

G-6410501

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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UPC



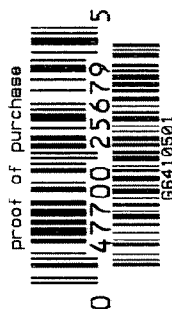
SERIAL NO.



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

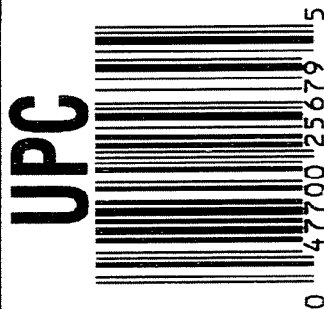
98606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB

DD FORM 96253



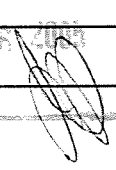
ORDER NO.	25679
BARREL LENGTH	24"
CAPACITY	6

G6410501



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410501

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-24-05	RTL
600	PROOF	MAGNA-FLUX	1-25-05	A
607	CHECK HEADSPACE	INSPECTED	1-25-05	A
610	DIS-ASSEMBLE GUN	JAN 7 2005	1-26-05	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR 		
615	ROLLMARK CALIBER		1-27-05	CW
617	DRILL AND TAP SIGHT HOLES		1-26-05	TRL
620	APPLY COATINGS (BARREL ACTION)		1/3/05	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			

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>8 lbs</u> <u>8 lbs</u> <u>8 lbs</u>	3-29-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	3-29-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.025</u> <u>.025</u> <u>.025</u>	3-29-05	AC
	J) ASSEMBLE STOCK		2-8-05	RTL
	K) ASSEMBLE SWIVEL STUDS		3-29-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-8-05	RTL
	M) IRON SIGHT ALIGNMENT		2-8-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-8-05	RTL
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	2-14-05	TRW
	MALFUNCTION <i>shave brass</i>	CORRECTION <i>OK</i>	2-16-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-14-05	AC
655	FINAL INSPECTION A) HEADSPACE		3-29-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.38</u> <u>2.67</u> <u>2.08</u> <u>2.25</u> <u>2.21</u>	3-29-05	TRW
	C) FUNCTION		3-29-05	AC
660	PACK		3/30/05	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. G-6410501

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	2.79	2.75		2.07	
PULL #2	2.48	2.40		2.19	
PULL #3	2.70	2.84		2.17	
PULL #4	2.65	2.60		2.17	
PULL #5	2.59	2.40		2.07	
TOTAL	13.21	12.99		10.67	
AVERAGE	2.64	2.59		2.13	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.26		
PULL #2	3.15	3.19		
PULL #3	3.10	3.24		
PULL #4	3.26	3.24		
PULL #5	3.38	3.10		
TOTAL	16.05	16.03		
AVERAGE	3.21	3.20		

	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	4.34	4.05		4.13
PULL #2	4.51	4.31		4.11
PULL #3	4.24	4.29		4.08
PULL #4	4.35	4.19		4.12
PULL #5	4.27	4.19		4.06
TOTAL	21.71	21.03		20.50
AVERAGE	4.34	4.20		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410501.___0
FILE DATE AND TIME: 02/14/2005 07:34

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

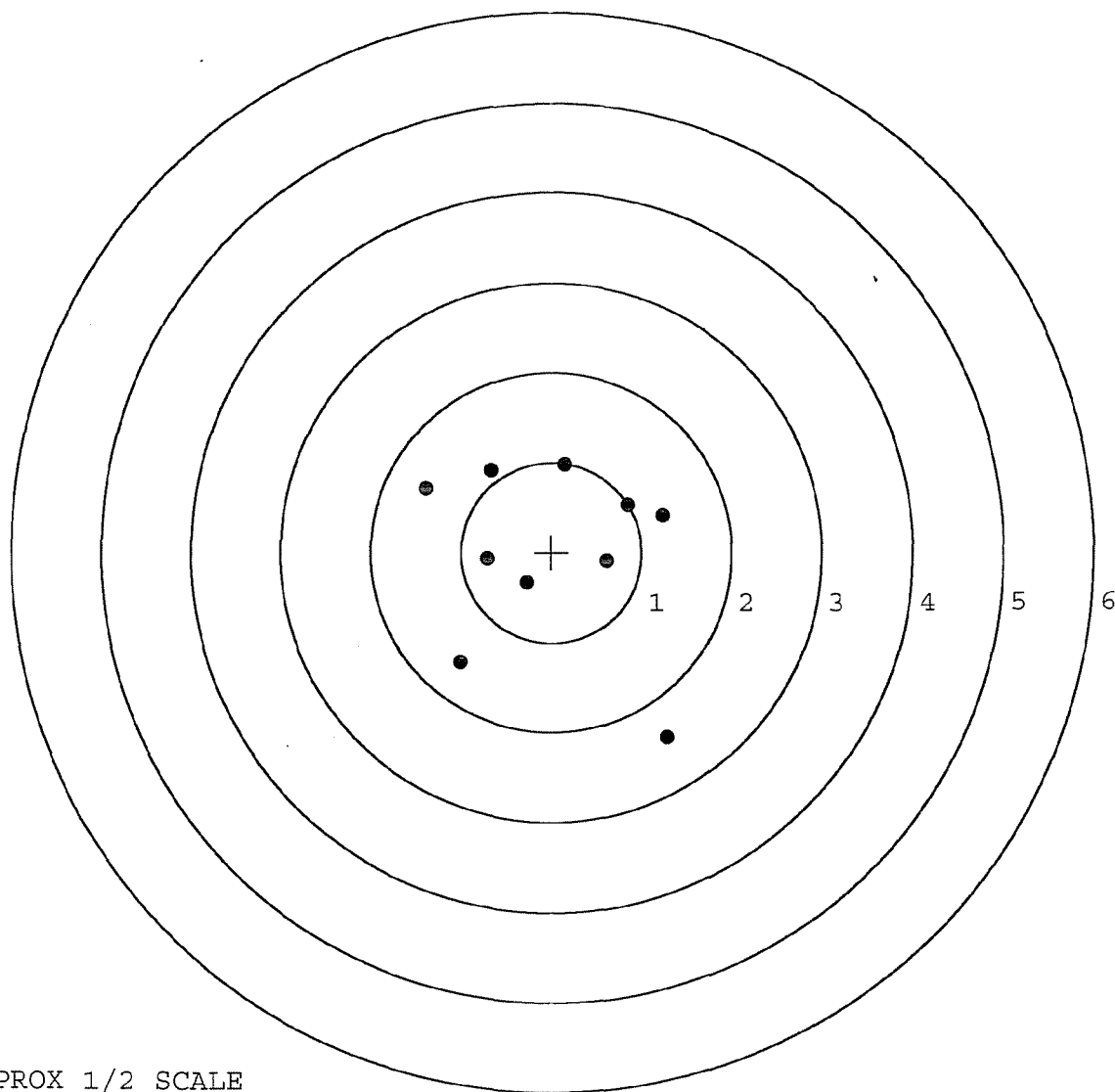
The Average X Centroid of the Five Target Set:	0.101
The Average Y Centroid of the Five Target Set:	0.053
The Average Point of Impact of the Five Target Set:	0.115
The Average Mean Radius of the Five Target Set:	0.984
The Distance from POA to Centroid Target #1:	0.026
The Distance from Centroid Target #2 to Centroid Target #1:	0.312
The Distance from Centroid Target #3 to Centroid Target #1:	0.102
The Distance from Centroid Target #4 to Centroid Target #1:	0.285
The Distance from Centroid Target #5 to Centroid Target #1:	0.332

SERIAL NUMBER: G6410501. __0
TARGET NUMBER: 1
FILE DATE: 02/14/2005
FILE TIME: 07:34

X CENTROID: 0.006
Y CENTROID: -0.026
POA TO CENTROID: 0.026
HORZ SPREAD: 2.668
VERT SPREAD: 3.037
GROUP SPREAD: 3.849
MIN RADIUS: 0.423
MAX RADIUS: 2.402
MEAN RADIUS: 1.178

POINT#	X	Y
1:	1.234	0.411
2:	0.845	0.529
3:	0.147	0.975
4:	0.614	-0.099
5:	-0.279	-0.339
6:	-0.713	-0.074
7:	-1.012	-1.223
8:	-1.388	0.712
9:	1.280	-2.062
10:	-0.671	0.913

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



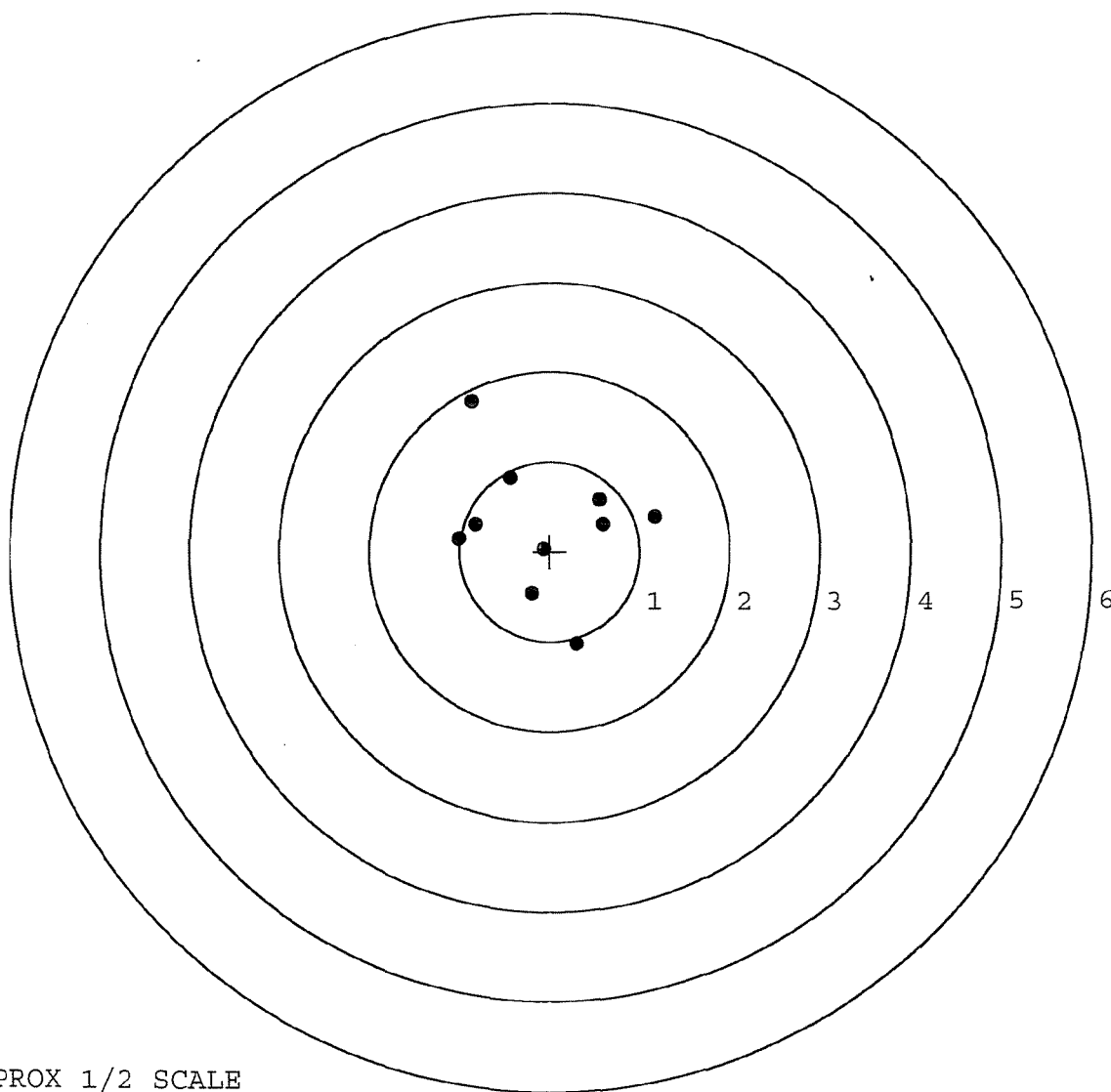
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410501. 0
TARGET NUMBER: 2
FILE DATE: 02/14/2005
FILE TIME: 07:34

X CENTROID: -0.081
Y CENTROID: 0.274
POA TO CENTROID: 0.286
HORZ SPREAD: 2.182
VERT SPREAD: 2.691
GROUP SPREAD: 2.934
MIN RADIUS: 0.248
MAX RADIUS: 1.596
MEAN RADIUS: 0.894

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.299	-1.029
2:	-0.200	-0.472
3:	-0.071	0.027
4:	0.592	0.309
5:	0.550	0.582
6:	1.173	0.388
7:	-0.446	0.826
8:	-0.830	0.305
9:	-1.009	0.145
10:	-0.869	1.662

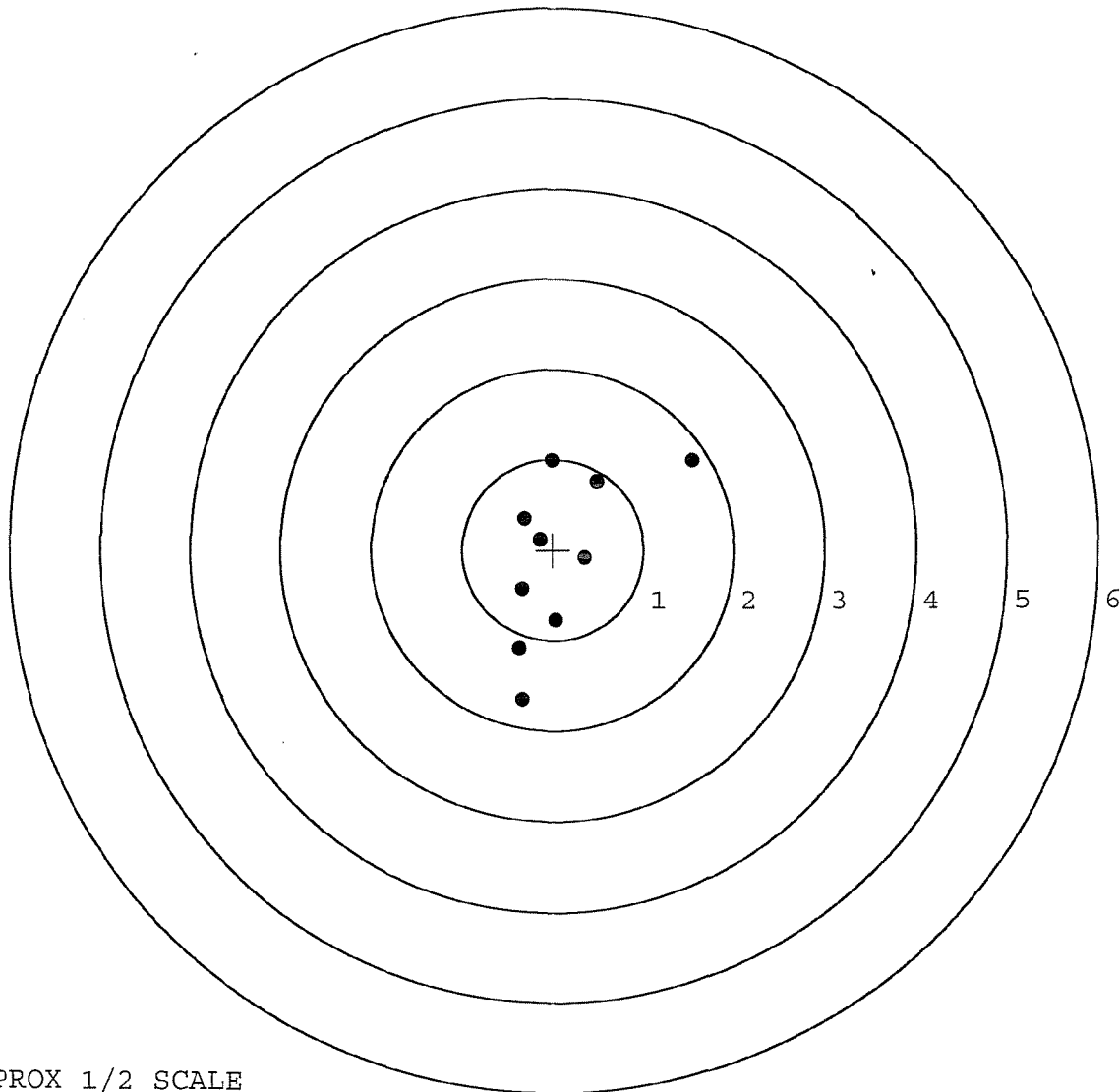


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410501.___0
TARGET NUMBER: 3
FILE DATE: 02/14/2005
FILE TIME: 07:34

POINT#	X	Y
1:	1.536	0.991
2:	0.483	0.755
3:	-0.014	0.990
4:	0.352	-0.088
5:	-0.140	0.108
6:	-0.320	0.345
7:	-0.344	-0.439
8:	0.030	-0.784
9:	-0.379	-1.097
10:	-0.335	-1.662

X CENTROID: 0.087
Y CENTROID: -0.088
POA TO CENTROID: 0.124
HORZ SPREAD: 1.915
VERT SPREAD: 2.653
GROUP SPREAD: 3.246
MIN RADIUS: 0.265
MAX RADIUS: 1.807
MEAN RADIUS: 0.898
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

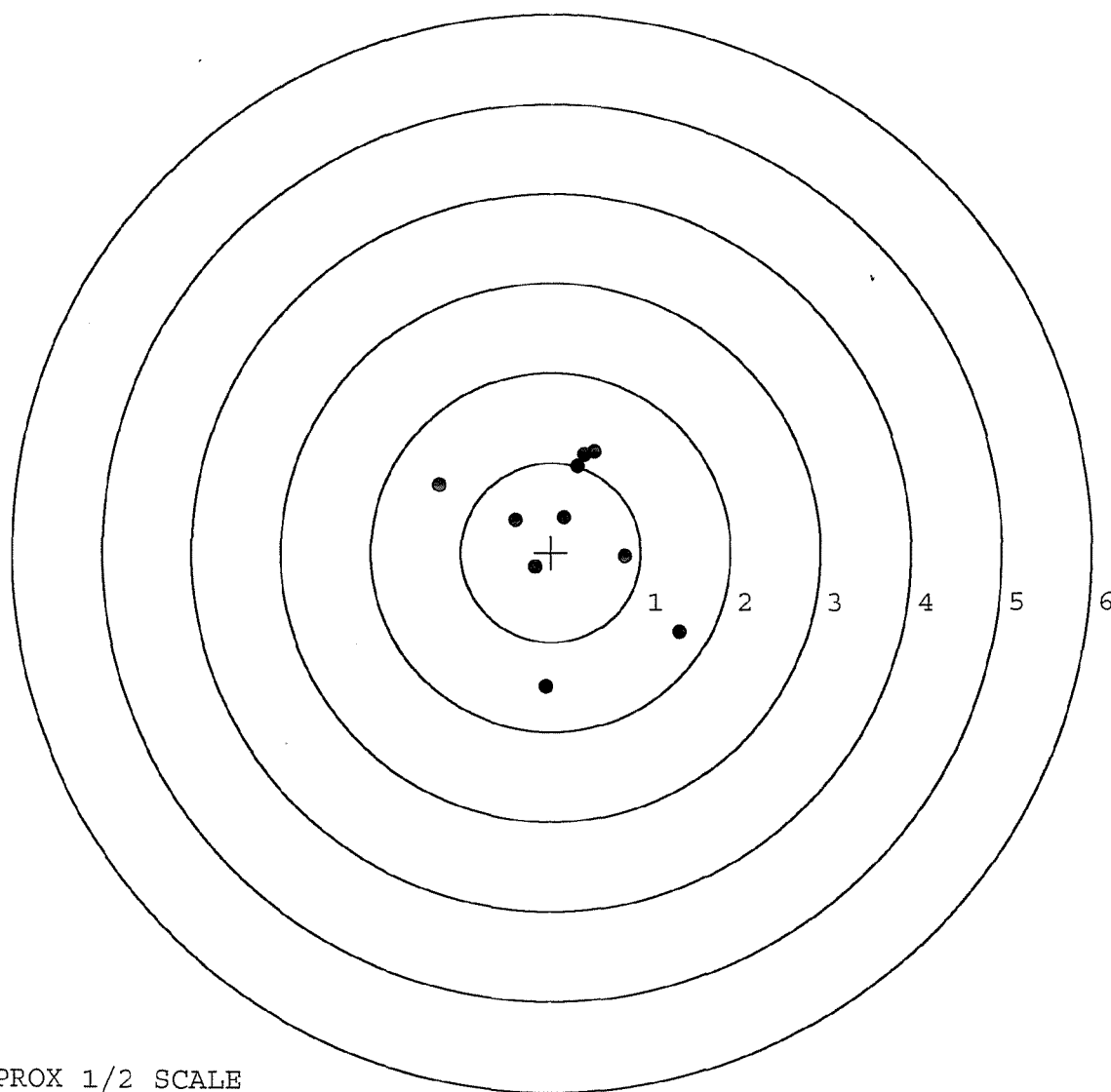


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410501. __0
TARGET NUMBER: 4
FILE DATE: 02/14/2005
FILE TIME: 07:34

POINT#	X	Y
1:	1.429	-0.892
2:	-0.055	-1.501
3:	0.826	-0.040
4:	-0.176	-0.161
5:	0.141	0.388
6:	-0.400	0.361
7:	-1.243	0.752
8:	0.481	1.125
9:	0.372	1.089
10:	0.298	0.965

X CENTROID: 0.167
Y CENTROID: 0.209
POA TO CENTROID: 0.267
HORZ SPREAD: 2.672
VERT SPREAD: 2.626
GROUP SPREAD: 2.680
MIN RADIUS: 0.181
MAX RADIUS: 1.724
MEAN RADIUS: 0.953
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 7

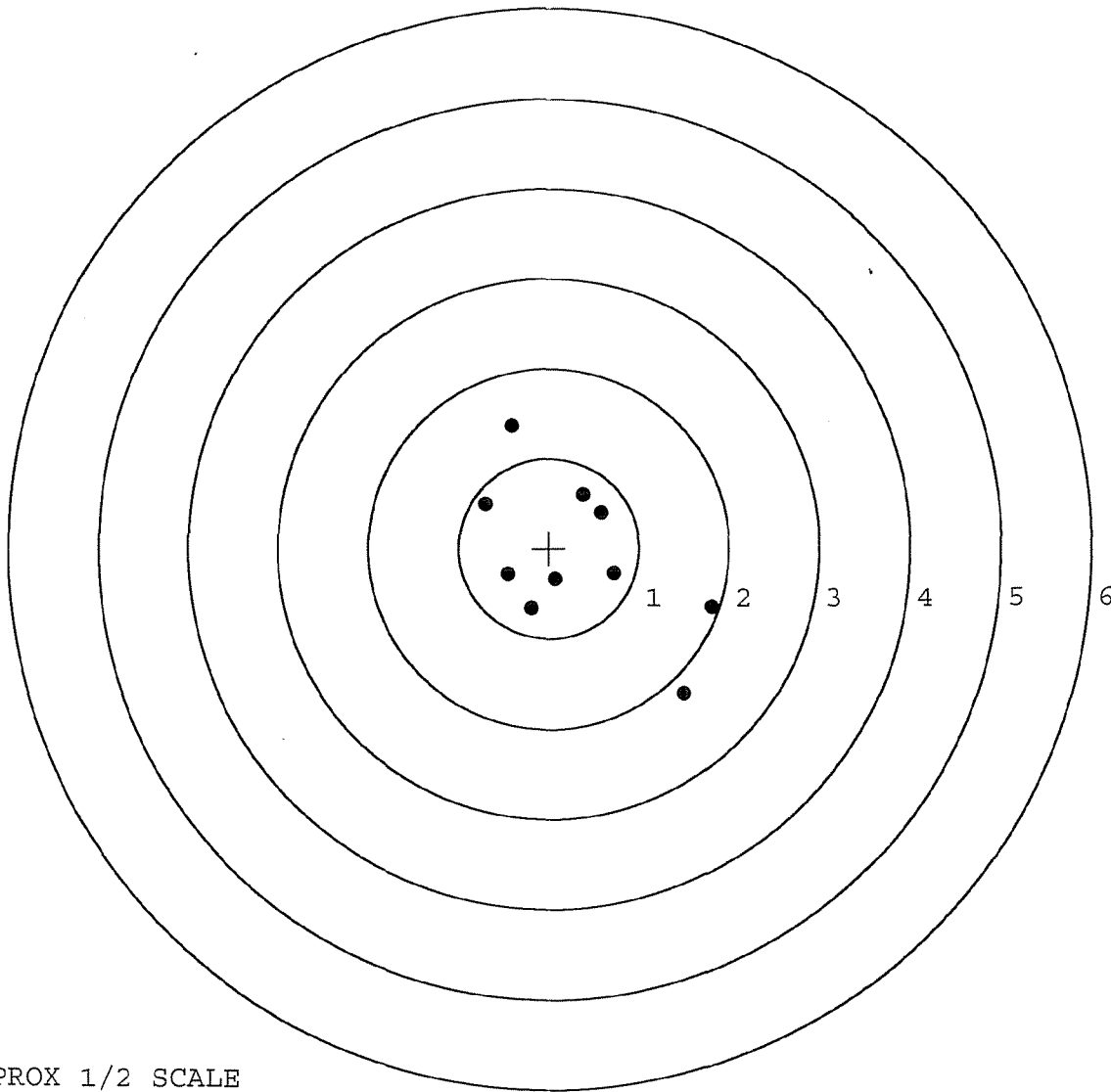


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410501.____0
TARGET NUMBER: 5
FILE DATE: 02/14/2005
FILE TIME: 07:34

POINT#	X	Y
1:	1.500	-1.609
2:	1.813	-0.656
3:	0.723	-0.285
4:	0.579	0.400
5:	0.378	0.599
6:	-0.712	0.489
7:	-0.415	1.361
8:	0.070	-0.350
9:	-0.455	-0.297
10:	-0.199	-0.678

X CENTROID: 0.328
Y CENTROID: -0.103
POA TO CENTROID: 0.344
HORZ SPREAD: 2.525
VERT SPREAD: 2.970
GROUP SPREAD: 3.534
MIN RADIUS: 0.358
MAX RADIUS: 1.908
MEAN RADIUS: 0.998
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 7



TARGET APPROX 1/2 SCALE