

G-6410503

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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UPC



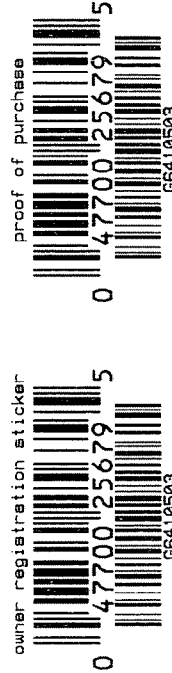
SERIAL NO.



**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

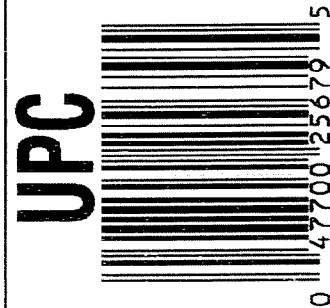


ORDER NO. **25679**

BARREL LENGTH 24"

CAPACITY 6

G6410503



3/11/2005 9:25:01 AM

Original

24

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 # G6410503

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RTL
600	PROOF		1-4-05	K
607	CHECK HEADSPACE	MAGNA-FLUX	1-4-05	AC
610	DIS-ASSEMBLE GUN	INSPECTED	1-4-05	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 3 4 2005 OPERATOR B.S.		
615	ROLLMARK CALIBER		1-5-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1-4-05	NO
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-17-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-17-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-17-05	RTL
	D) OIL FIRING PIN ASSEMBLY		2-8-05	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>6 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	<u>.024</u> <u>.024</u> <u>.024</u>	3-21-05	Ac
	J) ASSEMBLE STOCK		2-8-05	RR
	K) ASSEMBLE SWIVEL STUDS		3-21-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-8-05	RR
	M) IRON SIGHT ALIGNMENT		2-8-05	RR
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-8-05	RR
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	2-10-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-10-05	Ac
655	FINAL INSPECTION A) HEADSPACE		3-21-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.35</u> <u>2.87</u> <u>2.70</u> <u>2.76</u> <u>2.78</u>	3-21-05	TRW
	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 1-17-05

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.25	2.21		2.22	
PULL #2	2.46	2.18		2.09	
PULL #3	2.45	2.03		2.09	
PULL #4	2.46	2.05		2.08	
PULL #5	2.44	2.11		2.06	
TOTAL	12.06	10.58		10.54	
AVERAGE	2.41	2.11		2.10	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.06		
PULL #2	3.01	3.05		
PULL #3	3.44	3.04		
PULL #4	3.20	3.01		
PULL #5	3.17	3.04		
TOTAL	15.95	15.20		
AVERAGE	3.19	3.04		

	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	4.01	4.20		4.35
PULL #2	4.04	3.96		4.60
PULL #3	4.51	4.07		4.27
PULL #4	4.48	4.18		4.40
PULL #5	4.40	4.03		4.46
TOTAL	21.44	20.44		22.08
AVERAGE	4.28	4.08		4.41

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410503.__0

FILE DATE AND TIME: 02/10/2005 07:35

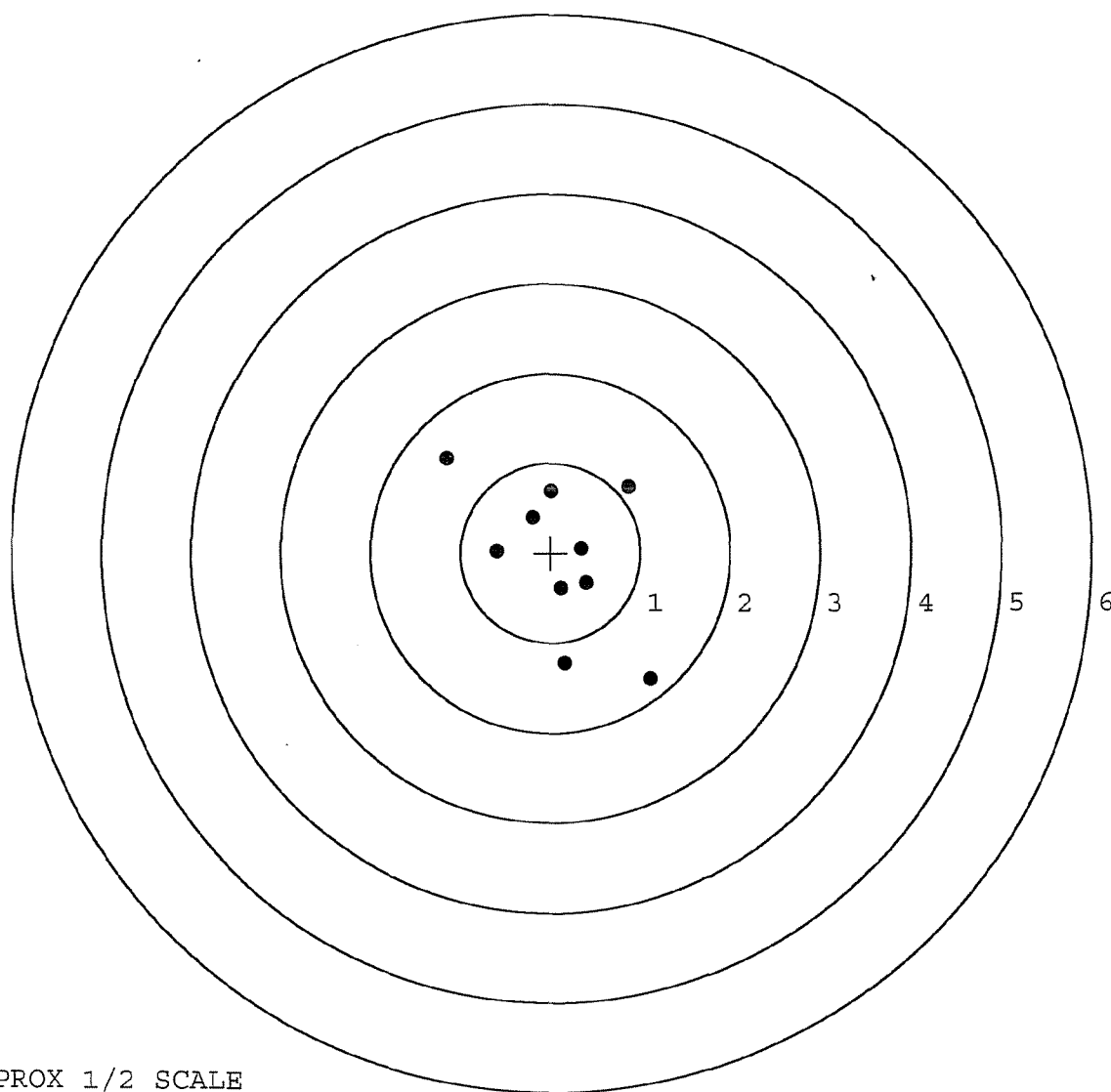
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.081
The Average Y Centroid of the Five Target Set:	-0.145
The Average Point of Impact of the Five Target Set:	0.166
The Average Mean Radius of the Five Target Set:	0.907
The Distance from POA to Centroid Target #1:	0.110
The Distance from Centroid Target #2 to Centroid Target #1:	0.378
The Distance from Centroid Target #3 to Centroid Target #1:	0.073
The Distance from Centroid Target #4 to Centroid Target #1:	0.123
The Distance from Centroid Target #5 to Centroid Target #1:	0.157

SERIAL NUMBER: G6410503. 0
TARGET NUMBER: 1
FILE DATE: 02/10/2005
FILE TIME: 07:35

X CENTROID: 0.101
Y CENTROID: -0.043
POA TO CENTROID: 0.110
HORZ SPREAD: 2.271
VERT SPREAD: 2.454
GROUP SPREAD: 3.344
MIN RADIUS: 0.257
MAX RADIUS: 1.695
MEAN RADIUS: 0.864
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.112	-1.404
2:	0.159	-1.229
3:	0.114	-0.396
4:	0.341	0.050
5:	0.861	0.737
6:	-0.006	0.693
7:	-0.210	0.387
8:	-0.595	0.017
9:	-1.159	1.050
10:	0.396	-0.336

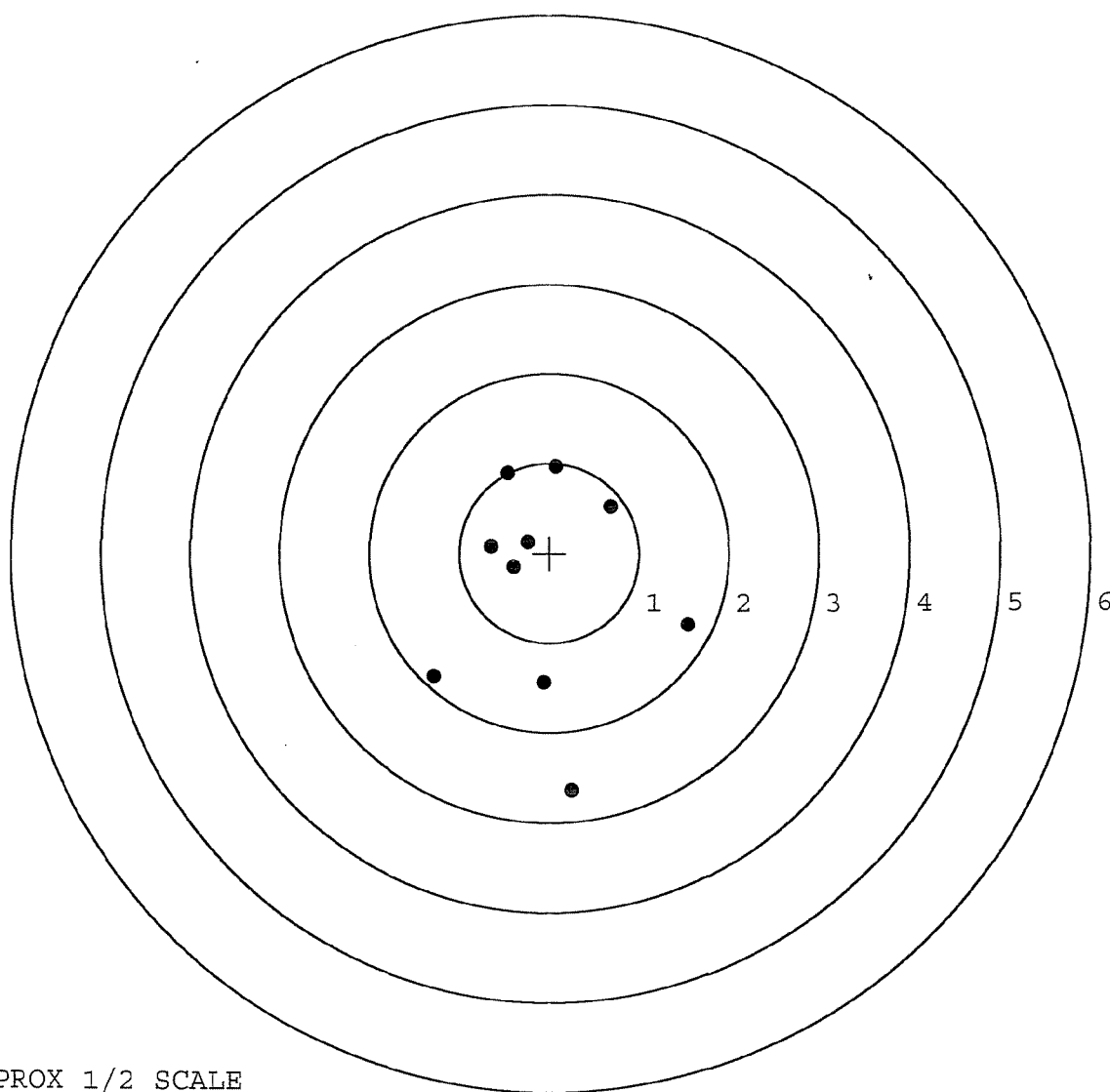


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410503.____0
TARGET NUMBER: 2
FILE DATE: 02/10/2005
FILE TIME: 07:35

X CENTROID: -0.057
Y CENTROID: -0.386
POA TO CENTROID: 0.390
HORZ SPREAD: 2.837
VERT SPREAD: 3.611
GROUP SPREAD: 3.615
MIN RADIUS: 0.417
MAX RADIUS: 2.282
MEAN RADIUS: 1.215
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.546	-0.805
2:	-0.068	-1.447
3:	-1.291	-1.378
4:	0.244	-2.648
5:	0.677	0.518
6:	0.077	0.963
7:	-0.461	0.893
8:	-0.647	0.077
9:	-0.241	0.125
10:	-0.406	-0.157

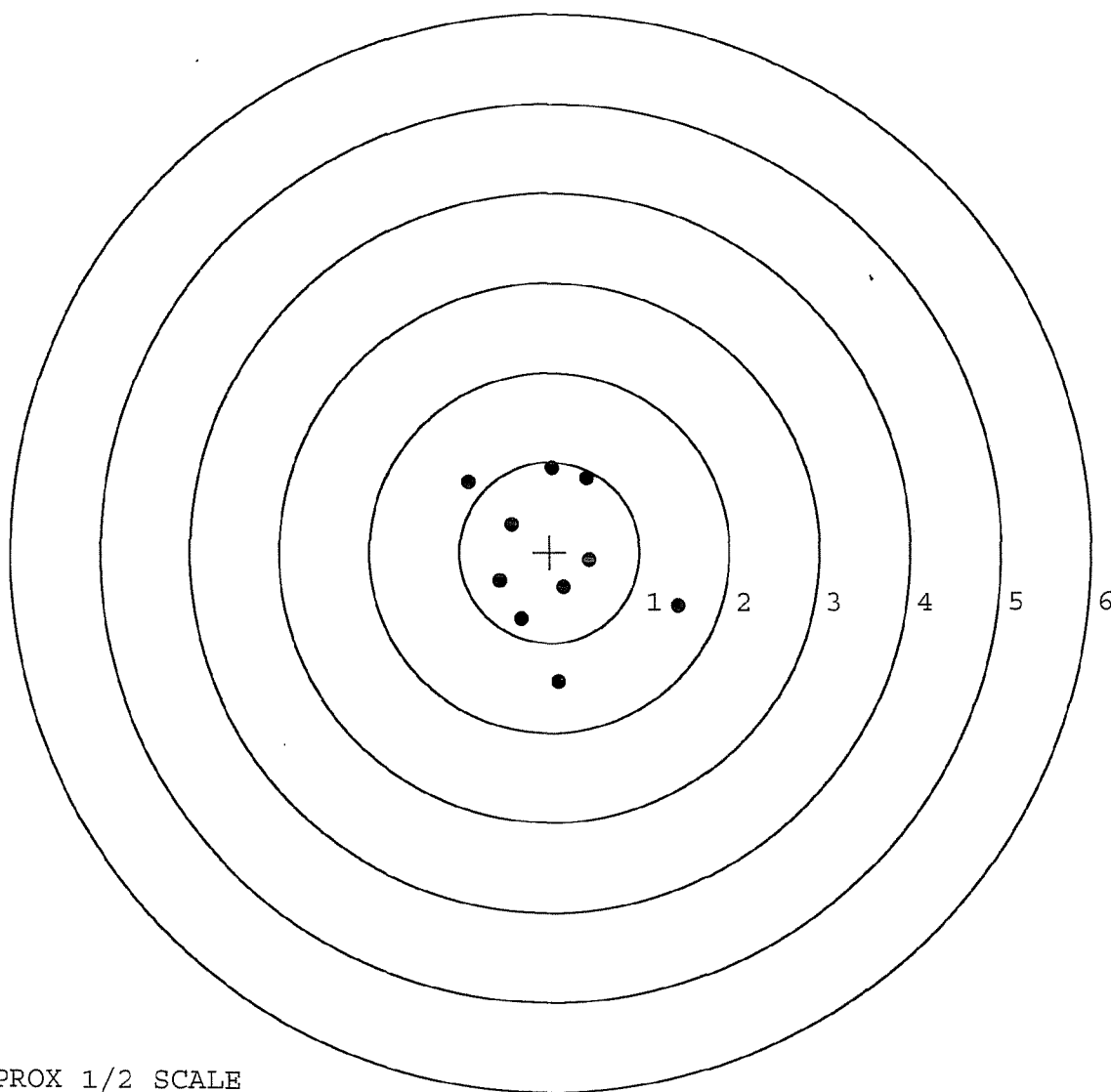


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410503. __0
TARGET NUMBER: 3
FILE DATE: 02/10/2005
FILE TIME: 07:35

POINT#	X	Y
1:	1.429	-0.598
2:	0.098	-1.439
3:	-0.556	-0.321
4:	-0.317	-0.742
5:	0.155	-0.390
6:	0.445	-0.088
7:	0.408	0.824
8:	0.026	0.935
9:	-0.427	0.304
10:	-0.906	0.775

X CENTROID: 0.036
Y CENTROID: -0.074
POA TO CENTROID: 0.082
HORZ SPREAD: 2.335
VERT SPREAD: 2.374
GROUP SPREAD: 2.709
MIN RADIUS: 0.338
MAX RADIUS: 1.489
MEAN RADIUS: 0.885
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

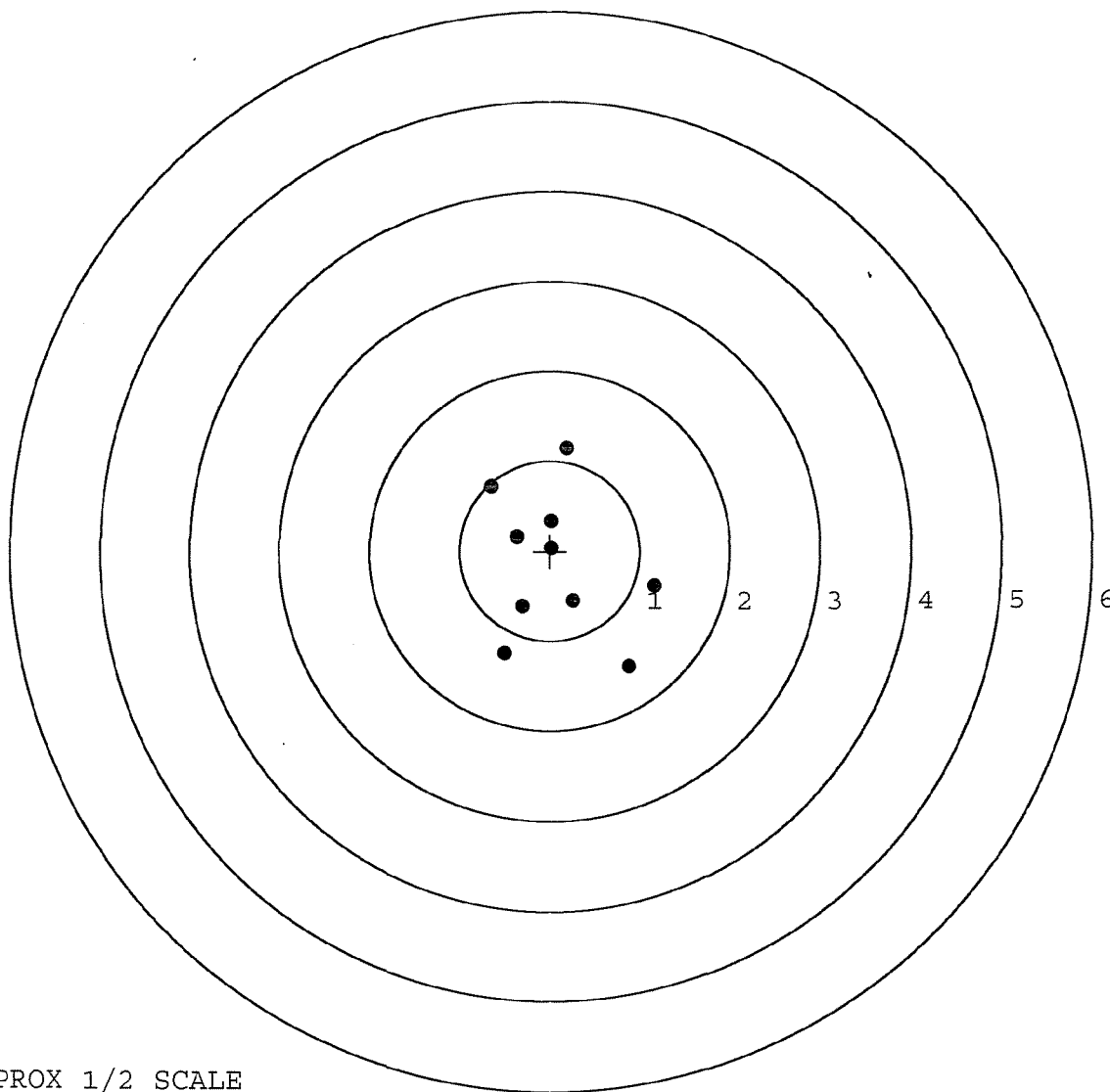


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410503. __0
TARGET NUMBER: 4
FILE DATE: 02/10/2005
FILE TIME: 07:35

POINT#	X	Y
1:	0.875	-1.293
2:	1.165	-0.387
3:	0.257	-0.556
4:	-0.307	-0.618
5:	-0.512	-1.141
6:	0.186	1.135
7:	-0.653	0.715
8:	-0.374	0.165
9:	0.013	0.337
10:	0.014	0.035

X CENTROID: 0.066
Y CENTROID: -0.161
POA TO CENTROID: 0.174
HORZ SPREAD: 1.818
VERT SPREAD: 2.428
GROUP SPREAD: 2.524
MIN RADIUS: 0.203
MAX RADIUS: 1.391
MEAN RADIUS: 0.837
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 10

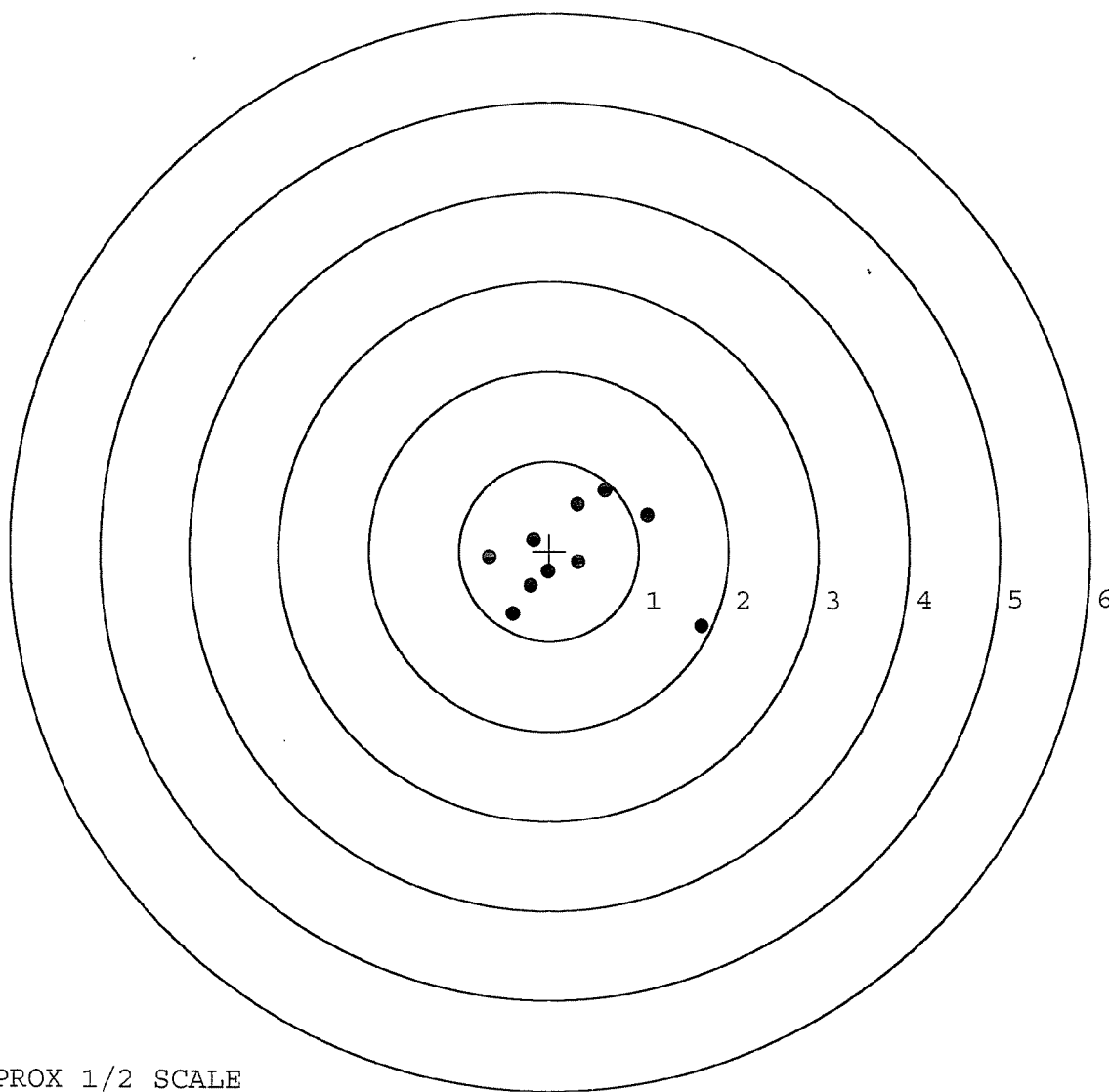


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410503. __0
TARGET NUMBER: 5
FILE DATE: 02/10/2005
FILE TIME: 07:35

POINT#	X	Y
1:	1.697	-0.841
2:	1.096	0.405
3:	0.624	0.680
4:	0.315	0.522
5:	0.324	-0.121
6:	-0.017	-0.230
7:	-0.174	0.124
8:	-0.672	-0.070
9:	-0.409	-0.704
10:	-0.212	-0.393

X CENTROID: 0.257
Y CENTROID: -0.063
POA TO CENTROID: 0.265
HORZ SPREAD: 2.369
VERT SPREAD: 1.521
GROUP SPREAD: 2.491
MIN RADIUS: 0.089
MAX RADIUS: 1.637
MEAN RADIUS: 0.732
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE