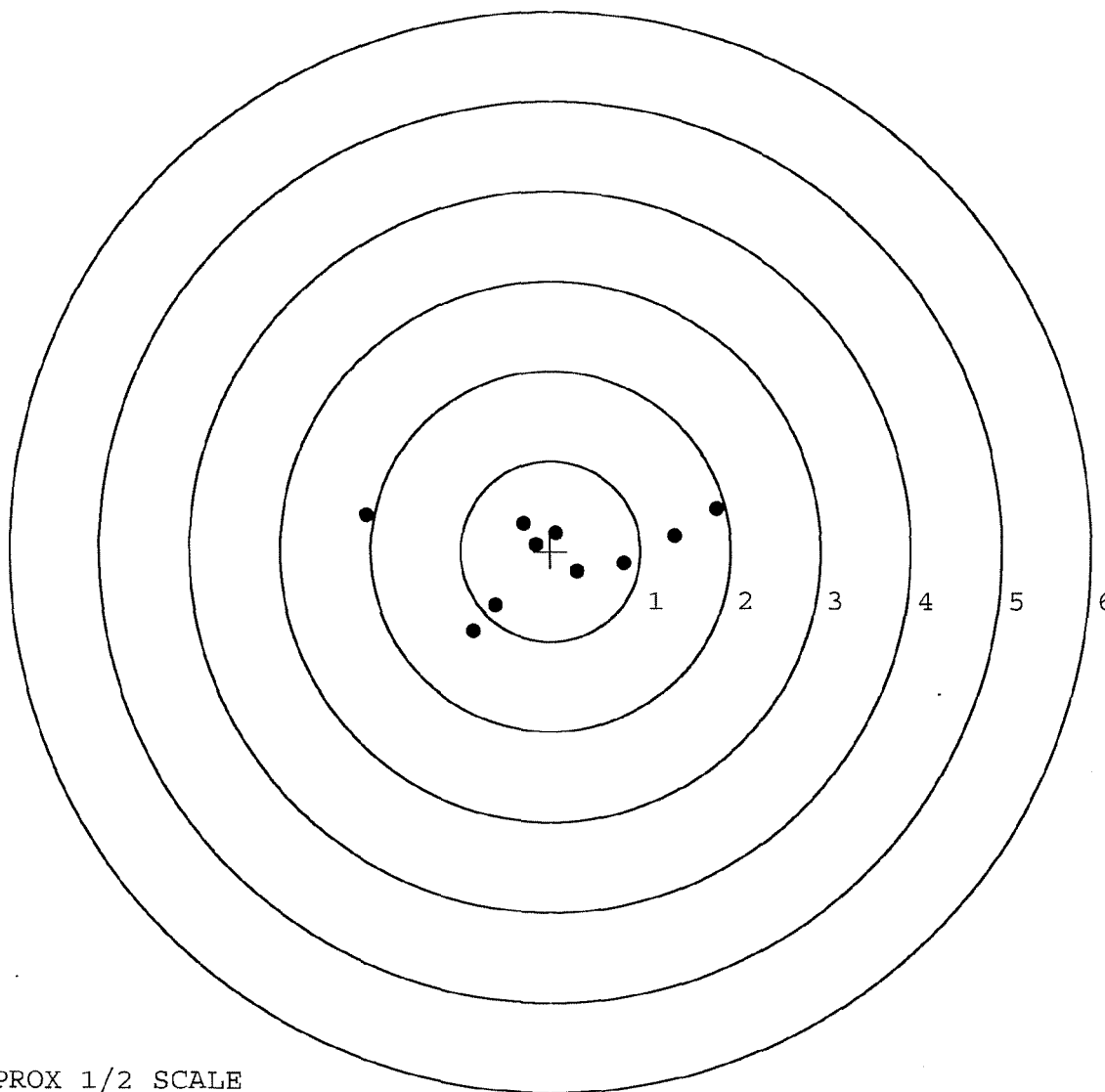


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410218. \_\_ 0  
TARGET NUMBER: 4  
FILE DATE: 02/04/2005  
FILE TIME: 07:43

X CENTROID: 0.042  
Y CENTROID: -0.022  
POA TO CENTROID: 0.047  
HORZ SPREAD: 3.893  
VERT SPREAD: 1.356  
GROUP SPREAD: 3.894  
MIN RADIUS: 0.227  
MAX RADIUS: 2.132  
MEAN RADIUS: 0.952  
# IN 1 IN DIAMETER: 4  
# IN 2 IN DIAMETER: 6  
# in 3 IN DIAMETER: 8

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.846  | 0.469  |
| 2:     | 1.381  | 0.171  |
| 3:     | 0.817  | -0.137 |
| 4:     | 0.298  | -0.225 |
| 5:     | -0.614 | -0.603 |
| 6:     | -0.854 | -0.887 |
| 7:     | -2.047 | 0.404  |
| 8:     | -0.301 | 0.313  |
| 9:     | -0.165 | 0.074  |
| 10:    | 0.061  | 0.205  |

