G6410317

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC

0 47700 25679 5

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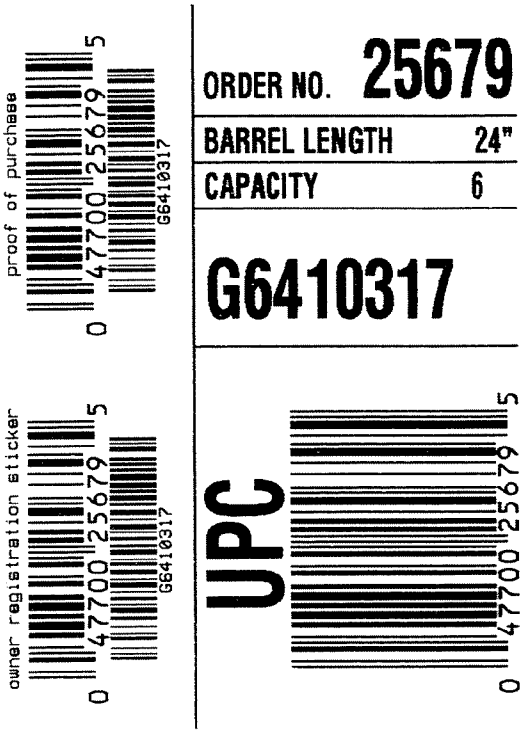
SERIAL NO.

G6410317

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



10/26/2004 7:45:53 AM

Original 1 Crib

25679

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

.MA25679

Shop Order: SWS56739

.ABSWS56739

Start Date: 9/28/2004
Finish Date: 10/14/2004

0540 01PC001
Flat Black Powder Coat, Barrel and

0003512599

0560 89SWS1
Reassemble Action.

0003512600

0690 89SWS1
Pack Rifle

0003512610

0700 89SWS1
Stencil SWS Container

.OP0700

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G641 0317

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8-24-04	RTZ
600	PROOF		8-24-04	RTZ
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-24-04	RTZ
610	DIS-ASSEMBLE GUN	AUG 25 2004	8-24-04	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR		
615	ROLLMARK CALIBER		8/25/04	LE
617	DRILL AND TAP SIGHT HOLES		8-24-04	TRW
620	APPLY COATINGS (BARREL ACTION)		9/7	
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		10/5/04	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10/5/04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10/5/04	DA
	D) OIL FIRING PIN ASSEMBLY		10-11-04	RTZ
	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 8.0 7.5	10-21-04	DA
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	2.0 2.5 2.0	10-21-04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.024 .024 .022	10-21-04	DA
	J) ASSEMBLE STOCK		10-11-04	RTL
	K) ASSEMBLE SWIVEL STUDS		10-27-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		10-26-04	RTL
	M) IRON SIGHT ALIGNMENT		10-26-04	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		10-26-04	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	10-15-04	TRW
	MALFUNCTION MCW	CORRECTION OK	10-19-04	TRW
	MALFUNCTION B.B.	CORRECTION OK	10-19-04	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
645	INSPECT FOR LIVE AMMO		10-15-04	TRW
655	FINAL INSPECTION A) HEADSPACE		10-27-04	RTL
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.37 2.44 2.30 2.43 2.35	10-21-04	DA
	C) FUNCTION		10-27-04	RTL
660	PACK		10/28/04	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 10-9-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.20	2.41		2.20	
PULL #2	2.19	2.45		2.22	
PULL #3	2.12	2.19		2.19	
PULL #4	2.16	2.18		2.19	
PULL #5	2.12	2.13		2.20	
TOTAL	10.79	11.36		11.00	
AVERAGE	2.15	2.27		2.20	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.19		
PULL #2	3.15	3.25		
PULL #3	3.21	3.15		
PULL #4	3.18	3.18		
PULL #5	3.12	3.18		
TOTAL	15.78	15.95		
AVERAGE	3.15	3.19		

	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	4.27	4.30		4.25
PULL #2	4.33	4.27		4.29
PULL #3	4.18	4.21		4.22
PULL #4	4.18	4.28		4.25
PULL #5	4.31	4.22		4.22
TOTAL	21.27	21.28		21.23
AVERAGE	4.25	4.25		4.24

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410317.__0
FILE DATE AND TIME: 10/15/2004 07:09

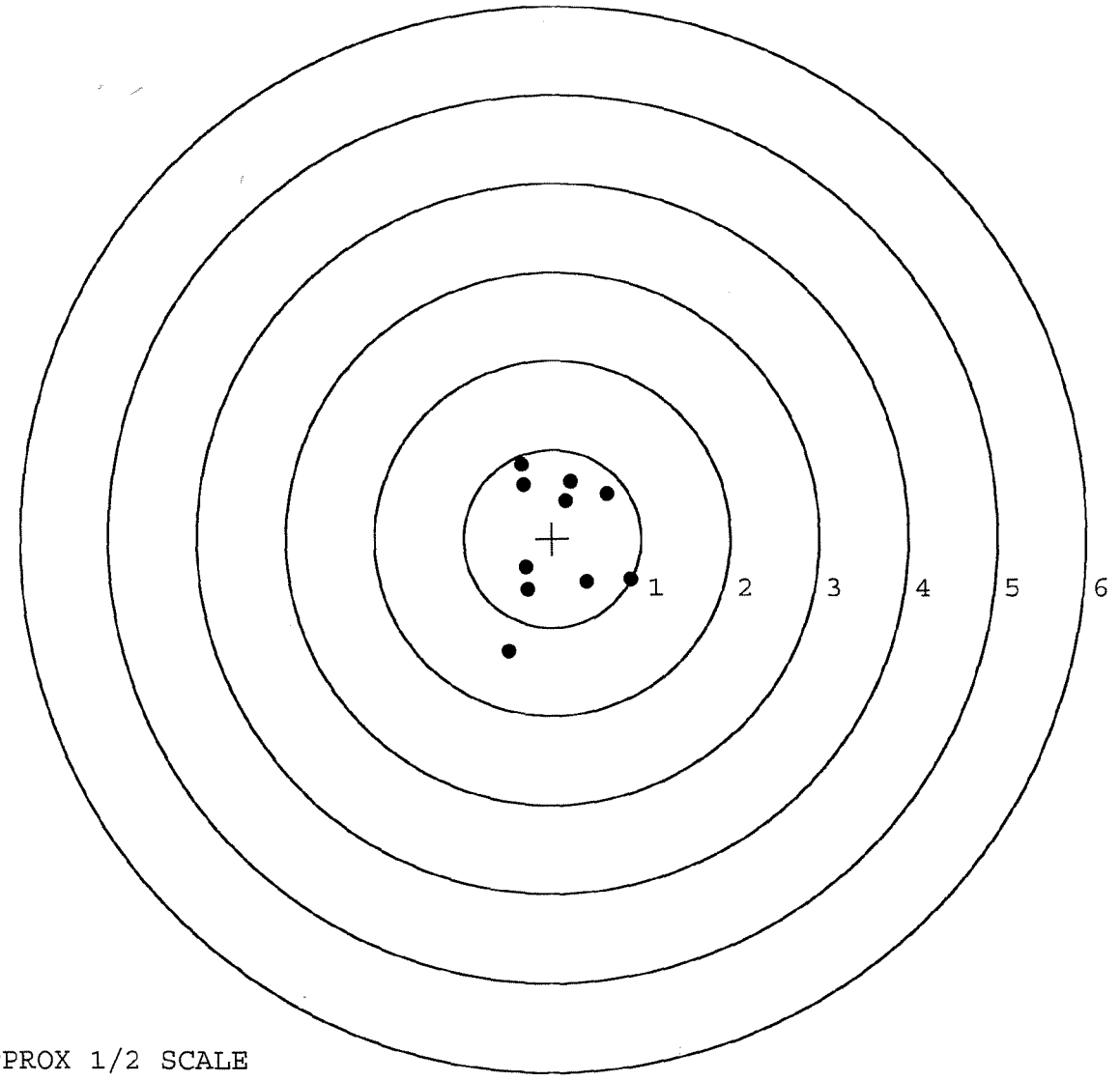
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.028
The Average Y Centroid of the Five Target Set:	-0.002
The Average Point of Impact of the Five Target Set:	0.028
The Average Mean Radius of the Five Target Set:	0.595
The Distance from POA to Centroid Target #1:	0.052
The Distance from Centroid Target #2 to Centroid Target #1:	0.104
The Distance from Centroid Target #3 to Centroid Target #1:	0.099
The Distance from Centroid Target #4 to Centroid Target #1:	0.050
The Distance from Centroid Target #5 to Centroid Target #1:	0.209

SERIAL NUMBER: G6410317.__0
TARGET NUMBER: 1
FILE DATE: 10/15/2004
FILE TIME: 07:09

X CENTROID:	0.051
Y CENTROID:	-0.012
POA TO CENTROID:	0.052
HORZ SPREAD:	1.373
VERT SPREAD:	2.107
GROUP SPREAD:	2.111
MIN RADIUS:	0.452
MAX RADIUS:	1.378
MEAN RADIUS:	0.758
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.884	-0.465
2:	0.392	-0.491
3:	0.614	0.504
4:	-0.489	-1.280
5:	-0.272	-0.580
6:	-0.298	-0.321
7:	0.153	0.428
8:	0.200	0.643
9:	-0.324	0.610
10:	-0.353	0.827

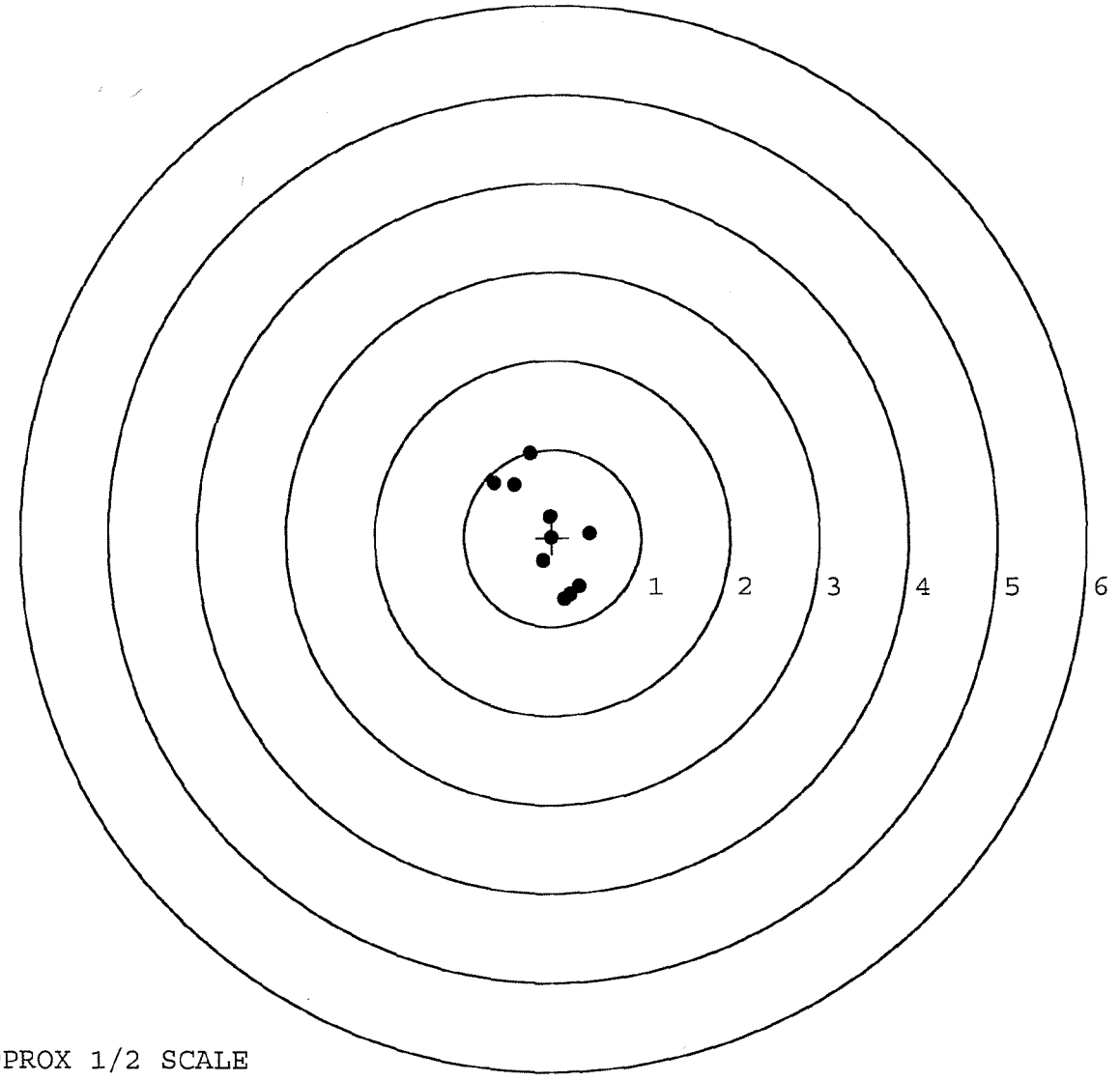


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410317.__0
TARGET NUMBER: 2
FILE DATE: 10/15/2004
FILE TIME: 07:09

X CENTROID:	-0.044
Y CENTROID:	0.032
POA TO CENTROID:	0.054
HORZ SPREAD:	1.086
VERT SPREAD:	1.654
GROUP SPREAD:	1.700
MIN RADIUS:	0.042
MAX RADIUS:	0.950
MEAN RADIUS:	0.567
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.137	-0.696
2:	0.302	-0.559
3:	-0.429	0.602
4:	-0.660	0.626
5:	-0.254	0.958
6:	-0.033	0.244
7:	0.426	0.053
8:	-0.019	-0.002
9:	-0.112	-0.263
10:	0.205	-0.643

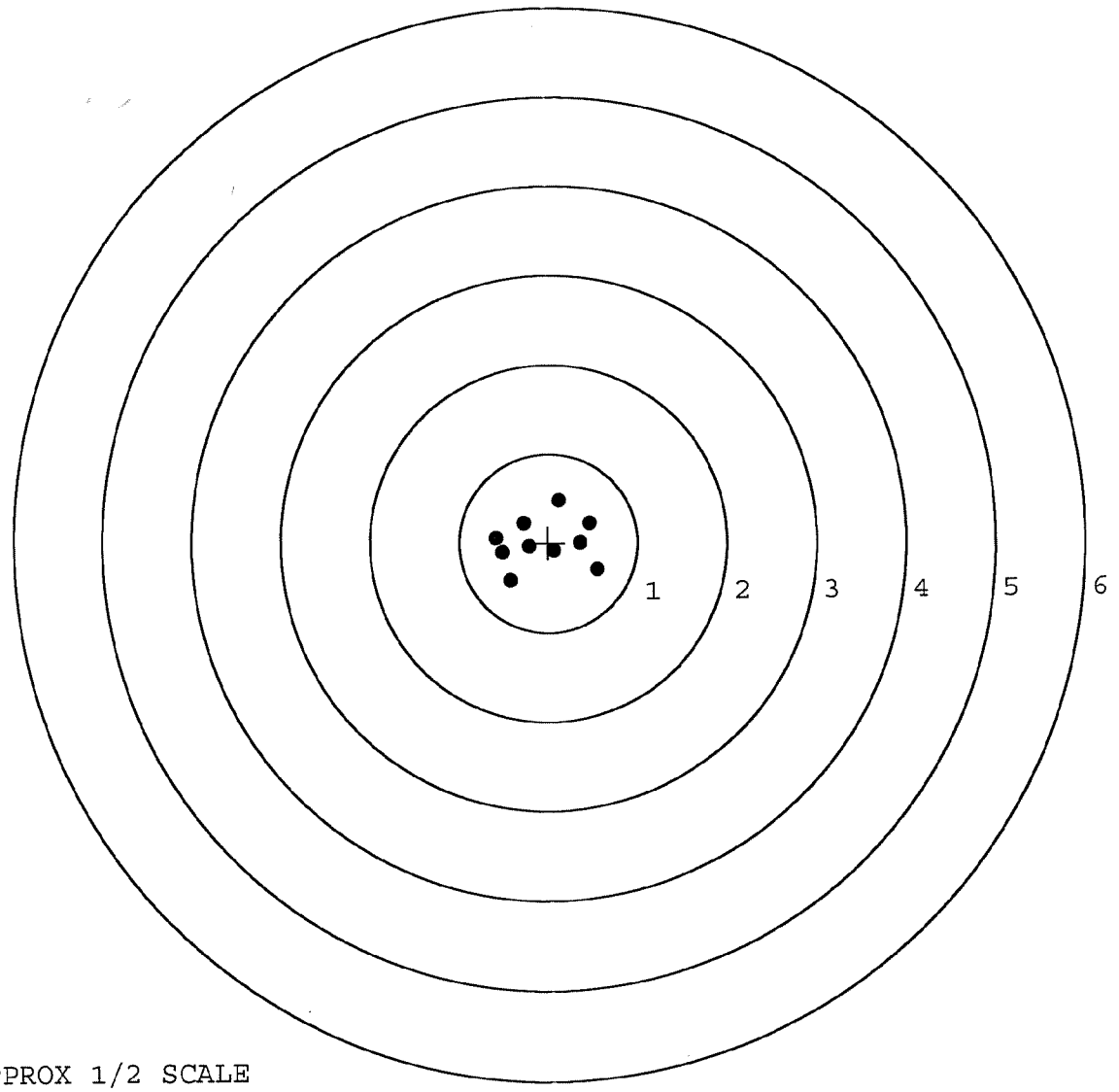


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410317.__0
TARGET NUMBER: 3
FILE DATE: 10/15/2004
FILE TIME: 07:09

X CENTROID:	-0.047
Y CENTROID:	0.000
POA TO CENTROID:	0.047
HORZ SPREAD:	1.142
VERT SPREAD:	0.901
GROUP SPREAD:	1.198
MIN RADIUS:	0.140
MAX RADIUS:	0.673
MEAN RADIUS:	0.438
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.551	-0.309
2:	0.462	0.214
3:	0.125	0.478
4:	-0.279	0.224
5:	-0.591	0.054
6:	-0.429	-0.423
7:	0.062	-0.088
8:	0.359	-0.007
9:	-0.215	-0.041
10:	-0.519	-0.107

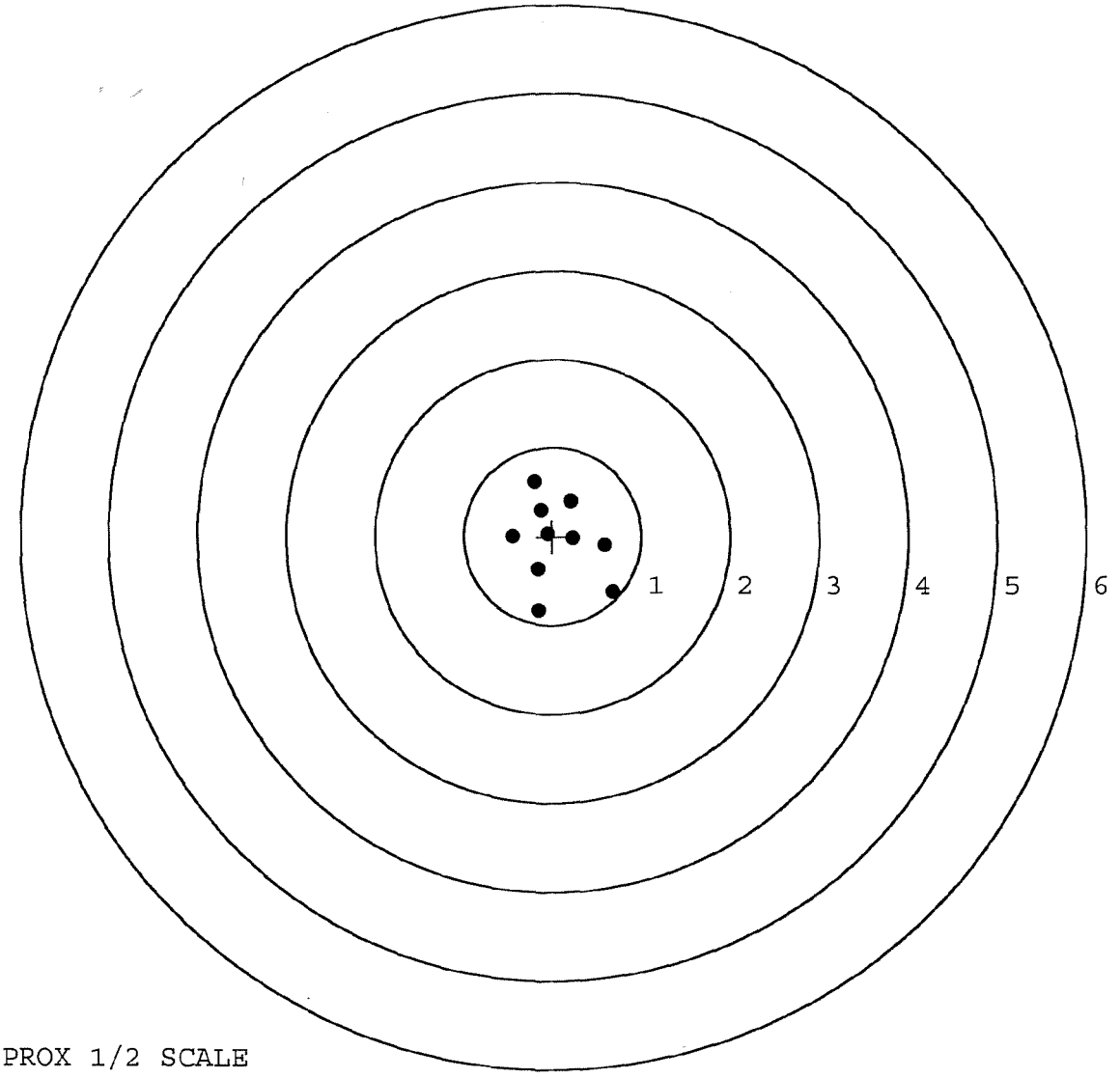


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410317.__0
TARGET NUMBER: 4
FILE DATE: 10/15/2004
FILE TIME: 07:09

X CENTROID:	0.053
Y CENTROID:	-0.063
POA TO CENTROID:	0.082
HORZ SPREAD:	1.134
VERT SPREAD:	1.456
GROUP SPREAD:	1.532
MIN RADIUS:	0.147
MAX RADIUS:	0.848
MEAN RADIUS:	0.503
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.682	-0.632
2:	-0.158	-0.840
3:	0.590	-0.105
4:	-0.206	0.616
5:	0.206	0.399
6:	0.231	-0.025
7:	-0.137	0.295
8:	-0.452	0.005
9:	-0.166	-0.372
10:	-0.060	0.032

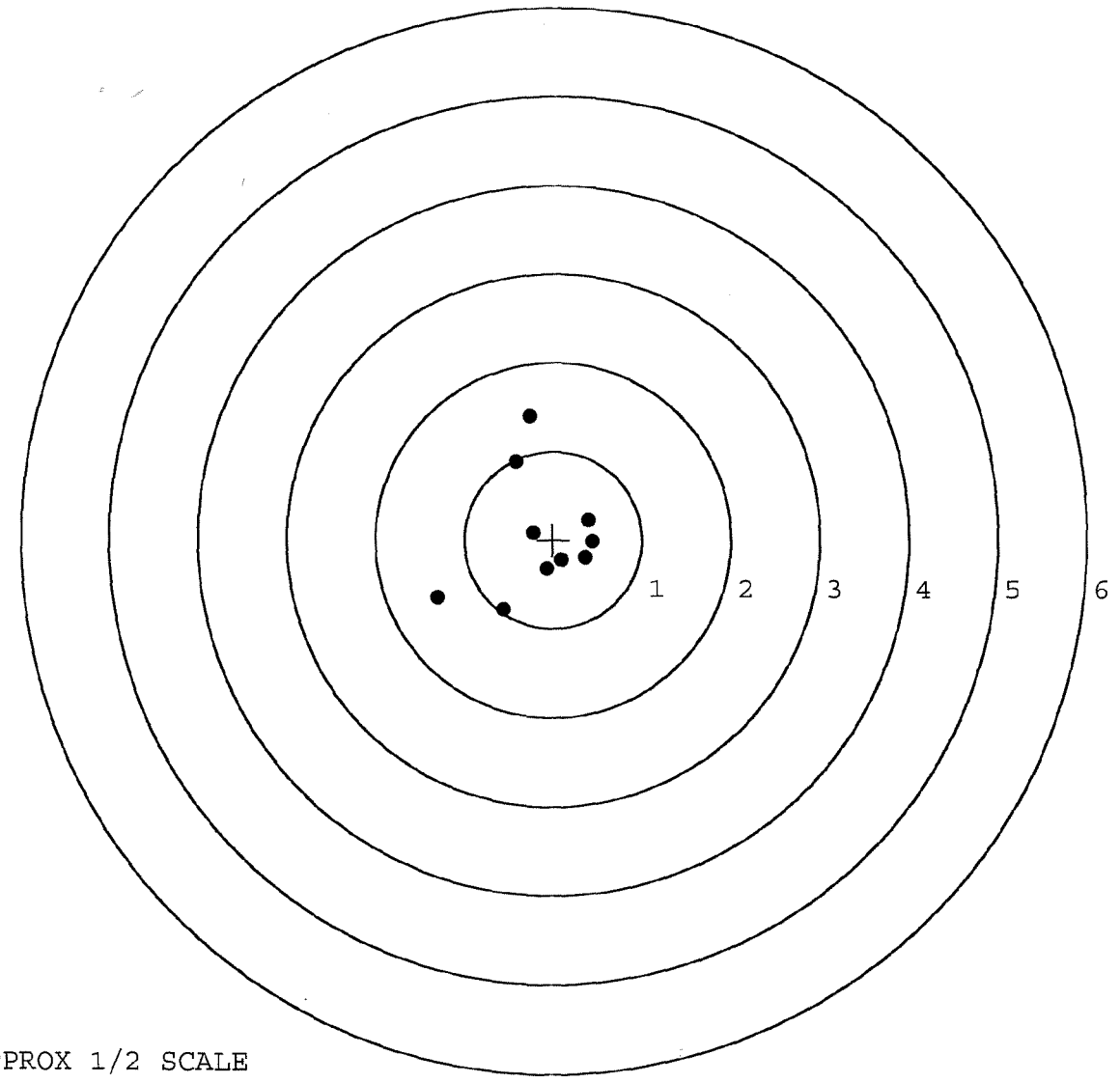


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410317.__0
TARGET NUMBER: 5
FILE DATE: 10/15/2004
FILE TIME: 07:09

X CENTROID:	-0.153
Y CENTROID:	0.034
POA TO CENTROID:	0.157
HORZ SPREAD:	1.740
VERT SPREAD:	2.184
GROUP SPREAD:	2.295
MIN RADIUS:	0.082
MAX RADIUS:	1.365
MEAN RADIUS:	0.709
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.559	-0.790
2:	-1.298	-0.657
3:	0.396	0.221
4:	0.371	-0.202
5:	0.442	-0.025
6:	0.100	-0.232
7:	-0.070	-0.331
8:	-0.221	0.080
9:	-0.426	0.880
10:	-0.268	1.394



TARGET APPROX 1/2 SCALE