

56410219

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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UPC



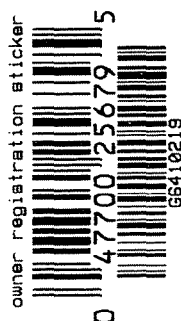
SERIAL NO.



**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

G6410219



3/11/2005 9:25:01 AM

Chib

6

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

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 # GL410219

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RTZ
600	PROOF		1-4-05	AC
607	CHECK HEADSPACE	MAGNA-FLUX	1-4-05	AC
610	DIS-ASSEMBLE GUN	INSPECTED	1-4-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 04 2005 OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		1-5-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1-14-05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-13-05	RA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-13-05	RA
	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>816s</u> <u>816s</u> <u>816s</u>	1-27-05	Ac
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>316s</u> <u>316s</u> <u>316s</u>	1-27-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.022</u> <u>.022</u>	1-27-05	Ac
	J) ASSEMBLE STOCK		1-21-05	RT
	K) ASSEMBLE SWIVEL STUDS			
	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 1-25-05	Ac
	MALFUNCTION <i>Feeds hard</i>	CORRECTION <i>OK</i>	1-25-05	Ac
	MALFUNCTION <i>CH</i>	CORRECTION <i>OK</i>	1-25-05	Ac
	MALFUNCTION	CORRECTION	<i>NY</i>	
	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>2.10</u> <u>2.10</u> <u>2.41</u> <u>2.49</u> <u>2.42</u>	1-27-05	Ac
	C) FUNCTION		1-27-05	Ac
660	PACK		3/18/05	OA

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 1-14-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.27	2.70		2.31	
PULL #2	2.63	2.39		2.20	
PULL #3	2.48	2.33		2.19	
PULL #4	2.63	2.14		2.30	
PULL #5	2.75	2.18		2.18	
TOTAL	12.76	11.74		11.18	
AVERAGE	2.55	2.34		2.23	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.44		
PULL #2	3.09	3.47		
PULL #3	3.17	3.39		
PULL #4	3.11	3.49		
PULL #5	3.07	3.44		
TOTAL	15.54	17.23		
AVERAGE	3.10	3.44		

	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	4.25	4.00		4.57
PULL #2	4.58	4.03		4.37
PULL #3	4.39	4.14		4.39
PULL #4	4.31	3.87		4.37
PULL #5	4.39	3.85		4.37
TOTAL	21.92	19.89		22.07
AVERAGE	4.38	3.97		4.41

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410219.__1
FILE DATE AND TIME: 02/09/2005 07:32

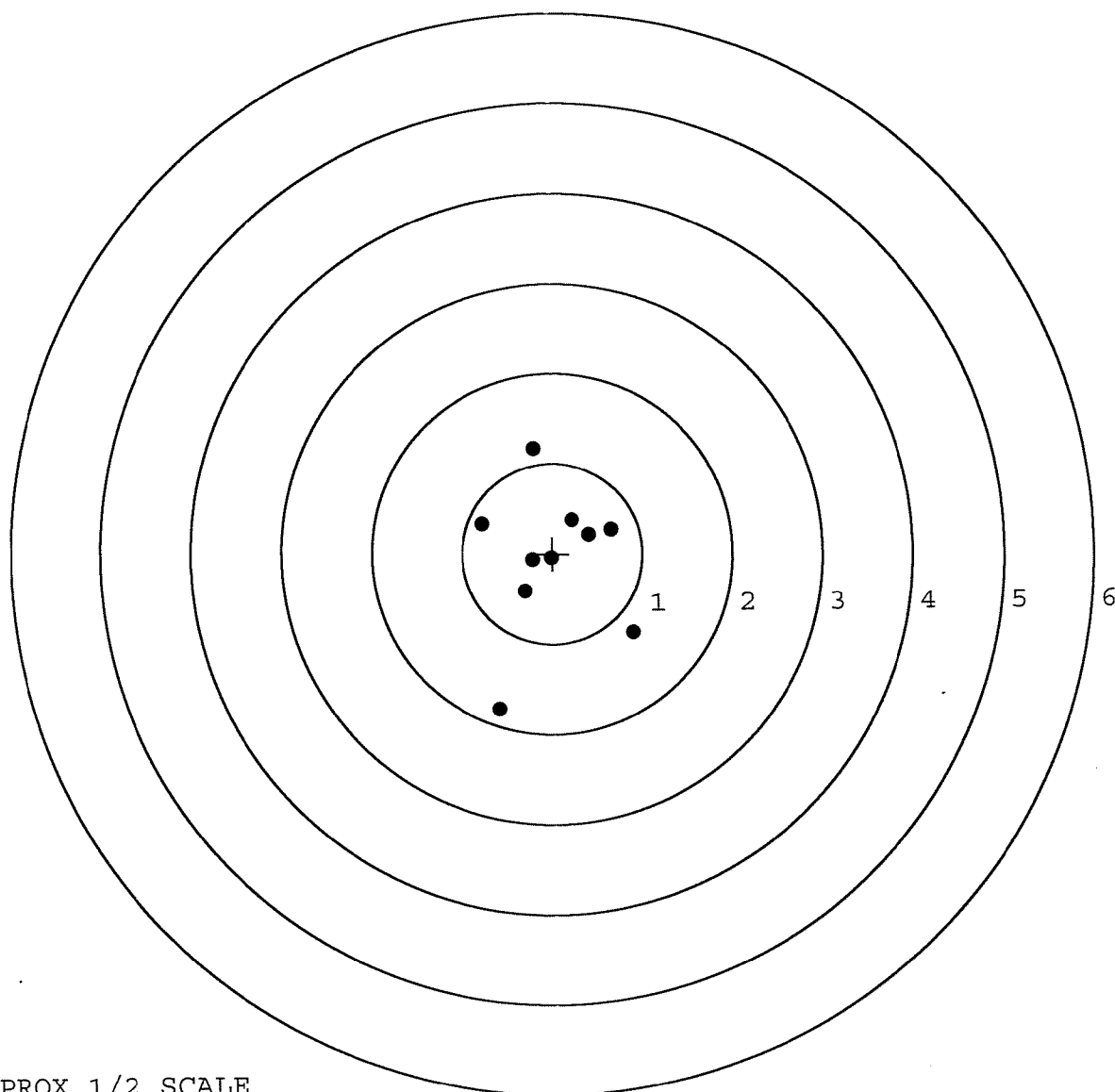
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.053
The Average Y Centroid of the Five Target Set:	-0.085
The Average Point of Impact of the Five Target Set:	0.100
The Average Mean Radius of the Five Target Set:	0.794
The Distance from POA to Centroid Target #1:	0.082
The Distance from Centroid Target #2 to Centroid Target #1:	0.166
The Distance from Centroid Target #3 to Centroid Target #1:	0.228
The Distance from Centroid Target #4 to Centroid Target #1:	0.173
The Distance from Centroid Target #5 to Centroid Target #1:	0.187

SERIAL NUMBER: G6410219. __1
TARGET NUMBER: 1
FILE DATE: 02/09/2005
FILE TIME: 07:32

X CENTROID: 0.005
Y CENTROID: -0.082
POA TO CENTROID: 0.082
HORZ SPREAD: 1.665
VERT SPREAD: 2.886
GROUP SPREAD: 2.914
MIN RADIUS: 0.041
MAX RADIUS: 1.752
MEAN RADIUS: 0.756
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.888	-0.886
2:	-0.601	-1.725
3:	0.658	0.263
4:	0.412	0.207
5:	0.221	0.367
6:	-0.020	-0.049
7:	-0.222	-0.071
8:	-0.310	-0.418
9:	-0.777	0.336
10:	-0.201	1.161

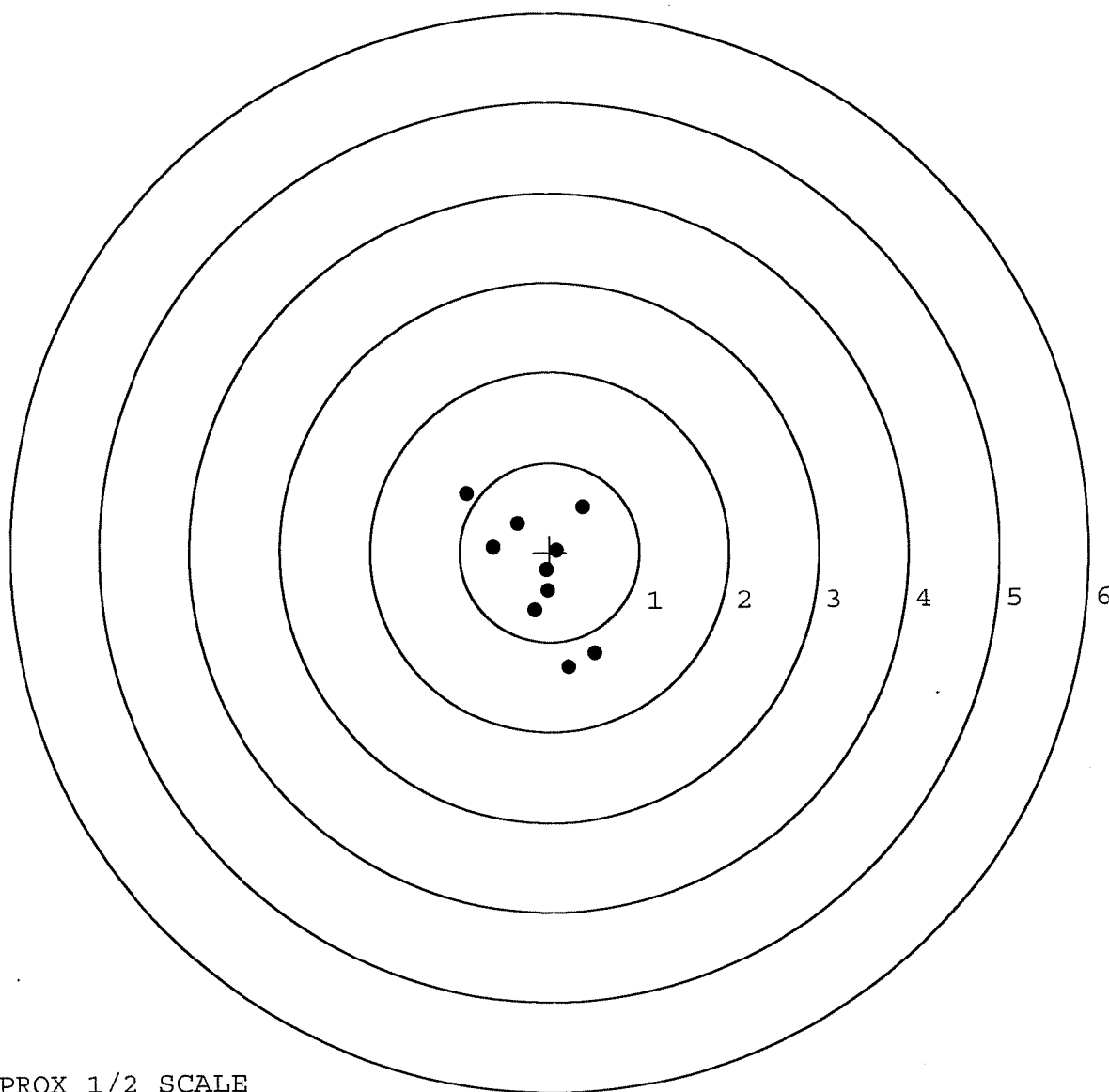


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410219. __1
TARGET NUMBER: 2
FILE DATE: 02/09/2005
FILE TIME: 07:32

X CENTROID: -0.099
Y CENTROID: -0.211
POA TO CENTROID: 0.233
HORZ SPREAD: 1.413
VERT SPREAD: 1.945
GROUP SPREAD: 2.283
MIN RADIUS: 0.056
MAX RADIUS: 1.196
MEAN RADIUS: 0.648
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.499	-1.129
2:	0.206	-1.281
3:	-0.178	-0.650
4:	-0.029	-0.432
5:	0.379	0.505
6:	0.075	0.023
7:	-0.356	0.322
8:	-0.630	0.065
9:	-0.914	0.664
10:	-0.045	-0.198

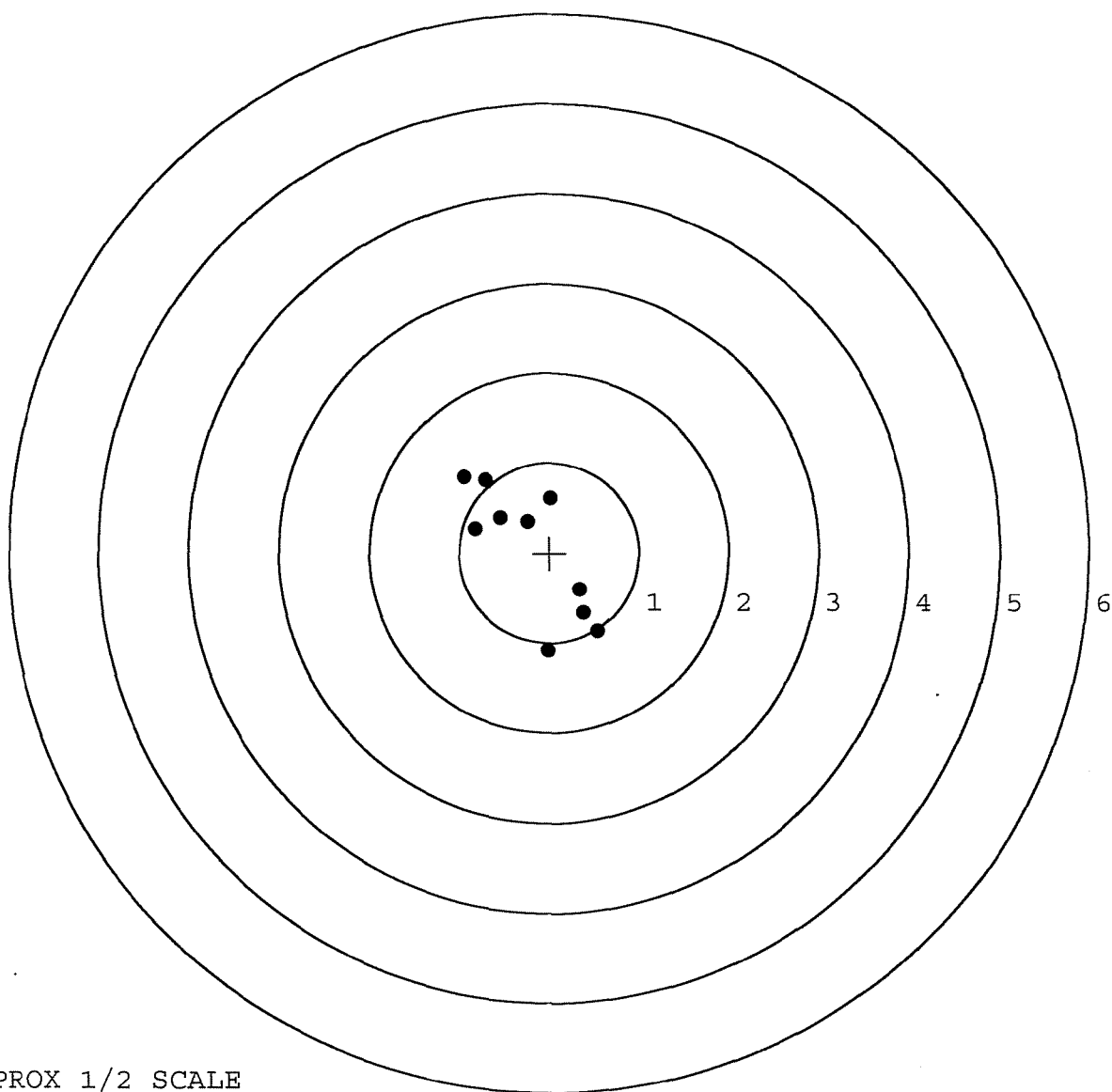


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410219. __1
TARGET NUMBER: 3
FILE DATE: 02/09/2005
FILE TIME: 07:32

X CENTROID: -0.199
Y CENTROID: 0.021
POA TO CENTROID: 0.200
HORZ SPREAD: 1.498
VERT SPREAD: 1.932
GROUP SPREAD: 2.279
MIN RADIUS: 0.324
MAX RADIUS: 1.167
MEAN RADIUS: 0.806
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.546	-0.878
2:	0.386	-0.669
3:	0.344	-0.407
4:	-0.015	-1.092
5:	0.016	0.611
6:	-0.242	0.342
7:	-0.543	0.392
8:	-0.821	0.264
9:	-0.708	0.805
10:	-0.952	0.840

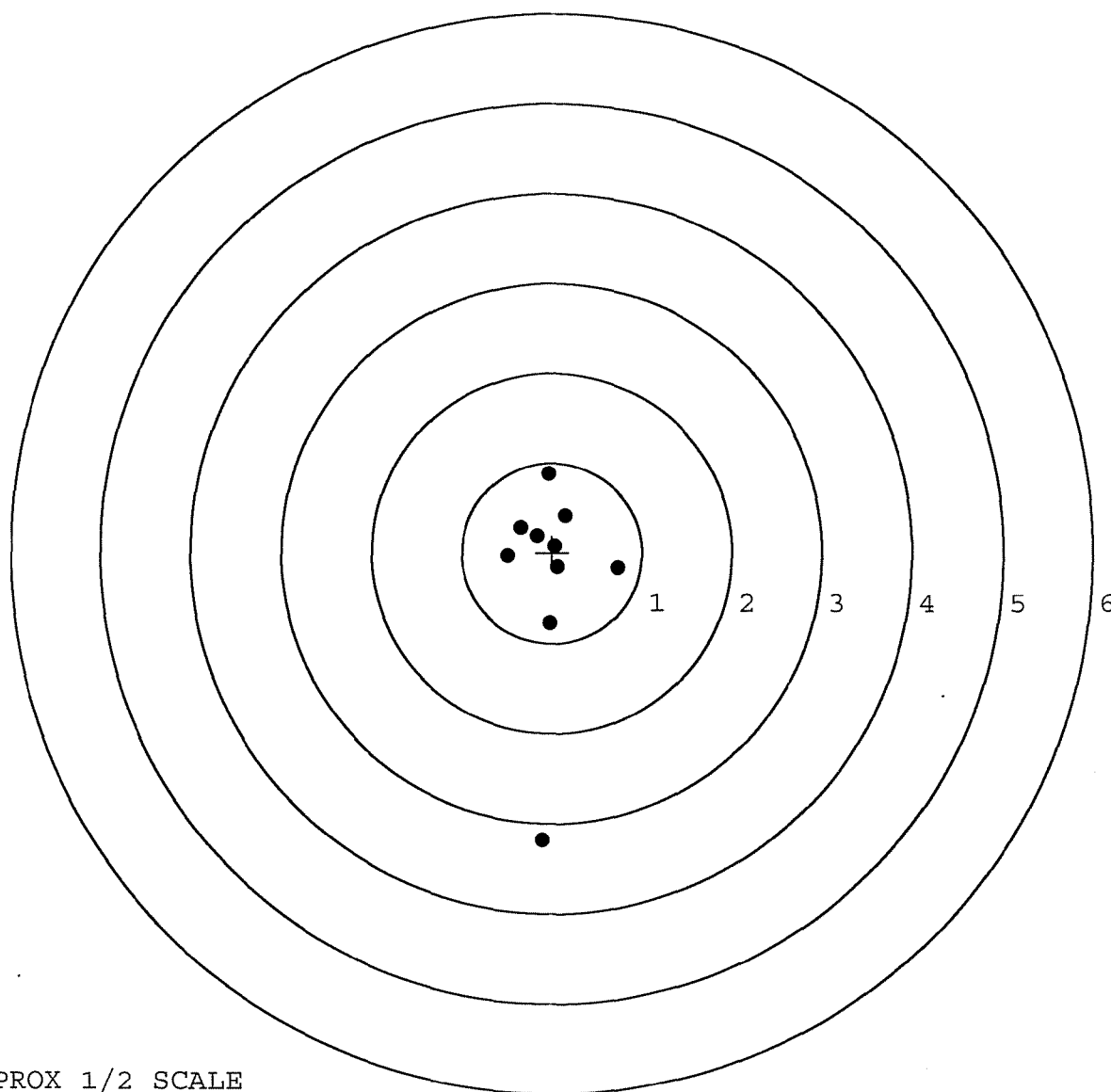


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410219. __1
TARGET NUMBER: 4
FILE DATE: 02/09/2005
FILE TIME: 07:32

X CENTROID: -0.020
Y CENTROID: -0.253
POA TO CENTROID: 0.254
HORZ SPREAD: 1.234
VERT SPREAD: 4.072
GROUP SPREAD: 4.073
MIN RADIUS: 0.118
MAX RADIUS: 2.944
MEAN RADIUS: 0.811
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.740	-0.165
2:	-0.022	-0.785
3:	-0.104	-3.196
4:	0.058	-0.165
5:	-0.040	0.876
6:	0.149	0.409
7:	0.032	0.073
8:	-0.169	0.184
9:	-0.349	0.274
10:	-0.494	-0.035



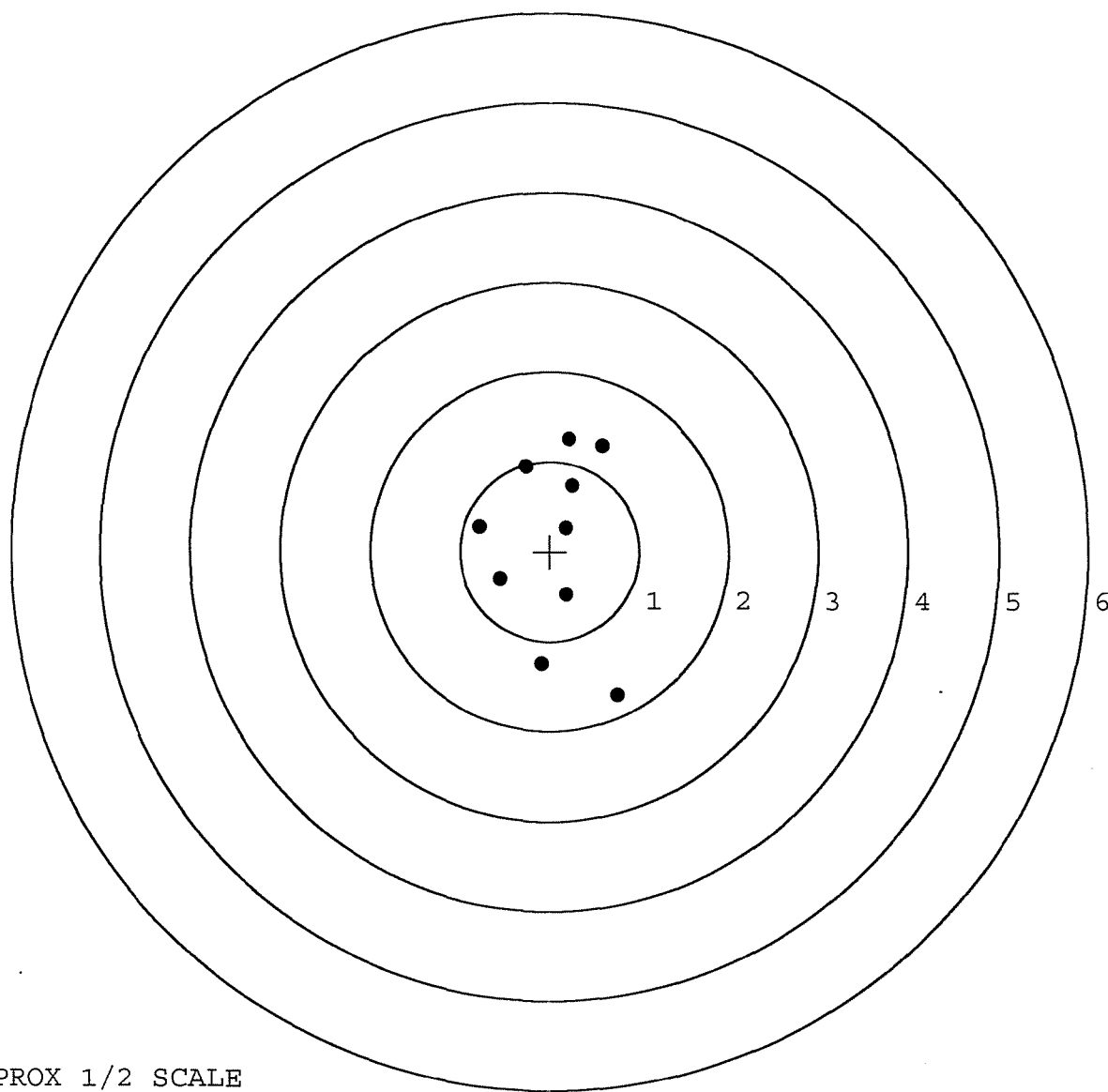
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410219. __1
TARGET NUMBER: 5
FILE DATE: 02/09/2005
FILE TIME: 07:32

X CENTROID: 0.050
Y CENTROID: 0.100
POA TO CENTROID: 0.112
HORZ SPREAD: 1.547
VERT SPREAD: 2.848
GROUP SPREAD: 2.900
MIN RADIUS: 0.211
MAX RADIUS: 1.839
MEAN RADIUS: 0.952

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.762	-1.595
2:	-0.088	-1.248
3:	0.188	-0.481
4:	-0.554	-0.312
5:	0.185	0.262
6:	-0.785	0.274
7:	0.250	0.729
8:	-0.268	0.942
9:	0.593	1.178
10:	0.216	1.253



TARGET APPROX 1/2 SCALE