

G6410242

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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M/24 7.62 NATO S.W.S.

UPC



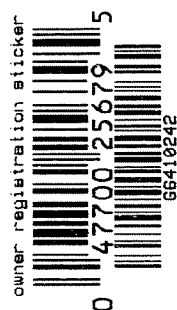
SERIAL NO.



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

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

DD, FORM 96253



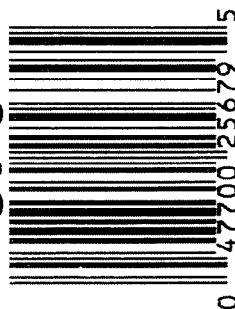
ORDER NO. **25679**

BARREL LENGTH **24"**

CAPACITY **6**

G6410242

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3/11/2005 9:25:01 AM

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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 # G641 0242

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-04	RTZ
600	PROOF		1-4-05	Ac
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-4-05	Ac
610	DIS-ASSEMBLE GUN	INSPECTED 2005	1-4-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	BS OPERATOR 2005		
615	ROLLMARK CALIBER		1-5-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1/19/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-17-05	RP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-17-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-17-05	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>8 lbs</u> <u>8 lbs</u> <u>8 lbs</u>	1-27-05	AC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>5 lbs</u> <u>5 lbs</u> <u>5 lbs</u>	1-27-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.023</u>	1-27-05	AC
	J) ASSEMBLE STOCK		1-21-05	RT
	K) ASSEMBLE SWIVEL STUDS		1-27-05	AC
	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	<u>PASS</u> <u>FAIL</u> 2-9-05	1-25-05	AC
	MALFUNCTION <i>MCW</i>	CORRECTION <i>OK</i>	1-25-05	AC
	MALFUNCTION <i>feeds hard</i>	CORRECTION <i>OK</i>	1-25-05	AC
	MALFUNCTION <i>floor plate opens</i>	CORRECTION <i>OK</i>	1-25-05	AC
	MALFUNCTION	CORRECTION	X	X
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>2.57</u> <u>2.57</u> <u>2.77</u> <u>2.57</u> <u>2.57</u>	1-27-05	AC
	C) FUNCTION		1-27-05	AC
660	PACK		3/19/05	DA

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	2.13	2.11		2.05	
PULL #2	2.17	2.17		2.23	
PULL #3	2.22	2.13		2.26	
PULL #4	2.04	2.11		2.20	
PULL #5	2.26	2.13		2.19	
TOTAL	10.82	10.65		10.93	
AVERAGE	2.16	2.13		2.18	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.15		
PULL #2	3.39	3.08		
PULL #3	3.27	3.02		
PULL #4	3.29	3.10		
PULL #5	3.22	2.93		
TOTAL	16.50	15.28		
AVERAGE	3.30	3.05		

	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	4.21	4.49		4.39
PULL #2	4.33	4.34		4.61
PULL #3	4.31	4.02		4.57
PULL #4	4.15	4.29		4.68
PULL #5	4.19	4.03		4.53
TOTAL	21.19	21.17		22.78
AVERAGE	4.23	4.23		4.55

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410242.__1
FILE DATE AND TIME: 02/09/2005 07:45

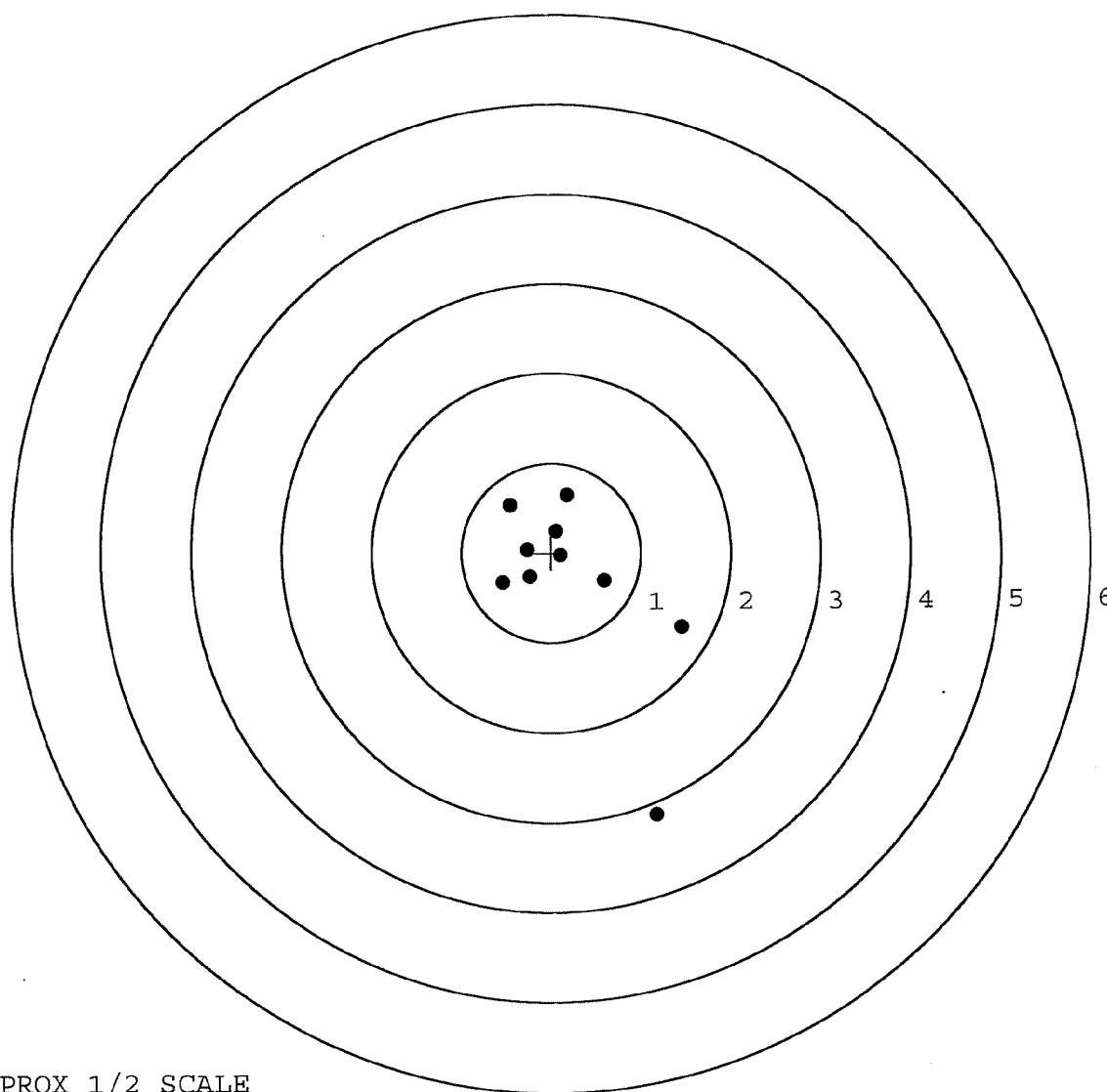
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.083
The Average Y Centroid of the Five Target Set:	-0.050
The Average Point of Impact of the Five Target Set:	0.097
The Average Mean Radius of the Five Target Set:	0.837
The Distance from POA to Centroid Target #1:	0.382
The Distance from Centroid Target #2 to Centroid Target #1:	0.457
The Distance from Centroid Target #3 to Centroid Target #1:	0.383
The Distance from Centroid Target #4 to Centroid Target #1:	0.300
The Distance from Centroid Target #5 to Centroid Target #1:	0.376

