G 6410304

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

proof of purchase
0 47700 25679 5
G6410304

owner registration sticker
0 47700 25679 5
G6410304

ORDER NO. 25679

BARREL LENGTH	24"
CAPACITY	6

G6410304

UPC
0 47700 25679 5

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.

G6410304

Original 5 crib

10/26/2004 7:45:22 AM

25679

M/24 7.62 NATO S.W.S. (LE SYSTEM)

.MA25679

Shop Order: SWS44487

.ABSWS44487

Start Date: 9/27/2004

Finish Date: 10/15/2004

0540 01PC001

Flat Black Powder Coat, Barrel and

0003512362

0560 89SWS1

Reassemble Action.

0003512363

0690 89SWS1

Pack Rifle

0003512373

0700 89SWS1

Stencil SWS Container

.OP0700

M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6041 0304

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8-24-04	RTL
600	PROOF	MAGNA-FLUX INSPECTED	8-24-04	RTL
607	CHECK HEADSPACE		8-24-04	RTL
610	DIS-ASSEMBLE GUN		8-24-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR		
615	ROLLMARK CALIBER		8/25/04	JB
617	DRILL AND TAP SIGHT HOLES		8-24-04	TRW
620	APPLY COATINGS (BARREL ACTION)		9/7	HP
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		9-22-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9-22-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9-22-04	RTL
	D) OIL FIRING PIN ASSEMBLY		9-28-04	RW
	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	7.5 7.5 7.0	10-5-04	DA
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	2.0 2.5 2.5	10-5-04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			10-5-04	RTL
	I) FIRING PIN INDENT	.020 MIN	.024 .026 .026	10-5-04	DA
	J) ASSEMBLE STOCK			9-28-04	RW
	K) ASSEMBLE SWIVEL STUDS			10-6-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			9-28-04	RW
	M) IRON SIGHT ALIGNMENT			9-28-04	RW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			9-28-04	RW
640	GALLERY TEST AND TARGET		PASS FAIL	9-29-04	[illegible]
	MALFUNCTION		CORRECTION N/A	9-29-04	[illegible]
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
645	INSPECT FOR LIVE AMMO			9-29-04	[illegible]
655	FINAL INSPECTION A) HEADSPACE			10-6-04	RTL
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	2.70 2.71 2.54 2.80 2.51	10-5-04	DA
	C) FUNCTION			10-6-04	RTL
660	PACK			10/7/04	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 9-28-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.22	2.25		2.07	
PULL #2	2.54	2.28		2.33	
PULL #3	2.58	2.38		2.53	
PULL #4	2.67	2.25		2.28	
PULL #5	2.68	2.20		2.17	
TOTAL	12.69	11.36		11.38	
AVERAGE	2.53	2.27		2.27	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.21	3.07		
PULL #2	3.02	2.98		
PULL #3	3.20	2.99		
PULL #4	3.12	3.13		
PULL #5	3.15	3.10		
TOTAL	15.70	15.27		
AVERAGE	3.14	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	4.24	4.10		4.03
PULL #2	4.18	4.00		4.27
PULL #3	4.26	3.95		4.28
PULL #4	4.17	3.93		4.28
PULL #5	4.08	3.94		4.21
TOTAL	20.94	19.92		
AVERAGE	4.18	3.98		

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410304.__0
FILE DATE AND TIME: 09/29/2004 05:54

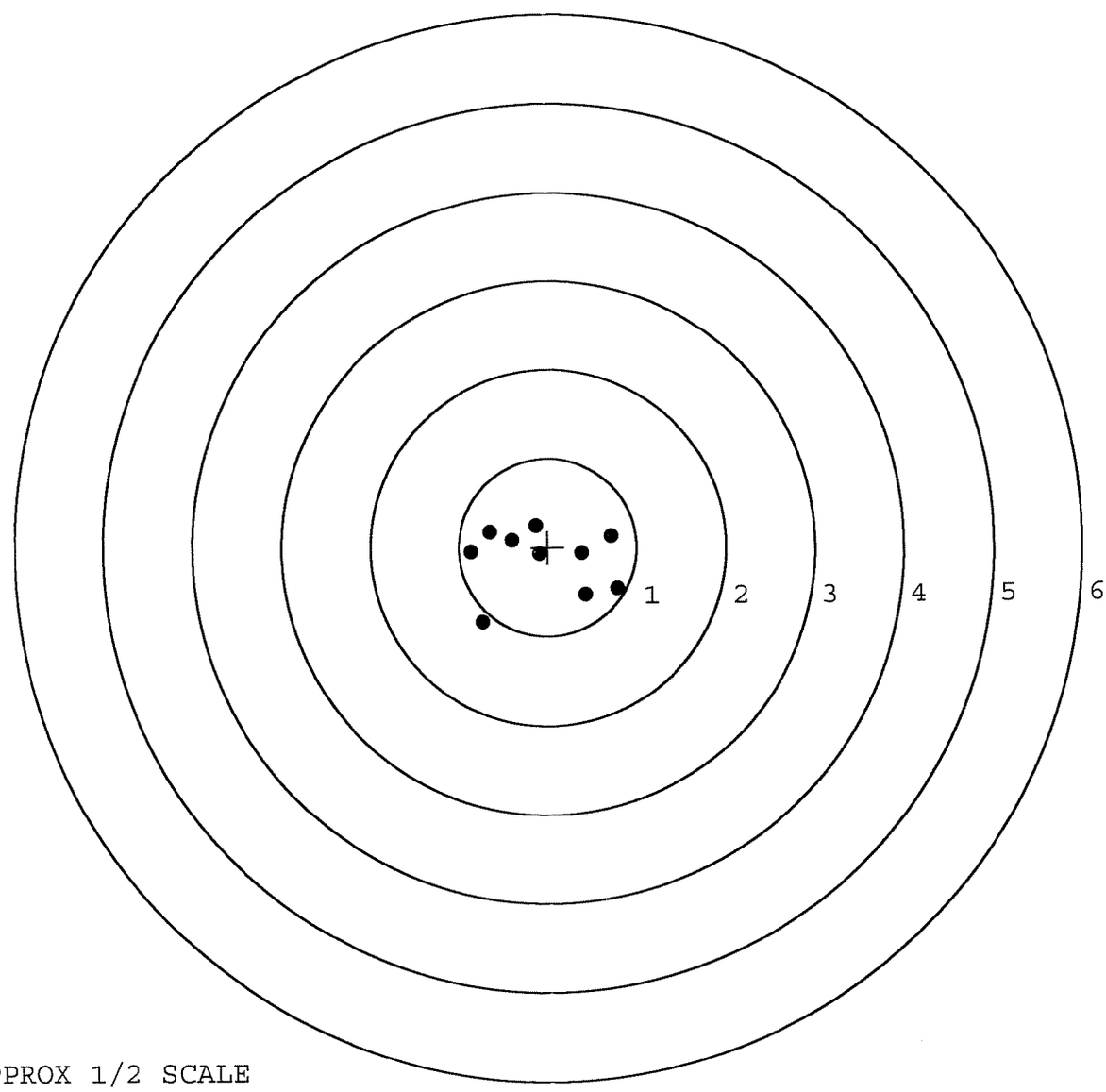
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.005
The Average Y Centroid of the Five Target Set:	-0.081
The Average Point of Impact of the Five Target Set:	0.081
The Average Mean Radius of the Five Target Set:	0.748
The Distance from POA to Centroid Target #1:	0.155
The Distance from Centroid Target #2 to Centroid Target #1:	0.288
The Distance from Centroid Target #3 to Centroid Target #1:	0.204
The Distance from Centroid Target #4 to Centroid Target #1:	0.041
The Distance from Centroid Target #5 to Centroid Target #1:	0.147

SERIAL NUMBER: G6410304.__0
TARGET NUMBER: 1
FILE DATE: 09/29/2004
FILE TIME: 05:54

X CENTROID:	-0.057
Y CENTROID:	-0.144
POA TO CENTROID:	0.155
HORZ SPREAD:	1.644
VERT SPREAD:	1.089
GROUP SPREAD:	1.748
MIN RADIUS:	0.078
MAX RADIUS:	0.976
MEAN RADIUS:	0.615
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.737	-0.845
2:	0.781	-0.480
3:	0.431	-0.543
4:	0.717	0.126
5:	0.387	-0.069
6:	-0.138	0.244
7:	-0.098	-0.078
8:	-0.405	0.080
9:	-0.647	0.175
10:	-0.863	-0.053

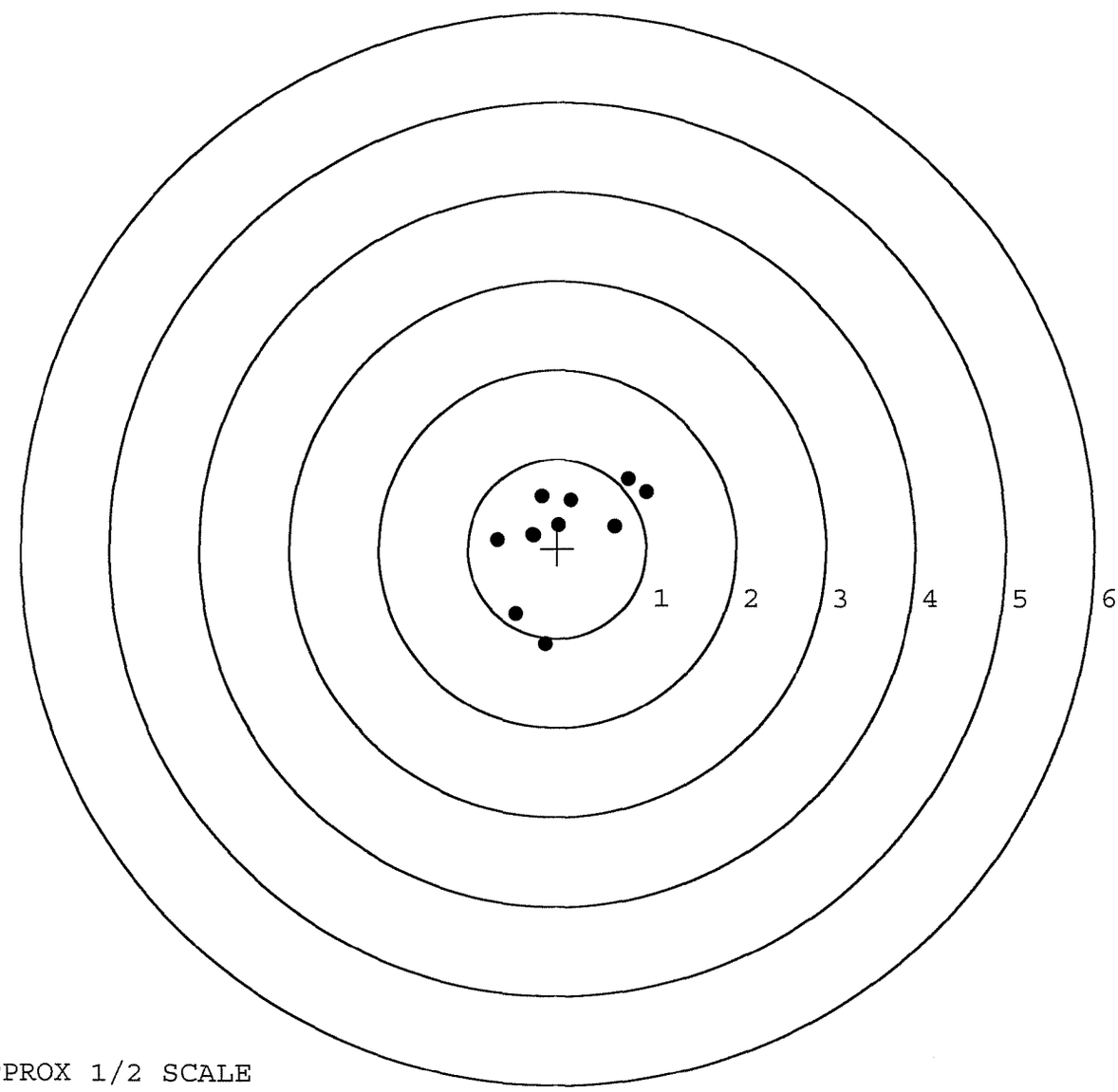


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410304.__0
TARGET NUMBER: 2
FILE DATE: 09/29/2004
FILE TIME: 05:54

X CENTROID:	-0.108
Y CENTROID:	0.140
POA TO CENTROID:	0.177
HORZ SPREAD:	1.674
VERT SPREAD:	1.853
GROUP SPREAD:	2.049
MIN RADIUS:	0.155
MAX RADIUS:	1.219
MEAN RADIUS:	0.606
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	12
# in 3 IN DIAMETER:	15

POINT#	X	Y
1:	-0.129	-1.070
2:	-0.459	-0.729
3:	1.005	0.637
4:	0.798	0.783
5:	0.653	0.252
6:	-0.263	0.149
7:	-0.277	0.156
8:	-0.277	0.154
9:	0.017	0.260
10:	0.156	0.540
11:	-0.169	0.582
12:	-0.669	0.095
13:	-0.669	0.095
14:	-0.669	0.095
15:	-0.669	0.095

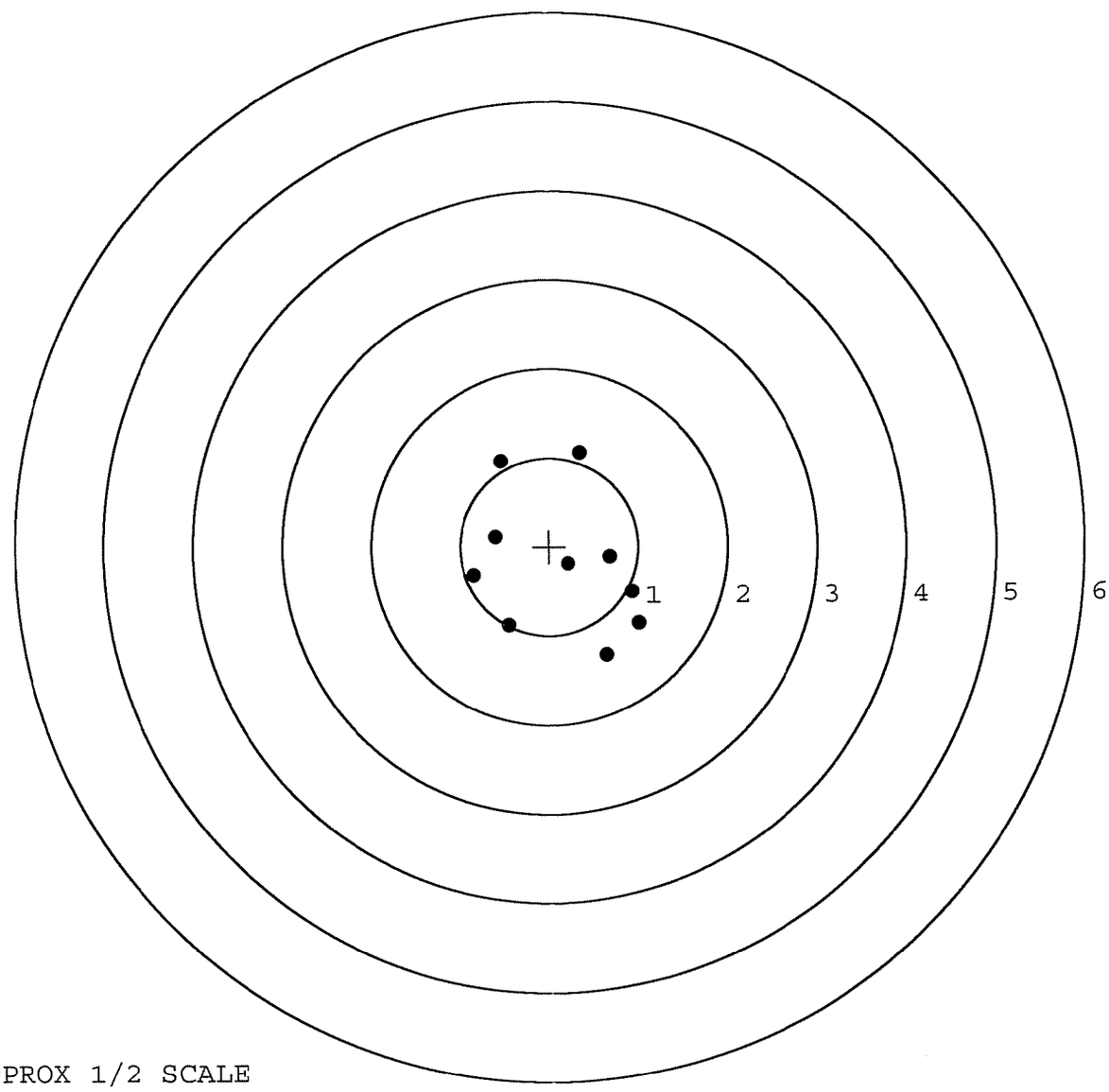


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410304.__0
TARGET NUMBER: 3
FILE DATE: 09/29/2004
FILE TIME: 05:54

X CENTROID:	0.138
Y CENTROID:	-0.202
POA TO CENTROID:	0.245
HORZ SPREAD:	1.851
VERT SPREAD:	2.285
GROUP SPREAD:	2.487
MIN RADIUS:	0.078
MAX RADIUS:	1.346
MEAN RADIUS:	0.905
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.645	-1.226
2:	1.001	-0.870
3:	0.931	-0.516
4:	0.683	-0.125
5:	0.216	-0.198
6:	-0.456	-0.891
7:	-0.850	-0.325
8:	-0.604	0.113
9:	-0.539	0.961
10:	0.354	1.059

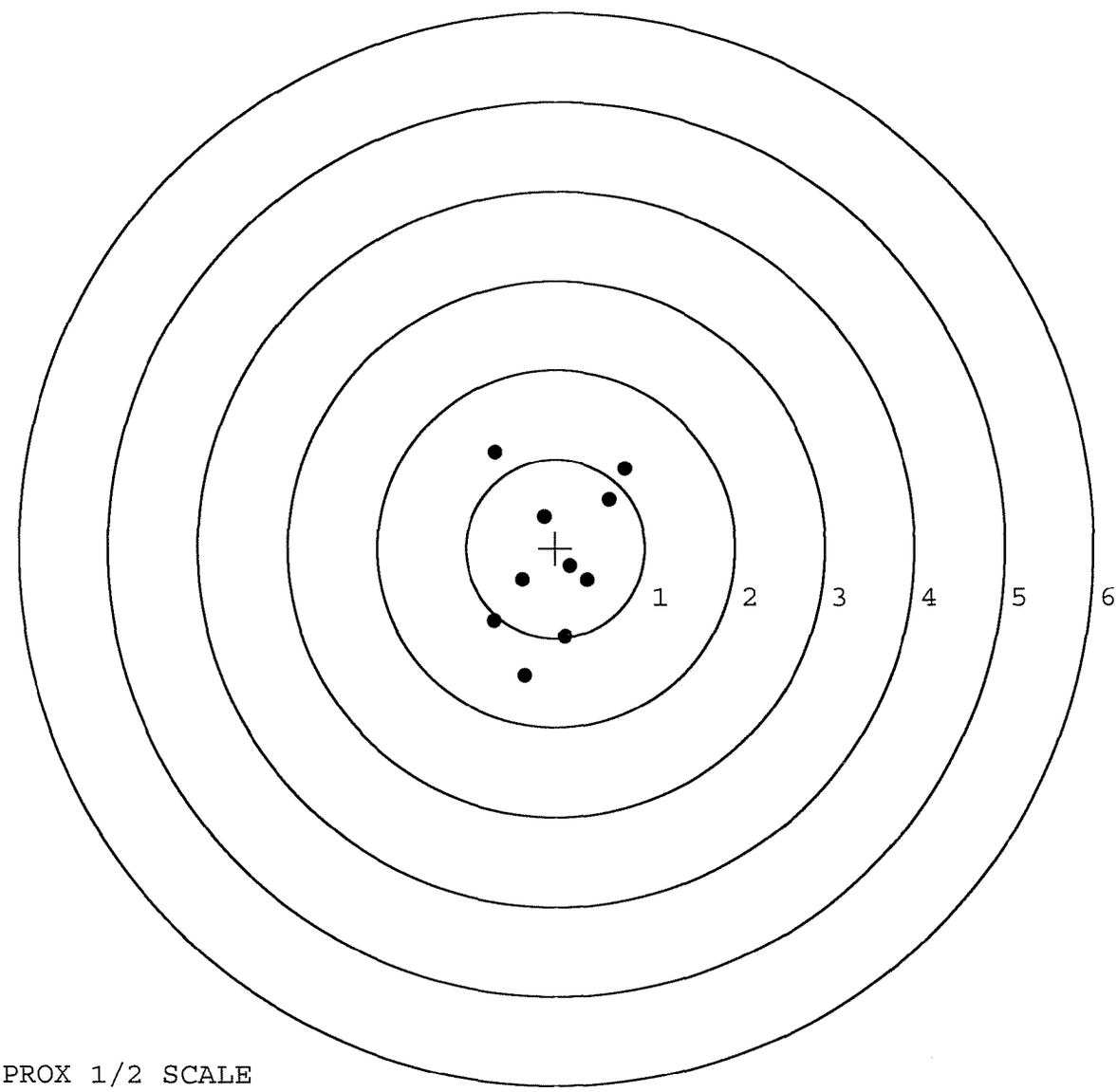


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410304.__0
TARGET NUMBER: 4
FILE DATE: 09/29/2004
FILE TIME: 05:54

X CENTROID:	-0.019
Y CENTROID:	-0.127
POA TO CENTROID:	0.129
HORZ SPREAD:	1.467
VERT SPREAD:	2.508
GROUP SPREAD:	2.530
MIN RADIUS:	0.198
MAX RADIUS:	1.376
MEAN RADIUS:	0.830
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.341	-1.426
2:	0.110	-0.988
3:	0.361	-0.359
4:	0.163	-0.204
5:	-0.371	-0.359
6:	-0.688	-0.808
7:	0.601	0.546
8:	0.779	0.892
9:	-0.133	0.350
10:	-0.675	1.082

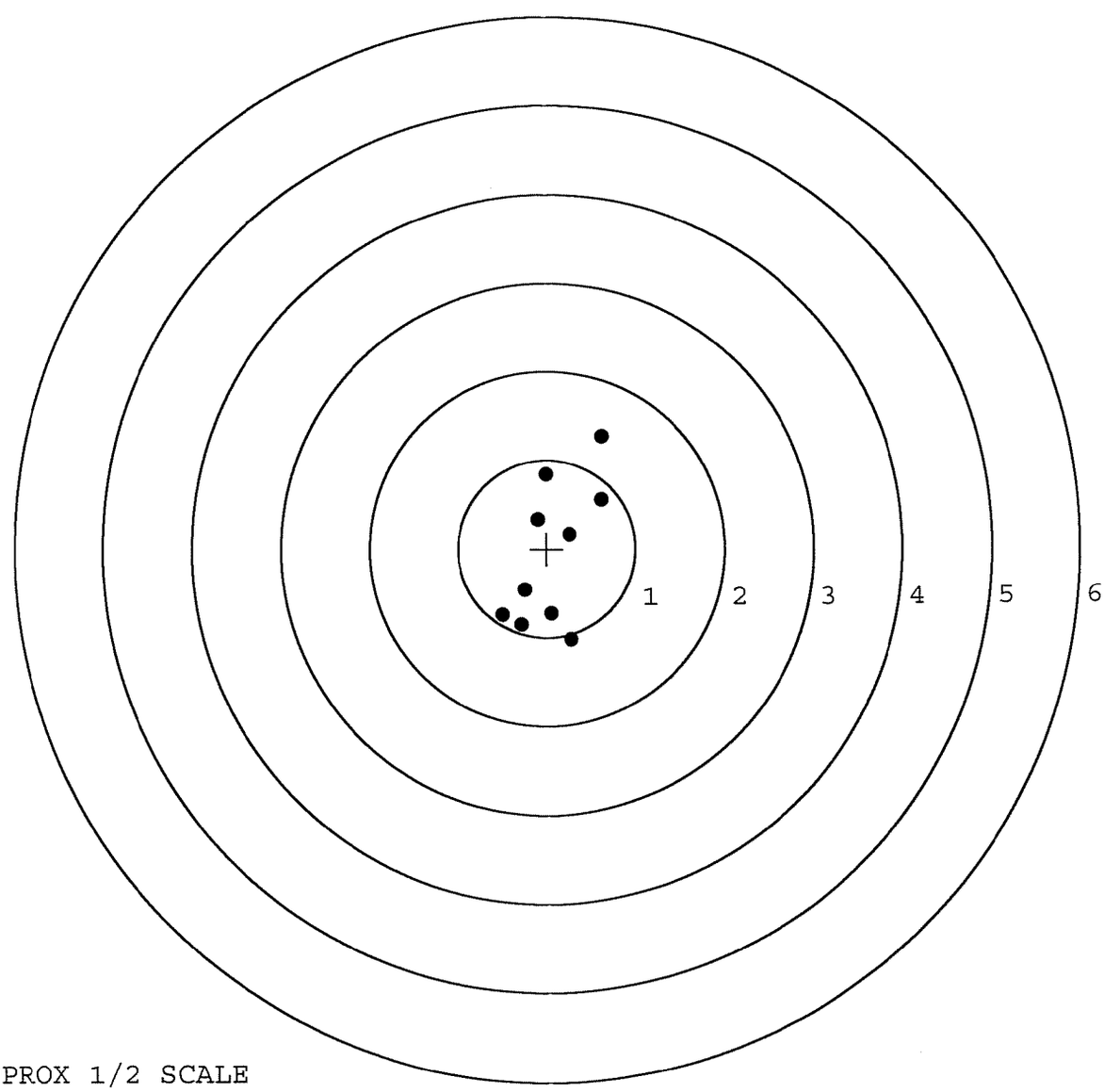


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410304.__0
TARGET NUMBER: 5
FILE DATE: 09/29/2004
FILE TIME: 05:54

X CENTROID:	0.070
Y CENTROID:	-0.071
POA TO CENTROID:	0.100
HORZ SPREAD:	1.131
VERT SPREAD:	2.285
GROUP SPREAD:	2.312
MIN RADIUS:	0.305
MAX RADIUS:	1.441
MEAN RADIUS:	0.784
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.280	-1.028
2:	0.263	0.166
3:	0.625	0.551
4:	0.631	1.257
5:	-0.009	0.836
6:	-0.100	0.328
7:	-0.249	-0.468
8:	0.052	-0.737
9:	-0.288	-0.865
10:	-0.500	-0.748



TARGET APPROX 1/2 SCALE