

G-6410245

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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UPC



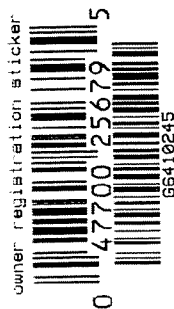
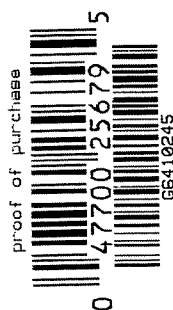
SERIAL NO.



**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

46 FORM 96253



ORDER NO. **25679**

BARREL LENGTH 24"

CAPACITY 6

G6410245



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410245

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420 & 430	ASSEMBLE ACTION ASSEMBLE TO STOCK		9-13-05	RTZ
440	PROOF		9-15-05	RTZ
460	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	9-16-05	RTZ
470	DIS-ASSEMBLE ACTION	SEP 20 2005	9-16-05	RTZ
480 & 490	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	4/80 MAGNETIC UNIT	9/20/05	WRM
500	ROLLMARK CALIBER		9-20-05	CW
510	DRILL AND TAP SIGHT HOLES		9-20-05	TRW
520	GOFF BLAST BBL / REC		9-21-05	LB
530 & 540	APPLY COATINGS (BARREL ACTION)		9/22	HP
	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		10-18-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-18-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-18-05	DA
	D) OIL FIRING PIN ASSEMBLY		10-20-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

REV-8405

OP #	OPERATION NAME	READINGS	DATE	INITIAL
560	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>2 16</u> <u>2 16</u> <u>2 16</u>	10-31-05	BC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 16</u> <u>2 16</u> <u>2 16</u>	10-31-05	BC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.022</u> <u>.022</u>	10-31-05	BC
	J) ASSEMBLE STOCK		10-20-05	RTL
	K) ASSEMBLE SWIVEL STUDS		10-31-05	BC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-31-05	BC
	M) IRON SIGHT ALIGNMENT		10-31-05	BC
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-31-05	BC
640 & 650	FUNCTION TEST AND TARGET	<u>PASS</u> FAIL <u>PASS</u> FAIL	10/22/05	MFG
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
660	INSPECT FOR LIVE AMMO		10/22/05	MFG
670	FINAL INSPECTION A) HEADSPACE		10-31-05	BC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.99</u> <u>2.58</u> <u>2.77</u> <u>2.33</u> <u>2.20</u>	10-25-05	BC
	C) FUNCTION		10-31-05	BC
690	PACK		11-1-05	RA

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)

DATE 10-19-05

TESTER RP

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.47	2.27		2.51	
PULL #2	2.38	2.66		2.71	
PULL #3	2.49	2.70		2.39	
PULL #4	2.46	2.29		2.52	
PULL #5	2.60	2.69		2.46	
TOTAL	12.40	12.61		12.59	
AVERAGE	2.48	2.52		2.51	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.02	3.37		
PULL #2	3.25	3.33		
PULL #3	3.10	3.37		
PULL #4	2.74	3.32		
PULL #5	2.71	3.42		
TOTAL	14.82	16.81		
AVERAGE	2.96	3.37		

	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	3.81	4.11		4.15
PULL #2	3.85	4.39		4.23
PULL #3	4.33	4.02		4.25
PULL #4	4.03	3.87		4.06
PULL #5	4.04	4.28		4.15
TOTAL	20.06	20.67		20.84
AVERAGE	4.01	4.13		4.16

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410245.__0
FILE DATE AND TIME: 10/22/2005 11:57

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.005
The Average Y Centroid of the Five Target Set:	-0.146
The Average Point of Impact of the Five Target Set:	0.146
The Average Mean Radius of the Five Target Set:	0.710
The Distance from POA to Centroid Target #1:	0.084
The Distance from Centroid Target #2 to Centroid Target #1:	0.072
The Distance from Centroid Target #3 to Centroid Target #1:	0.261
The Distance from Centroid Target #4 to Centroid Target #1:	0.098
The Distance from Centroid Target #5 to Centroid Target #1:	0.171

SERIAL NUMBER: G6410245. 0

TARGET NUMBER: 1

FILE DATE: 10/22/2005

FILE TIME: 11:57

POINT#	X	Y
1:	-0.057	0.377
2:	-0.223	0.530
3:	0.012	0.897
4:	0.263	0.638
5:	0.739	0.030
6:	0.181	-0.247
7:	0.022	-0.419
8:	-0.164	-0.304
9:	-0.421	-0.392
10:	0.285	-1.651

X CENTROID: 0.064

Y CENTROID: -0.054

POA TO CENTROID: 0.084

HORZ SPREAD: 1.160

VERT SPREAD: 2.548

GROUP SPREAD: 2.563

MIN RADIUS: 0.226

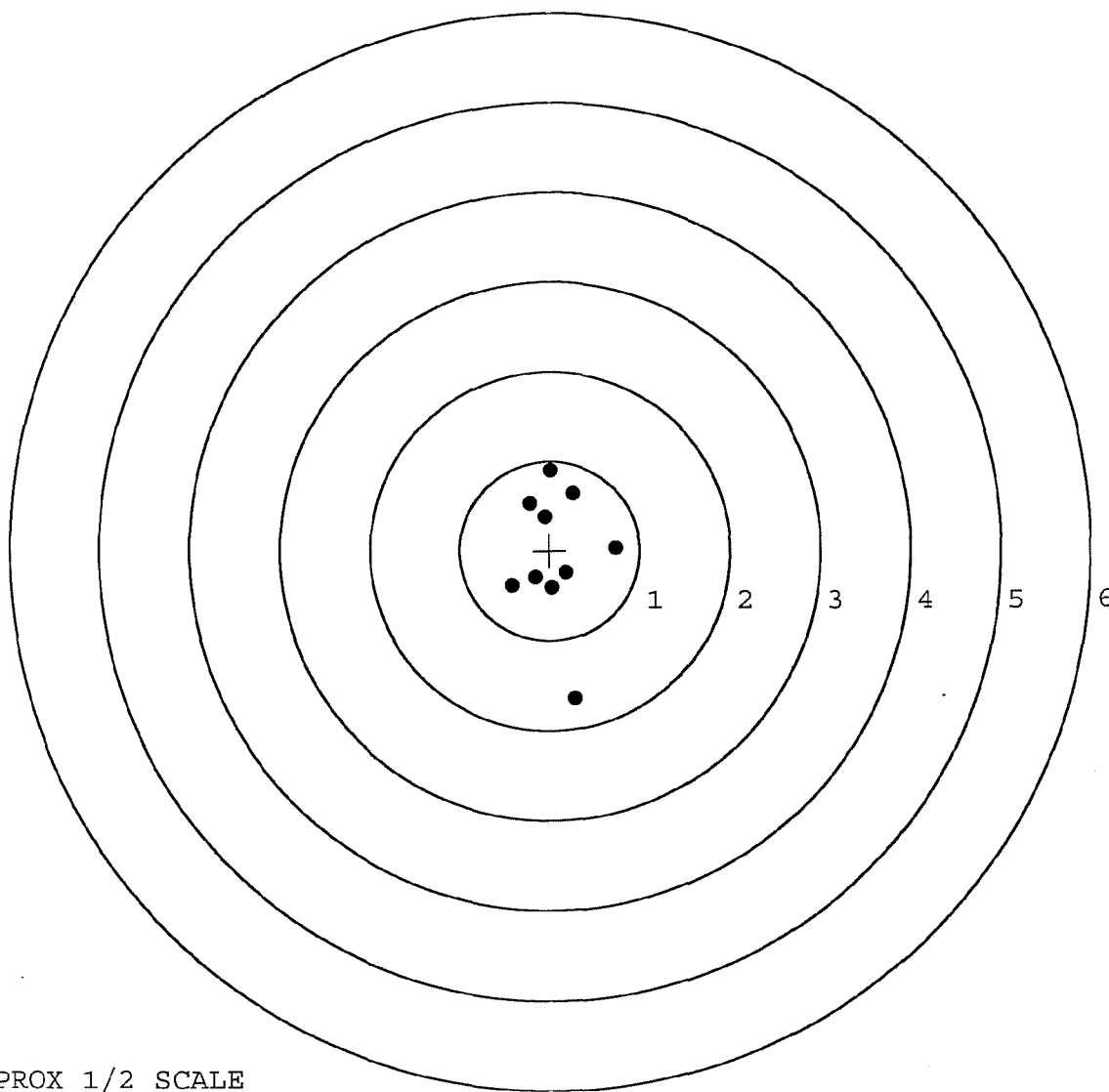
MAX RADIUS: 1.612

MEAN RADIUS: 0.659

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410245. 0

TARGET NUMBER: 2

FILE DATE: 10/22/2005

FILE TIME: 11:57

POINT#	X	Y
1:	-0.422	-0.023
2:	-0.528	-0.063
3:	-0.932	-0.408
4:	-0.209	-0.697
5:	-0.093	-0.313
6:	-0.029	-1.444
7:	0.936	-0.180
8:	1.011	0.614
9:	0.432	0.578
10:	0.254	0.713

X CENTROID: 0.042

Y CENTROID: -0.122

POA TO CENTROID: 0.129

HORZ SPREAD: 1.943

VERT SPREAD: 2.157

GROUP SPREAD: 2.306

MIN RADIUS: 0.234

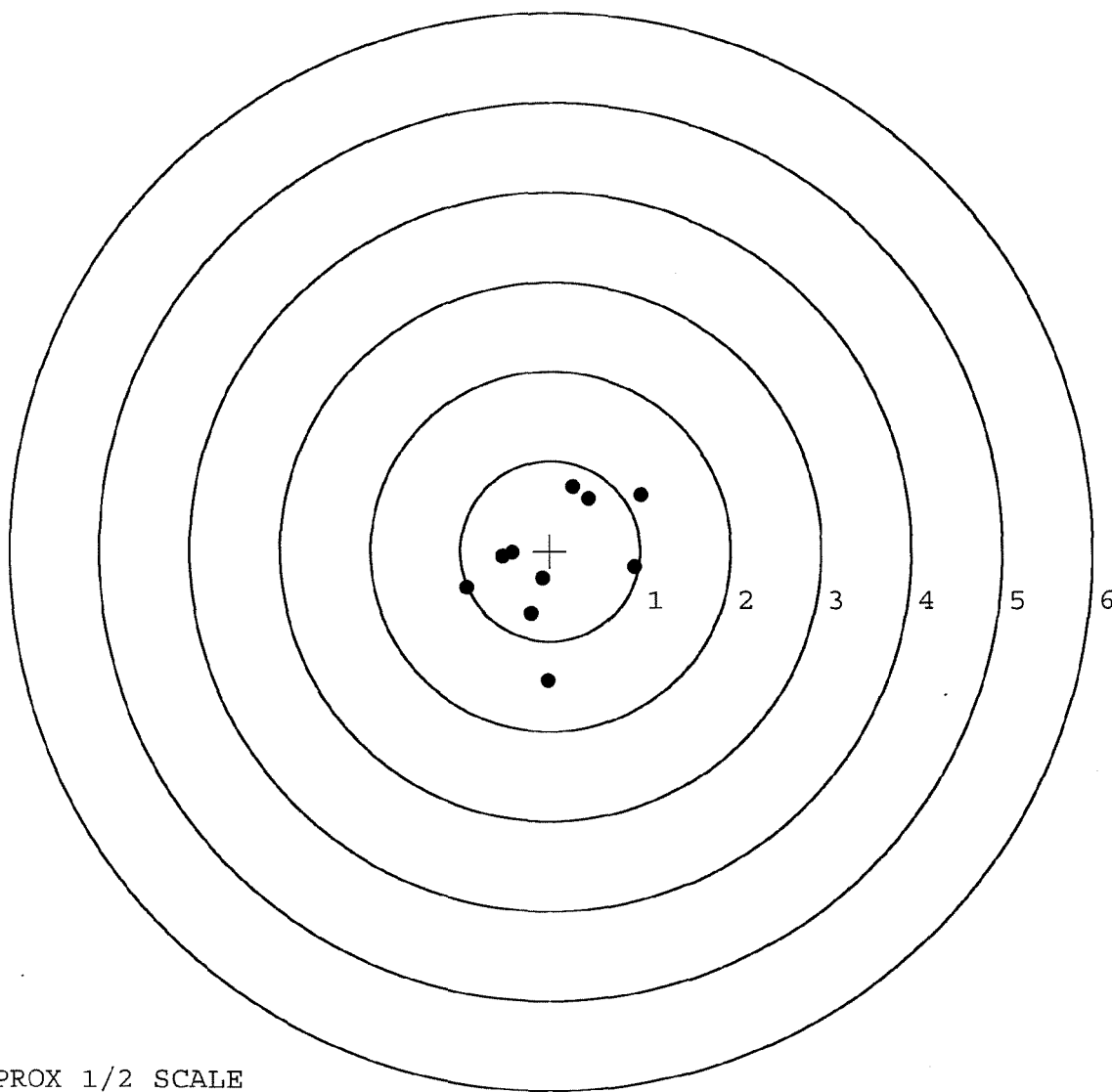
MAX RADIUS: 1.324

MEAN RADIUS: 0.802

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410245.___0

TARGET NUMBER: 3

FILE DATE: 10/22/2005

FILE TIME: 11:57

POINT#	X	Y
1:	-0.044	0.318
2:	0.239	0.811
3:	-0.140	-0.101
4:	-0.032	-0.313
5:	-0.376	-0.604
6:	-0.350	-0.981
7:	0.335	-0.951
8:	1.120	-0.057
9:	-0.293	-0.473
10:	-0.441	-0.723

X CENTROID: 0.002

Y CENTROID: -0.307

POA TO CENTROID: 0.307

HORZ SPREAD: 1.561

VERT SPREAD: 1.792

GROUP SPREAD: 1.736

MIN RADIUS: 0.034

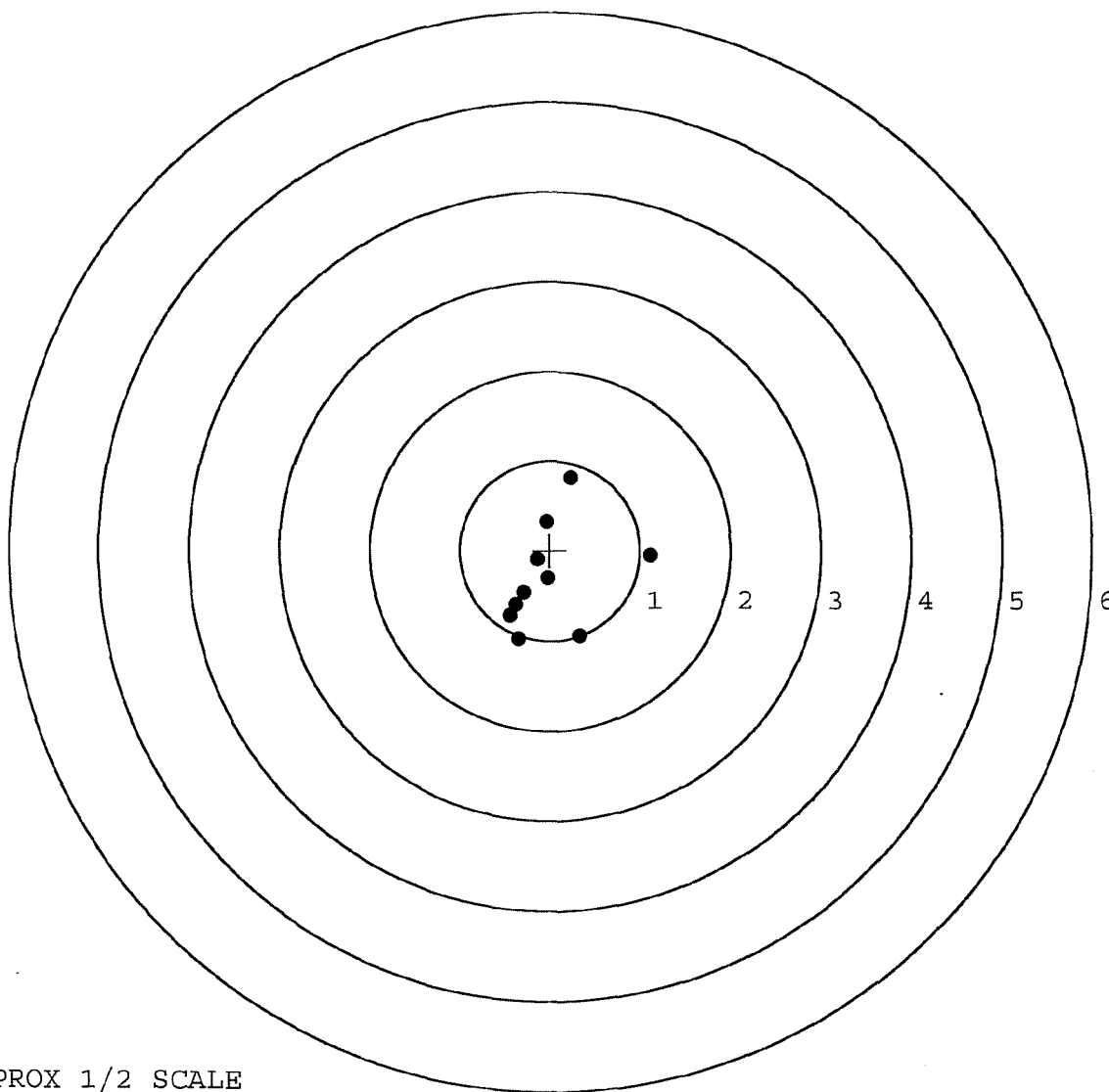
MAX RADIUS: 1.146

MEAN RADIUS: 0.611

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410245. __0

TARGET NUMBER: 4

FILE DATE: 10/22/2005

FILE TIME: 11:57

X CENTROID: -0.035

Y CENTROID: -0.059

POA TO CENTROID: 0.068

HORZ SPREAD: 1.394

VERT SPREAD: 2.191

GROUP SPREAD: 2.255

MIN RADIUS: 0.401

MAX RADIUS: 1.207

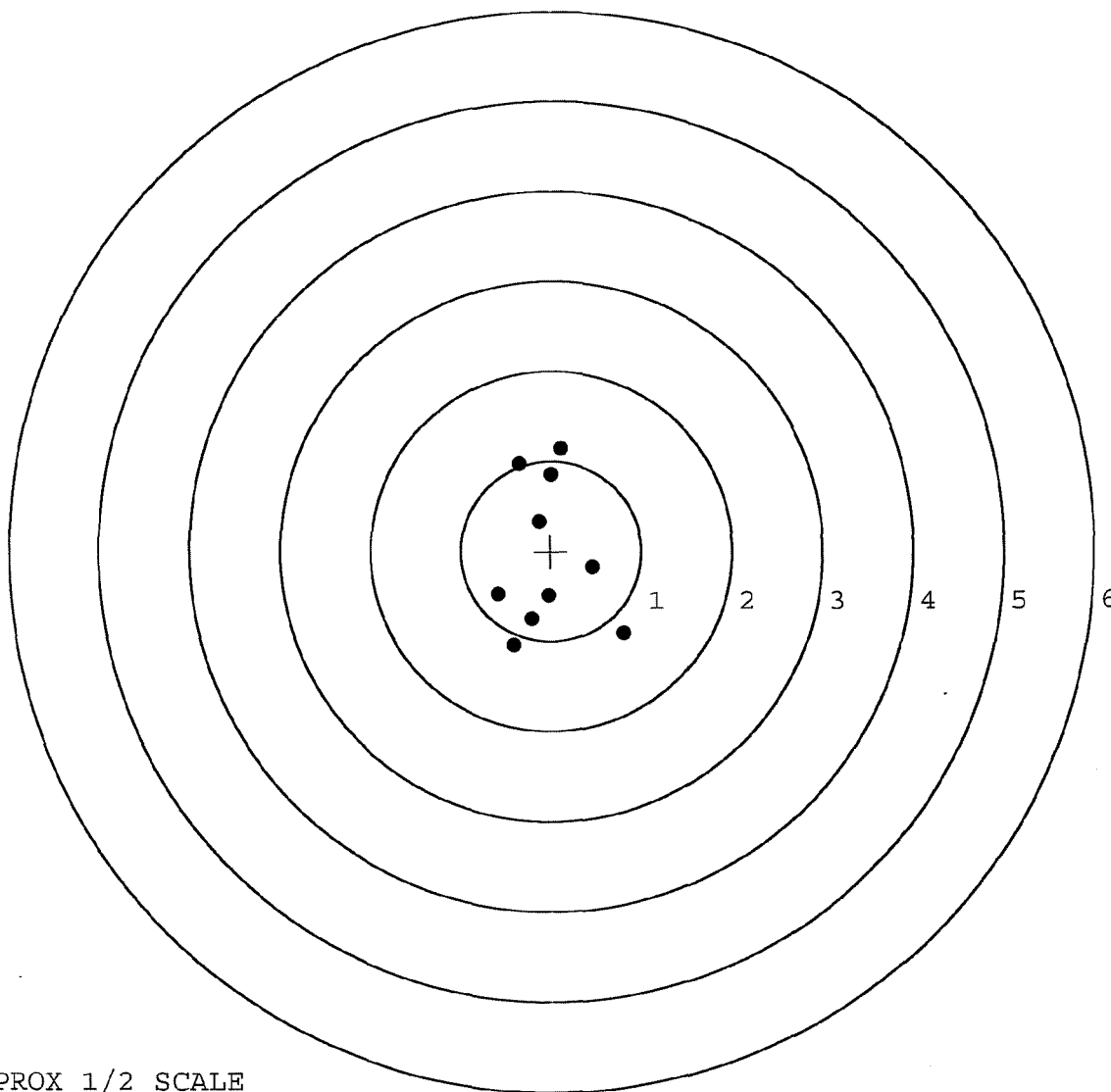
MEAN RADIUS: 0.821

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.138	0.328
2:	0.006	0.848
3:	0.120	1.138
4:	-0.353	0.967
5:	0.464	-0.177
6:	0.805	-0.918
7:	-0.033	-0.494
8:	-0.216	-0.756
9:	-0.412	-1.053
10:	-0.589	-0.474



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410245. __0

TARGET NUMBER: 5

FILE DATE: 10/22/2005

FILE TIME: 11:57

POINT#	X	Y
1:	0.124	0.649
2:	-0.314	0.496
3:	0.192	-0.127
4:	0.435	-0.088
5:	0.723	0.236
6:	-0.192	-0.351
7:	-0.595	-0.127
8:	-0.889	-0.509
9:	-0.197	-0.782
10:	0.245	-1.246

X CENTROID: -0.047

Y CENTROID: -0.185

POA TO CENTROID: 0.191

HORZ SPREAD: 1.612

VERT SPREAD: 1.895

GROUP SPREAD: 1.899

MIN RADIUS: 0.221

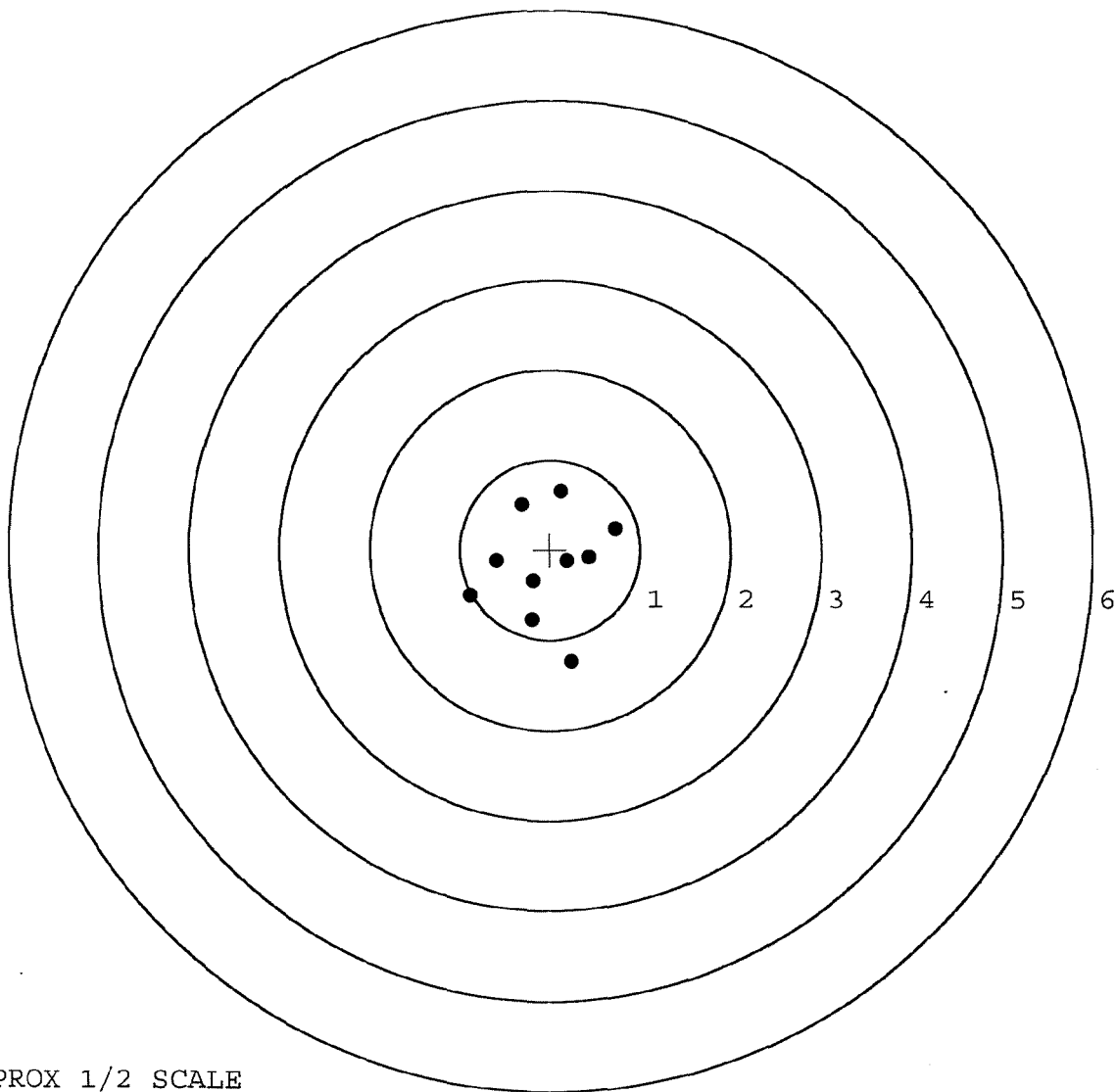
MAX RADIUS: 1.100

MEAN RADIUS: 0.659

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE