

G6410499

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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UPC



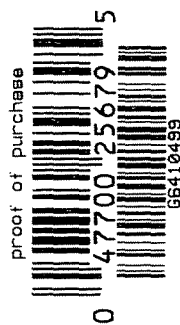
SERIAL NO.



**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
96117 - TRS BI POD ASSB

DD FORM 96253



ORDER NO. 25679

BARREL LENGTH 24"

CAPACITY 6

G6410499



3/11/2005 9:25:01 AM

Crib

23

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 # G6410499

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-24-05	RTL
600	PROOF		1-25-05	AE
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-25-05	AE
610	DIS-ASSEMBLE GUN		1-26-05	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 26 2005 OPERATOR 		
615	ROLLMARK CALIBER		1-27-05	CW
617	DRILL AND TAP SIGHT HOLES		1-26-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1/31/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-7-05	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-7-05	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-7-05	RTL
	D) OIL FIRING PIN ASSEMBLY		2-7-05	RTL
	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>5 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	3-21-05	AC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	3-21-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN			
	J) ASSEMBLE STOCK		2-8-05	RL
	K) ASSEMBLE SWIVEL STUDS		3-21-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-8-05	RL
	M) IRON SIGHT ALIGNMENT		2-8-05	RL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-8-05	RL
640	GALLERY TEST AND TARGET	PASS FAIL	2-11-05	TRLW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-11-05	AC
655	FINAL INSPECTION A) HEADSPACE		3-21-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.80</u> <u>2.59</u> <u>2.78</u> <u>2.48</u> <u>2.62</u>	3-21-05	TRLW
	C) FUNCTION		3-21-05	AC
660	PACK		3/24/05	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 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	2.13	2.41		2.46	
PULL #2	2.48	2.35		2.33	
PULL #3	2.56	2.31		2.38	
PULL #4	2.61	2.26		2.30	
PULL #5	2.53	2.14		2.27	
TOTAL	12.31	11.47		11.74	
AVERAGE	2.46	2.29		2.34	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	2.99		
PULL #2	3.29	2.98		
PULL #3	3.27	3.12		
PULL #4	3.20	3.02		
PULL #5	3.25	3.14		
TOTAL	16.26	15.25		
AVERAGE	3.25	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	3.94	4.17		4.57
PULL #2	4.28	4.13		4.53
PULL #3	4.23	3.97		4.50
PULL #4	4.26	4.04		4.51
PULL #5	4.21	4.03		4.51
TOTAL	20.92	20.34		22.62
AVERAGE	4.18	4.06		4.52

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410499.___0
FILE DATE AND TIME: 02/11/2005 09:47

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

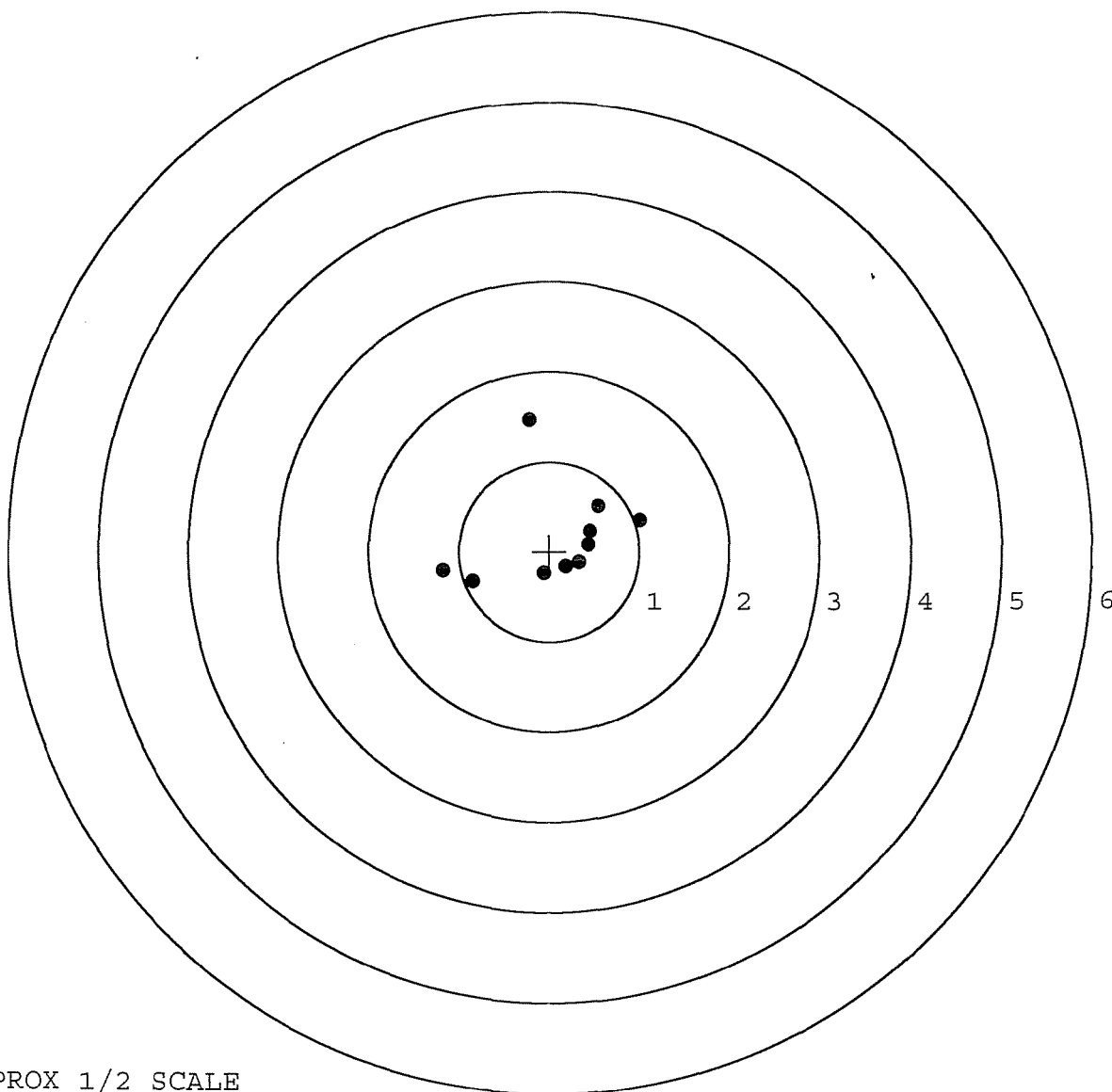
The Average X Centroid of the Five Target Set:	0.115
The Average Y Centroid of the Five Target Set:	-0.073
The Average Point of Impact of the Five Target Set:	0.136
The Average Mean Radius of the Five Target Set:	0.691
The Distance from POA to Centroid Target #1:	0.163
The Distance from Centroid Target #2 to Centroid Target #1:	0.283
The Distance from Centroid Target #3 to Centroid Target #1:	0.281
The Distance from Centroid Target #4 to Centroid Target #1:	0.439
The Distance from Centroid Target #5 to Centroid Target #1:	0.199

SERIAL NUMBER: G6410499. 0
TARGET NUMBER: 1
FILE DATE: 02/11/2005
FILE TIME: 09:47

X CENTROID: 0.062
Y CENTROID: 0.151
POA TO CENTROID: 0.163
HORZ SPREAD: 2.182
VERT SPREAD: 1.800
GROUP SPREAD: 1.928
MIN RADIUS: 0.346
MAX RADIUS: 1.342
MEAN RADIUS: 0.715

IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.004	0.350
2:	0.543	0.510
3:	-0.233	1.460
4:	-1.178	-0.220
5:	-0.849	-0.340
6:	-0.064	-0.246
7:	0.184	-0.172
8:	0.327	-0.126
9:	0.433	0.074
10:	0.449	0.222

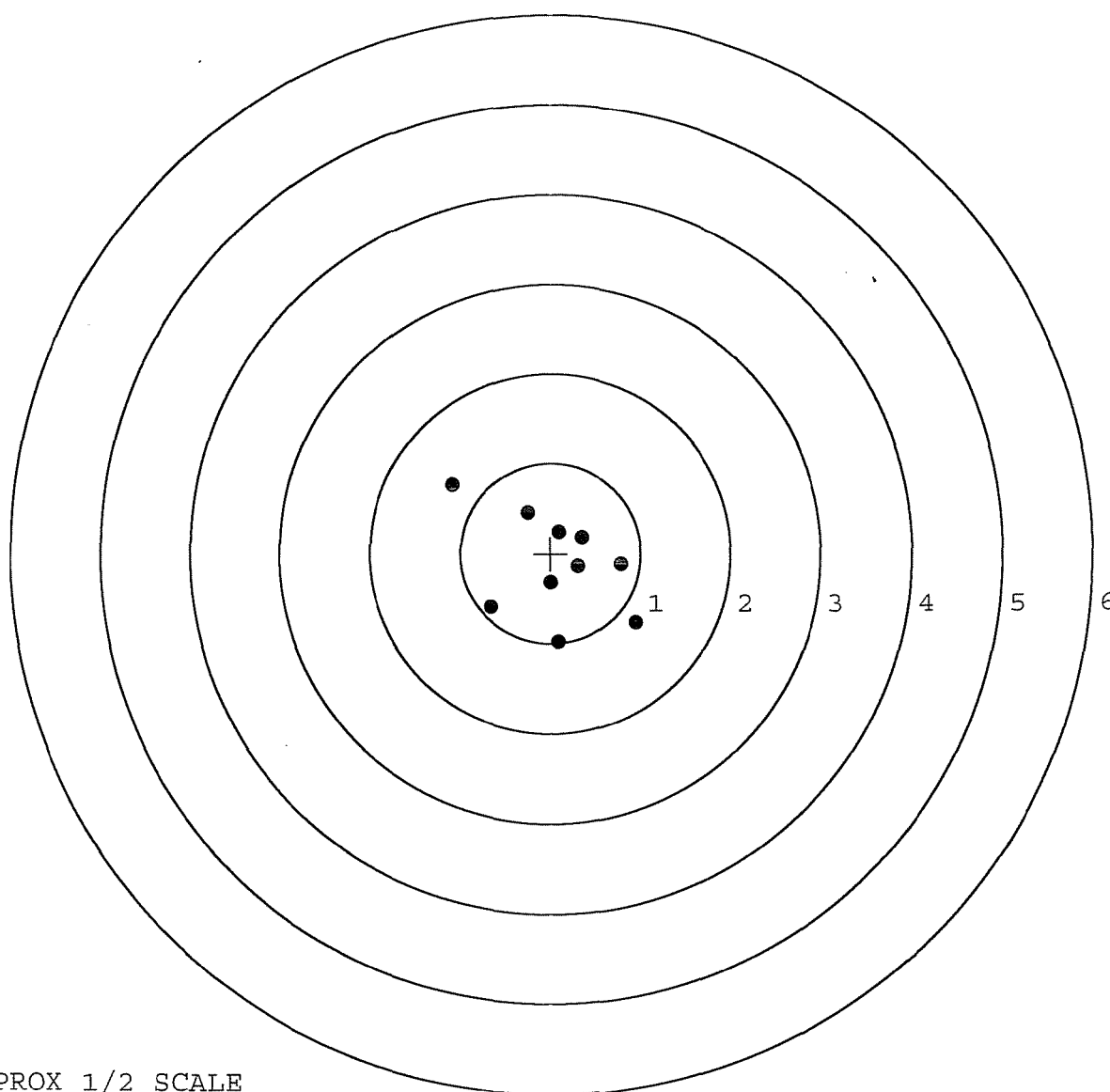


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410499. __0
TARGET NUMBER: 2
FILE DATE: 02/11/2005
FILE TIME: 09:47

X CENTROID: 0.053
Y CENTROID: -0.132
POA TO CENTROID: 0.142
HORZ SPREAD: 2.030
VERT SPREAD: 1.746
GROUP SPREAD: 2.540
MIN RADIUS: 0.197
MAX RADIUS: 1.448
MEAN RADIUS: 0.689
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.941	-0.770
2:	0.786	-0.116
3:	0.081	-0.989
4:	0.002	-0.322
5:	-0.662	-0.604
6:	0.303	-0.144
7:	0.087	0.240
8:	-0.256	0.448
9:	-1.089	0.757
10:	0.341	0.179



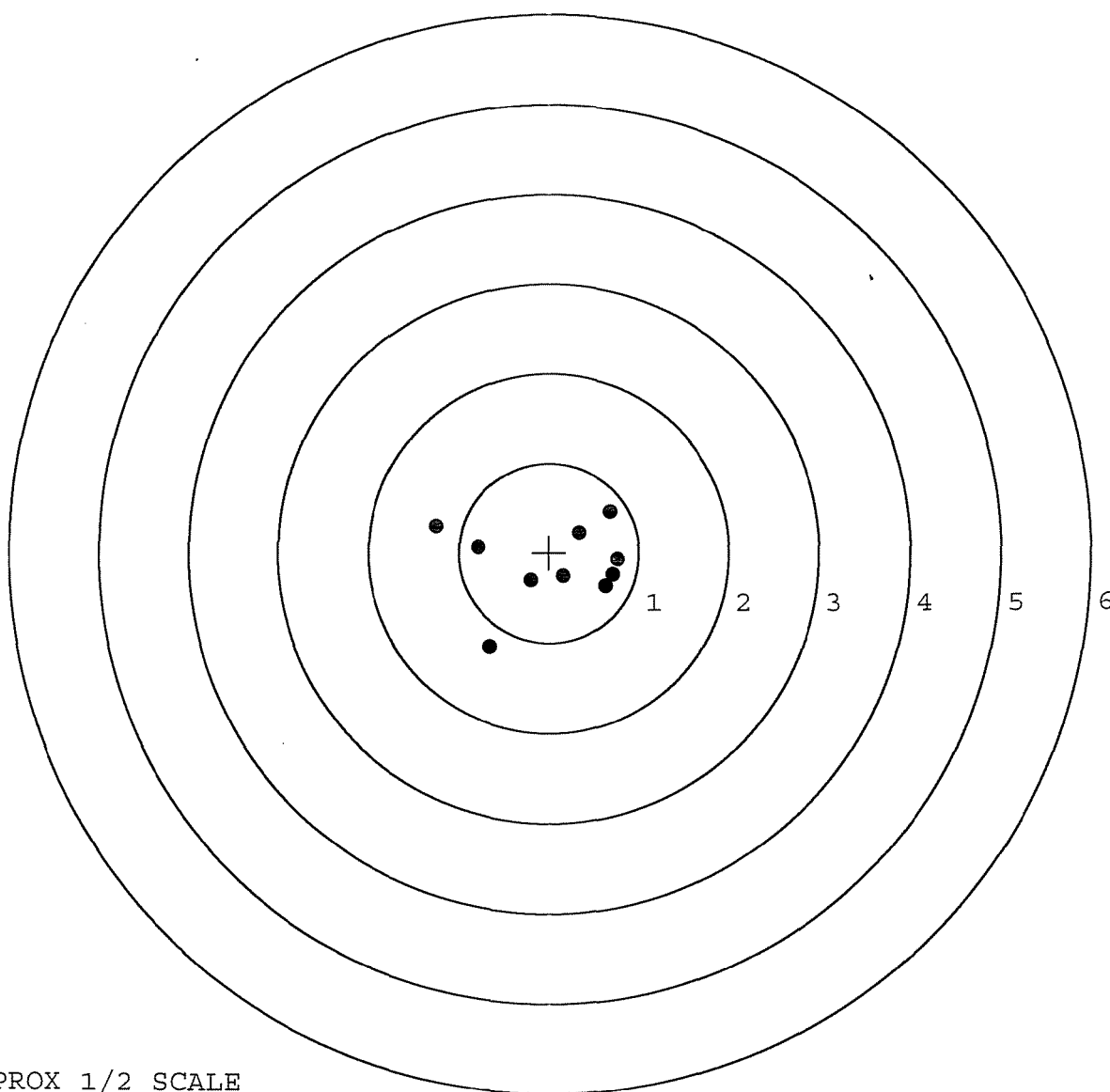
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410499. __0
TARGET NUMBER: 3
FILE DATE: 02/11/2005
FILE TIME: 09:47

X CENTROID: 0.036
Y CENTROID: -0.129
POA TO CENTROID: 0.134
HORZ SPREAD: 2.019
VERT SPREAD: 1.510
GROUP SPREAD: 2.052
MIN RADIUS: 0.178
MAX RADIUS: 1.360
MEAN RADIUS: 0.721

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.761	-0.074
2:	0.633	-0.368
3:	-0.659	-1.051
4:	0.154	-0.263
5:	0.327	0.214
6:	0.678	0.459
7:	-0.202	-0.309
8:	-0.783	0.058
9:	-1.258	0.290
10:	0.711	-0.245

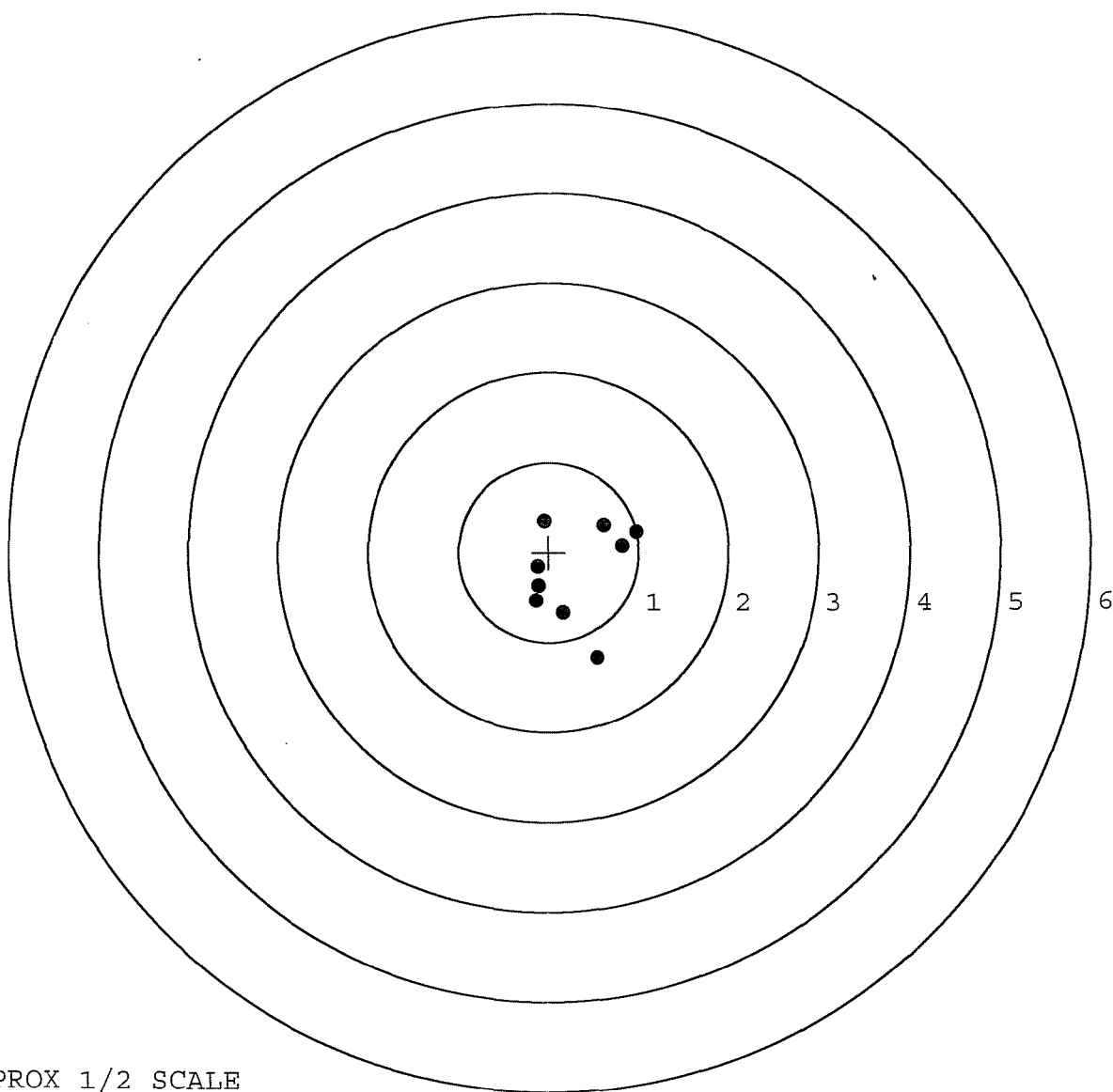


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410499. 0
TARGET NUMBER: 4
FILE DATE: 02/11/2005
FILE TIME: 09:47

X CENTROID: 0.296
Y CENTROID: -0.220
POA TO CENTROID: 0.369
HORZ SPREAD: 1.114
VERT SPREAD: 1.525
GROUP SPREAD: 1.641
MIN RADIUS: 0.421
MAX RADIUS: 0.991
MEAN RADIUS: 0.618
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.545	-1.179
2:	0.155	-0.677
3:	-0.143	-0.544
4:	-0.115	-0.377
5:	-0.121	-0.160
6:	-0.060	0.346
7:	0.613	0.302
8:	0.816	0.079
9:	0.971	0.230

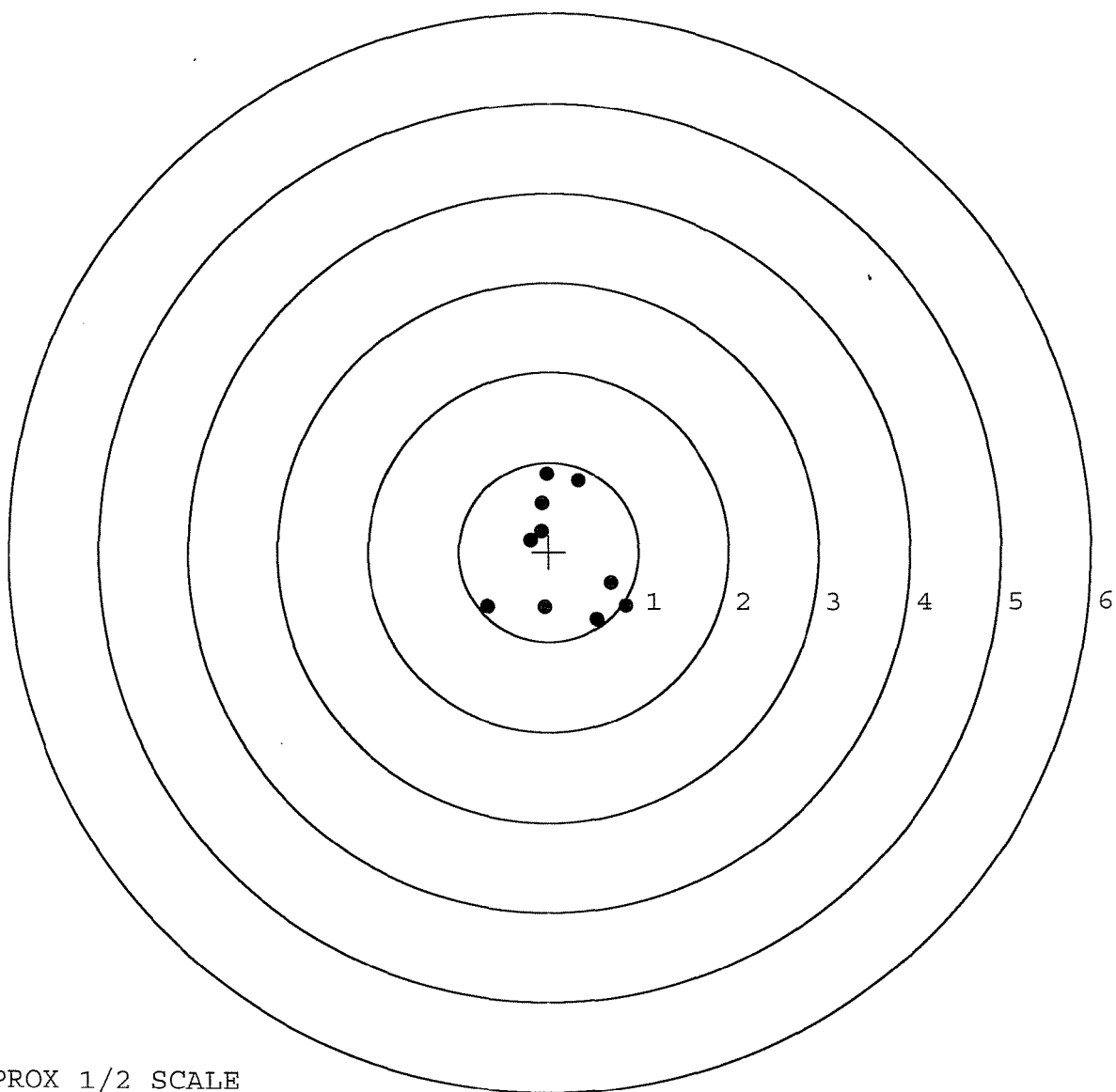


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410499. 0
TARGET NUMBER: 5
FILE DATE: 02/11/2005
FILE TIME: 09:47

X CENTROID: 0.128
Y CENTROID: -0.036
POA TO CENTROID: 0.133
HORZ SPREAD: 1.534
VERT SPREAD: 1.627
GROUP SPREAD: 1.730
MIN RADIUS: 0.340
MAX RADIUS: 0.993
MEAN RADIUS: 0.710
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.678	-0.615
2:	-0.053	-0.623
3:	-0.080	0.233
4:	-0.083	0.544
5:	-0.028	0.873
6:	0.324	0.795
7:	0.690	-0.341
8:	0.856	-0.605
9:	0.539	-0.754
10:	-0.204	0.133



TARGET APPROX 1/2 SCALE