

G6410258

**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

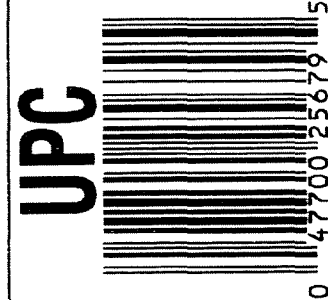


ORDER NO. 25679

BARREL LENGTH 24"

CAPACITY 6

G6410258



ORDER — 25679

M/24 7.62 NATO S.W.S.

UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



SERIAL NO.



3/11/2005 9:25:01 AM

Original

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 # G6410258

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-27-04	RT
600	PROOF		12-28-04	A
607	CHECK HEADSPACE		12-28-04	A
610	DIS-ASSEMBLE GUN		12-28-04	RT
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		12/29/04	AS
617	DRILL AND TAP SIGHT HOLES		12-28-04	TRW
620	APPLY COATINGS (BARREL ACTION)		1/5/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-9-05	RT
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-9-05	RT
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-9-05	RT
	D) OIL FIRING PIN ASSEMBLY		2-9-05	RT
	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>7 16s</u> <u>7 16s</u> <u>7 16s</u>	2-17-05	AC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 16s</u> <u>3 16s</u> <u>3 16s</u>	2-17-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		2	
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	2-17-05	AC
	J) ASSEMBLE STOCK		2-9-05	RT
	K) ASSEMBLE SWIVEL STUDS		2-18-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-9-05	RT
	M) IRON SIGHT ALIGNMENT		2-9-05	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-9-05	RT
640	GALLERY TEST AND TARGET	PASS FAIL	2-14-05	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-14-05	TRW
655	FINAL INSPECTION A) HEADSPACE		2-17-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.78</u> <u>2.49</u> <u>2.67</u> <u>2.57</u> <u>2.77</u>	2-17-05	TRW
	C) FUNCTION		2-17-05	AC
660	PACK		3/18/05	RA

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 2-1-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.37	2.33		2.19	
PULL #2	2.28	2.46		2.44	
PULL #3	2.53	2.50		2.34	
PULL #4	2.52	2.43		2.40	
PULL #5	2.60	2.52		2.36	
TOTAL	12.30	12.24		11.73	
AVERAGE	2.46	2.44		2.34	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.20		
PULL #2	3.30	3.09		
PULL #3	3.54	3.19		
PULL #4	3.42	3.13		
PULL #5	3.46	3.18		
TOTAL	17.05	15.79		
AVERAGE	3.41	3.15		

	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	4.22	4.07		4.19
PULL #2	4.27	4.08		4.04
PULL #3	4.27	4.15		4.12
PULL #4	4.29	4.13		4.15
PULL #5	4.20	4.19		4.17
TOTAL	21.25	20.62		20.67
AVERAGE	4.25	4.12		4.13

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410258.__0
FILE DATE AND TIME: 02/14/2005 07:39

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.074
The Average Y Centroid of the Five Target Set:	-0.042
The Average Point of Impact of the Five Target Set:	0.085
The Average Mean Radius of the Five Target Set:	0.911
The Distance from POA to Centroid Target #1:	0.048
The Distance from Centroid Target #2 to Centroid Target #1:	0.073
The Distance from Centroid Target #3 to Centroid Target #1:	0.218
The Distance from Centroid Target #4 to Centroid Target #1:	0.367
The Distance from Centroid Target #5 to Centroid Target #1:	0.263

SERIAL NUMBER: G6410258. 0

TARGET NUMBER: 1

FILE DATE: 02/14/2005

FILE TIME: 07:39

X CENTROID: -0.010

Y CENTROID: -0.047

POA TO CENTROID: 0.048

HORZ SPREAD: 2.538

VERT SPREAD: 2.583

GROUP SPREAD: 2.594

MIN RADIUS: 0.143

MAX RADIUS: 1.436

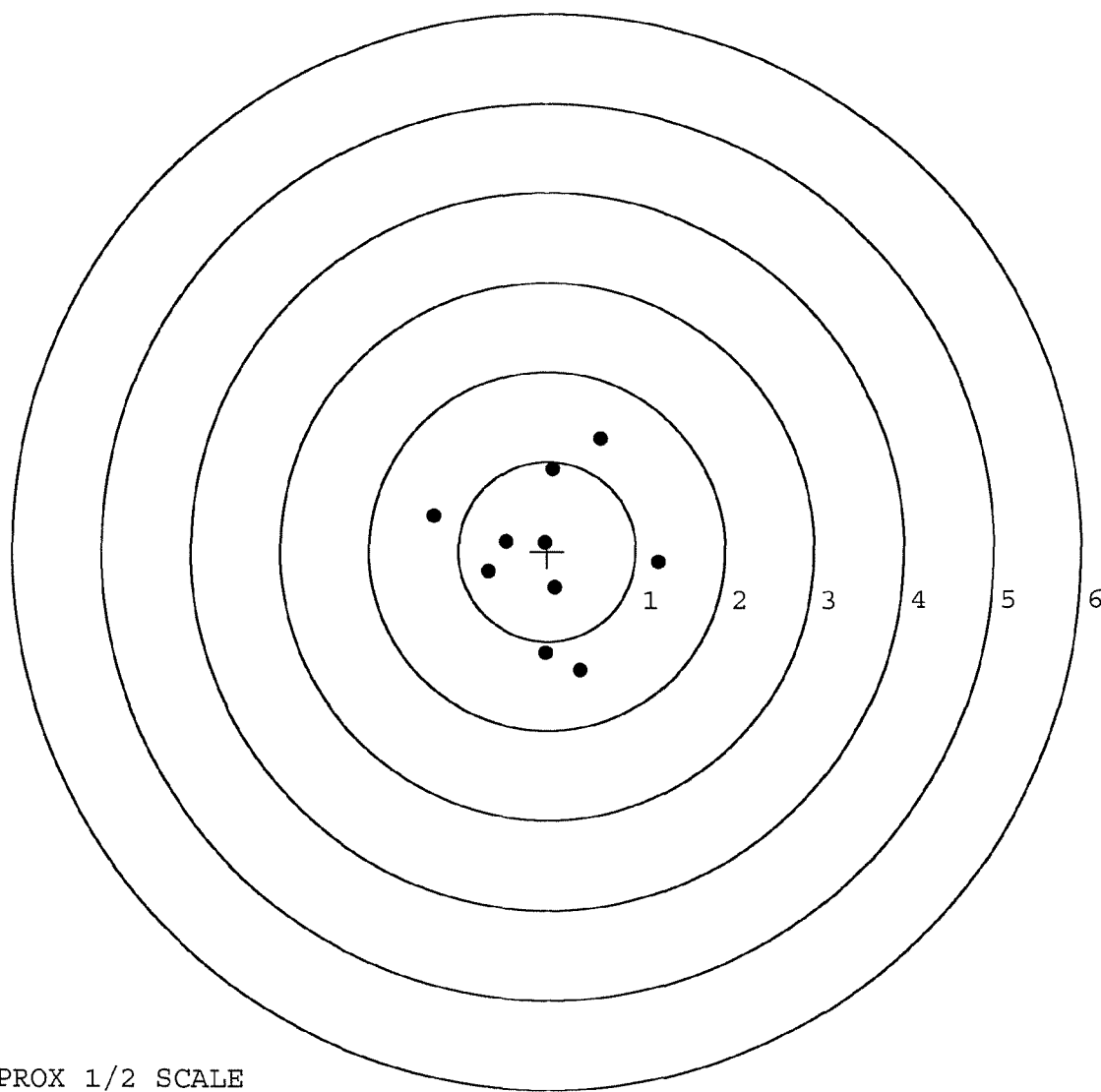
MEAN RADIUS: 0.912

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.259	-0.133
2:	0.364	-1.330
3:	-0.032	-1.135
4:	0.082	-0.409
5:	-0.028	0.095
6:	-0.468	0.112
7:	-0.662	-0.230
8:	-1.279	0.393
9:	0.064	0.918
10:	0.601	1.253



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410258. __0

TARGET NUMBER: 2

FILE DATE: 02/14/2005

FILE TIME: 07:39

X CENTROID: -0.079

Y CENTROID: -0.071

POA TO CENTROID: 0.106

HORZ SPREAD: 2.382

VERT SPREAD: 3.799

GROUP SPREAD: 3.975

MIN RADIUS: 0.390

MAX RADIUS: 2.111

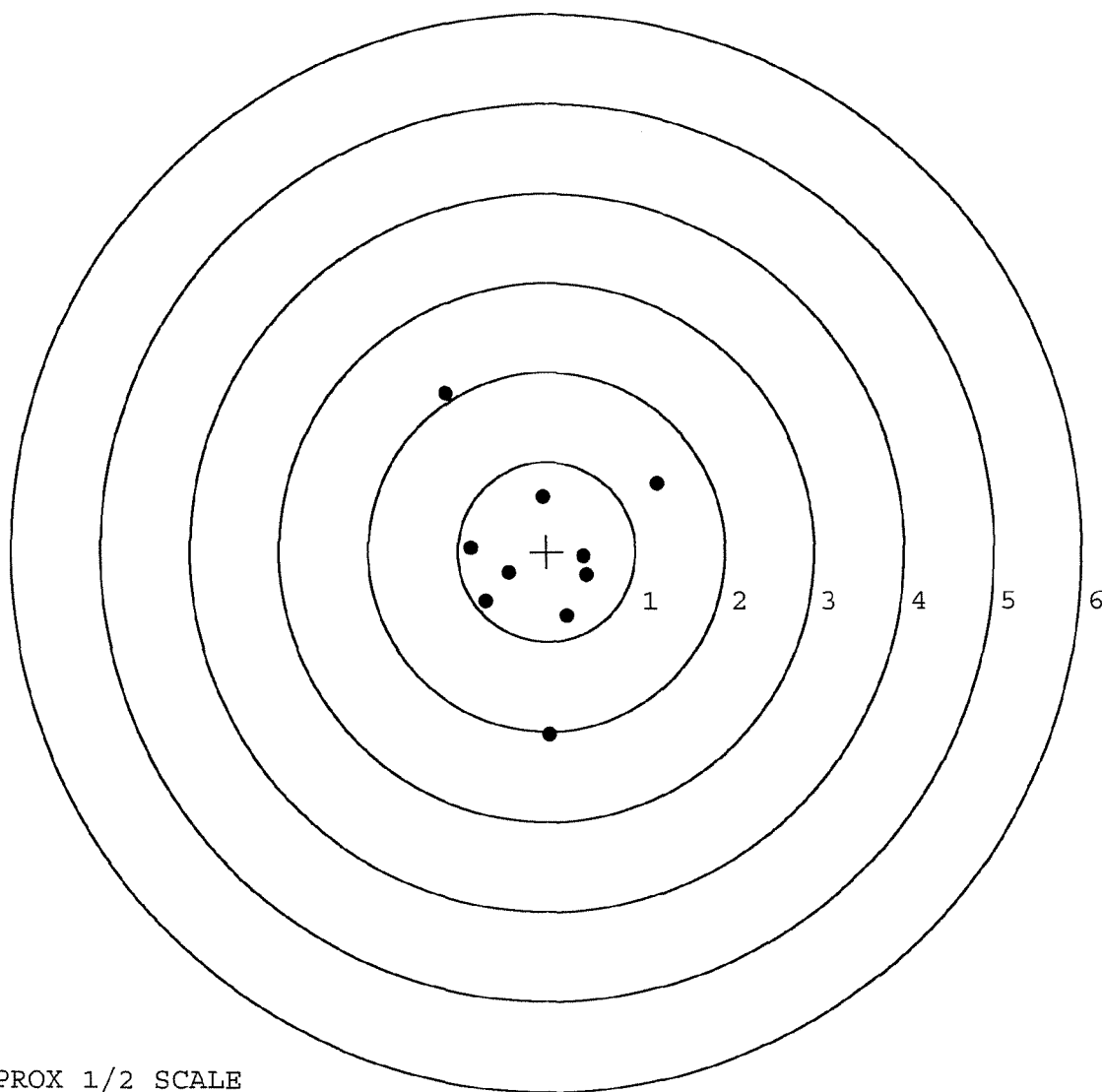
MEAN RADIUS: 1.005

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	0.030	-2.044
2:	1.243	0.756
3:	0.416	-0.052
4:	0.453	-0.261
5:	0.225	-0.715
6:	-0.428	-0.244
7:	-0.687	-0.557
8:	-0.852	0.045
9:	-0.049	0.610
10:	-1.139	1.755



