

G6410504

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



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UPC



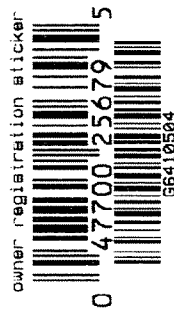
SERIAL NO.



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

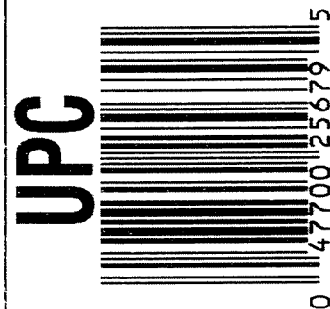
98606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB

DD, FORM 96253



ORDER NO.	25679
BARREL LENGTH	24"
CAPACITY	6

G6410504



Original
3/11/2005 9:25:01 AM
15
Crib

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 #

66410504

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RTZ
600	PROOF		1-4-05	K
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-4-05	K
610	DIS-ASSEMBLE GUN		1-4-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 14 2005 OPERATOR BS		
615	ROLLMARK CALIBER		1-5-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRCJ
620	APPLY COATINGS (BARREL ACTION)		1-4-05	HP
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		1-15-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-15-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-1-05	RR
	D) OIL FIRING PIN ASSEMBLY		2-1-05	RR
	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>6 lbs</u> <u>6 lbs</u> <u>5 lbs</u>	2-16-05	AC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>	2-16-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.023</u> <u>.024</u>	2-16-05	A
	J) ASSEMBLE STOCK		2-1-05	RTL
	K) ASSEMBLE SWIVEL STUDS		2-18-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-1-05	RTL
	M) IRON SIGHT ALIGNMENT		2-1-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-1-05	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	2-3-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-3-05	TRW
655	FINAL INSPECTION A) HEADSPACE		2-16-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.76</u> <u>2.96</u> <u>2.85</u> <u>2.91</u> <u>2.55</u>	2-17-05	TRW
	C) FUNCTION		2-16-05	AC
660	PACK		3/19/05	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 1-19-05

TESTER TRL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.33	2.28		2.47	
PULL #2	2.02	2.07		2.43	
PULL #3	2.51	2.01		2.41	
PULL #4	2.16	2.09		2.41	
PULL #5	2.18	2.01		2.41	
TOTAL	11.20	10.46		12.13	
AVERAGE	2.24	2.09		2.42	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.30	3.35		
PULL #2	3.42	3.35		
PULL #3	3.19	3.32		
PULL #4	3.24	3.30		
PULL #5	3.43	3.38		
TOTAL	16.58	16.70		
AVERAGE	3.31	3.34		

	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	4.54	3.82		4.28
PULL #2	4.01	4.68		4.62
PULL #3	4.54	4.52		4.63
PULL #4	3.79	4.40		4.47
PULL #5	3.98	3.66		4.55
TOTAL	20.86	21.08		22.55
AVERAGE	4.17	4.21		4.51

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410504.___0
FILE DATE AND TIME: 02/03/2005 09:26

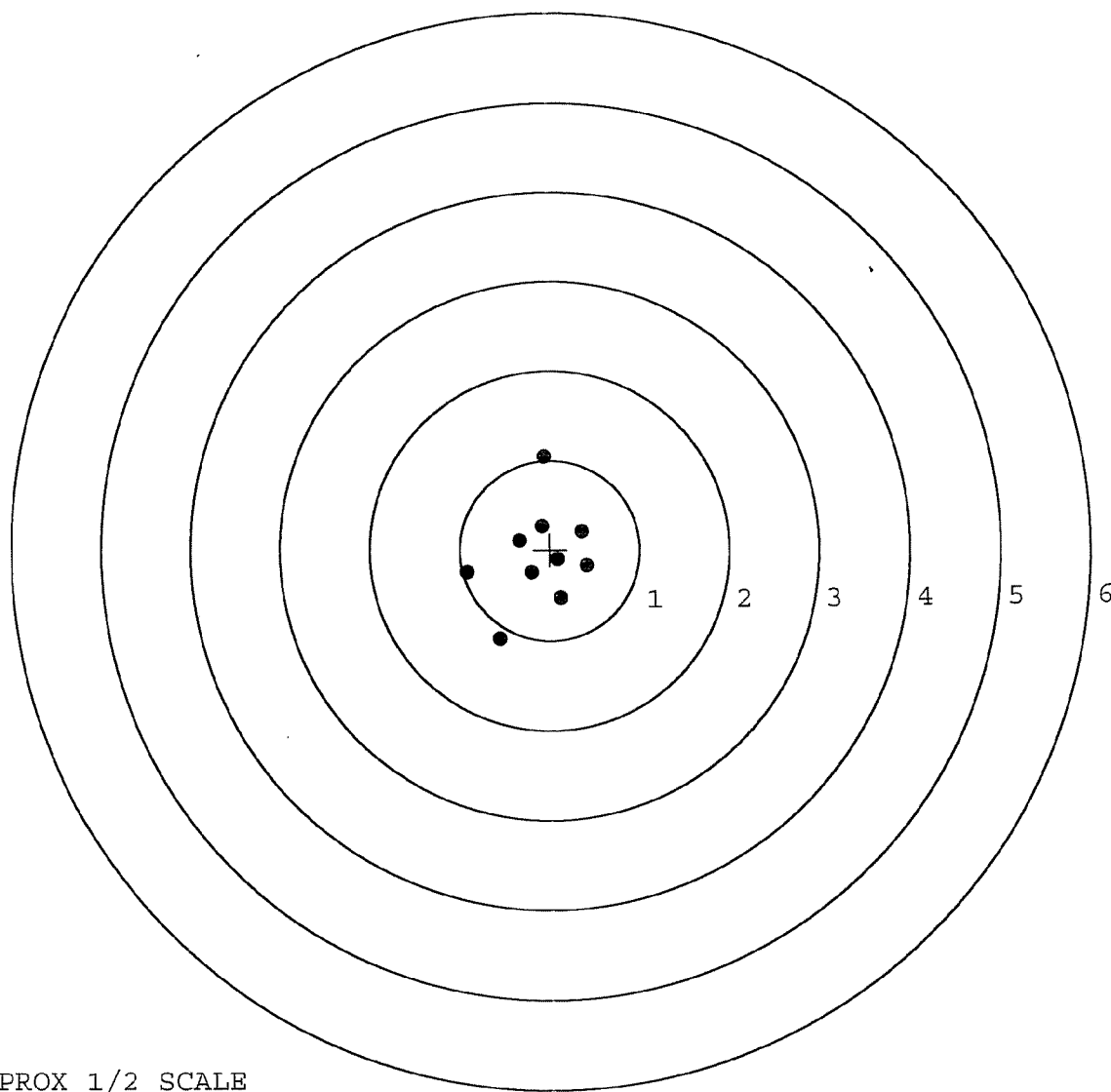
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.022
The Average Y Centroid of the Five Target Set:	0.088
The Average Point of Impact of the Five Target Set:	0.091
The Average Mean Radius of the Five Target Set:	0.619
The Distance from POA to Centroid Target #1:	0.143
The Distance from Centroid Target #2 to Centroid Target #1:	0.318
The Distance from Centroid Target #3 to Centroid Target #1:	0.243
The Distance from Centroid Target #4 to Centroid Target #1:	0.313
The Distance from Centroid Target #5 to Centroid Target #1:	0.266

SERIAL NUMBER: G6410504. __0
TARGET NUMBER: 1
FILE DATE: 02/03/2005
FILE TIME: 09:26

X CENTROID: -0.123
Y CENTROID: -0.071
POA TO CENTROID: 0.143
HORZ SPREAD: 1.333
VERT SPREAD: 2.027
GROUP SPREAD: 2.089
MIN RADIUS: 0.206
MAX RADIUS: 1.115
MEAN RADIUS: 0.561
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.925	-0.249
2:	-0.567	-0.985
3:	-0.063	1.042
4:	0.356	0.203
5:	-0.089	0.263
6:	-0.345	0.101
7:	-0.213	-0.257
8:	0.118	-0.537
9:	0.408	-0.183
10:	0.085	-0.109

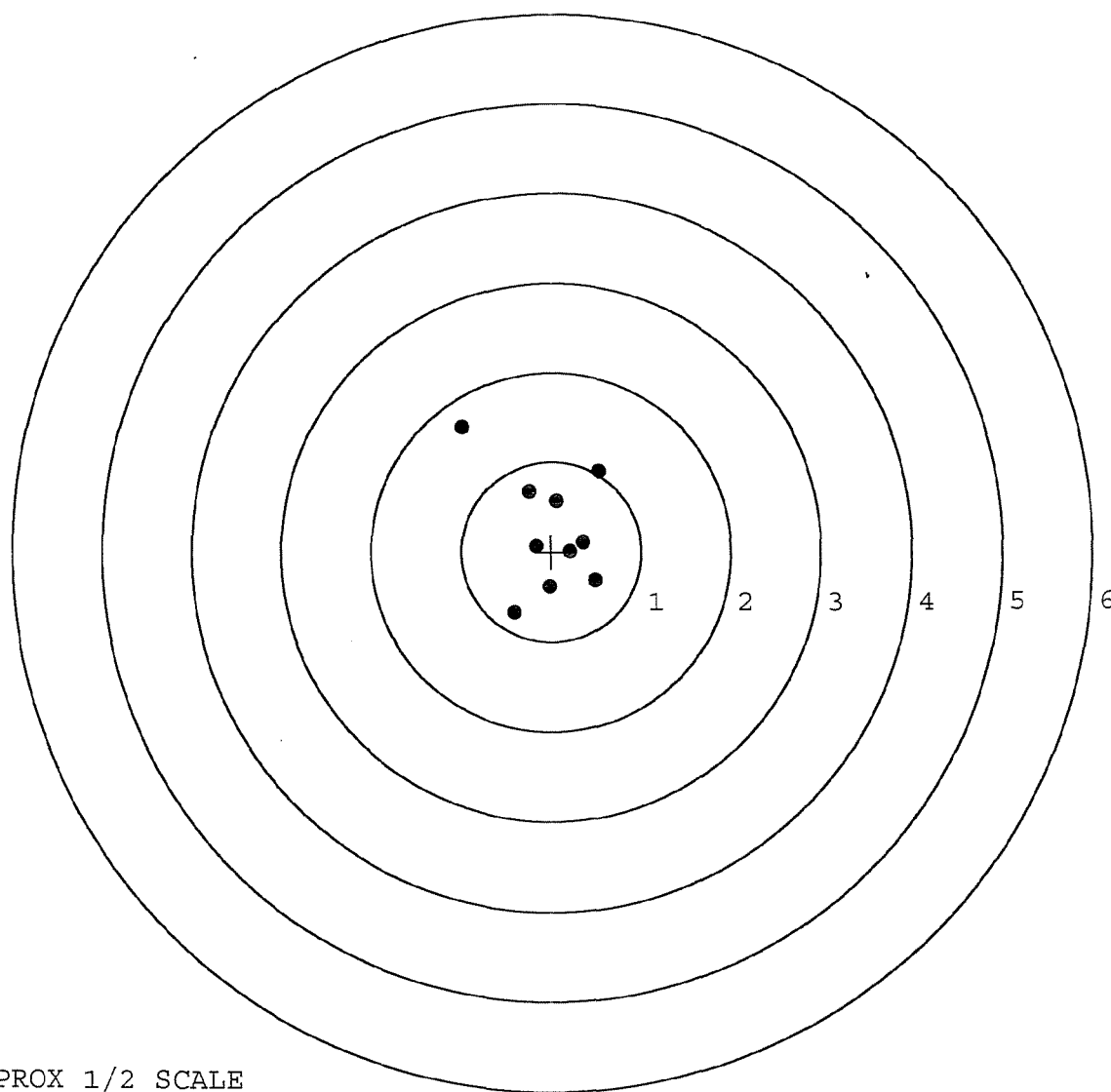


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410504. __0
TARGET NUMBER: 2
FILE DATE: 02/03/2005
FILE TIME: 09:26

POINT#	X	Y
1:	0.527	0.898
2:	0.055	0.565
3:	-0.251	0.668
4:	-0.995	1.381
5:	-0.414	-0.674
6:	0.491	-0.316
7:	0.358	0.106
8:	-0.169	0.064
9:	-0.026	-0.389
10:	0.209	-0.006

X CENTROID: -0.021
Y CENTROID: 0.230
POA TO CENTROID: 0.231
HORZ SPREAD: 1.522
VERT SPREAD: 2.055
GROUP SPREAD: 2.256
MIN RADIUS: 0.222
MAX RADIUS: 1.508
MEAN RADIUS: 0.651
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

