

G-641 0247

ORDER 25679

M/24 7.62 NATO S.W.S.

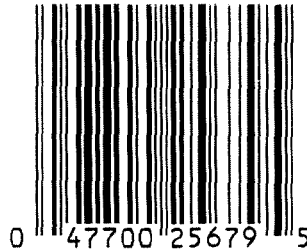
UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



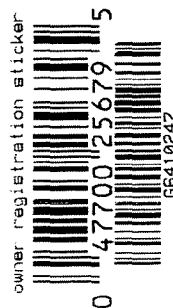
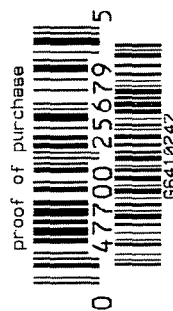
SERIAL NO.



**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
96187 - TRS BI POD ASSB

46 FORM 96253

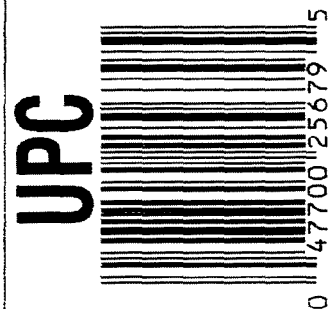


ORDER NO. **25679**

BARREL LENGTH **24"**

CAPACITY **6**

G6410247



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # GL440247

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-29-04	RTL
600	PROOF		12-29-04	RT
607	CHECK HEADSPACE		12-29-04	RT
610	DIS-ASSEMBLE GUN		12-30-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		12-30-04	RT
615	ROLLMARK CALIBER		1-3-05	CW
617	DRILL AND TAP SIGHT HOLES		12-30-04	TRW
620	APPLY COATINGS (BARREL ACTION)		1/8/05	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>6.2</u> <u>5.5</u> <u>5.5</u>	1-22-05	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.2</u> <u>2.2</u> <u>2.2</u>	1-22-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1023</u> <u>1025</u> <u>1023</u>	1-22-05	DA
	J) ASSEMBLE STOCK		1-22-05	RT
	K) ASSEMBLE SWIVEL STUDS		1-24-05	RT
	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	<u>PASS</u> FAIL	1-20-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-20-05	TRW
655	FINAL INSPECTION A) HEADSPACE		1-24-05	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u> <u>2.66</u> <u>2.46</u> <u>2.46</u> <u>2.22</u>	1-22-05	DA
	C) FUNCTION		1-24-05	RT
660	PACK		1-25-05	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

11.11.04

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.14	2.28		2.19	
PULL #2	2.41	2.64		2.27	
PULL #3	2.41	2.54		2.30	
PULL #4	2.53	2.44		2.20	
PULL #5	2.50	2.56		2.21	
TOTAL	11.99	12.46		11.17	
AVERAGE	2.39	2.49		2.23	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.08		
PULL #2	3.44	3.29		
PULL #3	3.35	3.27		
PULL #4	3.34	3.37		
PULL #5	3.55	3.44		
TOTAL	16.90	16.45		
AVERAGE	3.38	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	4.36	4.39		4.18
PULL #2	4.37	4.25		4.23
PULL #3	4.47	4.30		4.20
PULL #4	4.58	4.21		4.22
PULL #5	4.46	4.29		4.16
TOTAL	22.24	21.44		20.99
AVERAGE	4.44	4.28		4.19

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410247.__1

FILE DATE AND TIME: 09/27/2005 11:16

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.049
The Average Y Centroid of the Five Target Set:	-0.173
The Average Point of Impact of the Five Target Set:	0.180
The Average Mean Radius of the Five Target Set:	1.063
The Distance from POA to Centroid Target #1:	0.277
The Distance from Centroid Target #2 to Centroid Target #1:	0.481
The Distance from Centroid Target #3 to Centroid Target #1:	0.335
The Distance from Centroid Target #4 to Centroid Target #1:	0.341
The Distance from Centroid Target #5 to Centroid Target #1:	0.462

SERIAL NUMBER: G6410247. __1

TARGET NUMBER: 1

FILE DATE: 09/27/2005

FILE TIME: 11:16

POINT#	X	Y
1:	0.383	-1.685
2:	0.342	-1.429
3:	1.080	-0.621
4:	0.453	0.074
5:	0.225	0.215
6:	0.974	1.014
7:	-0.032	0.461
8:	-0.362	0.383
9:	-0.925	0.177
10:	0.249	0.014

X CENTROID: 0.239

Y CENTROID: -0.140

POA TO CENTROID: 0.277

HORZ SPREAD: 2.005

VERT SPREAD: 2.699

GROUP SPREAD: 2.763

MIN RADIUS: 0.154

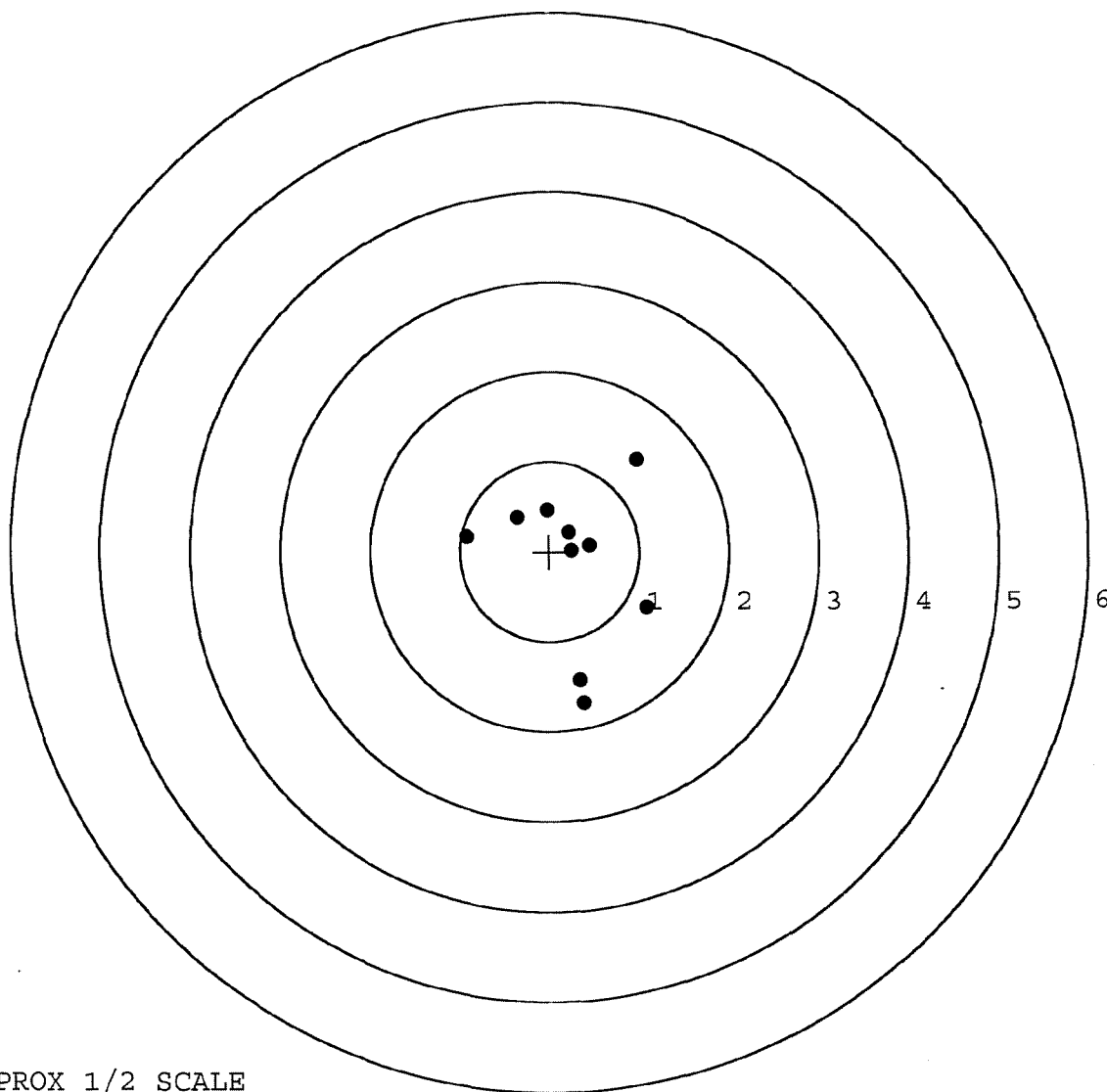
MAX RADIUS: 1.552

MEAN RADIUS: 0.866

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9



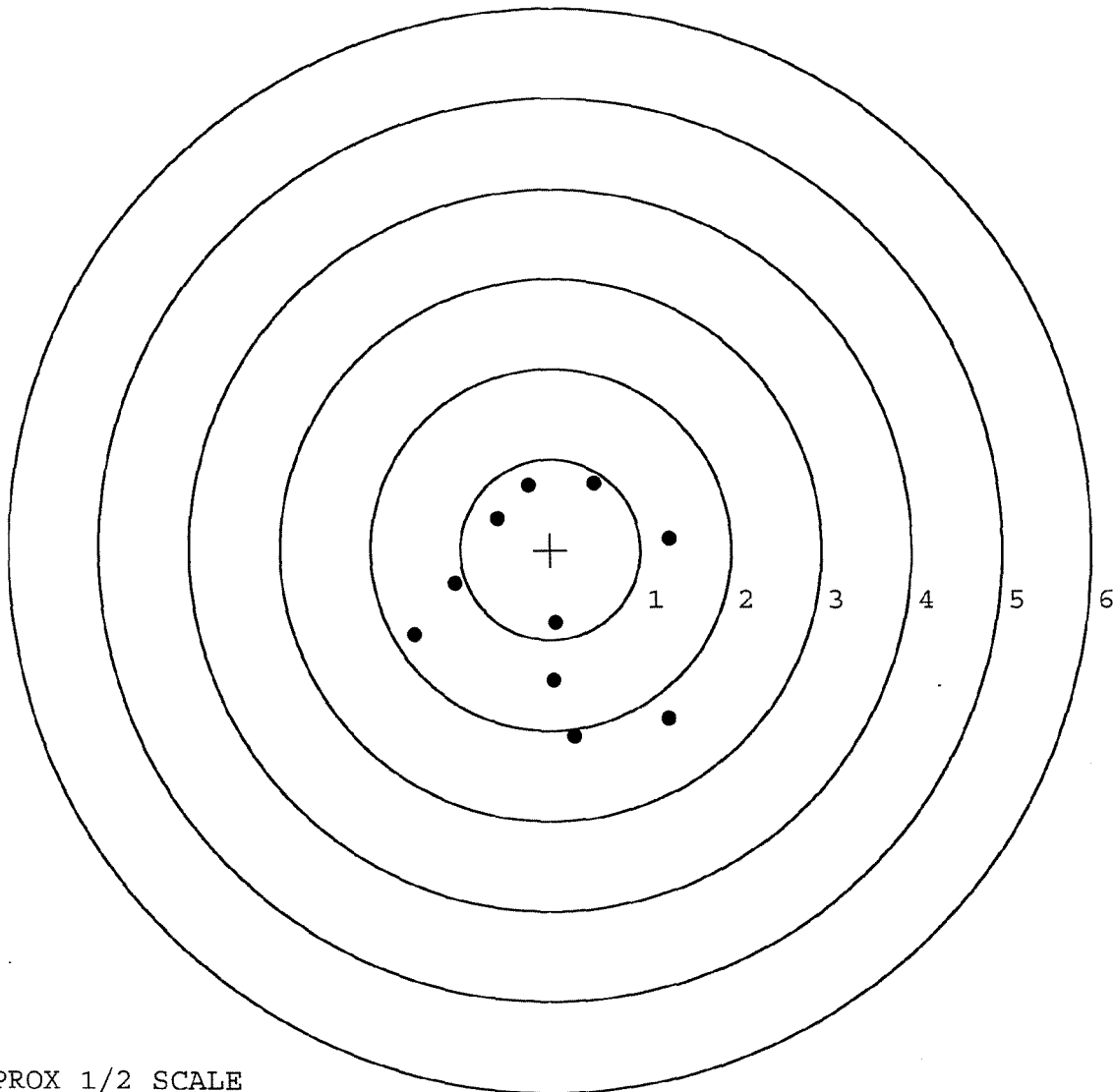
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410247. __1
TARGET NUMBER: 2
FILE DATE: 09/27/2005
FILE TIME: 11:16

X CENTROID: 0.011
Y CENTROID: -0.563
POA TO CENTROID: 0.563
HORZ SPREAD: 2.828
VERT SPREAD: 2.807
GROUP SPREAD: 3.024
MIN RADIUS: 0.262
MAX RADIUS: 1.855
MEAN RADIUS: 1.244

POINT#	X	Y
1:	1.318	0.120
2:	0.490	0.739
3:	-0.243	0.710
4:	-0.590	0.350
5:	0.063	-0.820
6:	-1.056	-0.378
7:	-1.510	-0.951
8:	0.041	-1.455
9:	0.275	-2.068
10:	1.317	-1.880

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 2
in 3 IN DIAMETER: 7

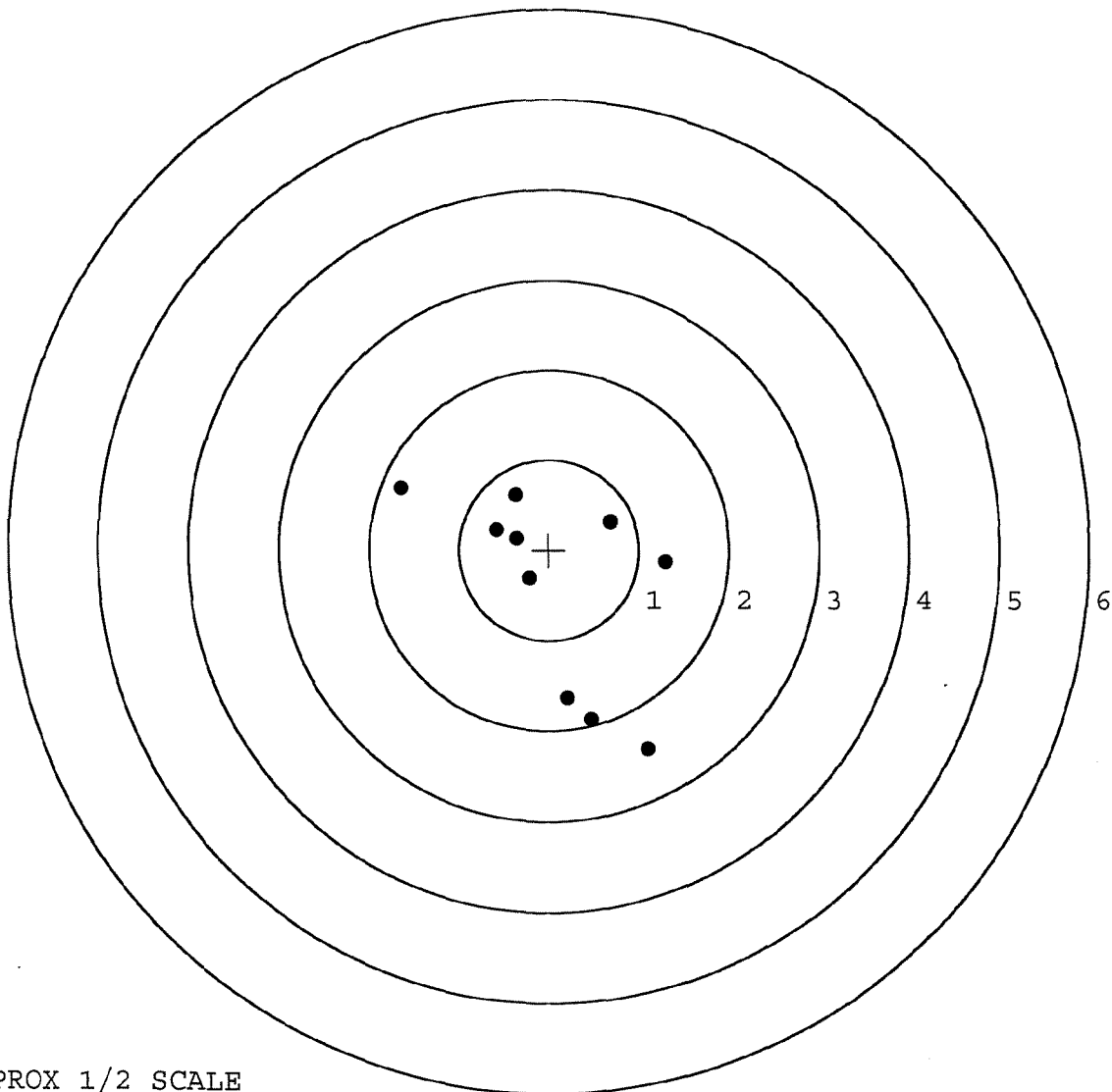


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410247. __1
TARGET NUMBER: 3
FILE DATE: 09/27/2005
FILE TIME: 11:16

POINT#	X	Y
1:	1.300	-0.136
2:	0.685	0.319
3:	-0.215	-0.319
4:	-0.359	0.123
5:	-0.582	0.225
6:	-0.369	0.606
7:	-1.653	0.682
8:	0.219	-1.644
9:	0.475	-1.881
10:	1.104	-2.211

X CENTROID: 0.060
Y CENTROID: -0.424
POA TO CENTROID: 0.428
HORZ SPREAD: 2.953
VERT SPREAD: 2.893
GROUP SPREAD: 3.996
MIN RADIUS: 0.295
MAX RADIUS: 2.070
MEAN RADIUS: 1.211
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 7

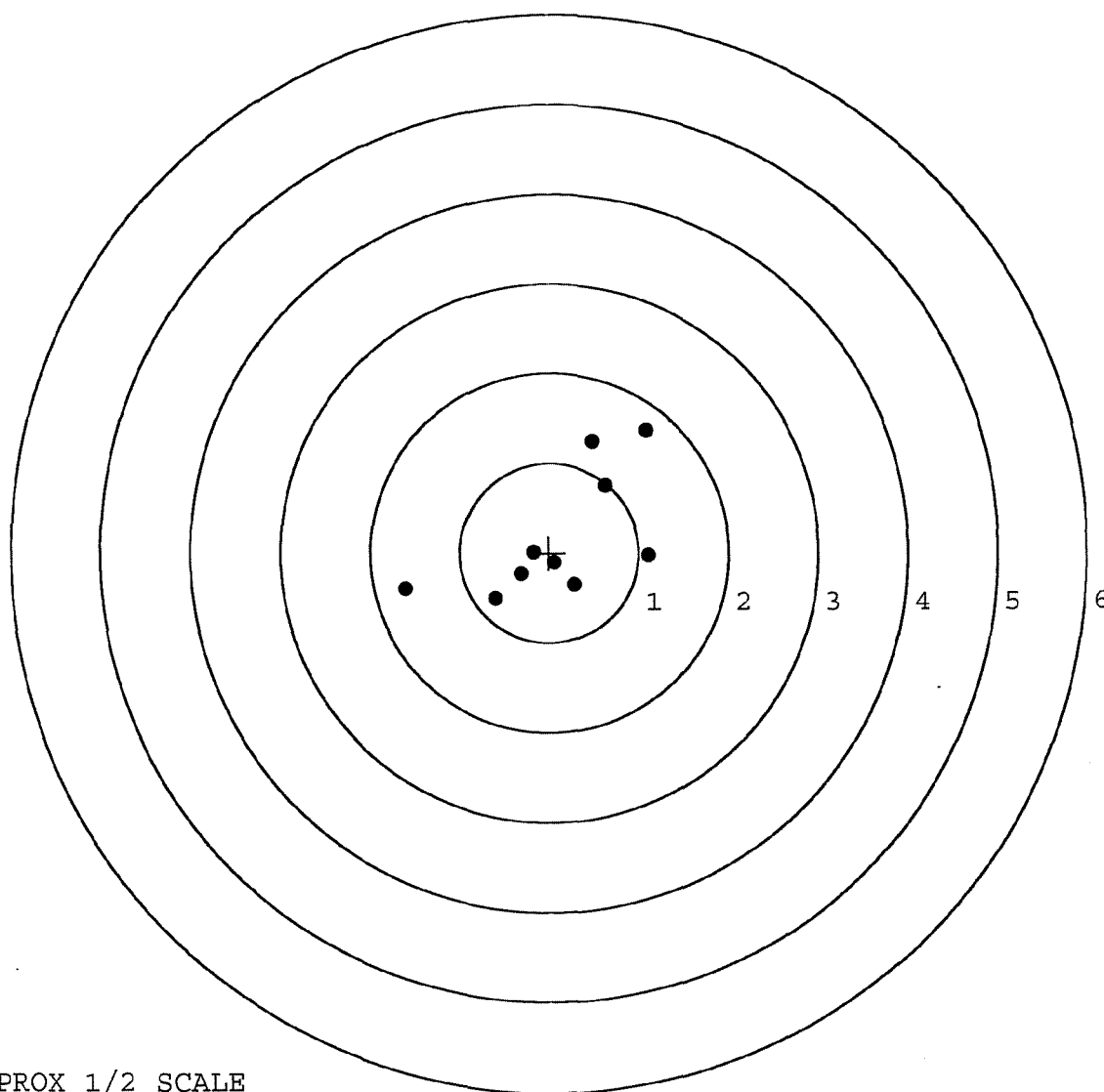


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410247.___1
TARGET NUMBER: 4
FILE DATE: 09/27/2005
FILE TIME: 11:16

X CENTROID: 0.096
Y CENTROID: 0.170
POA TO CENTROID: 0.195
HORZ SPREAD: 2.722
VERT SPREAD: 1.858
GROUP SPREAD: 3.216
MIN RADIUS: 0.280
MAX RADIUS: 1.799
MEAN RADIUS: 0.901
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.110	-0.038
2:	0.627	0.748
3:	0.488	1.236
4:	1.089	1.350
5:	0.285	-0.364
6:	0.065	-0.109
7:	-0.175	0.012
8:	-0.317	-0.236
9:	-0.601	-0.508
10:	-1.612	-0.395



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410247. __1

TARGET NUMBER: 5

FILE DATE: 09/27/2005

FILE TIME: 11:16

X CENTROID: -0.162

Y CENTROID: 0.090

POA TO CENTROID: 0.185

HORZ SPREAD: 3.239

VERT SPREAD: 3.236

GROUP SPREAD: 3.243

MIN RADIUS: 0.163

MAX RADIUS: 2.106

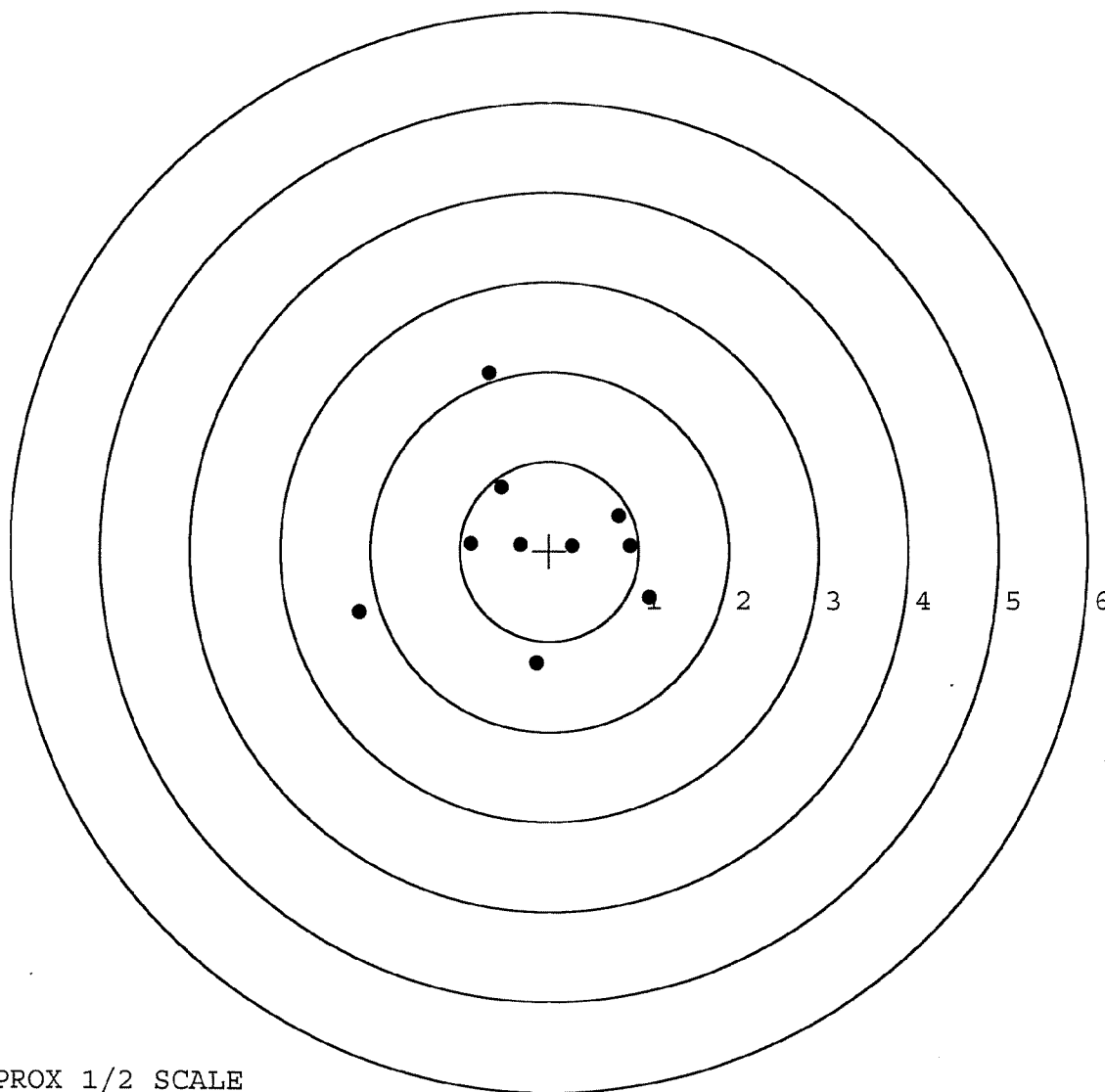
MEAN RADIUS: 1.091

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.118	-0.524
2:	0.906	0.058
3:	0.777	0.388
4:	0.258	0.054
5:	-0.323	0.067
6:	-0.879	0.086
7:	-0.535	0.709
8:	-0.142	-1.246
9:	-2.121	-0.682
10:	-0.680	1.990



TARGET APPROX 1/2 SCALE