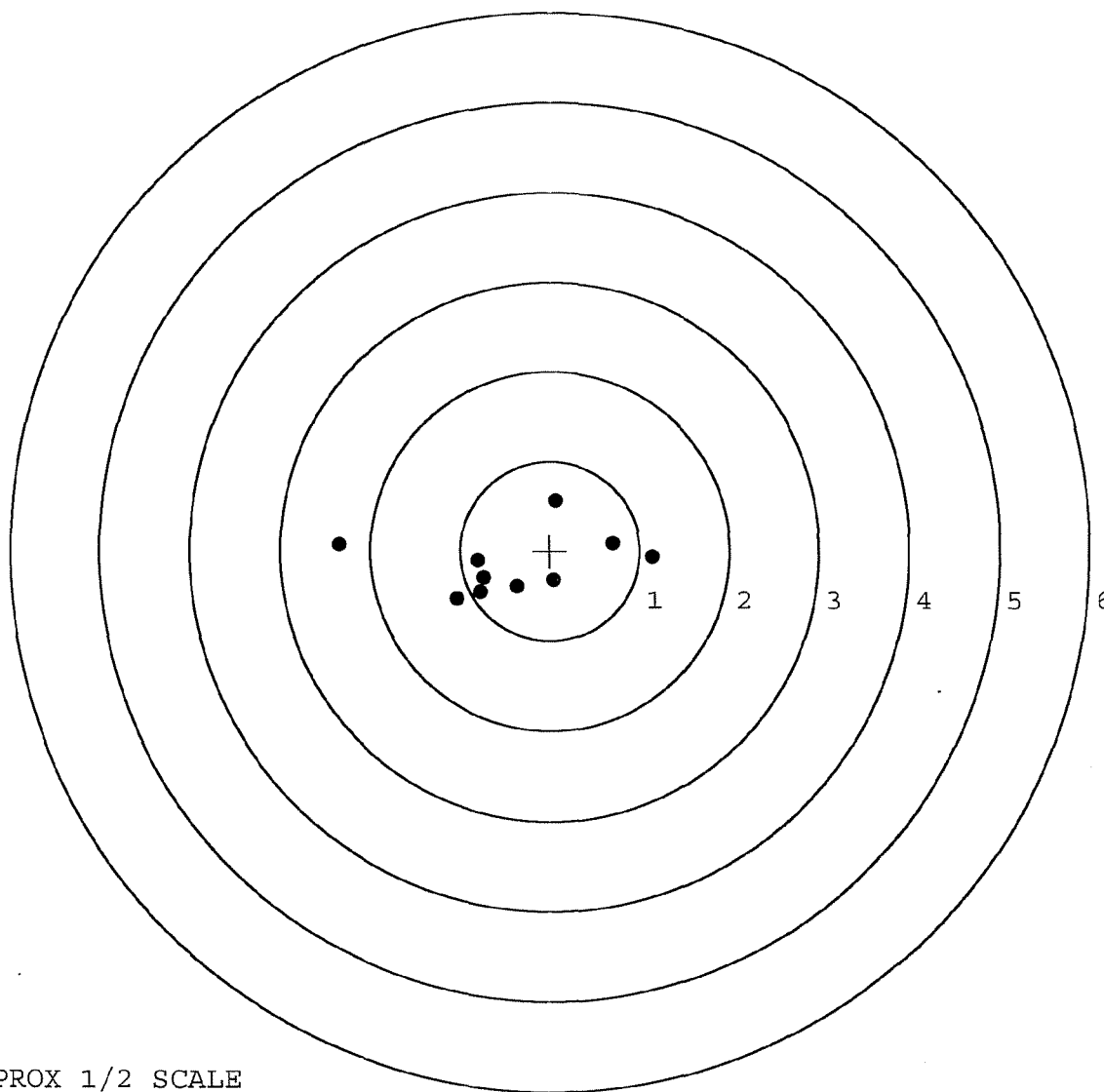


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410218. \_\_0  
TARGET NUMBER: 5  
FILE DATE: 02/04/2005  
FILE TIME: 07:43

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.142  | -0.070 |
| 2:     | 0.703  | 0.091  |
| 3:     | 0.063  | 0.565  |
| 4:     | 0.046  | -0.330 |
| 5:     | -0.372 | -0.400 |
| 6:     | -2.342 | 0.066  |
| 7:     | -0.802 | -0.109 |
| 8:     | -0.739 | -0.304 |
| 9:     | -0.774 | -0.465 |
| 10:    | -1.036 | -0.543 |

X CENTROID: -0.411  
Y CENTROID: -0.150  
POA TO CENTROID: 0.438  
HORZ SPREAD: 3.484  
VERT SPREAD: 1.108  
GROUP SPREAD: 3.487  
MIN RADIUS: 0.253  
MAX RADIUS: 1.943  
MEAN RADIUS: 0.821  
# IN 1 IN DIAMETER: 5  
# IN 2 IN DIAMETER: 7  
# in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE