

G-6410222

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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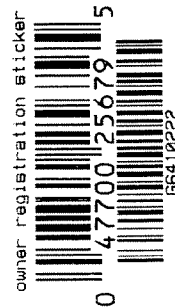
SERIAL NO.



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

96606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BIPOD ASSB

46 FORM 96253

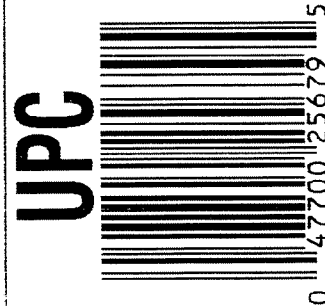


ORDER NO. **25679**

BARREL LENGTH 24"

CAPACITY 6

G6410222



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # GL6410222

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-27-04	RTL
600	PROOF		12-28-04	K
607	CHECK HEADSPACE		12-28-04	K
610	DIS-ASSEMBLE GUN		12-28-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		DEC 29 2004 OPERATOR	[Signature]
615	ROLLMARK CALIBER		12/29/04	K
617	DRILL AND TAP SIGHT HOLES		12-28-04	TKLW
620	APPLY COATINGS (BARREL ACTION)		1/5/05	HP
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		1-12-05	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-12-05	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-12-05	RTL
	D) OIL FIRING PIN ASSEMBLY		1-12-05	RTL
	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>6.0</u> <u>5.0</u> <u>5.0</u>	1-17-05	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	1-17-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1.024</u> <u>1.024</u> <u>1.023</u>	1-17-05	DA
	J) ASSEMBLE STOCK		1-12-05	RR
	K) ASSEMBLE SWIVEL STUDS		1-17-05	RTZ
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT	N.A.		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	PASS FAIL	1-13-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-13-05	TRW
655	FINAL INSPECTION A) HEADSPACE		1-17-05	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.54</u> <u>2.58</u> <u>2.64</u> <u>2.69</u> <u>2.40</u>	1-17-05	DA
	C) FUNCTION		1-17-05	RTZ
660	PACK		1-19-05	D.A.

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 11-10-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.24	2.51		2.22	
PULL #2	2.42	2.49		2.24	
PULL #3	2.58	2.37		2.29	
PULL #4	2.46	2.56		2.18	
PULL #5	2.47	2.41		2.33	
TOTAL	12.17	12.34		11.26	
AVERAGE	2.43	2.46		2.25	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.26		
PULL #2	3.44	3.24		
PULL #3	3.34	3.07		
PULL #4	3.23	3.27		
PULL #5	3.32	3.25		
TOTAL	16.67	16.09		
AVERAGE	3.33	3.21		

	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	4.29	4.12		4.18
PULL #2	4.57	4.11		4.22
PULL #3	4.24	4.12		4.06
PULL #4	4.24	4.15		4.21
PULL #5	4.26	4.00		4.20
TOTAL	21.60	20.50		20.87
AVERAGE	4.32	4.10		4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410222.__2
FILE DATE AND TIME: 09/28/2005 18:43

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.183
The Average Y Centroid of the Five Target Set:	-0.119
The Average Point of Impact of the Five Target Set:	0.219
The Average Mean Radius of the Five Target Set:	0.925
The Distance from POA to Centroid Target #1:	0.229
The Distance from Centroid Target #2 to Centroid Target #1:	0.124
The Distance from Centroid Target #3 to Centroid Target #1:	0.135
The Distance from Centroid Target #4 to Centroid Target #1:	0.097
The Distance from Centroid Target #5 to Centroid Target #1:	0.179

SERIAL NUMBER: G6410222. 2

TARGET NUMBER: 1

FILE DATE: 09/28/2005

FILE TIME: 18:43

POINT#	X	Y
1:	0.569	1.083
2:	0.004	1.002
3:	0.158	0.424
4:	-0.311	0.326
5:	0.329	-0.821
6:	0.111	-1.031
7:	-0.398	-1.191
8:	1.089	-0.630
9:	1.789	0.488
10:	-1.255	-0.588

X CENTROID: 0.209

Y CENTROID: -0.094

POA TO CENTROID: 0.229

HORZ SPREAD: 3.044

VERT SPREAD: 2.274

GROUP SPREAD: 3.229

MIN RADIUS: 0.520

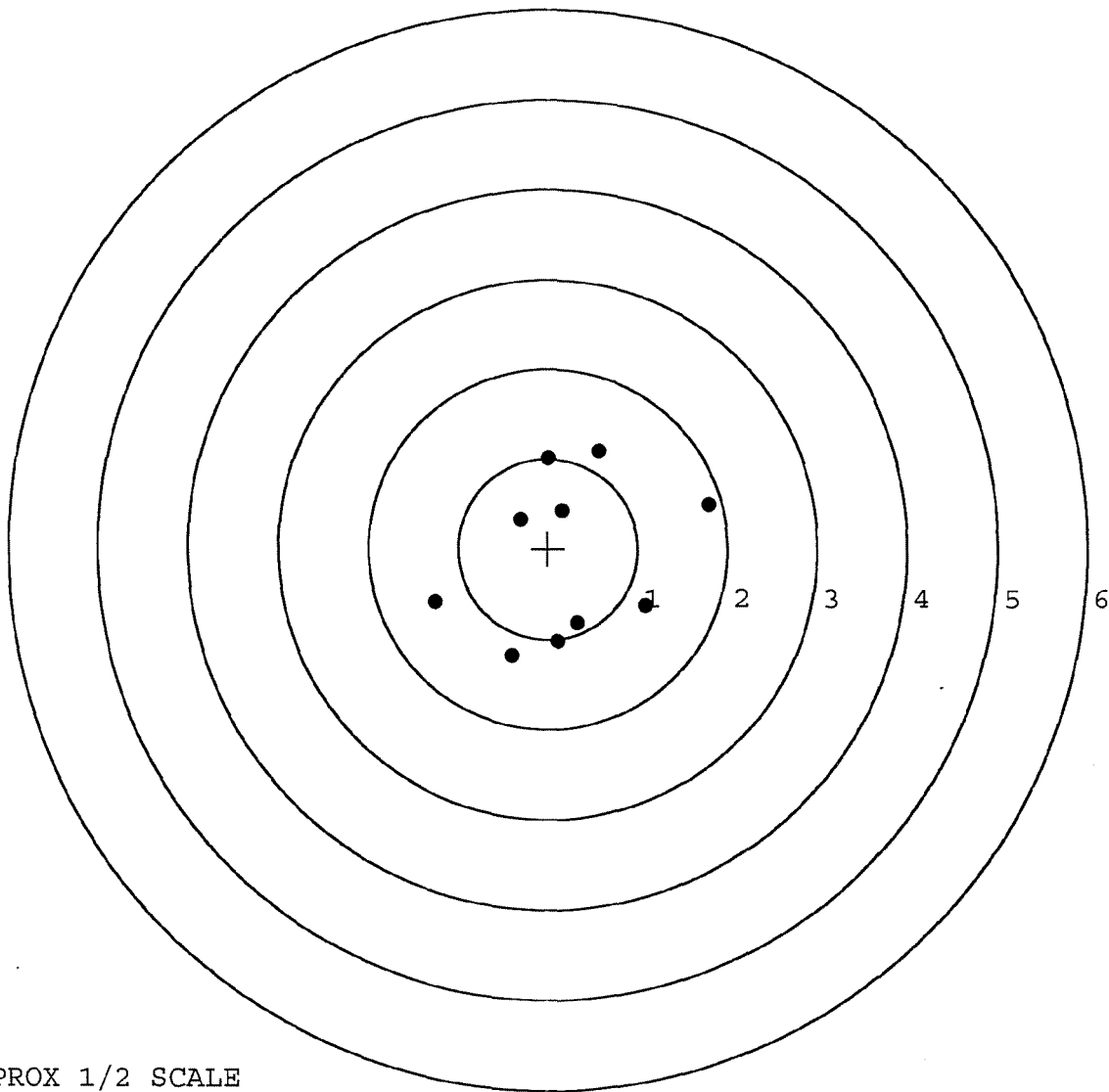
MAX RADIUS: 1.684

MEAN RADIUS: 1.073

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 8

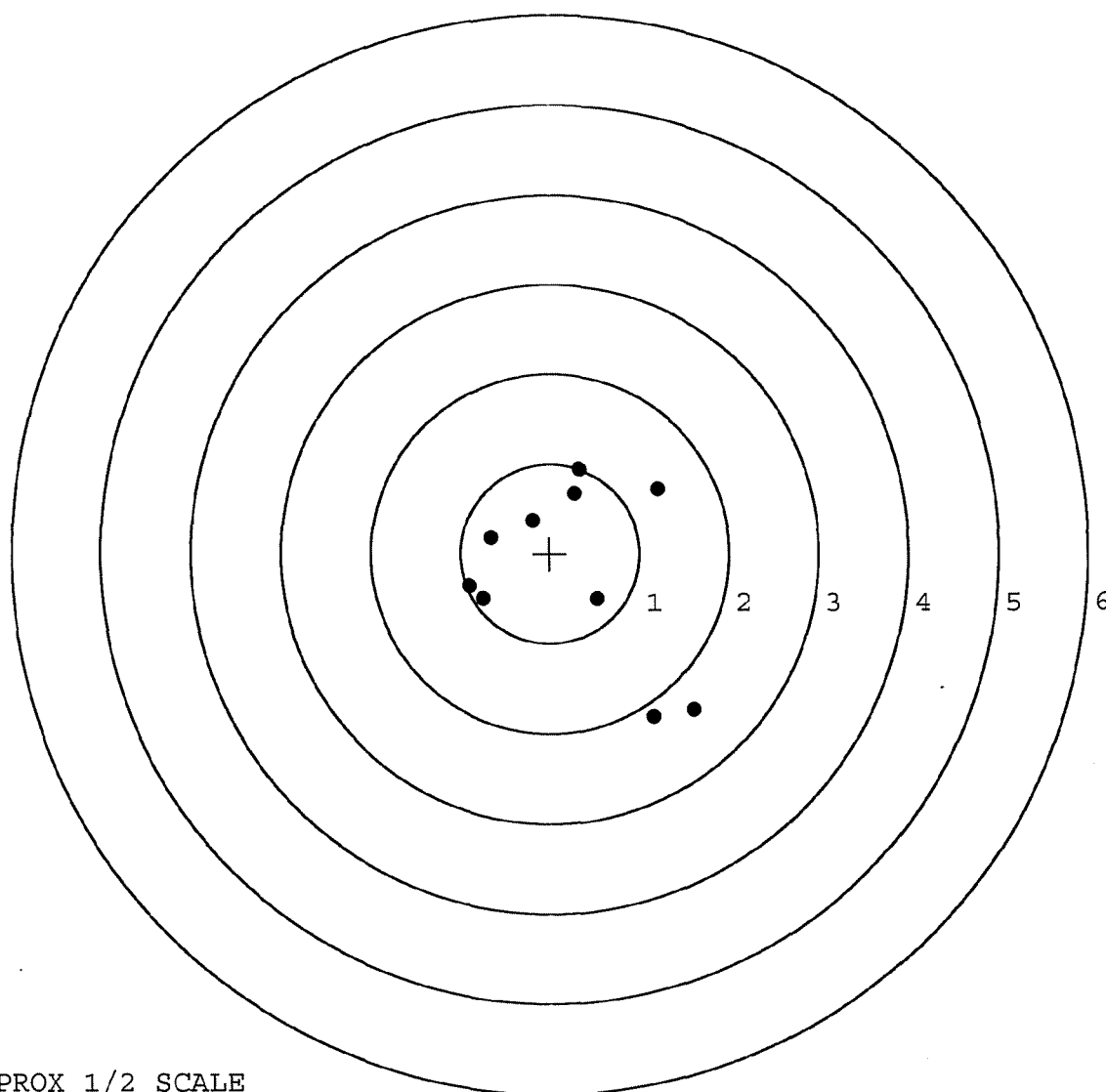


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410222. __2
TARGET NUMBER: 2
FILE DATE: 09/28/2005
FILE TIME: 18:43

X CENTROID: 0.260
Y CENTROID: -0.206
POA TO CENTROID: 0.332
HORZ SPREAD: 2.503
VERT SPREAD: 2.766
GROUP SPREAD: 2.971
MIN RADIUS: 0.407
MAX RADIUS: 2.038
MEAN RADIUS: 1.160
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.327	0.943
2:	0.280	0.671
3:	-0.197	0.367
4:	-0.655	0.182
5:	-0.901	-0.366
6:	-0.750	-0.506
7:	0.530	-0.511
8:	1.159	-1.823
9:	1.203	0.719
10:	1.602	-1.740



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410222. __2

TARGET NUMBER: 3

FILE DATE: 09/28/2005

FILE TIME: 18:43

POINT#	X	Y
1:	0.482	-0.329
2:	0.019	-0.514
3:	-0.937	-1.439
4:	1.167	-1.010
5:	1.679	-1.434
6:	0.884	0.391
7:	0.914	0.656
8:	0.005	0.696
9:	-0.261	0.623
10:	-1.127	0.293

X CENTROID: 0.282

Y CENTROID: -0.207

POA TO CENTROID: 0.350

HORZ SPREAD: 2.806

VERT SPREAD: 2.135

GROUP SPREAD: 3.295

MIN RADIUS: 0.234

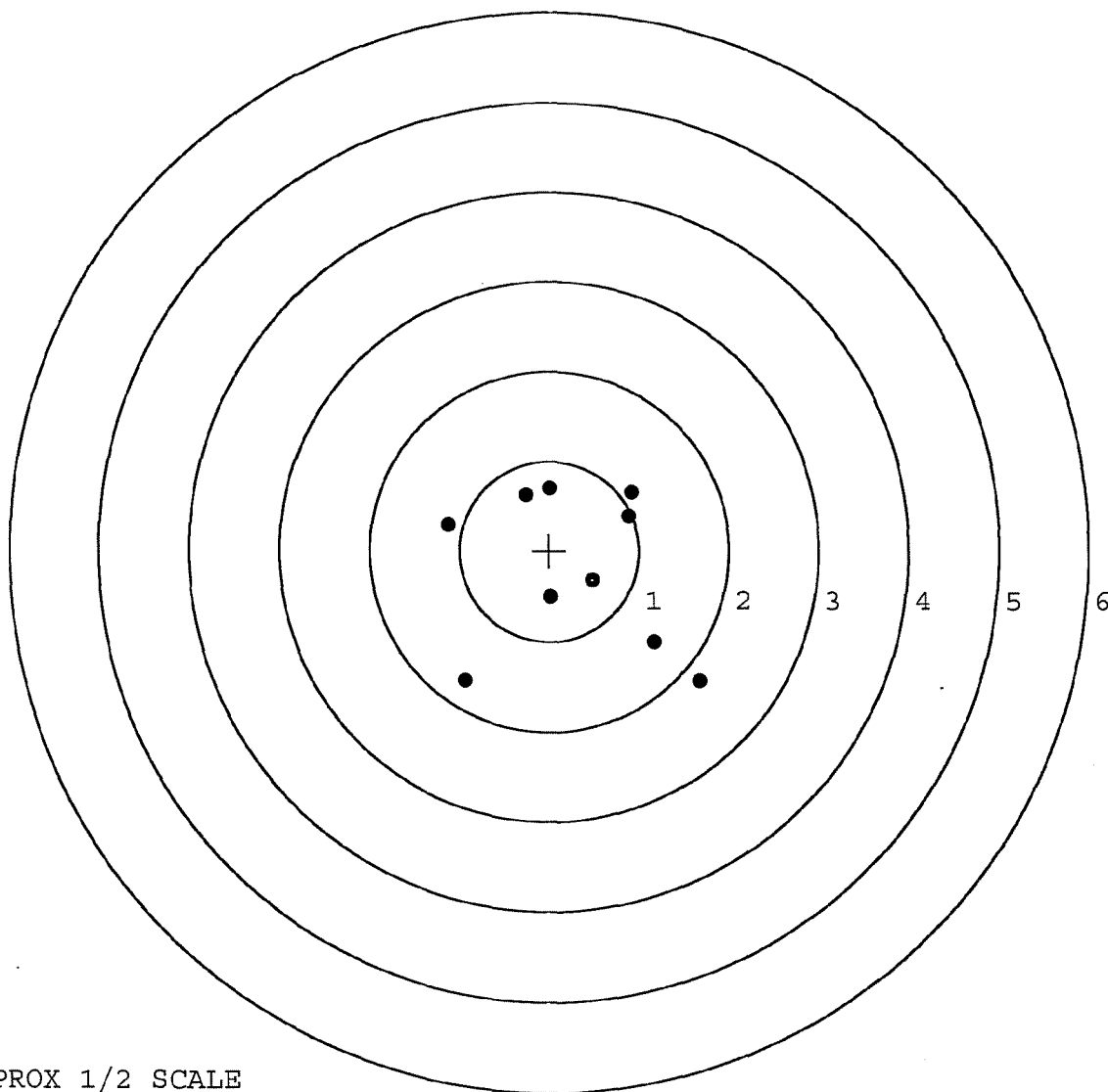
MAX RADIUS: 1.859

MEAN RADIUS: 1.078

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410222.__2

TARGET NUMBER: 4

FILE DATE: 09/28/2005

FILE TIME: 18:43

POINT#	X	Y
1:	0.634	0.366
2:	0.278	0.449
3:	0.075	0.356
4:	-0.028	0.683
5:	-0.346	0.141
6:	-0.316	0.034
7:	0.202	-0.560
8:	-0.135	-0.481
9:	-0.313	-1.193
10:	1.275	-0.123

X CENTROID: 0.133

Y CENTROID: -0.033

POA TO CENTROID: 0.137

HORZ SPREAD: 1.621

VERT SPREAD: 1.876

GROUP SPREAD: 1.915

MIN RADIUS: 0.393

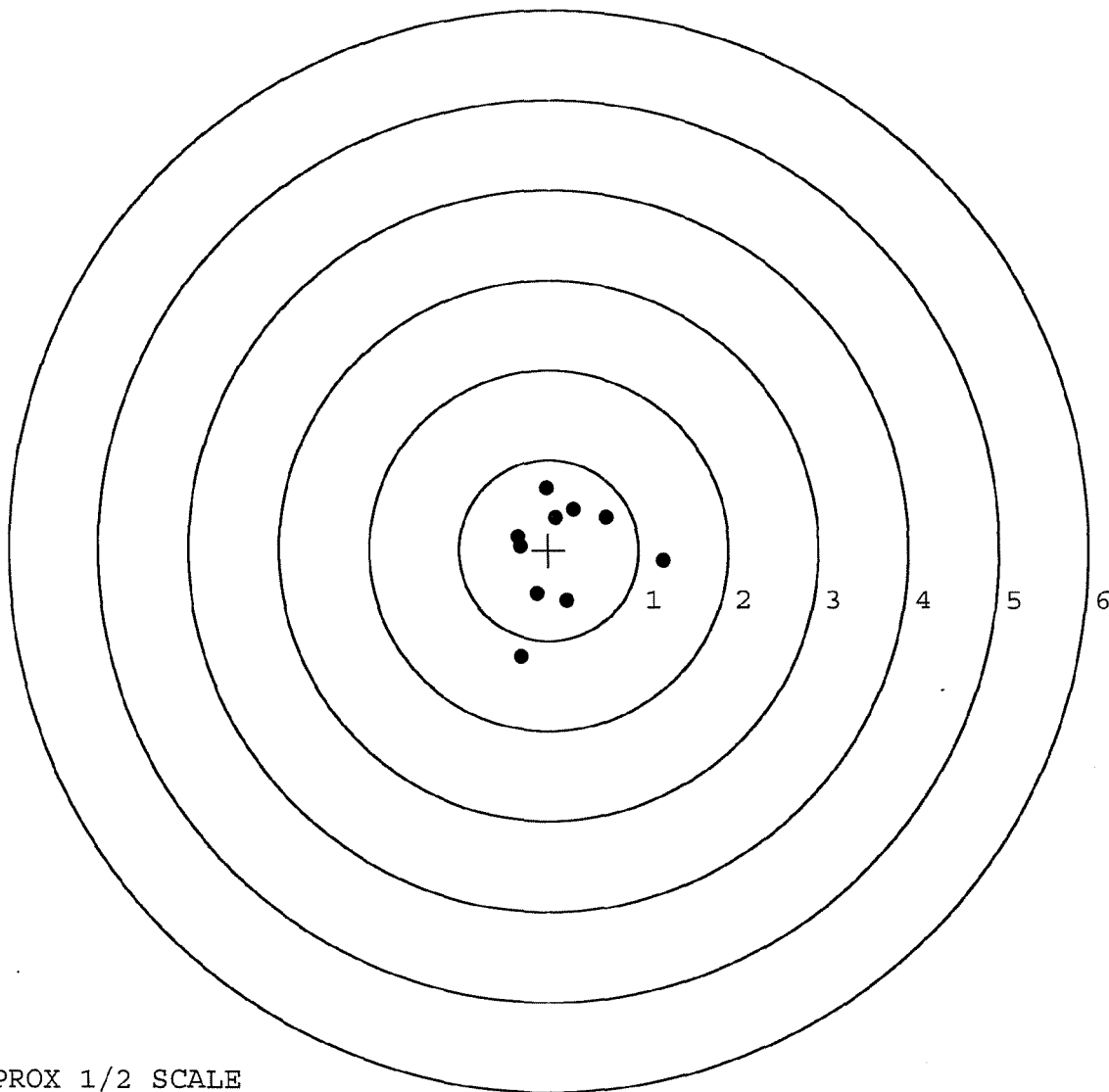
MAX RADIUS: 1.243

MEAN RADIUS: 0.668

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410222. _2

TARGET NUMBER: 5

FILE DATE: 09/28/2005

FILE TIME: 18:43

POINT#	X	Y
1:	0.660	0.443
2:	1.053	0.092
3:	0.062	0.252
4:	0.095	-0.173
5:	0.303	-0.356
6:	-0.581	-0.229
7:	-0.449	0.099
8:	-0.361	0.819
9:	0.188	-0.799
10:	-0.638	-0.716

X CENTROID: 0.033

Y CENTROID: -0.057

POA TO CENTROID: 0.066

HORZ SPREAD: 1.691

VERT SPREAD: 1.618

GROUP SPREAD: 1.874

MIN RADIUS: 0.132

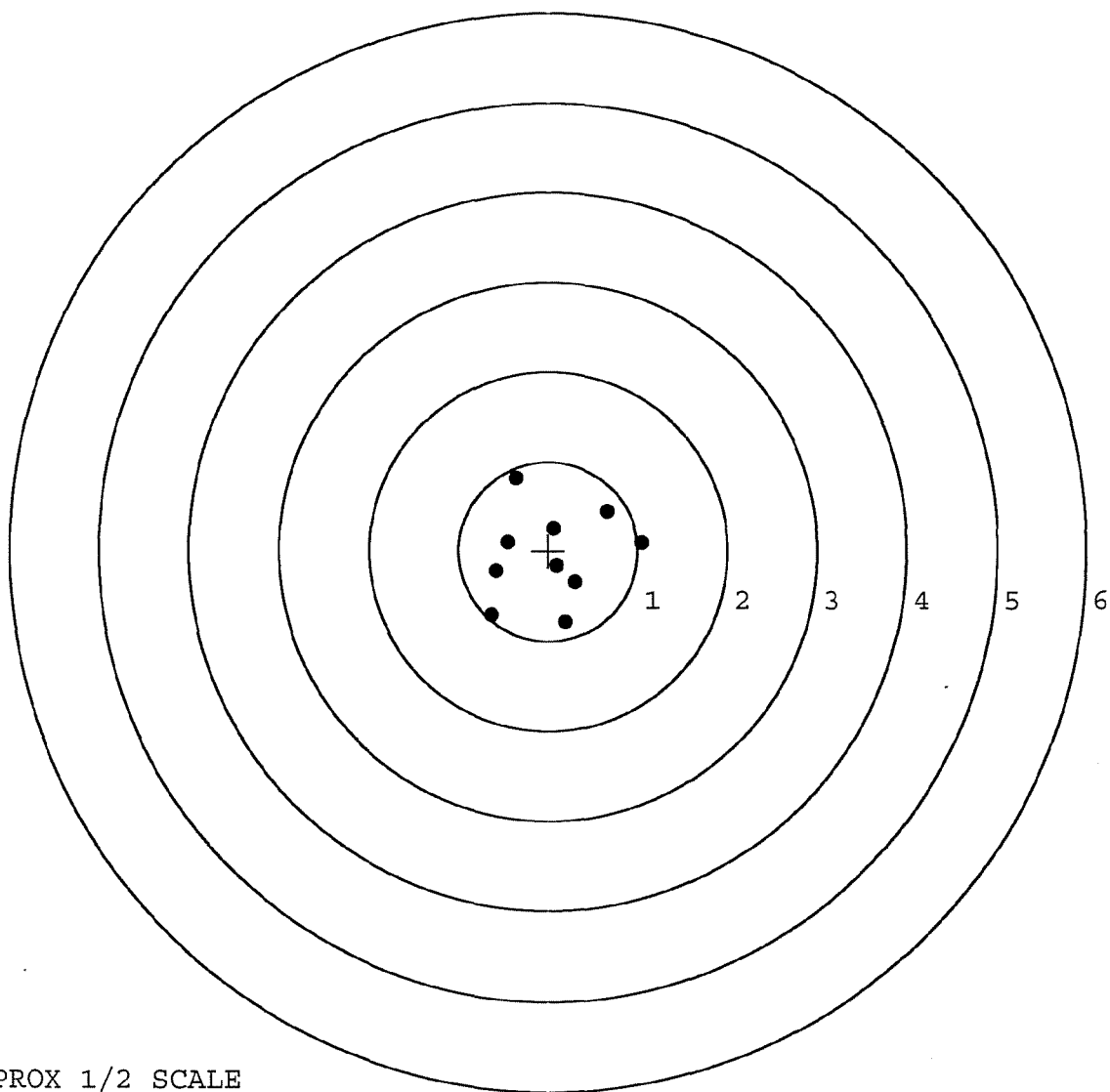
MAX RADIUS: 1.031

MEAN RADIUS: 0.648

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE