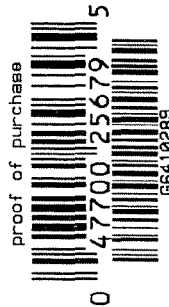


G6410289

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

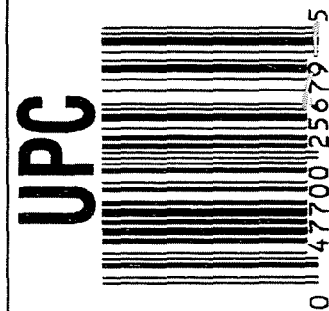
98606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB

DD FORM 96253



ORDER NO.	25679
BARREL LENGTH	24"
CAPACITY	6

G6410289



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



0 47700 25679 5

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



0 47700 25679 5

SERIAL NO.



G6410209

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 # G6410289

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RTZ
600	PROOF		1-4-05	K
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-4-05	K
610	DIS-ASSEMBLE GUN	JAN 31 2005	1-4-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		1-5-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1-14-05	HP
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		1-18-05	D.A.
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-18-05	D.A.
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-1-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		2-1-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3-21-05	TRW

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>	3-21-05	Ac
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	3-21-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	3-21-05	Ac
	J) ASSEMBLE STOCK		2-1-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		3-21-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-1-05	RTZ
	M) IRON SIGHT ALIGNMENT		2-1-05	RTZ
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-1-05	RTZ
640	GALLERY TEST AND TARGET	PASS FAIL	2-4-05	Ac
	MALFUNCTION	CORRECTION	OK	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-4-05	Ac
655	FINAL INSPECTION A) HEADSPACE		3-21-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.47</u> <u>2.44</u> <u>2.48</u> <u>2.45</u> <u>2.57</u>	3-21-05	TRW
	C) FUNCTION		3-21-05	Ac
660	PACK		3/23/05	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 1-18-05

TESTER TRLW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.38	2.25		2.16	
PULL #2	2.40	2.11		2.05	
PULL #3	2.40	2.69		2.12	
PULL #4	2.46	2.29		2.10	
PULL #5	2.49	2.24		2.09	
TOTAL	12.13	11.58		10.52	
AVERAGE	2.42	2.31		2.10	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.10		
PULL #2	3.45	3.09		
PULL #3	3.31	3.08		
PULL #4	3.14	3.01		
PULL #5	3.15	3.15		
TOTAL	16.36	15.43		
AVERAGE	3.27	3.08		

	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	4.46	3.98		4.13
PULL #2	4.21	4.00		4.04
PULL #3	4.18	4.45		4.04
PULL #4	4.13	4.23		4.08
PULL #5	4.15	4.15		4.06
TOTAL	21.13	20.81		20.35
AVERAGE	4.22	4.16		4.07

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410289.___0
FILE DATE AND TIME: 02/04/2005 07:39

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.068
The Average Y Centroid of the Five Target Set:	-0.058
The Average Point of Impact of the Five Target Set:	0.090
The Average Mean Radius of the Five Target Set:	0.800
The Distance from POA to Centroid Target #1:	0.205
The Distance from Centroid Target #2 to Centroid Target #1:	0.312
The Distance from Centroid Target #3 to Centroid Target #1:	0.258
The Distance from Centroid Target #4 to Centroid Target #1:	0.084
The Distance from Centroid Target #5 to Centroid Target #1:	0.518

SERIAL NUMBER: G6410289. 0

TARGET NUMBER: 1

FILE DATE: 02/04/2005

FILE TIME: 07:39

X CENTROID: 0.088

Y CENTROID: -0.185

POA TO CENTROID: 0.205

HORZ SPREAD: 2.647

VERT SPREAD: 2.832

GROUP SPREAD: 3.433

MIN RADIUS: 0.045

MAX RADIUS: 2.061

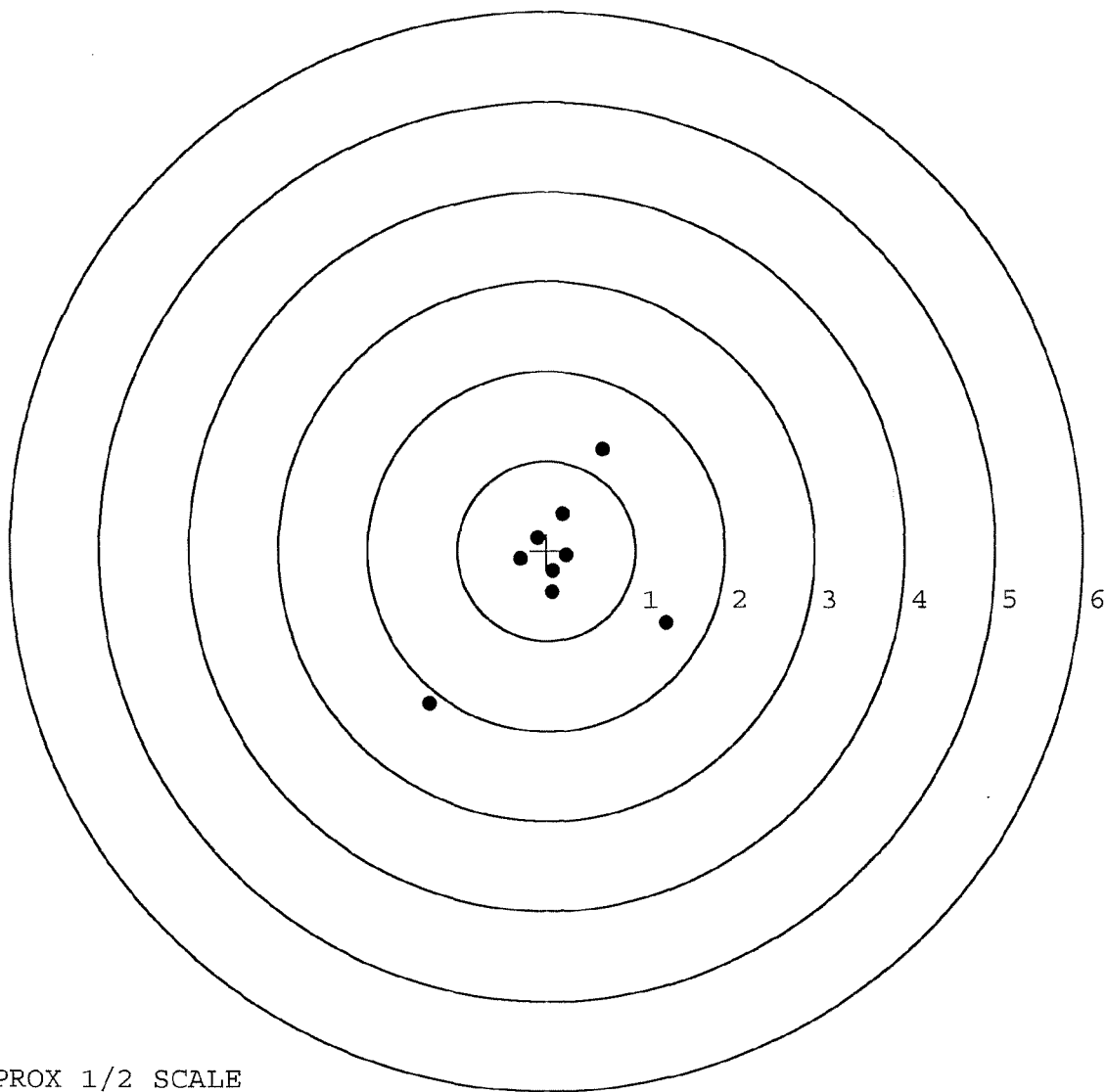
MEAN RADIUS: 0.753

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.337	-0.808
2:	-1.310	-1.700
3:	0.630	1.132
4:	0.178	0.412
5:	0.223	-0.057
6:	0.071	-0.227
7:	0.060	-0.468
8:	-0.296	-0.094
9:	-0.103	0.143



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410289. 0

TARGET NUMBER: 2

FILE DATE: 02/04/2005

FILE TIME: 07:39

POINT#	X	Y
1:	0.738	-0.289
2:	0.742	-0.165
3:	0.161	0.054
4:	0.167	0.298
5:	-0.149	-0.105
6:	-0.122	-0.529
7:	-0.679	-0.895
8:	-1.124	0.051
9:	-0.807	0.706
10:	-0.641	0.765

X CENTROID: -0.171

Y CENTROID: -0.011

POA TO CENTROID: 0.172

HORZ SPREAD: 1.866

VERT SPREAD: 1.660

GROUP SPREAD: 1.660

MIN RADIUS: 0.097

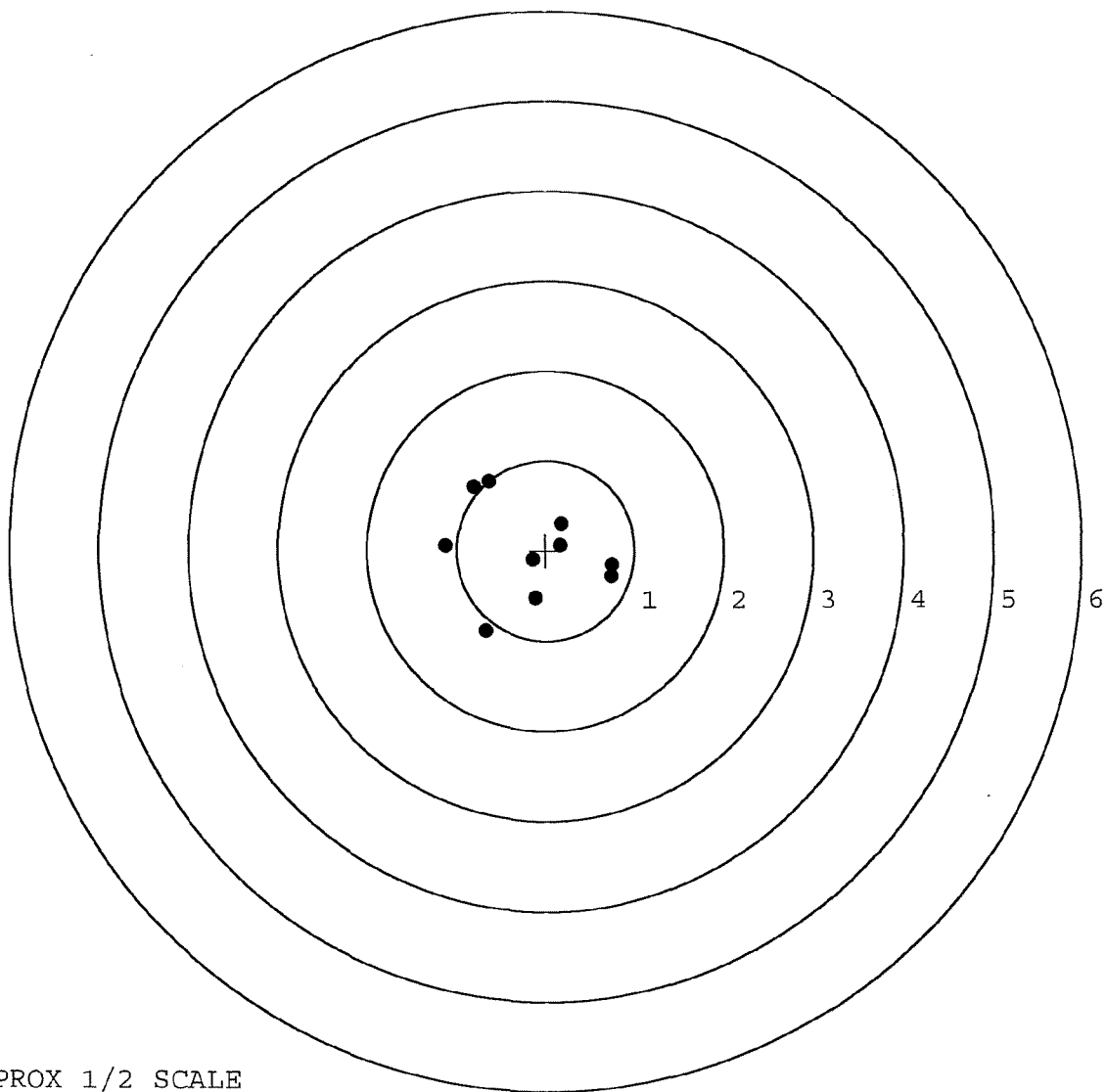
MAX RADIUS: 1.019

MEAN RADIUS: 0.713

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

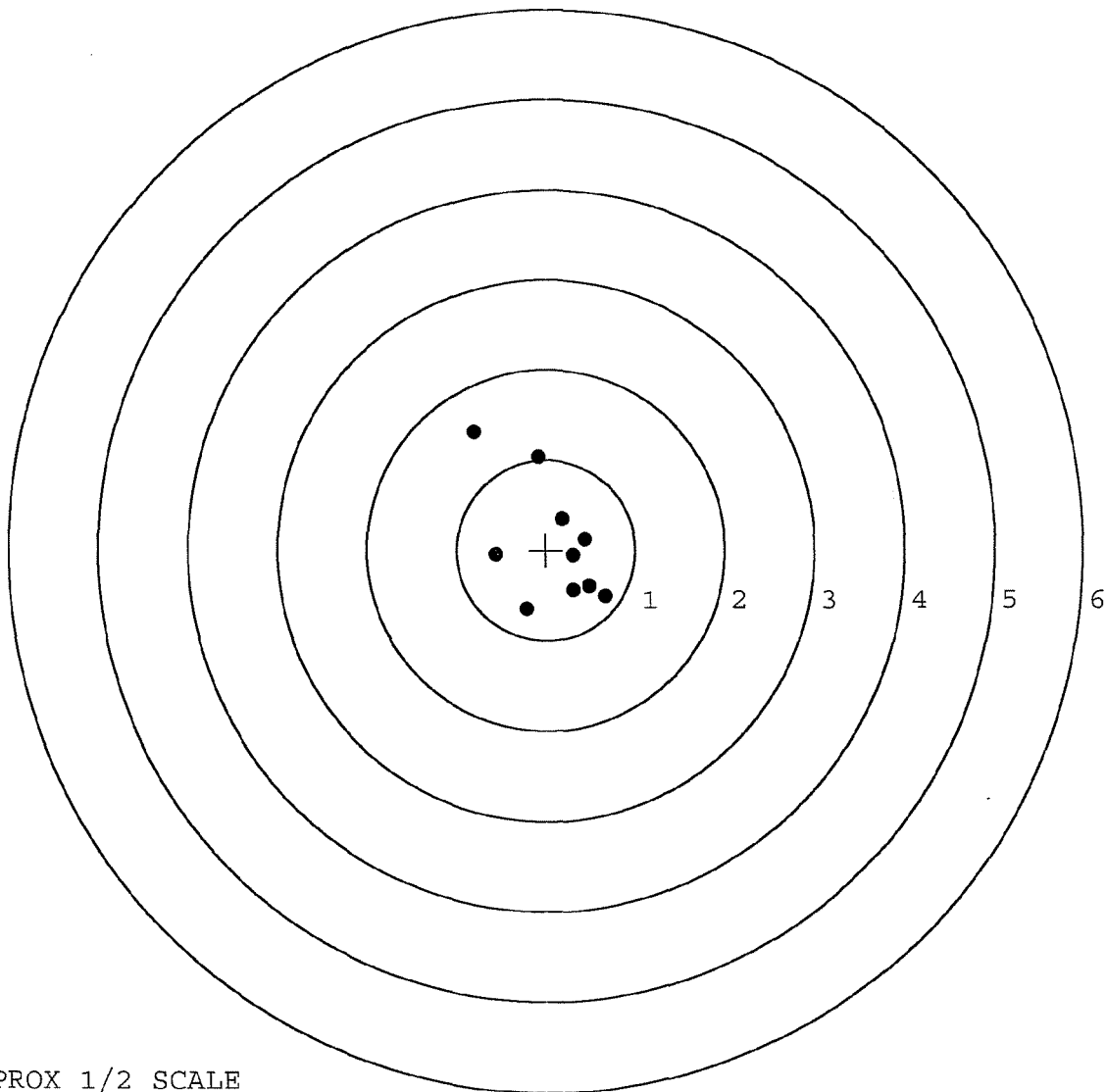


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410289. __0
TARGET NUMBER: 3
FILE DATE: 02/04/2005
FILE TIME: 07:39

X CENTROID: 0.068
Y CENTROID: 0.072
POA TO CENTROID: 0.099
HORZ SPREAD: 1.465
VERT SPREAD: 1.968
GROUP SPREAD: 2.339
MIN RADIUS: 0.264
MAX RADIUS: 1.515
MEAN RADIUS: 0.687
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.224	-0.655
2:	-0.561	-0.047
3:	0.436	0.124
4:	0.300	-0.055
5:	0.174	0.351
6:	-0.092	1.033
7:	-0.801	1.313
8:	0.664	-0.511
9:	0.484	-0.395
10:	0.301	-0.442

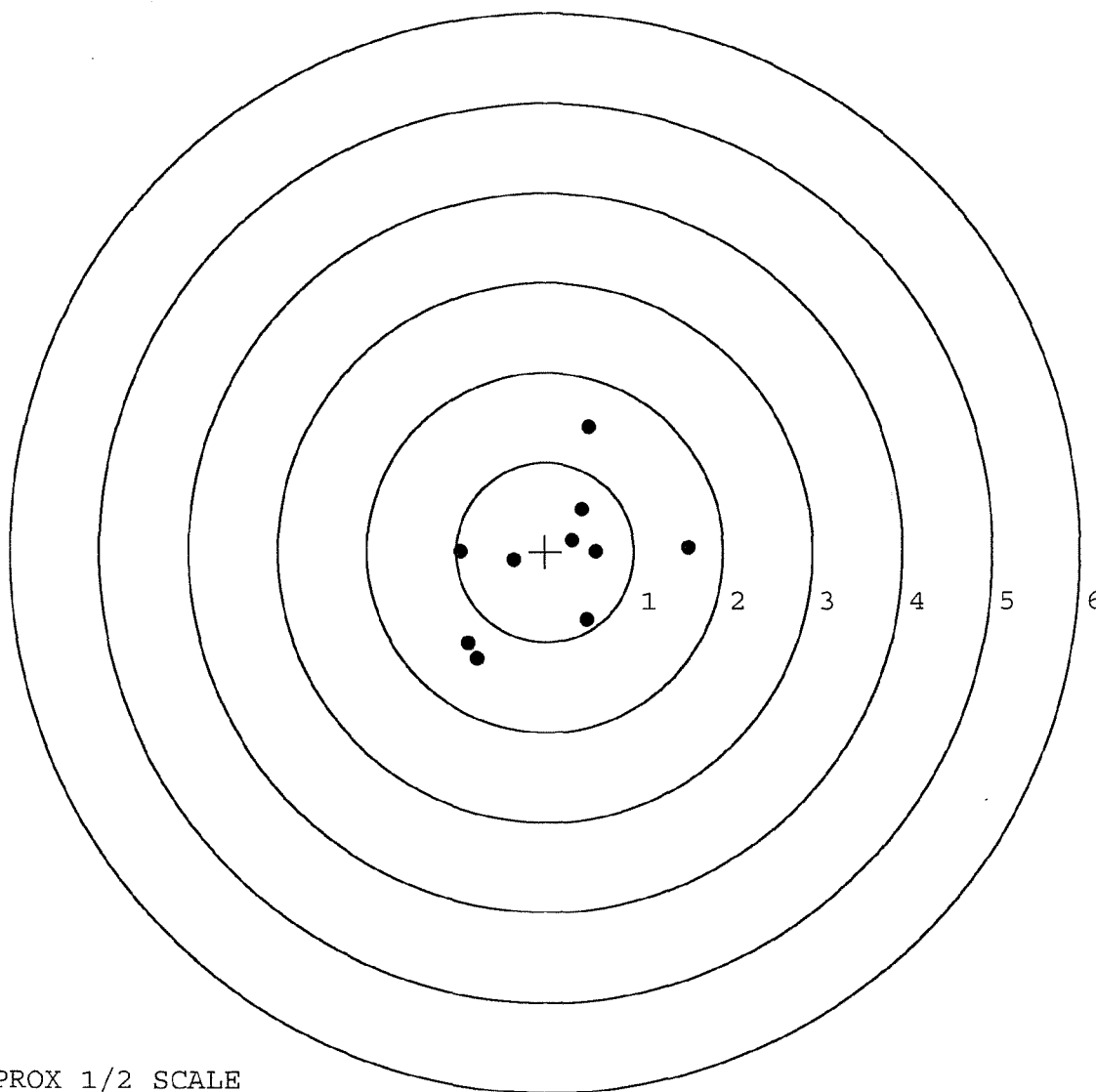


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410289. __0
TARGET NUMBER: 4
FILE DATE: 02/04/2005
FILE TIME: 07:39

X CENTROID: 0.090
Y CENTROID: -0.101
POA TO CENTROID: 0.135
HORZ SPREAD: 2.565
VERT SPREAD: 2.587
GROUP SPREAD: 2.874
MIN RADIUS: 0.311
MAX RADIUS: 1.546
MEAN RADIUS: 0.949
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.616	0.048
2:	0.462	-0.755
3:	-0.864	-1.014
4:	-0.772	-1.192
5:	-0.949	0.000
6:	-0.356	-0.094
7:	0.571	-0.001
8:	0.301	0.127
9:	0.413	0.475
10:	0.480	1.395



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410289. 0

TARGET NUMBER: 5

FILE DATE: 02/04/2005

FILE TIME: 07:39

X CENTROID: -0.417

Y CENTROID: -0.065

POA TO CENTROID: 0.421

HORZ SPREAD: 2.887

VERT SPREAD: 1.926

GROUP SPREAD: 3.152

MIN RADIUS: 0.296

MAX RADIUS: 1.980

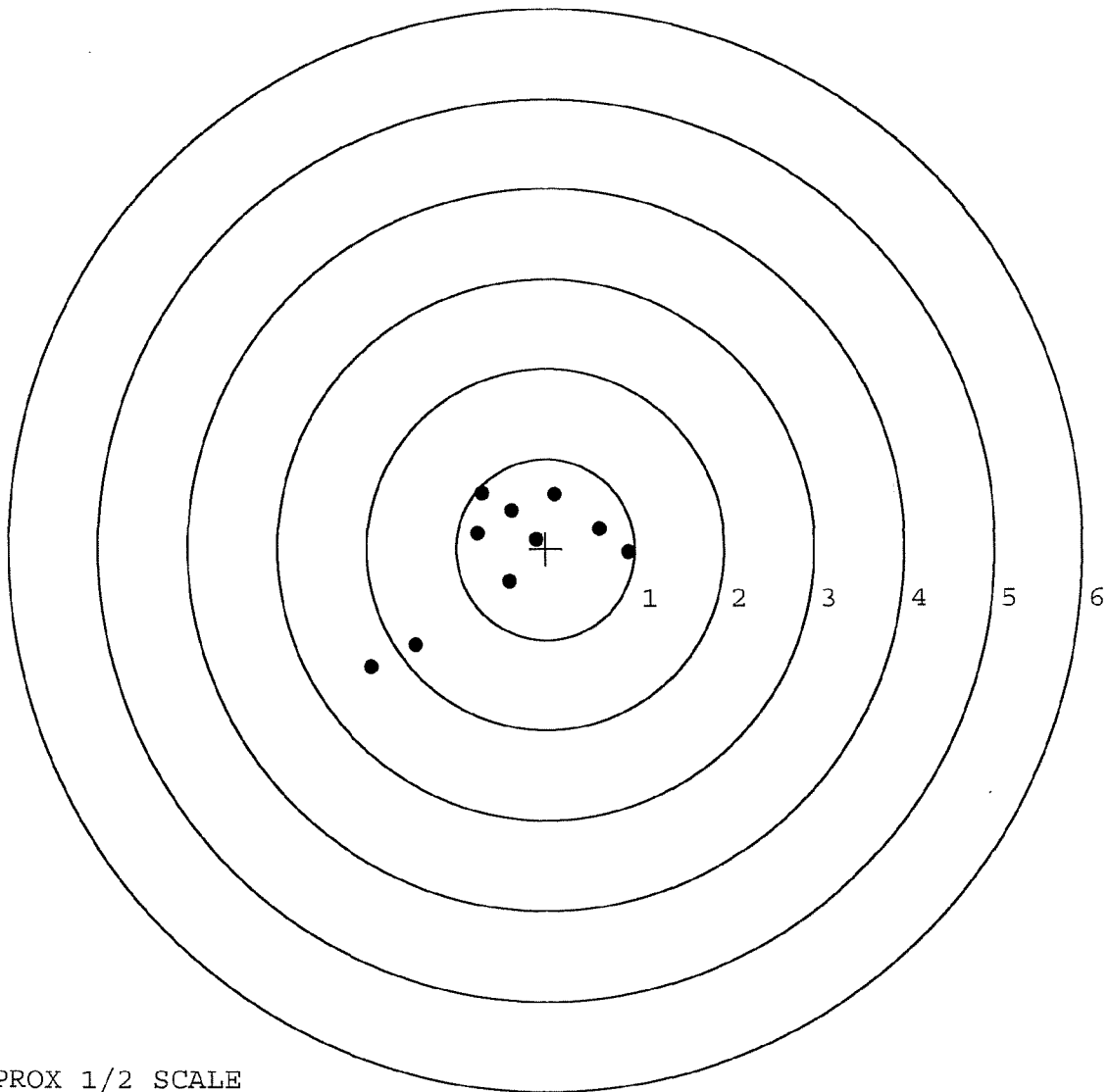
MEAN RADIUS: 0.897

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.932	-0.046
2:	0.603	0.215
3:	0.099	0.602
4:	-0.108	0.104
5:	-0.391	0.423
6:	-0.712	0.615
7:	-0.761	0.173
8:	-0.413	-0.361
9:	-1.459	-1.061
10:	-1.955	-1.311



TARGET APPROX 1/2 SCALE