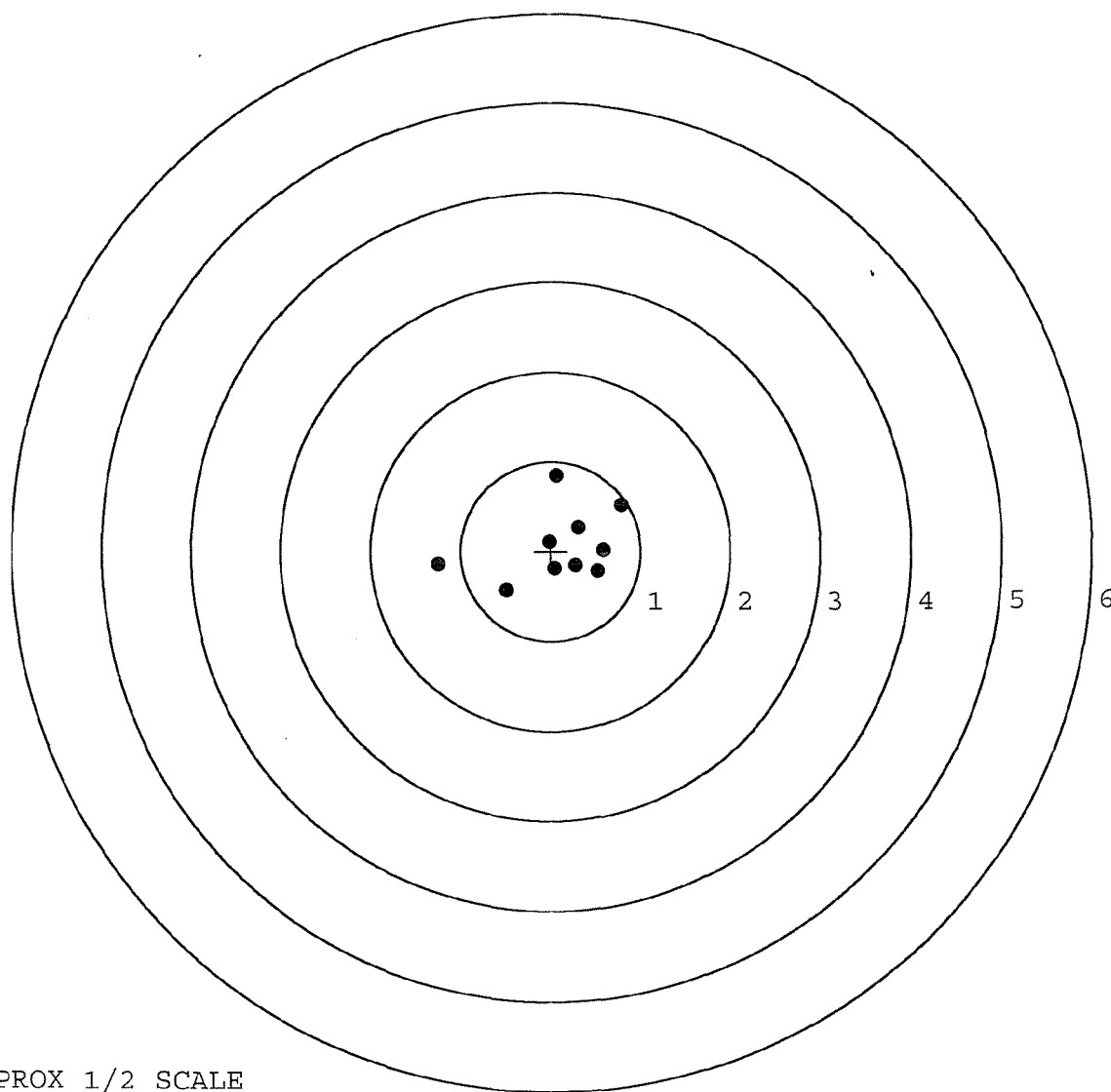


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410504. __0
TARGET NUMBER: 3
FILE DATE: 02/03/2005
FILE TIME: 09:26

X CENTROID: 0.083
Y CENTROID: 0.057
POA TO CENTROID: 0.101
HORZ SPREAD: 2.033
VERT SPREAD: 1.281
GROUP SPREAD: 2.141
MIN RADIUS: 0.109
MAX RADIUS: 1.346
MEAN RADIUS: 0.573
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.786	0.517
2:	0.062	0.845
3:	-0.496	-0.436
4:	-1.247	-0.153
5:	0.593	0.019
6:	0.526	-0.223
7:	0.303	0.262
8:	-0.017	0.100
9:	0.046	-0.198
10:	0.274	-0.163

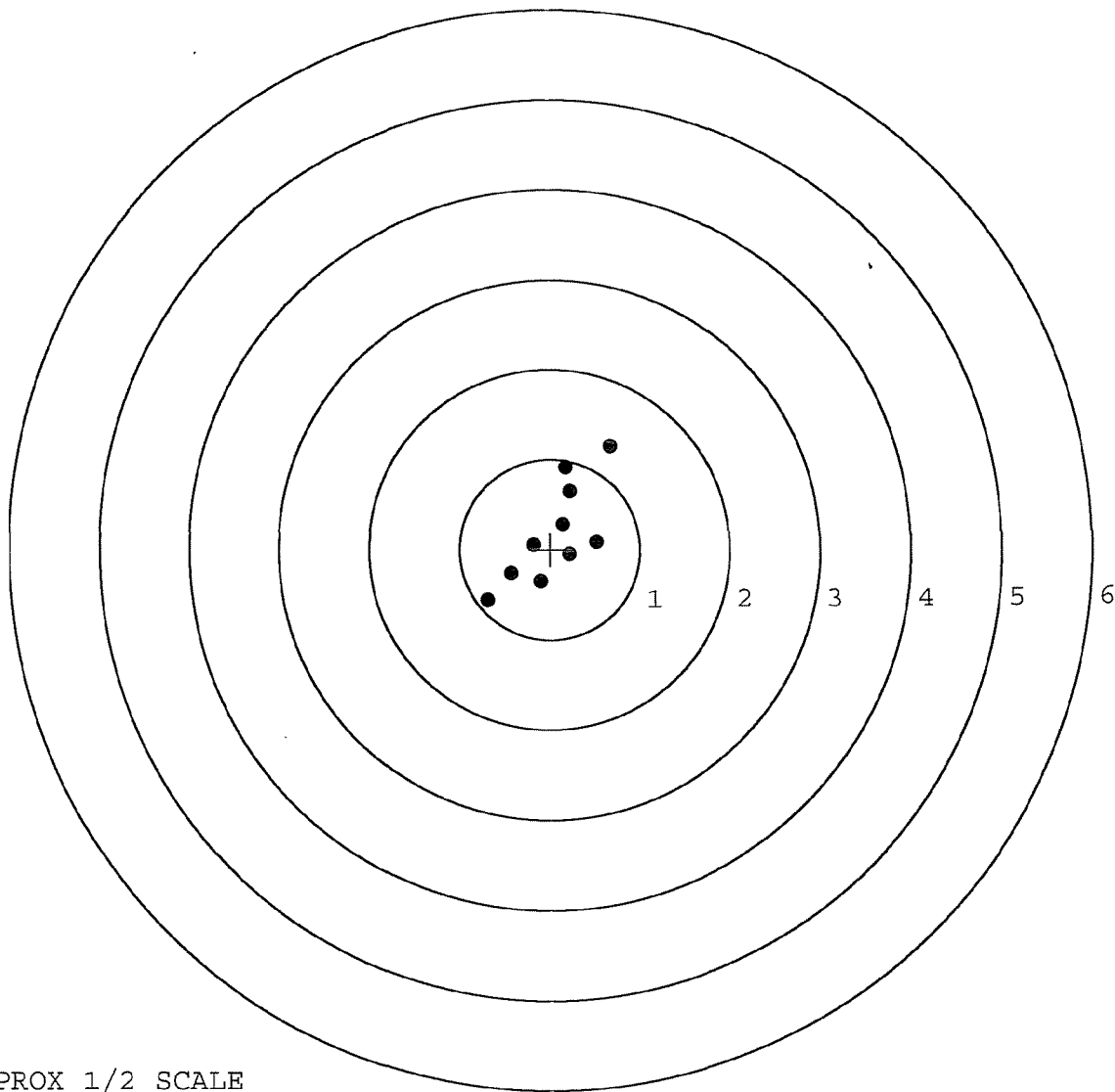


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410504. 0
TARGET NUMBER: 4
FILE DATE: 02/03/2005
FILE TIME: 09:26

X CENTROID: 0.055
Y CENTROID: 0.186
POA TO CENTROID: 0.194
HORZ SPREAD: 1.371
VERT SPREAD: 1.707
GROUP SPREAD: 2.189
MIN RADIUS: 0.132
MAX RADIUS: 1.142
MEAN RADIUS: 0.584
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.676	1.145
2:	0.178	0.908
3:	0.233	0.645
4:	-0.695	-0.562
5:	0.519	0.086
6:	0.152	0.275
7:	0.218	-0.057
8:	-0.186	0.052
9:	-0.110	-0.357
10:	-0.437	-0.272

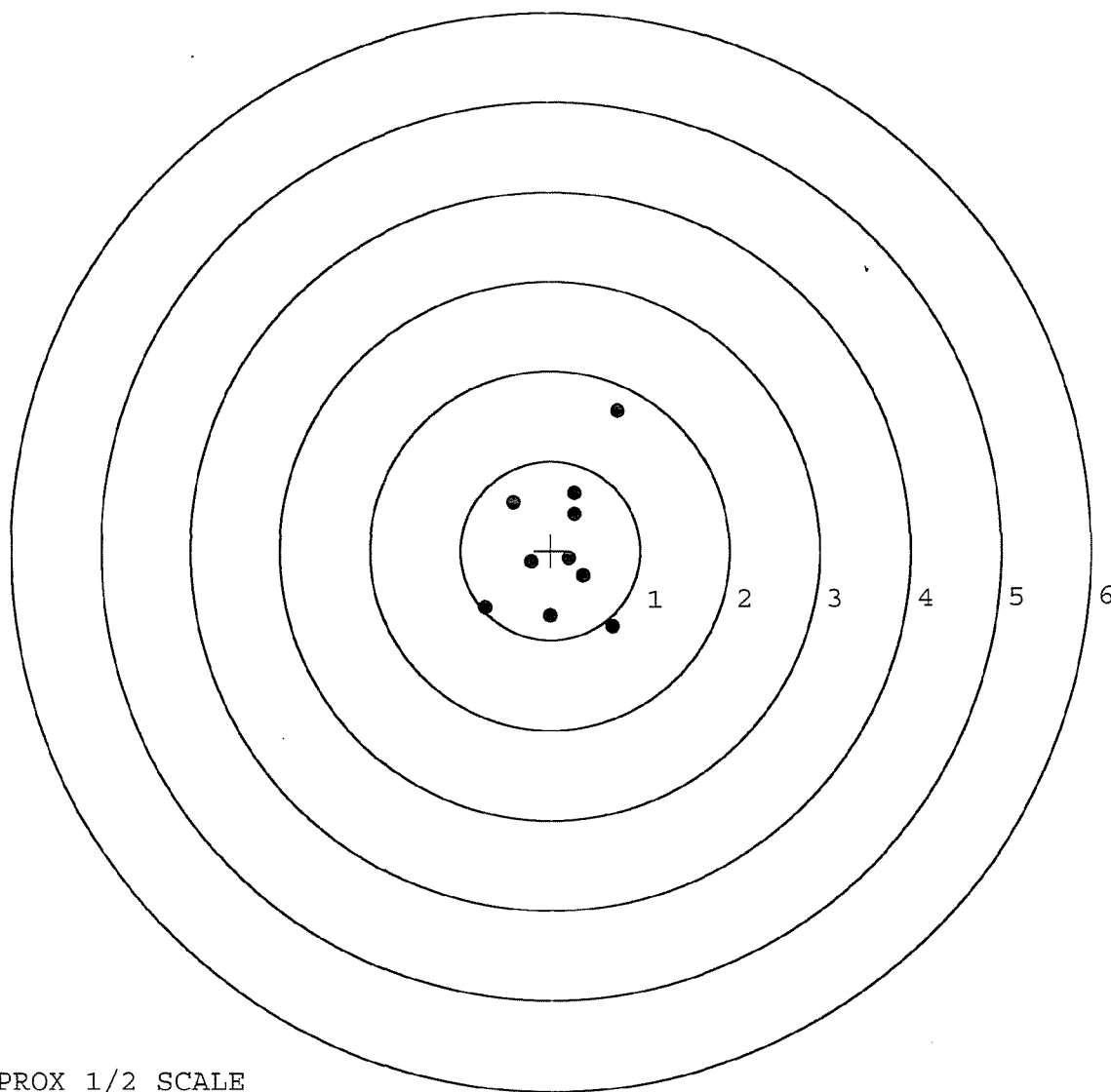


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410504.___0
TARGET NUMBER: 5
FILE DATE: 02/03/2005
FILE TIME: 09:26

X CENTROID: 0.119
Y CENTROID: 0.039
POA TO CENTROID: 0.125
HORZ SPREAD: 1.488
VERT SPREAD: 2.408
GROUP SPREAD: 2.651
MIN RADIUS: 0.155
MAX RADIUS: 1.641
MEAN RADIUS: 0.728
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.688	-0.857
2:	-0.012	-0.738
3:	-0.732	-0.643
4:	0.756	1.551
5:	0.274	0.644
6:	0.278	0.409
7:	-0.408	0.542
8:	-0.217	-0.132
9:	0.361	-0.293
10:	0.201	-0.092



TARGET APPROX 1/2 SCALE