

G 6410506

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



0 47700 25679 5

ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



0 47700 25679 5

SERIAL NO.

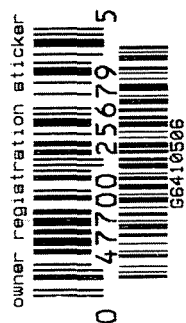
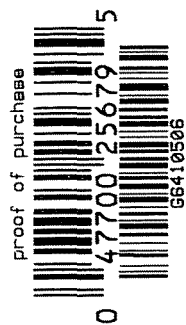


G6410506

**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

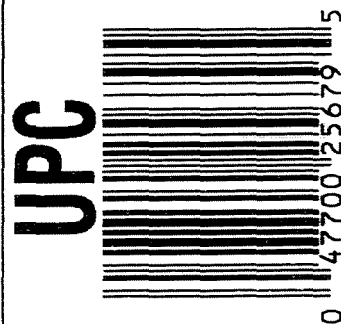


ORDER NO. 25679

BARREL LENGTH 24"

CAPACITY 6

G6410506



3/11/2005 9:25:01 AM

Crib

01

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

78ROT01

Goff Blast Barrel & Rec Assembly,



0003770797

0540

01PC001

Flat Black Powder Coat, Barrel and



0003770799

0560

89SWS1

Reassemble Action.



0003770800

0690

89SWS1

Pack Rifle & Stencil SWS Container



.OP0690

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66410506

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-24-05	RTL
600	PROOF		1-25-05	RT
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	1-25-05	RT
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	DRW
620	APPLY COATINGS (BARREL ACTION)		1/3/05	N/A
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		2-6-05	RT
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		2-6-05	LR
	C) INSPECT EJECTOR HOLE FOR CHAMFER		2-6-05	RT
	D) OIL FIRING PIN ASSEMBLY		2-6-05	RT
	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 16s</u> <u>6 16s</u> <u>6 16s</u>	2-16-05	Ac
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2 16s</u> <u>2 16s</u> <u>2 16s</u>	2-16-05	Ac
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	2-16-05	Ac
	J) ASSEMBLE STOCK		2-16-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		2-18-05	A
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-16-05	RL
	M) IRON SIGHT ALIGNMENT		2-16-05	RL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-16-05	RL
640	GALLERY TEST AND TARGET	PASS FAIL	2-17-05	Ac
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-17-05	TRW
655	FINAL INSPECTION A) HEADSPACE		2-16-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.19</u> <u>2.18</u> <u>2.09</u> <u>2.08</u> <u>2.11</u>	2-18-05	TRW
	C) FUNCTION		2-16-05	Ac
660	PACK		3/19/05	RTA

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)

DATE 2-2-05
 TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.12	2.47		2.23	
PULL #2	2.11	2.45		2.22	
PULL #3	2.37	2.31		2.23	
PULL #4	2.73	2.45		2.25	
PULL #5	2.79	2.47		2.23	
TOTAL	12.12	12.15		11.16	
AVERAGE	2.42	2.43		2.23	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.02	3.02		
PULL #2	3.35	3.14		
PULL #3	3.30	3.12		
PULL #4	3.29	3.00		
PULL #5	3.37	3.17		
TOTAL	16.33	15.45		
AVERAGE	3.26	3.09		

	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	4.32	4.32		4.37
PULL #2	4.35	4.31		4.33
PULL #3	4.27	3.90		4.38
PULL #4	4.32	4.27		4.42
PULL #5	3.89	4.18		4.27
TOTAL	21.15	20.98		21.77
AVERAGE	4.23	4.19		4.35

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410506.___0
FILE DATE AND TIME: 02/07/2005 07:49

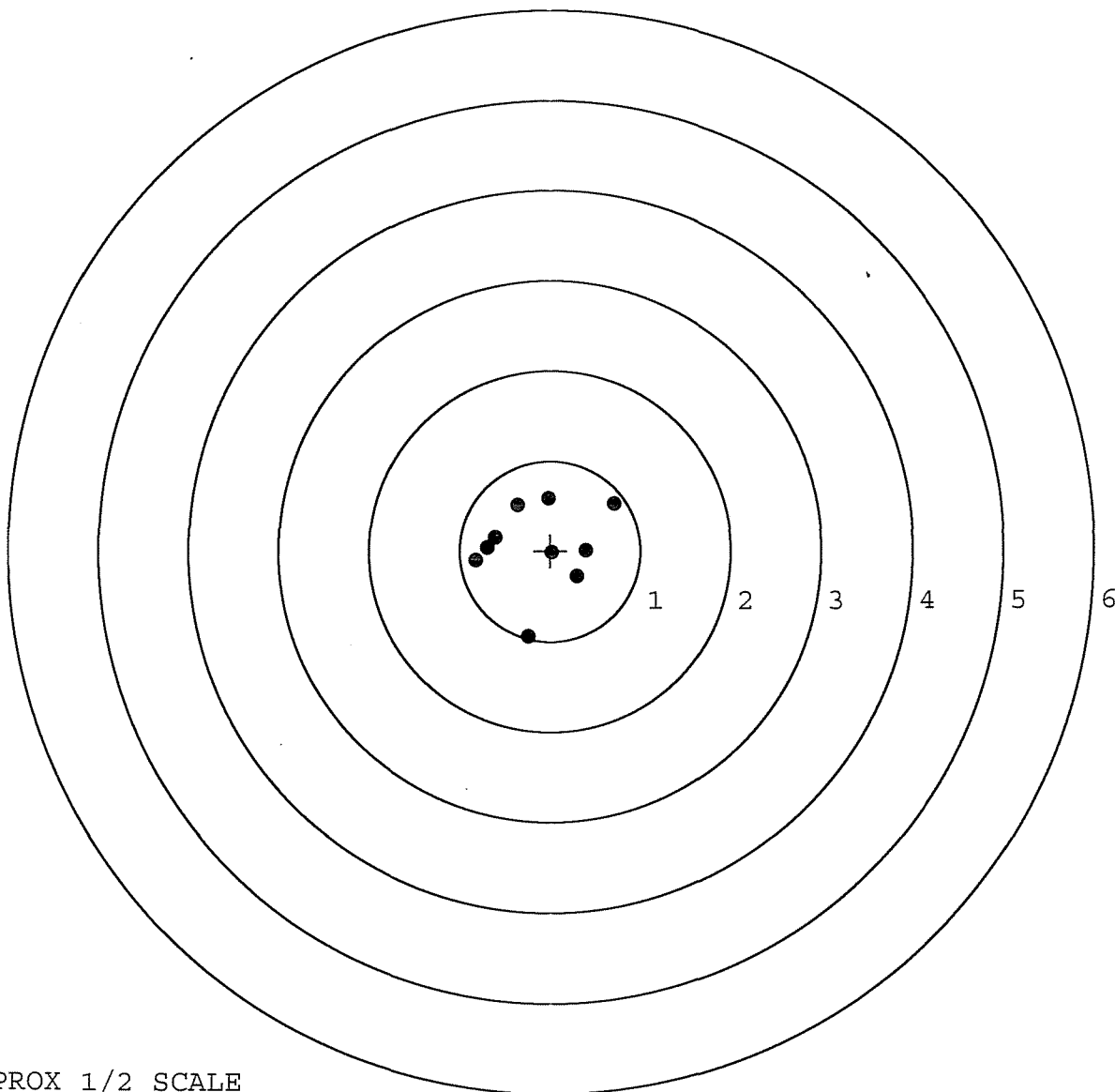
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.094
The Average Y Centroid of the Five Target Set:	-0.074
The Average Point of Impact of the Five Target Set:	0.120
The Average Mean Radius of the Five Target Set:	0.717
The Distance from POA to Centroid Target #1:	0.143
The Distance from Centroid Target #2 to Centroid Target #1:	0.058
The Distance from Centroid Target #3 to Centroid Target #1:	0.324
The Distance from Centroid Target #4 to Centroid Target #1:	0.058
The Distance from Centroid Target #5 to Centroid Target #1:	0.195

SERIAL NUMBER: G6410506. 0
TARGET NUMBER: 1
FILE DATE: 02/07/2005
FILE TIME: 07:49

X CENTROID: -0.137
Y CENTROID: 0.042
POA TO CENTROID: 0.143
HORZ SPREAD: 1.528
VERT SPREAD: 1.534
GROUP SPREAD: 1.753
MIN RADIUS: 0.167
MAX RADIUS: 1.000
MEAN RADIUS: 0.604
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.248	-0.952
2:	0.296	-0.289
3:	0.399	-0.002
4:	0.017	-0.023
5:	0.703	0.521
6:	-0.031	0.582
7:	-0.369	0.509
8:	-0.613	0.148
9:	-0.825	-0.108
10:	-0.697	0.034

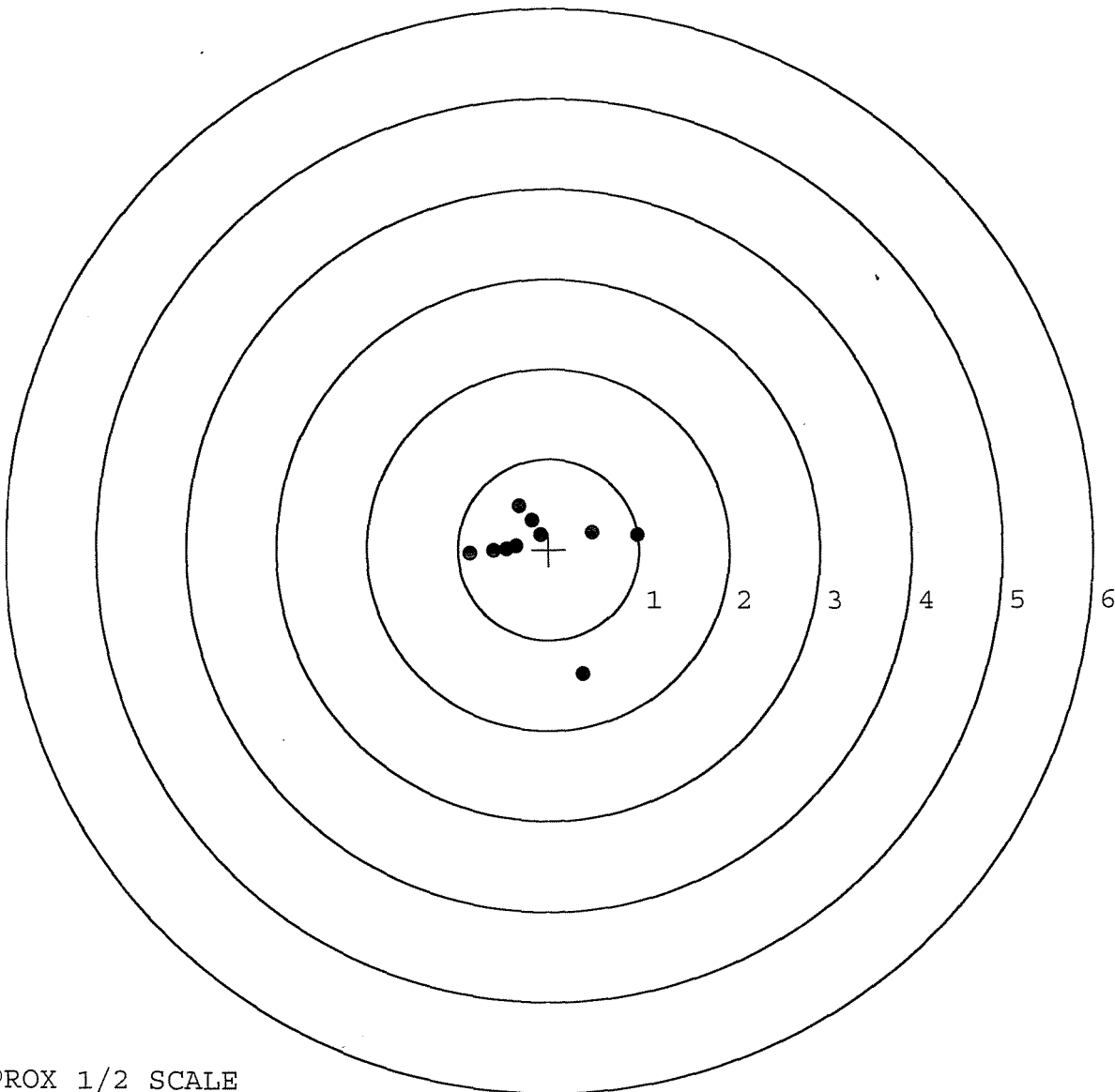


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410506. __0
TARGET NUMBER: 2
FILE DATE: 02/07/2005
FILE TIME: 07:49

X CENTROID: -0.107
Y CENTROID: -0.008
POA TO CENTROID: 0.107
HORZ SPREAD: 1.850
VERT SPREAD: 1.862
GROUP SPREAD: 1.992
MIN RADIUS: 0.174
MAX RADIUS: 1.452
MEAN RADIUS: 0.612
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.381	-1.376
2:	0.983	0.166
3:	0.484	0.189
4:	-0.867	-0.049
5:	-0.612	-0.017
6:	-0.468	-0.003
7:	-0.363	0.034
8:	-0.088	0.165
9:	-0.192	0.325
10:	-0.328	0.486

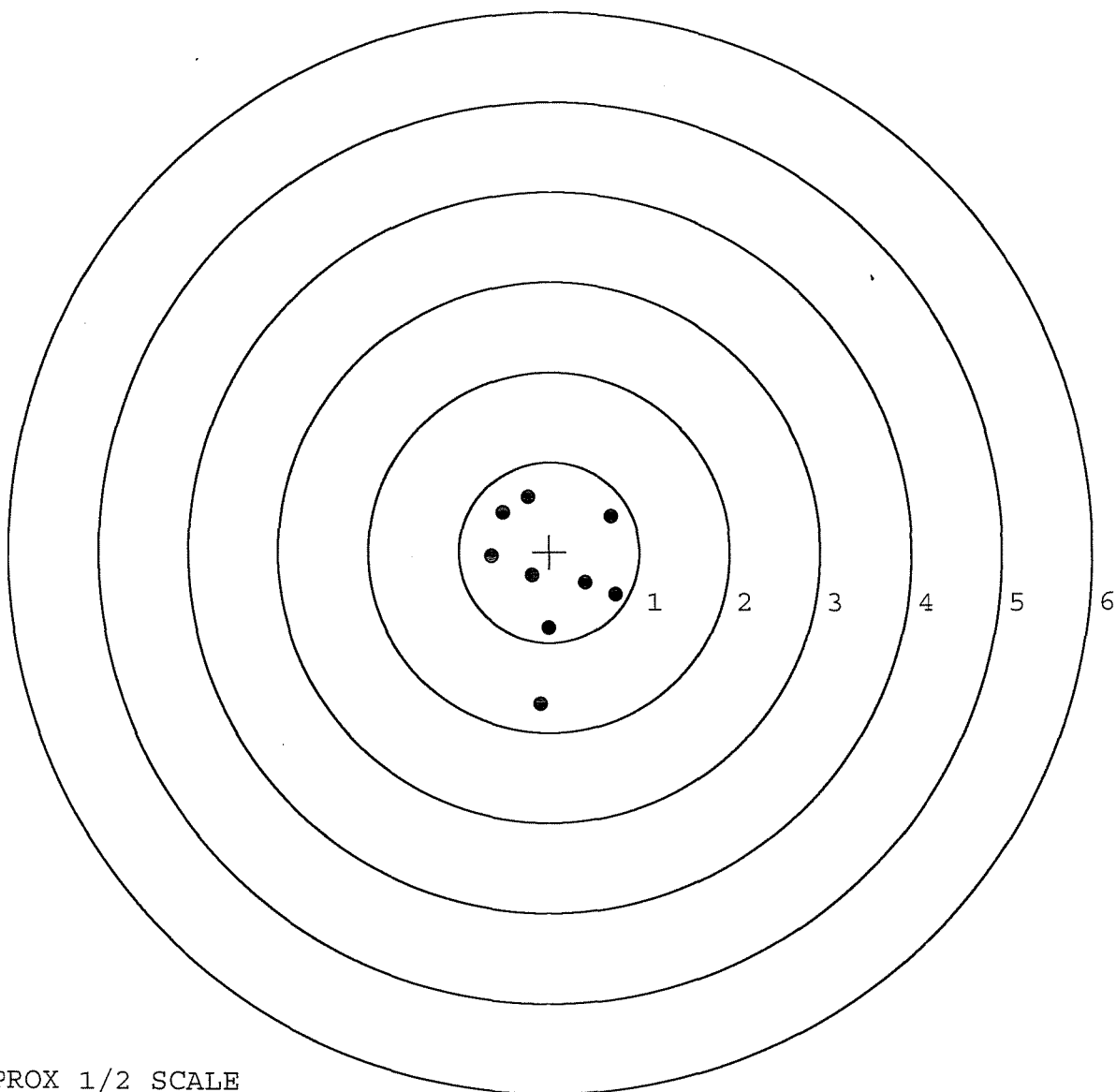


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410506. 0
TARGET NUMBER: 3
FILE DATE: 02/07/2005
FILE TIME: 07:49

X CENTROID: 0.009
Y CENTROID: -0.247
POA TO CENTROID: 0.248
HORZ SPREAD: 1.374
VERT SPREAD: 2.302
GROUP SPREAD: 2.306
MIN RADIUS: 0.203
MAX RADIUS: 1.449
MEAN RADIUS: 0.752
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	-0.100	-1.692
2:	-0.018	-0.842
3:	0.728	-0.472
4:	0.399	-0.341
5:	-0.194	-0.264
6:	-0.646	-0.057
7:	0.677	0.394
8:	-0.243	0.610
9:	-0.524	0.437

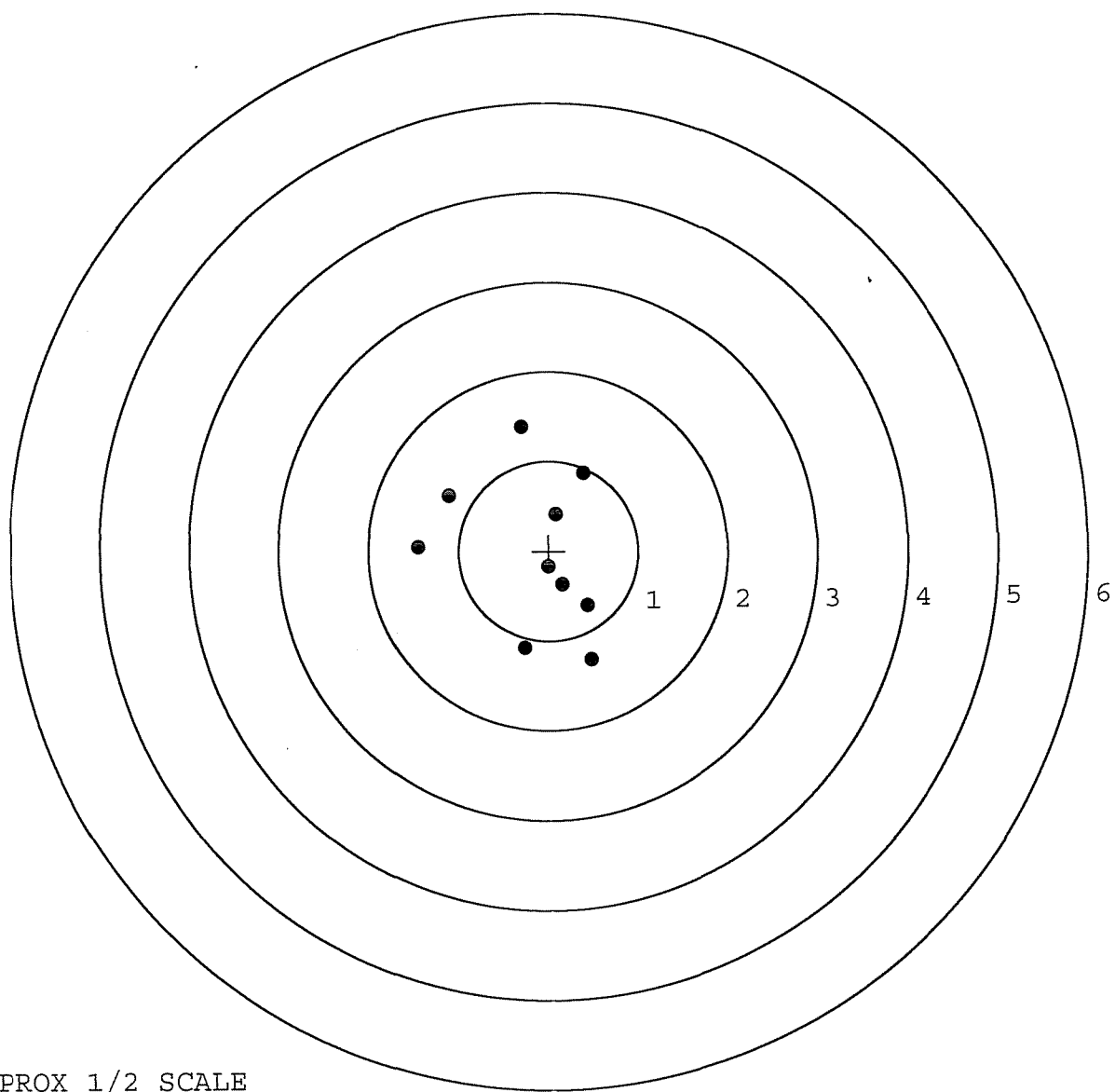


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410506. 0
TARGET NUMBER: 4
FILE DATE: 02/07/2005
FILE TIME: 07:49

X CENTROID: -0.158
Y CENTROID: -0.012
POA TO CENTROID: 0.158
HORZ SPREAD: 1.917
VERT SPREAD: 2.603
GROUP SPREAD: 2.710
MIN RADIUS: 0.222
MAX RADIUS: 1.402
MEAN RADIUS: 0.934
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.467	-1.219
2:	-0.275	-1.086
3:	0.433	-0.609
4:	-0.008	-0.176
5:	0.092	0.411
6:	0.396	0.866
7:	-0.287	1.384
8:	-1.099	0.621
9:	-1.450	0.058
10:	0.151	-0.374

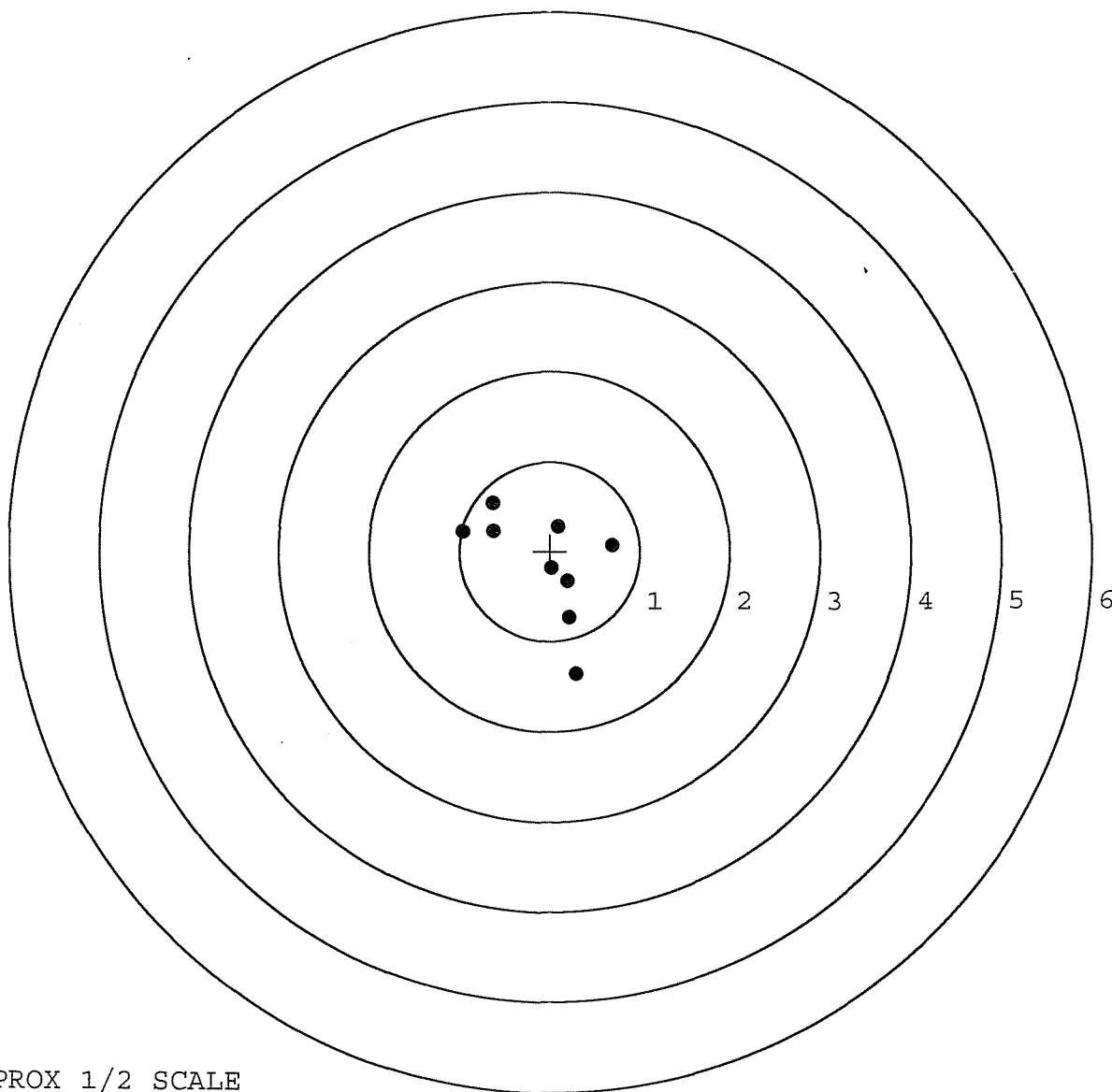


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410506. __0
TARGET NUMBER: 5
FILE DATE: 02/07/2005
FILE TIME: 07:49

X CENTROID: -0.079
Y CENTROID: -0.144
POA TO CENTROID: 0.164
HORZ SPREAD: 1.653
VERT SPREAD: 1.913
GROUP SPREAD: 2.125
MIN RADIUS: 0.110
MAX RADIUS: 1.281
MEAN RADIUS: 0.684
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.294	-1.370
2:	0.693	0.072
3:	0.092	0.275
4:	-0.632	0.543
5:	-0.960	0.226
6:	-0.631	0.228
7:	0.020	-0.191
8:	0.195	-0.337
9:	0.218	-0.743



TARGET APPROX 1/2 SCALE