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410258. 0

TARGET NUMBER: 3

FILE DATE: 02/14/2005

FILE TIME: 07:39

X CENTROID: -0.158

Y CENTROID: 0.114

POA TO CENTROID: 0.194

HORZ SPREAD: 3.332

VERT SPREAD: 2.101

GROUP SPREAD: 3.344

MIN RADIUS: 0.293

MAX RADIUS: 2.236

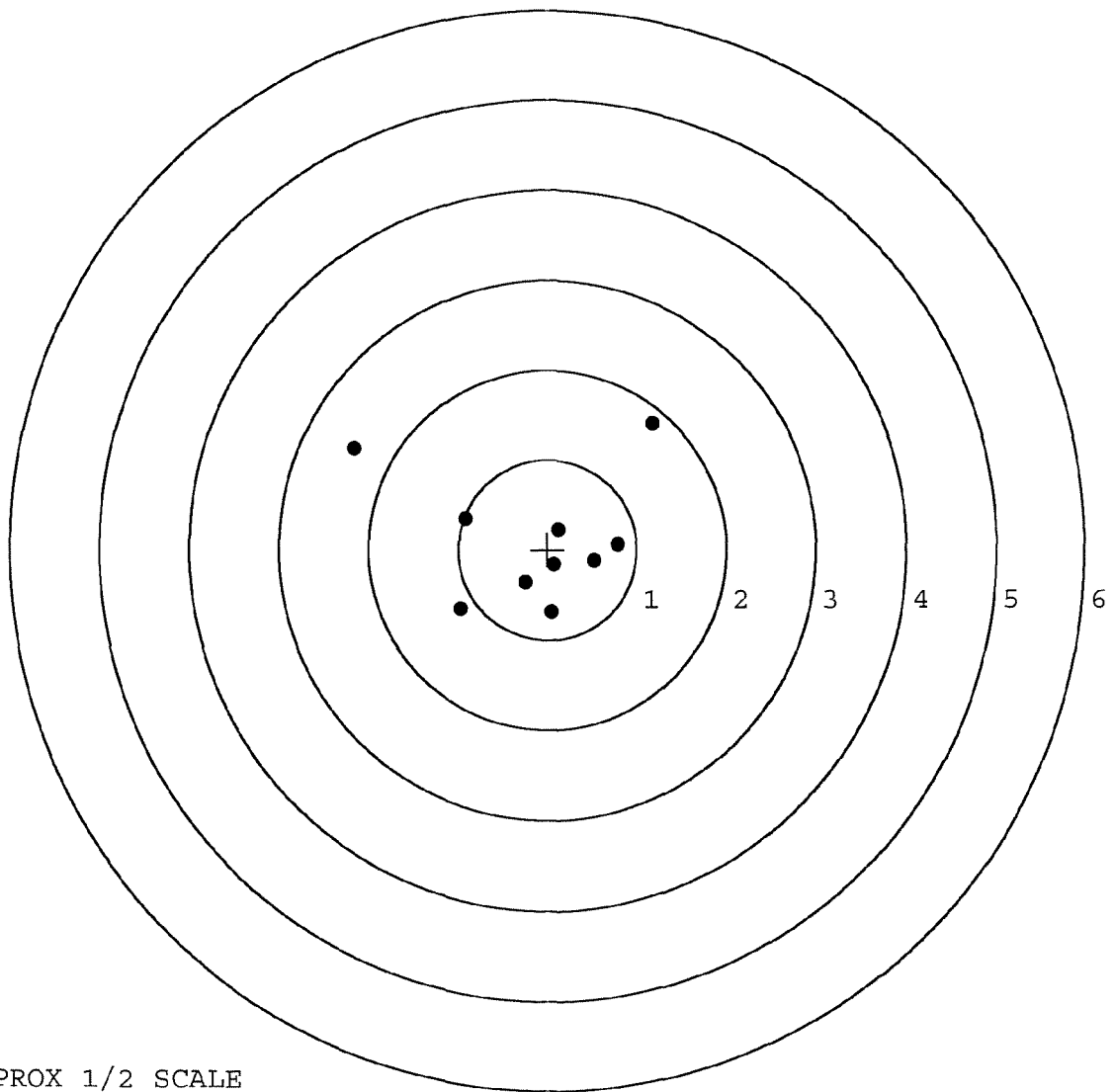
MEAN RADIUS: 0.968

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.178	1.404
2:	-0.926	0.345
3:	-2.154	1.122
4:	-0.975	-0.661
5:	0.045	-0.697
6:	-0.247	-0.367
7:	0.072	-0.169
8:	0.115	0.220
9:	0.523	-0.126
10:	0.791	0.065



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410258. 0

TARGET NUMBER: 4

FILE DATE: 02/14/2005

FILE TIME: 07:39

X CENTROID: -0.043

Y CENTROID: -0.412

POA TO CENTROID: 0.414

HORZ SPREAD: 2.213

VERT SPREAD: 2.321

GROUP SPREAD: 2.358

MIN RADIUS: 0.073

MAX RADIUS: 1.569

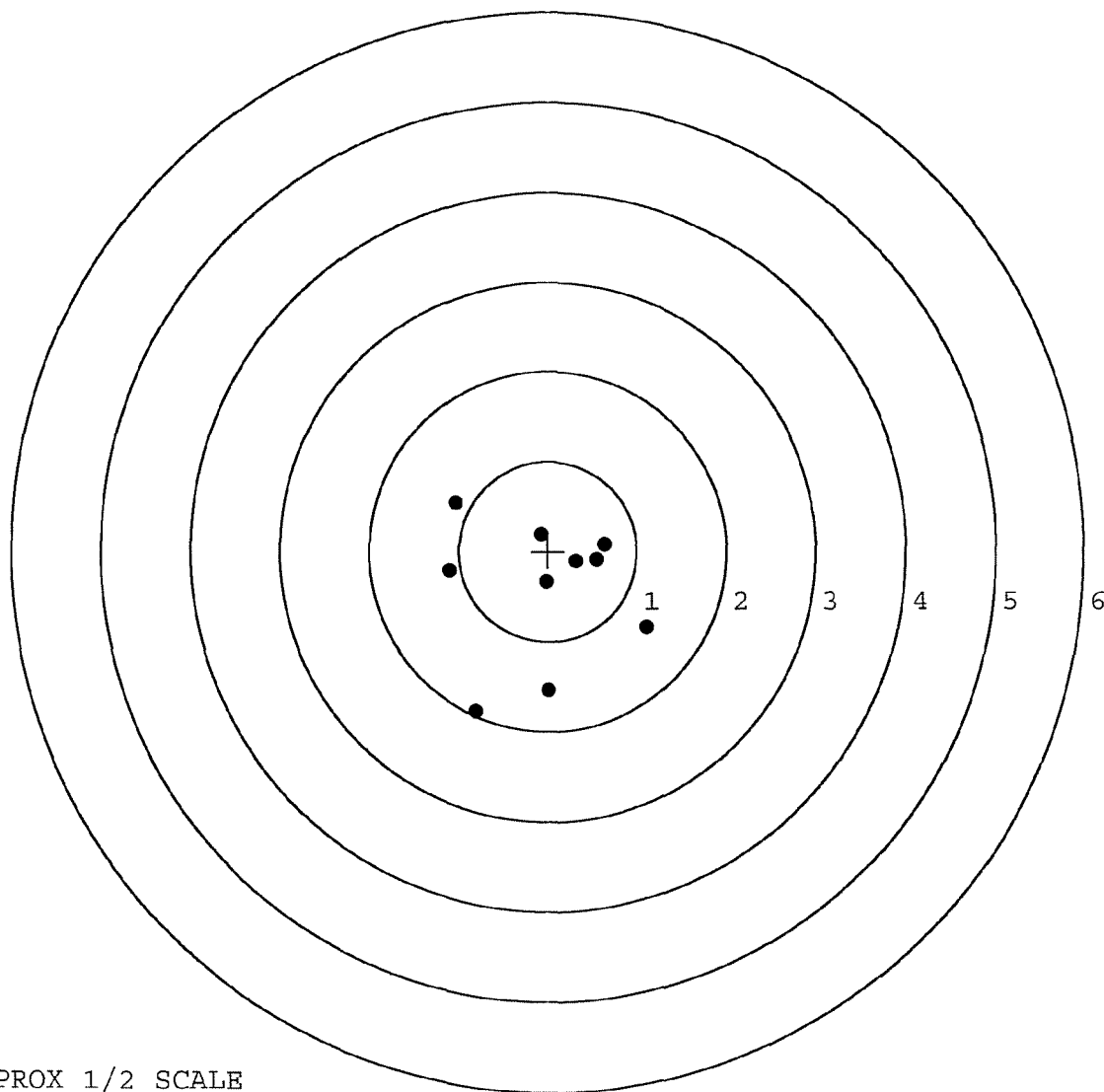
MEAN RADIUS: 0.905

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.107	-0.846
2:	0.011	-1.549
3:	-0.811	-1.780
4:	-1.106	-0.214
5:	-1.036	0.541
6:	0.636	0.082
7:	0.550	-0.092
8:	-0.078	0.189
9:	-0.022	-0.342
10:	0.317	-0.111



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410258. __0

TARGET NUMBER: 5

FILE DATE: 02/14/2005

FILE TIME: 07:39

X CENTROID: -0.080

Y CENTROID: 0.207

POA TO CENTROID: 0.222

HORZ SPREAD: 2.510

VERT SPREAD: 1.699

GROUP SPREAD: 2.603

MIN RADIUS: 0.080

MAX RADIUS: 1.568

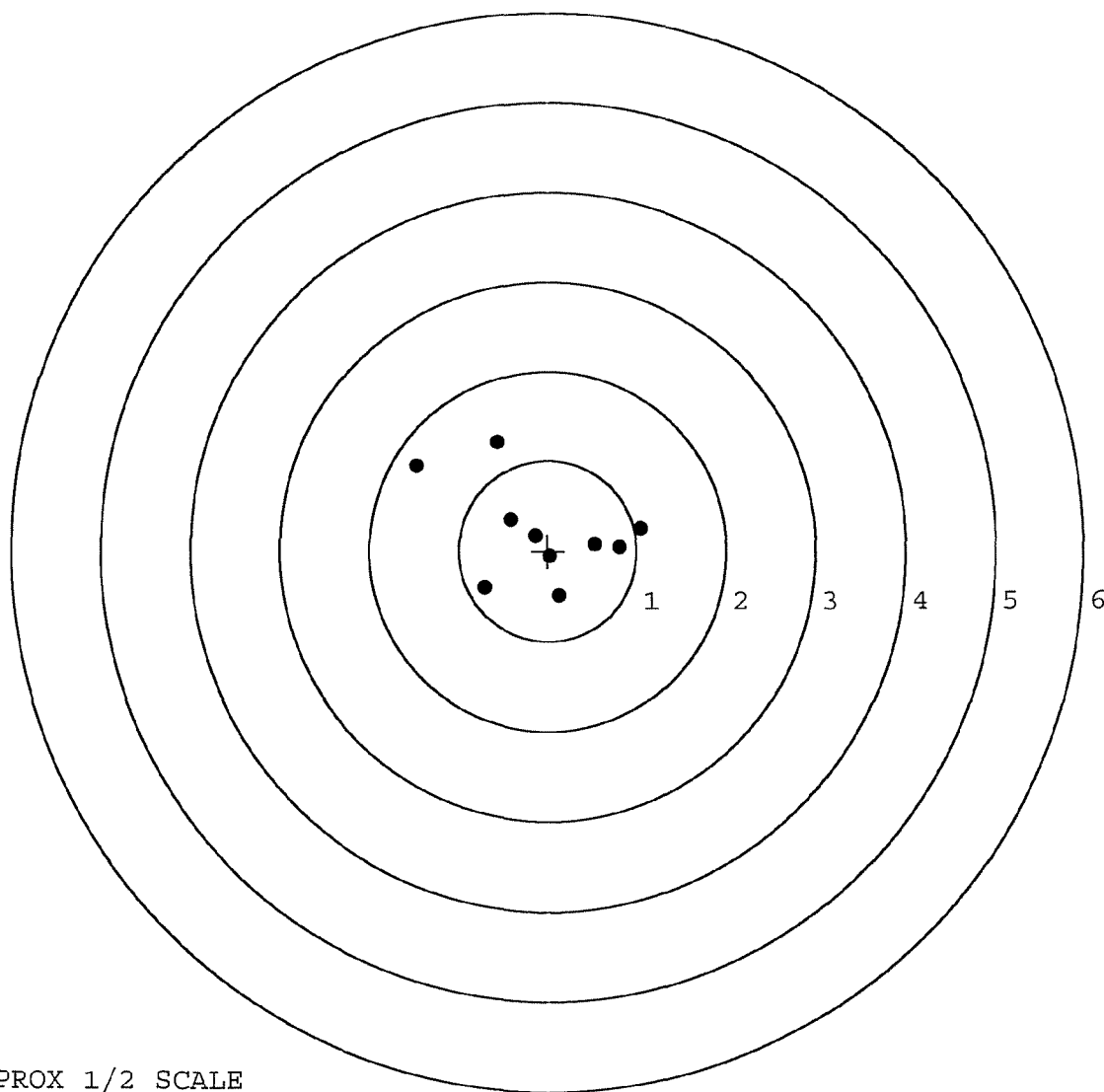
MEAN RADIUS: 0.767

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.122	-0.496
2:	-0.709	-0.411
3:	1.043	0.247
4:	0.808	0.043
5:	0.529	0.077
6:	0.022	-0.055
7:	-0.152	0.173
8:	-0.424	0.351
9:	-0.567	1.203
10:	-1.467	0.938



TARGET APPROX 1/2 SCALE