SERIAL NUMBER: G6410242.___1
TARGET NUMBER: 1
FILE DATE: 02/09/2005
FILE TIME: 07:45

X CENTROID: 0.201
Y CENTROID: -0.325
POA TO CENTROID: 0.382
HORZ SPREAD: 1.986
VERT SPREAD: 3.563
GROUP SPREAD: 3.813
MIN RADIUS: 0.309
MAX RADIUS: 2.765
MEAN RADIUS: 0.924
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.148	-2.923
2:	1.443	-0.843
3:	0.593	-0.316
4:	0.182	0.640
5:	-0.456	0.536
6:	0.055	0.245
7:	0.106	-0.031
8:	-0.543	-0.328
9:	-0.244	-0.269
10:	-0.270	0.038

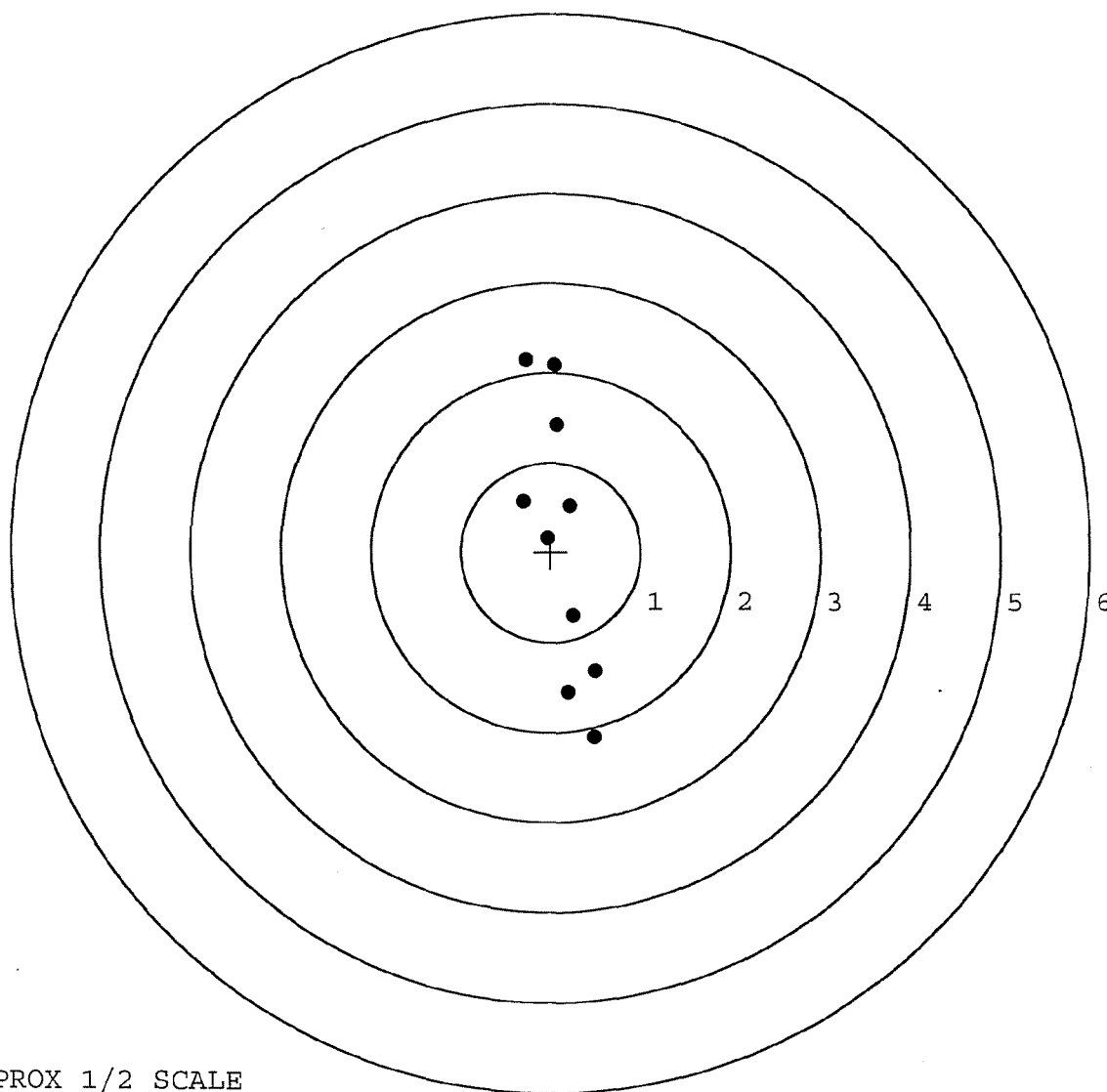


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410242. __ 1
TARGET NUMBER: 2
FILE DATE: 02/09/2005
FILE TIME: 07:45

X CENTROID: 0.116
Y CENTROID: 0.124
POA TO CENTROID: 0.170
HORZ SPREAD: 0.810
VERT SPREAD: 4.202
GROUP SPREAD: 4.273
MIN RADIUS: 0.157
MAX RADIUS: 2.215
MEAN RADIUS: 1.274
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 5

POINT#	X	Y
1:	0.496	-2.058
2:	0.201	-1.556
3:	0.502	-1.326
4:	0.255	-0.710
5:	-0.037	0.157
6:	0.220	0.515
7:	-0.308	0.566
8:	0.072	1.422
9:	0.042	2.085
10:	-0.282	2.144



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410242. __1

TARGET NUMBER: 3

FILE DATE: 02/09/2005

FILE TIME: 07:45

POINT#	X	Y
1:	-1.352	-2.014
2:	0.189	-0.576
3:	0.197	-0.362
4:	-0.522	-0.553
5:	0.182	0.257
6:	-0.063	0.275
7:	-0.008	0.008
8:	0.014	0.818
9:	0.317	1.047
10:	0.839	0.964

X CENTROID: -0.021

Y CENTROID: -0.014

POA TO CENTROID: 0.025

HORZ SPREAD: 2.191

VERT SPREAD: 3.061

GROUP SPREAD: 3.697

MIN RADIUS: 0.025

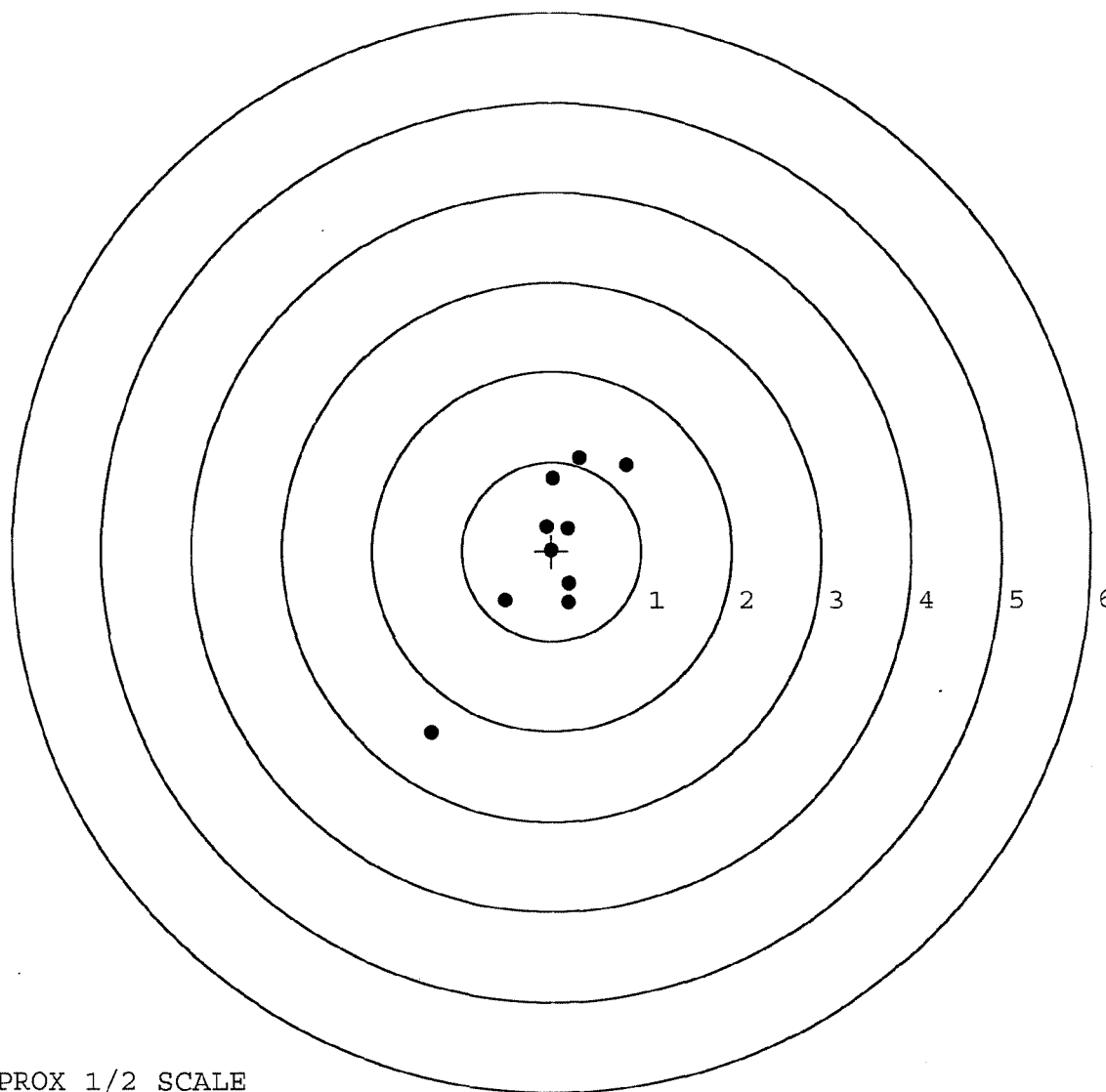
MAX RADIUS: 2.403

MEAN RADIUS: 0.805

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

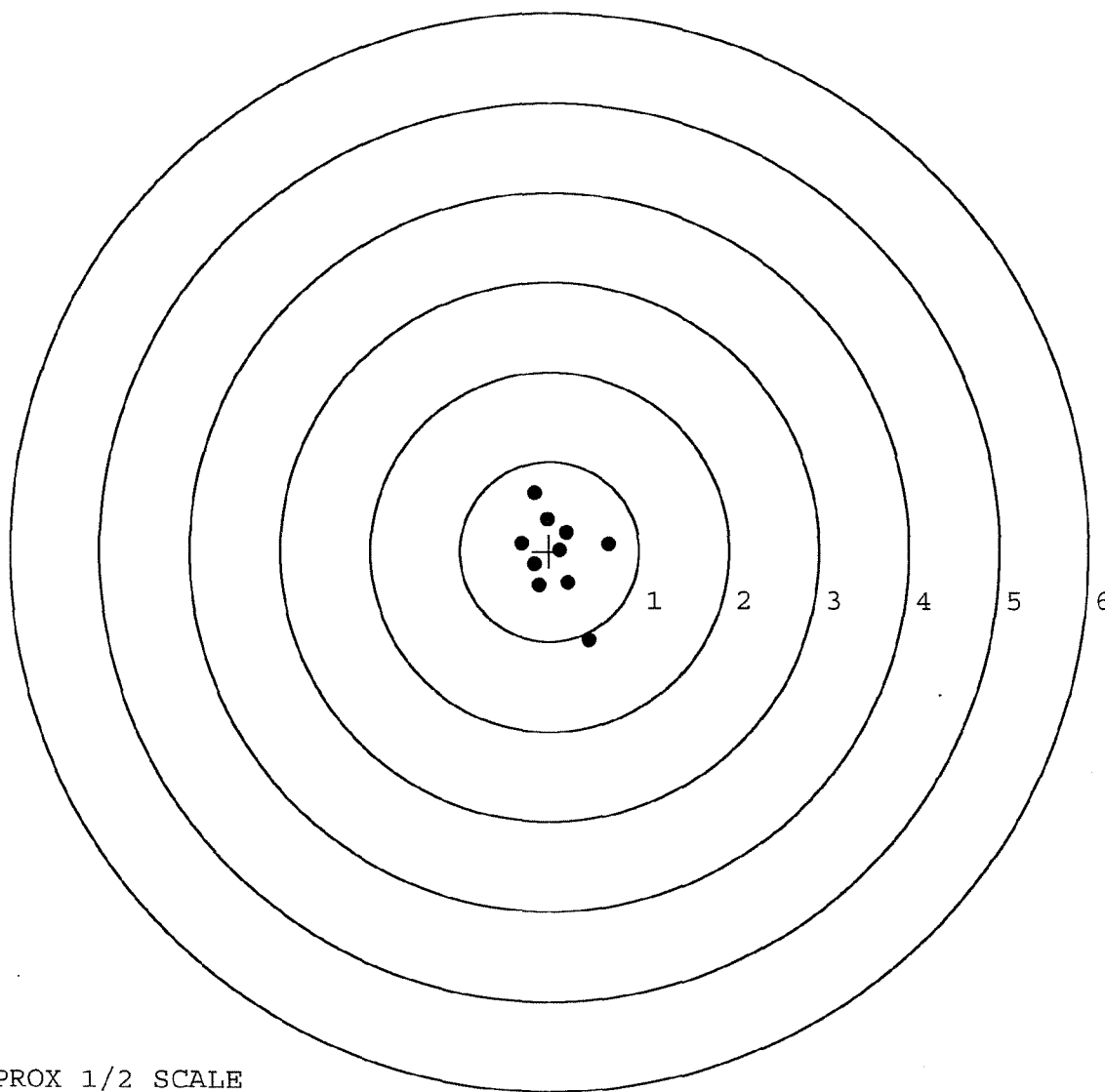


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410242. __1
TARGET NUMBER: 4
FILE DATE: 02/09/2005
FILE TIME: 07:45

X CENTROID: 0.083
Y CENTROID: -0.050
POA TO CENTROID: 0.097
HORZ SPREAD: 0.972
VERT SPREAD: 1.644
GROUP SPREAD: 1.756
MIN RADIUS: 0.068
MAX RADIUS: 1.010
MEAN RADIUS: 0.452
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.446	-0.992
2:	0.661	0.084
3:	-0.172	0.652
4:	0.188	0.208
5:	-0.027	0.354
6:	-0.311	0.081
7:	-0.168	-0.153
8:	-0.114	-0.382
9:	0.208	-0.359
10:	0.119	0.008



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410242. __1

TARGET NUMBER: 5

FILE DATE: 02/09/2005

FILE TIME: 07:45

POINT#	X	Y
1:	0.462	-0.413
2:	0.592	0.143
3:	0.294	0.069
4:	0.239	0.764
5:	0.764	1.054
6:	-0.437	0.677
7:	-0.559	-0.093
8:	-0.187	-0.508
9:	-0.216	-0.724
10:	-0.576	-0.840

X CENTROID: 0.038

Y CENTROID: 0.013

POA TO CENTROID: 0.040

HORZ SPREAD: 1.340

VERT SPREAD: 1.894

GROUP SPREAD: 2.320

MIN RADIUS: 0.262

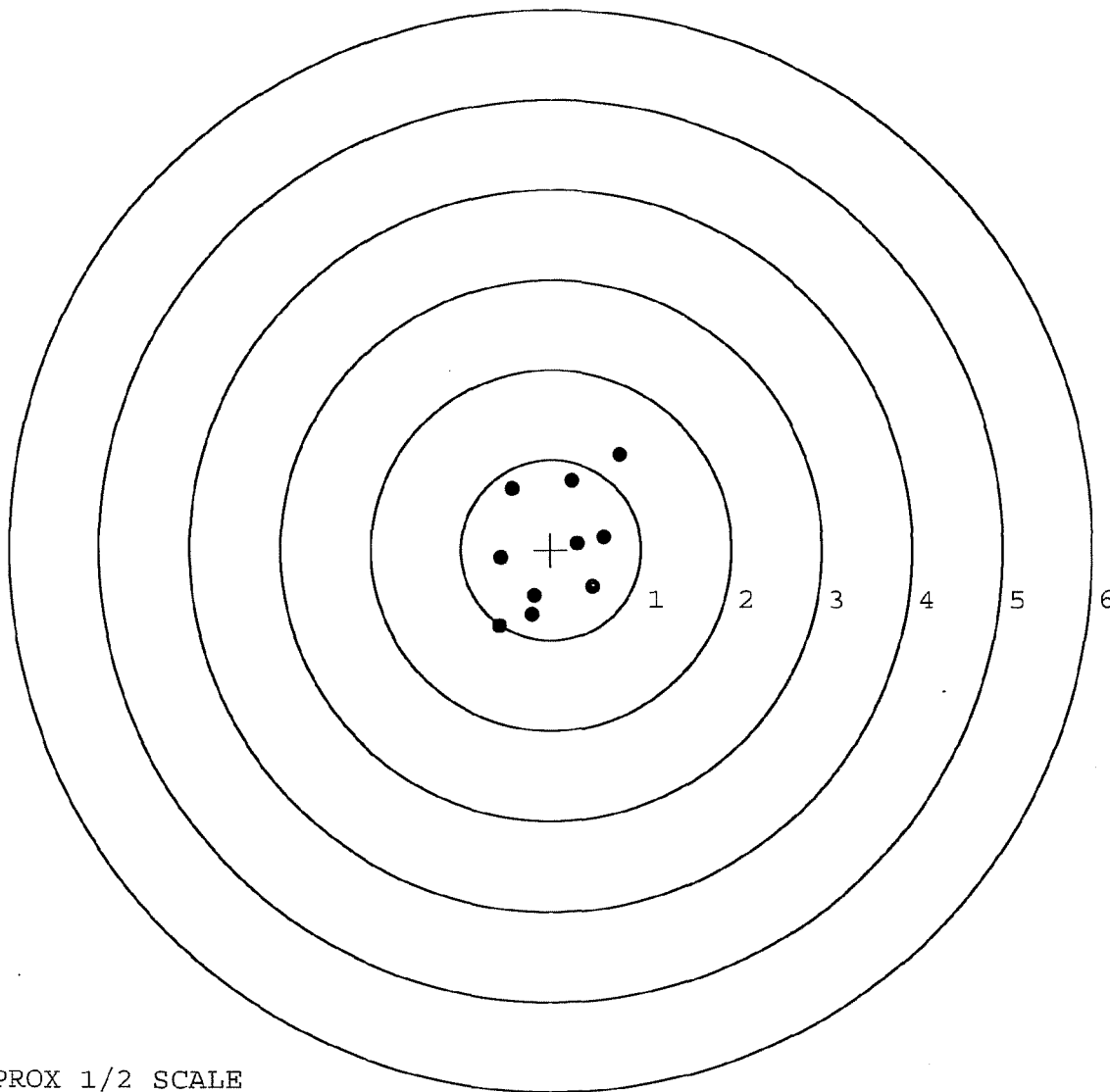
MAX RADIUS: 1.269

MEAN RADIUS: 0.730

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE