

G 6410 228

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC

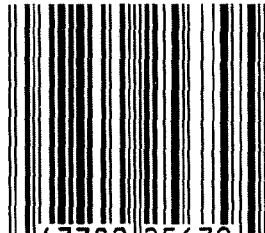


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ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



0 47700 25679 5

SERIAL NO.

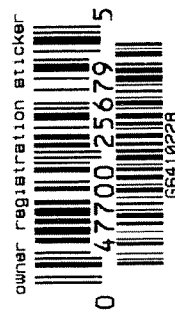


G6410228

**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



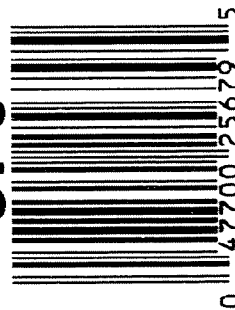
ORDER NO. **25679**

BARREL LENGTH 24"

CAPACITY 6

G6410228

UPC



3/11/2006 9:25:01 AM

CRIB

3

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 # G6410228

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-24-05	RTL
600	PROOF		1-25-05	Ac
607	CHECK HEADSPACE	MAGNA - FLUX	1-25-05	Ac
610	DIS-ASSEMBLE GUN	INSPECTED	1-26-05	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 25 2005 OPERATOR 		
615	ROLLMARK CALIBER		1-27-05	CW
617	DRILL AND TAP SIGHT HOLES		1-26-05	TRL
620	APPLY COATINGS (BARREL ACTION)		1/31/05	NP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-7-05	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-7-05	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-7-05	RR
	D) OIL FIRING PIN ASSEMBLY		2-7-05	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 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	<u>2-16-05</u>	<u>AC</u>
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	<u>2-16-05</u>	<u>AC</u>
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	<u>2-16-05</u>	<u>AC</u>
	J) ASSEMBLE STOCK		<u>2-7-05</u>	<u>RL</u>
	K) ASSEMBLE SWIVEL STUDS		<u>2-18-05</u>	<u>AC</u>
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		<u>2-7-05</u>	<u>RL</u>
	M) IRON SIGHT ALIGNMENT		<u>2-7-05</u>	<u>RL</u>
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		<u>2-7-05</u>	<u>RL</u>
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	<u>2-7-05</u>	<u>TRW</u>
	MALFUNCTION <u>creep in trigger</u>	CORRECTION <u>OK</u>	<u>2-16-05</u>	<u>TRW</u>
	MALFUNCTION <u>CH</u>	CORRECTION <u>OK</u>	<u>2-16-05</u>	<u>TRW</u>
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		<u>2-17-05</u>	<u>AC</u>
655	FINAL INSPECTION A) HEADSPACE		<u>2-16-05</u>	<u>AC</u>
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.66</u> <u>2.64</u> <u>2.21</u> <u>2.53</u>	<u>2-17-05</u>	<u>TRW</u>
	C) FUNCTION		<u>2-16-05</u>	<u>AC</u>
660	PACK		<u>3/18/05</u>	<u>DA</u>

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410228.___0
FILE DATE AND TIME: 02/07/2005 07:53

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.008
The Average Y Centroid of the Five Target Set:	0.001
The Average Point of Impact of the Five Target Set:	0.008
The Average Mean Radius of the Five Target Set:	0.712
The Distance from POA to Centroid Target #1:	0.235
The Distance from Centroid Target #2 to Centroid Target #1:	0.234
The Distance from Centroid Target #3 to Centroid Target #1:	0.425
The Distance from Centroid Target #4 to Centroid Target #1:	0.197
The Distance from Centroid Target #5 to Centroid Target #1:	0.401

SERIAL NUMBER: G6410228.___0

TARGET NUMBER: 1

FILE DATE: 02/07/2005

FILE TIME: 07:53

POINT#	X	Y
1:	1.161	1.081
2:	-0.032	1.576
3:	-0.430	0.886
4:	0.171	0.273
5:	0.194	-0.131
6:	-0.358	-0.040
7:	-0.191	-0.311
8:	-0.430	-0.583
9:	-0.729	-0.722
10:	-1.310	-0.727

X CENTROID: -0.195

Y CENTROID: 0.130

POA TO CENTROID: 0.235

HORZ SPREAD: 2.471

VERT SPREAD: 2.303

GROUP SPREAD: 3.062

MIN RADIUS: 0.235

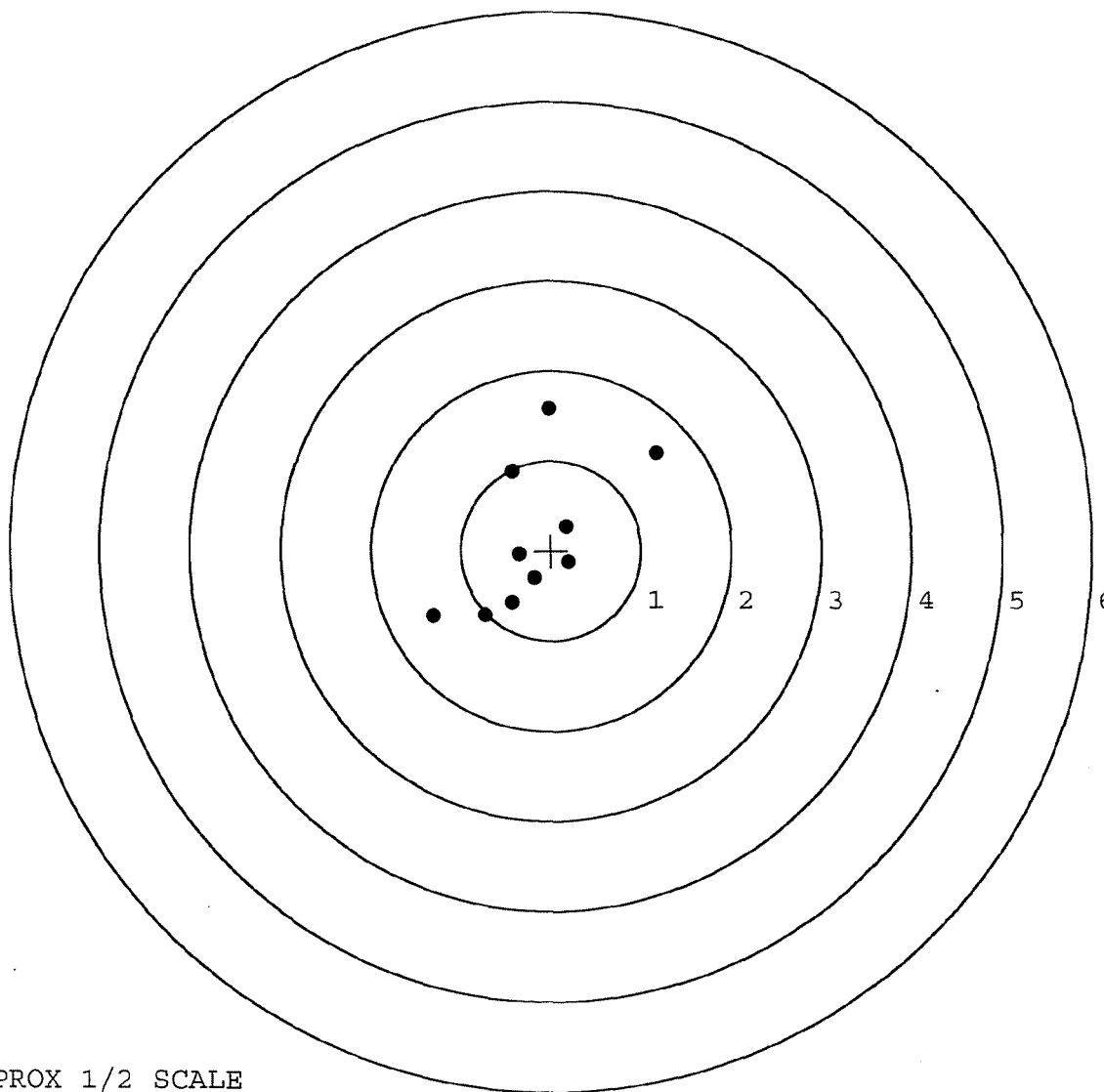
MAX RADIUS: 1.656

MEAN RADIUS: 0.860

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410228. __0

TARGET NUMBER: 2

FILE DATE: 02/07/2005

FILE TIME: 07:53

POINT#	X	Y
1:	0.735	0.233
2:	0.521	0.812
3:	0.275	0.239
4:	0.319	-0.085
5:	0.215	-0.411
6:	-0.258	-0.539
7:	-0.351	-0.194
8:	-0.701	-0.122
9:	-0.691	0.375
10:	-0.072	-0.306

X CENTROID: -0.001

Y CENTROID: 0.000

POA TO CENTROID: 0.001

HORZ SPREAD: 1.436

VERT SPREAD: 1.351

GROUP SPREAD: 1.560

MIN RADIUS: 0.314

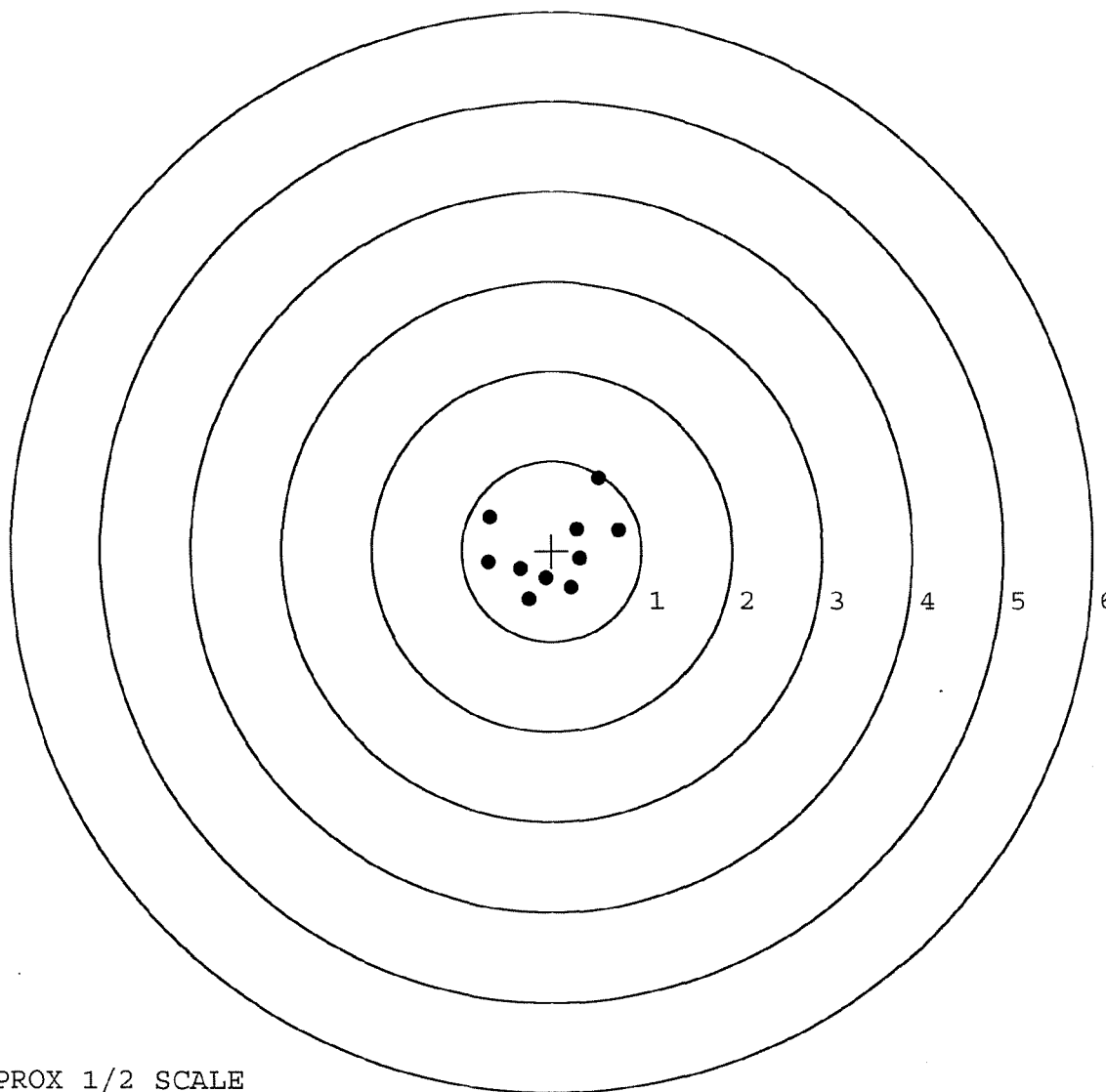
MAX RADIUS: 0.965

MEAN RADIUS: 0.571

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

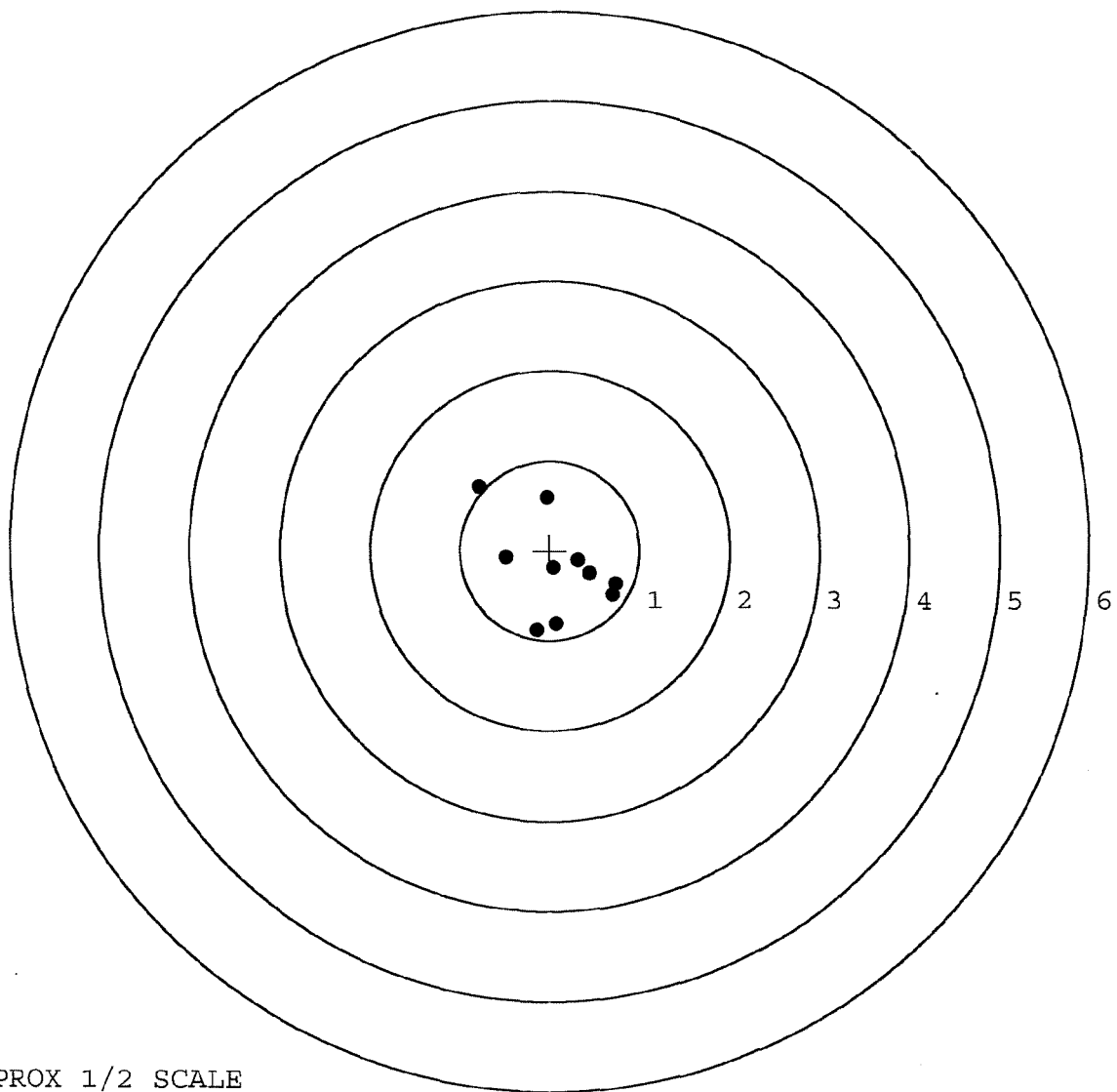


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410228. __ 0
TARGET NUMBER: 3
FILE DATE: 02/07/2005
FILE TIME: 07:53

X CENTROID: 0.085
Y CENTROID: -0.189
POA TO CENTROID: 0.207
HORZ SPREAD: 1.520
VERT SPREAD: 1.605
GROUP SPREAD: 1.917
MIN RADIUS: 0.043
MAX RADIUS: 1.261
MEAN RADIUS: 0.601
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.034	0.595
2:	-0.793	0.716
3:	-0.488	-0.078
4:	-0.142	-0.889
5:	0.078	-0.819
6:	0.697	-0.490
7:	0.727	-0.368
8:	0.446	-0.259
9:	0.315	-0.107
10:	0.042	-0.192

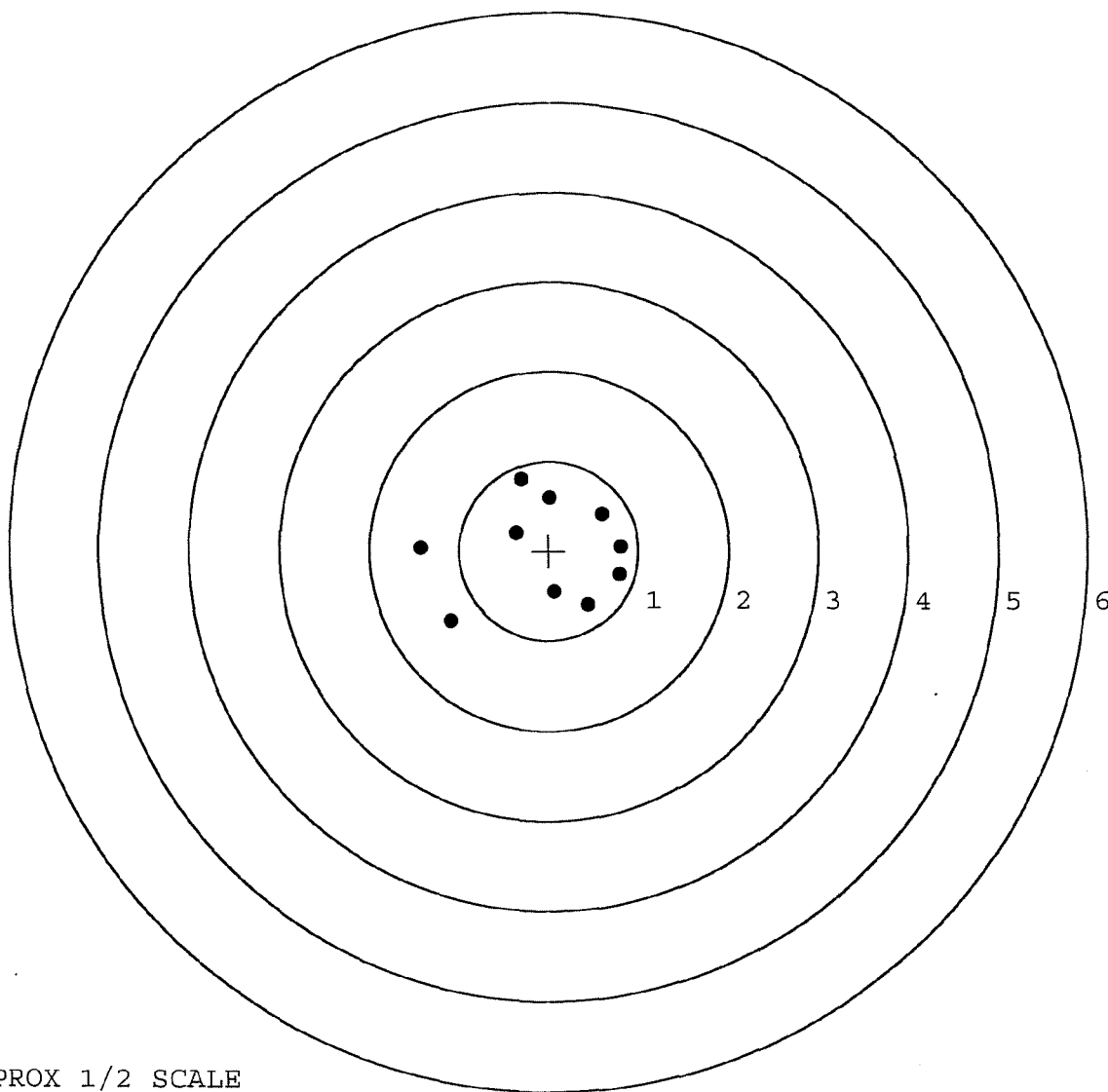


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410228. __0
TARGET NUMBER: 4
FILE DATE: 02/07/2005
FILE TIME: 07:53

X CENTROID: -0.050
Y CENTROID: -0.003
POA TO CENTROID: 0.050
HORZ SPREAD: 2.229
VERT SPREAD: 1.591
GROUP SPREAD: 2.233
MIN RADIUS: 0.371
MAX RADIUS: 1.378
MEAN RADIUS: 0.825
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.440	-0.608
2:	0.066	-0.465
3:	0.591	0.418
4:	0.802	0.047
5:	0.787	-0.260
6:	-0.362	0.197
7:	0.010	0.594
8:	-0.312	0.803
9:	-1.427	0.033
10:	-1.090	-0.788



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410228. __0

TARGET NUMBER: 5

FILE DATE: 02/07/2005

FILE TIME: 07:53

POINT#	X	Y
1:	1.741	0.897
2:	0.855	0.742
3:	0.056	0.479
4:	0.251	0.185
5:	-0.180	0.353
6:	0.057	-0.726
7:	0.013	-0.475
8:	0.194	-0.297
9:	-0.139	-0.254
10:	-0.844	-0.259

X CENTROID: 0.200

Y CENTROID: 0.064

POA TO CENTROID: 0.211

HORZ SPREAD: 2.585

VERT SPREAD: 1.623

GROUP SPREAD: 2.832

MIN RADIUS: 0.131

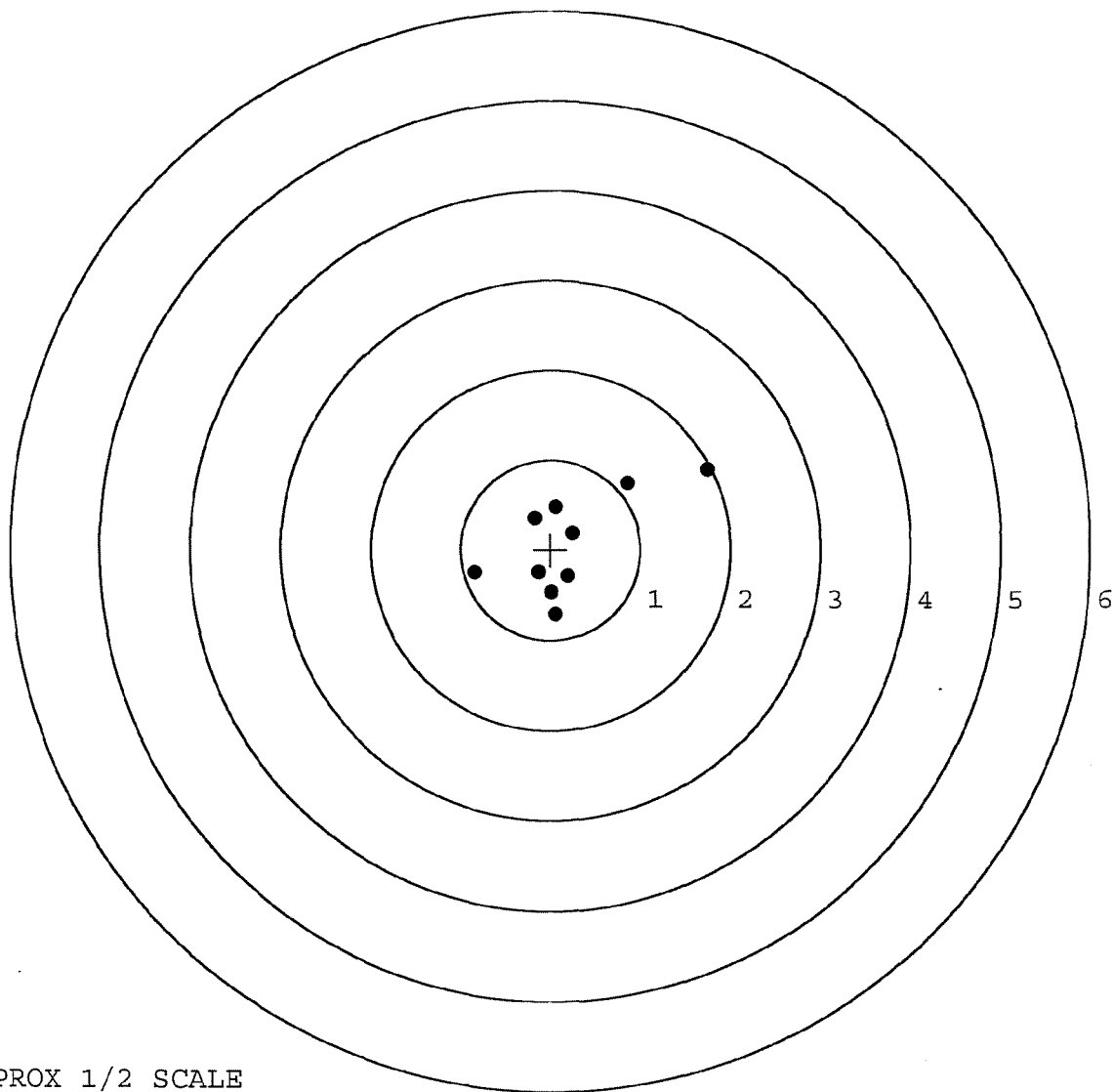
MAX RADIUS: 1.751

MEAN RADIUS: 0.704

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

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

2-2-05

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.31	2.74		2.12	
PULL #2	2.79	2.75		2.16	
PULL #3	2.58	2.73		2.12	
PULL #4	2.68	2.63		2.08	
PULL #5	2.78	2.47		2.05	
TOTAL	13.14	13.32		10.53	
AVERAGE	2.62	2.66		2.10	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.19		
PULL #2	3.28	3.31		
PULL #3	3.23	3.37		
PULL #4	3.28	3.36		
PULL #5	3.27	3.25		
TOTAL	16.35	16.48		
AVERAGE	3.27	3.29		

	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	4.18	4.23		3.91
PULL #2	4.28	4.21		4.33
PULL #3	4.23	4.09		4.39
PULL #4	4.04	4.07		4.34
PULL #5	4.22	4.01		3.94
TOTAL	20.95	20.61		20.91
AVERAGE	4.19	4.12		4.18