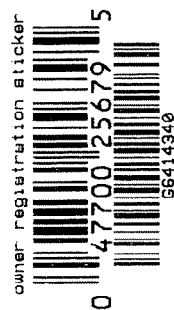
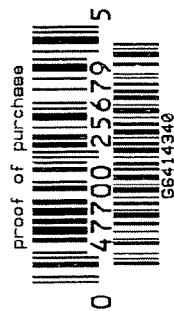


G-641 4340

**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**

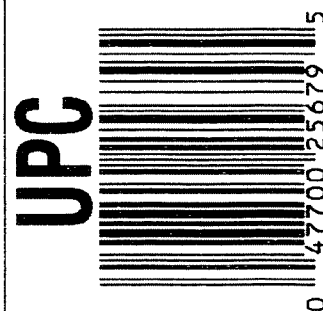


ORDER NO. **25679**

BARREL LENGTH **24"**

CAPACITY **6**

**G6414340**



**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.



66414340

3/11/2005 9:25:01 AM

Copy

LL

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 # G6414340

| OP #      | OPERATION NAME                                                 | READINGS            | DATE     | INITIAL |
|-----------|----------------------------------------------------------------|---------------------|----------|---------|
| 575 & 580 | ASSEMBLE ACTION AND STOCK                                      |                     | 10-19-04 | RTL     |
| 600       | PROOF                                                          |                     | 10-20-04 | AC      |
| 607       | CHECK HEADSPACE                                                |                     | 10-20-04 | AK      |
| 610       | DIS-ASSEMBLE GUN                                               |                     |          |         |
| 612       | MAGNAFLUX BBL ACTION<br>MAGNAFLUX BOLT                         |                     |          |         |
| 615       | ROLLMARK CALIBER                                               |                     | 10/27/04 | AB      |
| 617       | DRILL AND TAP<br>SIGHT HOLES                                   |                     | 10-22-04 | TRW     |
| 620       | APPLY COATINGS<br>(BARREL ACTION)                              |                     | 10/30    | HP      |
|           | (BOLT)                                                         |                     |          |         |
| 625       | FINAL ASSEMBLY                                                 |                     |          |         |
|           | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                     | 11-8-04  | RTL     |
|           | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                     | 11-8-04  | RTL     |
|           | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                     | 11-8-04  | RTL     |
|           | D) OIL FIRING PIN ASSEMBLY                                     |                     | 11-8-04  | RTL     |
|           | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE         | 2.50 LBS +/- .5 LBS |          |         |

| OP #  | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|-------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 625   | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>7 lbs</u> <u>7 lbs</u> <u>7 lbs</u>                      | 2-16-05 | AC      |
| CONT. |                                                                          |                                                             |         |         |
|       | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>                      | 2-16-05 | AC      |
|       | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|       | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.023</u> <u>.023</u> <u>.023</u>                         | 2-16-05 | AC      |
|       | J) ASSEMBLE STOCK                                                        |                                                             | 11-8-04 | RTL     |
|       | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 2-18-05 | A       |
|       | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 |                                                             | 2-7-05  | RTL     |
|       | M) IRON SIGHT<br>ALIGNMENT                                               |                                                             | 2-7-05  | RTL     |
|       | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                             | 2-7-05  | RTL     |
| 640   | GALLERY TEST AND<br>TARGET                                               | <u>PASS</u> FAIL                                            | 2-15-04 | TRLW    |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 645   | INSPECT FOR LIVE AMMO                                                    |                                                             | 2-15-04 | TRLW    |
| 655   | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 2-16-05 | AC      |
|       | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.94</u> <u>2.90</u> <u>2.86</u> <u>2.88</u> <u>2.82</u> | 2-18-05 | TRLW    |
|       | 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 6-17-04

TESTER TRW

|         | 2.50 LBS<br>INITIAL | 2.50 LBS AFTER<br>50 CYCLES | FINAL TEST & TO RESET<br>2.50 LBS |       | COMMENTS |
|---------|---------------------|-----------------------------|-----------------------------------|-------|----------|
| PULL #1 | 2.56                | 2.74                        |                                   | 2.80  |          |
| PULL #2 | 2.44                | 2.67                        |                                   | 2.82  |          |
| PULL #3 | 2.56                | 2.65                        |                                   | 2.82  |          |
| PULL #4 | 2.59                | 2.72                        |                                   | 2.83  |          |
| PULL #5 | 2.61                | 2.73                        |                                   | 2.79  |          |
| TOTAL   | 12.76               | 13.51                       |                                   | 14.06 |          |
| AVERAGE | 2.55                | 2.70                        |                                   | 2.81  |          |

|         | 3.00 LBS<br>INITIAL | 3.00 LBS AFTER<br>20 CYCLES |  | COMMENTS |
|---------|---------------------|-----------------------------|--|----------|
| PULL #1 | 3.34                | 3.16                        |  |          |
| PULL #2 | 3.13                | 3.05                        |  |          |
| PULL #3 | 3.14                | 3.06                        |  |          |
| PULL #4 | 3.15                | 2.96                        |  |          |
| PULL #5 | 3.11                | 3.03                        |  |          |
| TOTAL   | 15.87               | 15.26                       |  |          |
| AVERAGE | 3.17                | 3.05                        |  |          |

|         | 4.00 LBS<br>INITIAL | 4.00 LBS AFTER<br>20 CYCLES | MAX SETTING GREATER<br>THAN 4 LBS | RESET TO 4 LBS FOR<br>TARGET & ACCURACY |
|---------|---------------------|-----------------------------|-----------------------------------|-----------------------------------------|
| PULL #1 | 4.15                | 4.10                        |                                   | 4.20                                    |
| PULL #2 | 4.25                | 4.08                        |                                   | 4.18                                    |
| PULL #3 | 4.32                | 4.14                        |                                   | 3.91                                    |
| PULL #4 | 4.10                | 4.19                        |                                   | 4.04                                    |
| PULL #5 | 4.12                | 4.22                        |                                   | 4.17                                    |
| TOTAL   | 20.94               | 20.73                       |                                   | 20.50                                   |
| AVERAGE | 4.18                | 4.14                        |                                   | 4.10                                    |

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414340.\_\_0  
FILE DATE AND TIME: 12/15/2004 08:03

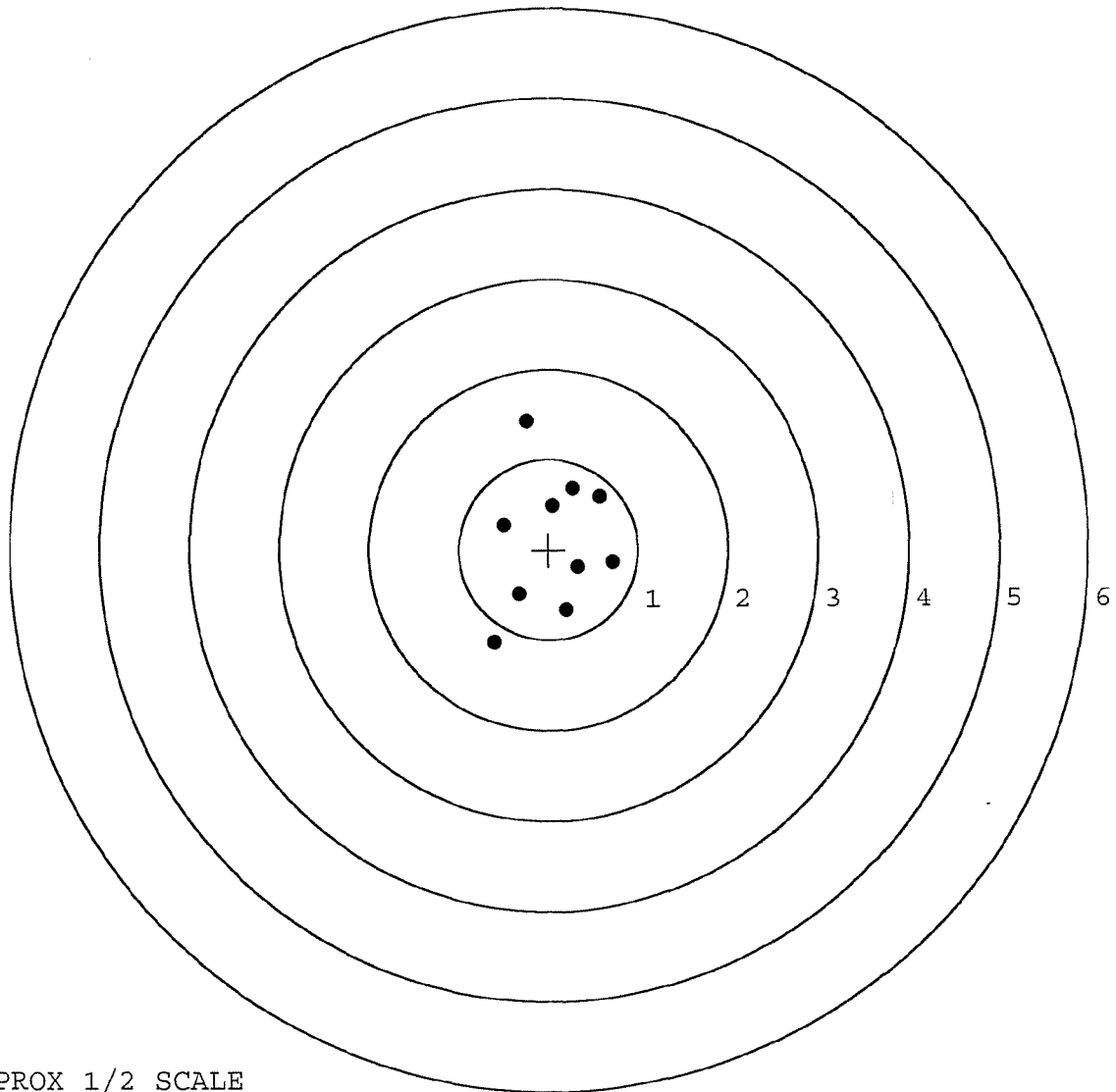
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | -0.006 |
| The Average Y Centroid of the Five Target Set:              | -0.084 |
| The Average Point of Impact of the Five Target Set:         | 0.084  |
| The Average Mean Radius of the Five Target Set:             | 0.660  |
| The Distance from POA to Centroid Target #1:                | 0.103  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.230  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.337  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.210  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.230  |

SERIAL NUMBER: G6414340. \_\_0  
TARGET NUMBER: 1  
FILE DATE: 12/15/2004  
FILE TIME: 08:03

X CENTROID: 0.042  
Y CENTROID: 0.094  
POA TO CENTROID: 0.103  
HORZ SPREAD: 1.334  
VERT SPREAD: 2.458  
GROUP SPREAD: 2.485  
MIN RADIUS: 0.394  
MAX RADIUS: 1.364  
MEAN RADIUS: 0.759  
# IN 1 IN DIAMETER: 2  
# IN 2 IN DIAMETER: 8  
# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.716  | -0.140 |
| 2:     | 0.333  | -0.187 |
| 3:     | 0.194  | -0.668 |
| 4:     | -0.336 | -0.495 |
| 5:     | -0.618 | -1.032 |
| 6:     | 0.572  | 0.588  |
| 7:     | 0.273  | 0.682  |
| 8:     | 0.046  | 0.488  |
| 9:     | -0.508 | 0.275  |
| 10:    | -0.252 | 1.426  |

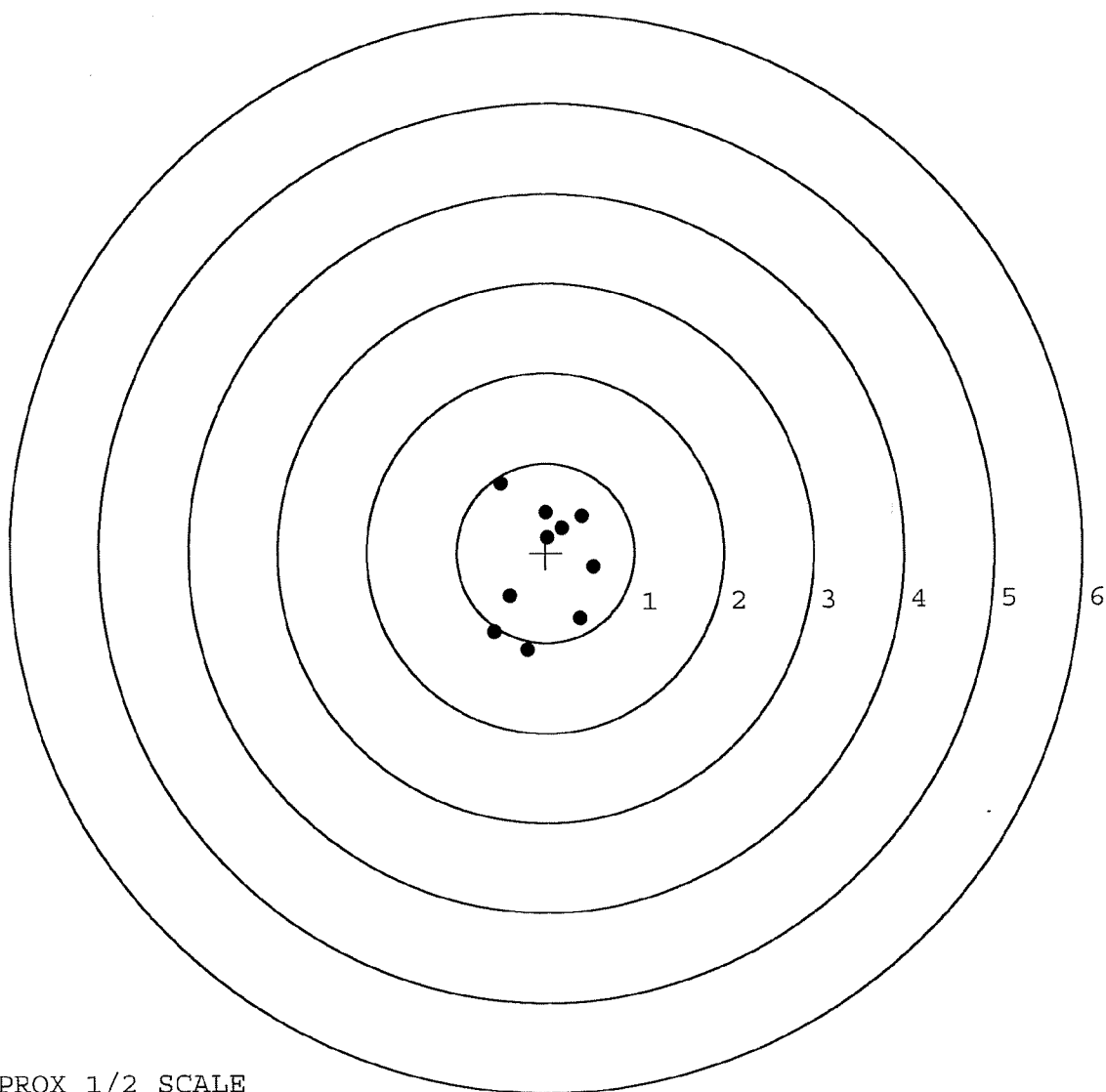


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414340. \_\_0  
TARGET NUMBER: 2  
FILE DATE: 12/15/2004  
FILE TIME: 08:03

X CENTROID: -0.020  
Y CENTROID: -0.127  
POA TO CENTROID: 0.129  
HORZ SPREAD: 1.127  
VERT SPREAD: 1.860  
GROUP SPREAD: 1.882  
MIN RADIUS: 0.297  
MAX RADIUS: 1.025  
MEAN RADIUS: 0.679  
# IN 1 IN DIAMETER: 2  
# IN 2 IN DIAMETER: 9  
# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.386  | -0.737 |
| 2:     | 0.536  | -0.162 |
| 3:     | -0.219 | -1.085 |
| 4:     | -0.591 | -0.884 |
| 5:     | -0.412 | -0.486 |
| 6:     | -0.506 | 0.775  |
| 7:     | 0.407  | 0.412  |
| 8:     | 0.185  | 0.277  |
| 9:     | 0.015  | 0.168  |
| 10:    | 0.003  | 0.448  |

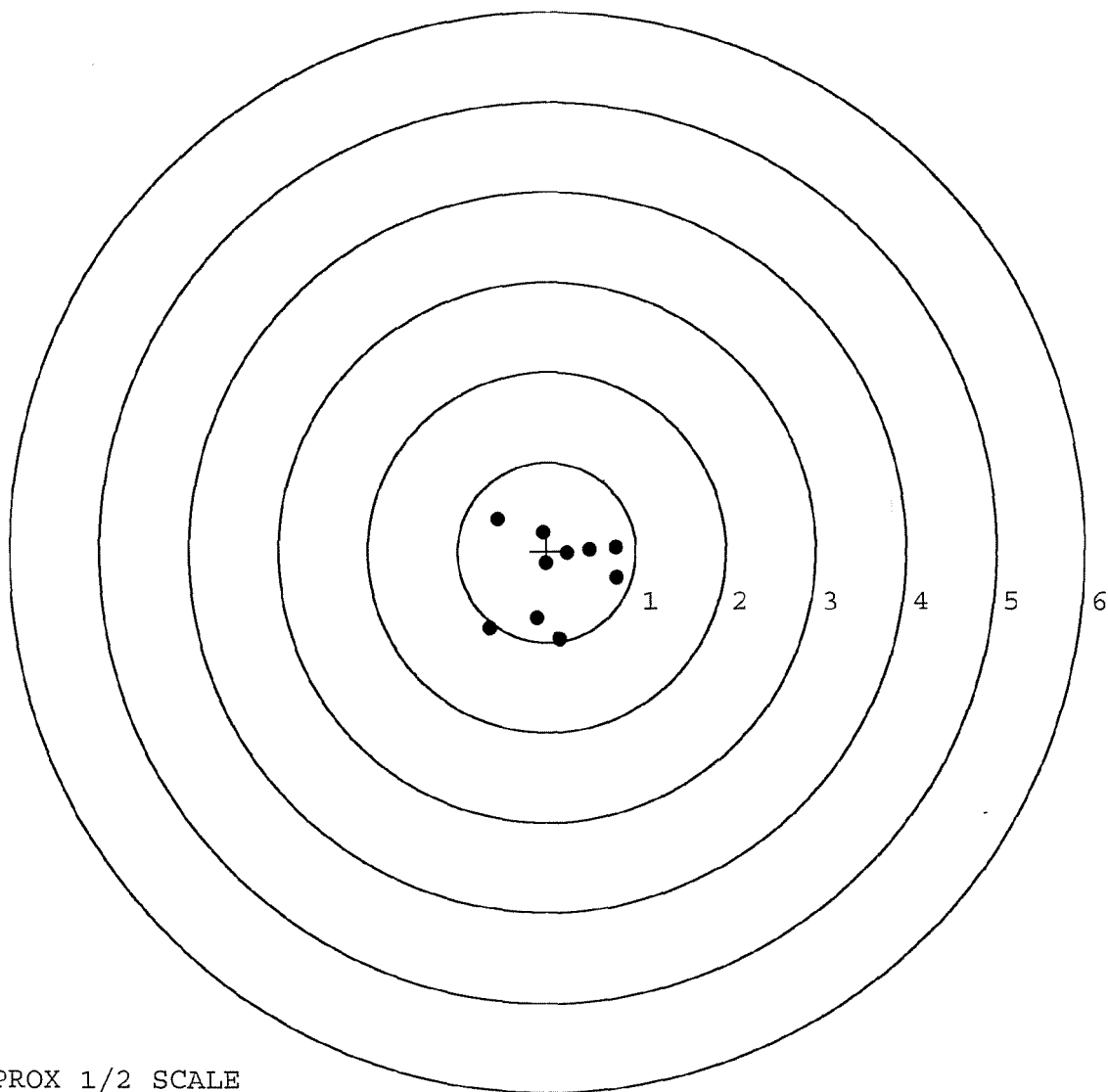


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414340. 0  
TARGET NUMBER: 3  
FILE DATE: 12/15/2004  
FILE TIME: 08:03

X CENTROID: 0.105  
Y CENTROID: -0.238  
POA TO CENTROID: 0.260  
HORZ SPREAD: 1.424  
VERT SPREAD: 1.322  
GROUP SPREAD: 1.686  
MIN RADIUS: 0.157  
MAX RADIUS: 0.969  
MEAN RADIUS: 0.589  
# IN 1 IN DIAMETER: 4  
# IN 2 IN DIAMETER: 10  
# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.145  | -0.968 |
| 2:     | -0.113 | -0.745 |
| 3:     | -0.641 | -0.856 |
| 4:     | 0.783  | -0.287 |
| 5:     | -0.559 | 0.354  |
| 6:     | 0.780  | 0.051  |
| 7:     | 0.485  | 0.024  |
| 8:     | 0.229  | -0.023 |
| 9:     | -0.015 | -0.137 |
| 10:    | -0.045 | 0.211  |

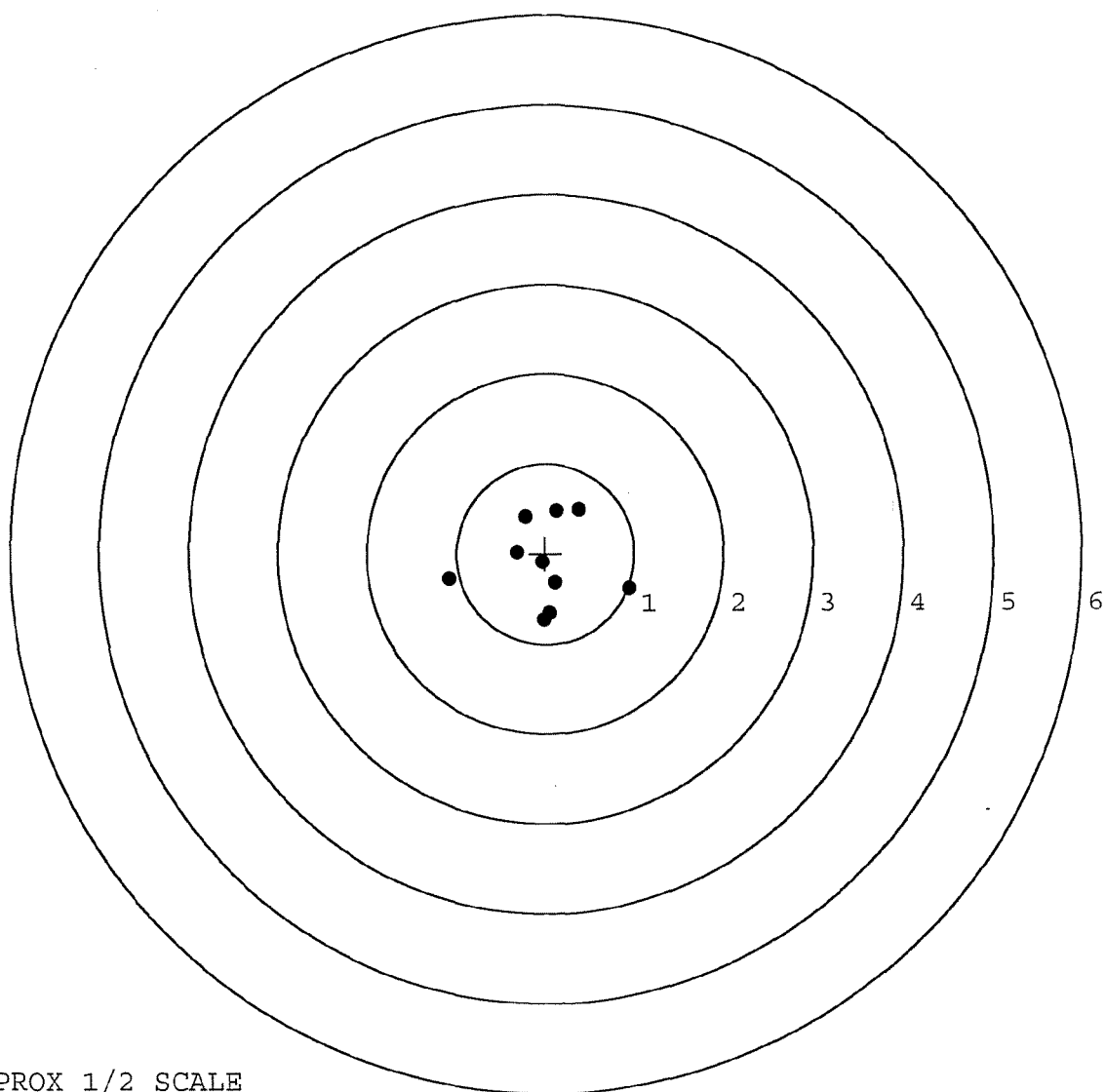


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414340. 0  
TARGET NUMBER: 4  
FILE DATE: 12/15/2004  
FILE TIME: 08:03

X CENTROID: -0.010  
Y CENTROID: -0.110  
POA TO CENTROID: 0.110  
HORZ SPREAD: 2.031  
VERT SPREAD: 1.236  
GROUP SPREAD: 2.034  
MIN RADIUS: 0.028  
MAX RADIUS: 1.090  
MEAN RADIUS: 0.577  
# IN 1 IN DIAMETER: 3  
# IN 2 IN DIAMETER: 9  
# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.945  | -0.391 |
| 2:     | 0.044  | -0.665 |
| 3:     | -1.086 | -0.283 |
| 4:     | 0.376  | 0.499  |
| 5:     | 0.125  | 0.478  |
| 6:     | -0.232 | 0.407  |
| 7:     | -0.322 | 0.015  |
| 8:     | -0.035 | -0.098 |
| 9:     | 0.112  | -0.323 |
| 10:    | -0.024 | -0.737 |



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414340. 0

TARGET NUMBER: 5

FILE DATE: 12/15/2004

FILE TIME: 08:03

| POINT# | X | Y |
|--------|---|---|
|--------|---|---|

|    |       |        |
|----|-------|--------|
| 1: | 1.107 | -0.814 |
|----|-------|--------|

|    |       |        |
|----|-------|--------|
| 2: | 0.267 | -0.448 |
|----|-------|--------|

|    |       |       |
|----|-------|-------|
| 3: | 0.467 | 0.129 |
|----|-------|-------|

|    |       |       |
|----|-------|-------|
| 4: | 0.169 | 0.224 |
|----|-------|-------|

|    |        |        |
|----|--------|--------|
| 5: | -0.197 | -0.066 |
|----|--------|--------|

|    |        |        |
|----|--------|--------|
| 6: | -0.312 | -0.686 |
|----|--------|--------|

|    |        |        |
|----|--------|--------|
| 7: | -0.540 | -0.184 |
|----|--------|--------|

|    |        |       |
|----|--------|-------|
| 8: | -0.571 | 0.888 |
|----|--------|-------|

|    |        |       |
|----|--------|-------|
| 9: | -1.010 | 0.410 |
|----|--------|-------|

|     |        |       |
|-----|--------|-------|
| 10: | -0.838 | 0.159 |
|-----|--------|-------|

X CENTROID: -0.146

Y CENTROID: -0.039

POA TO CENTROID: 0.151

HORZ SPREAD: 2.117

VERT SPREAD: 1.702

GROUP SPREAD: 2.445

MIN RADIUS: 0.058

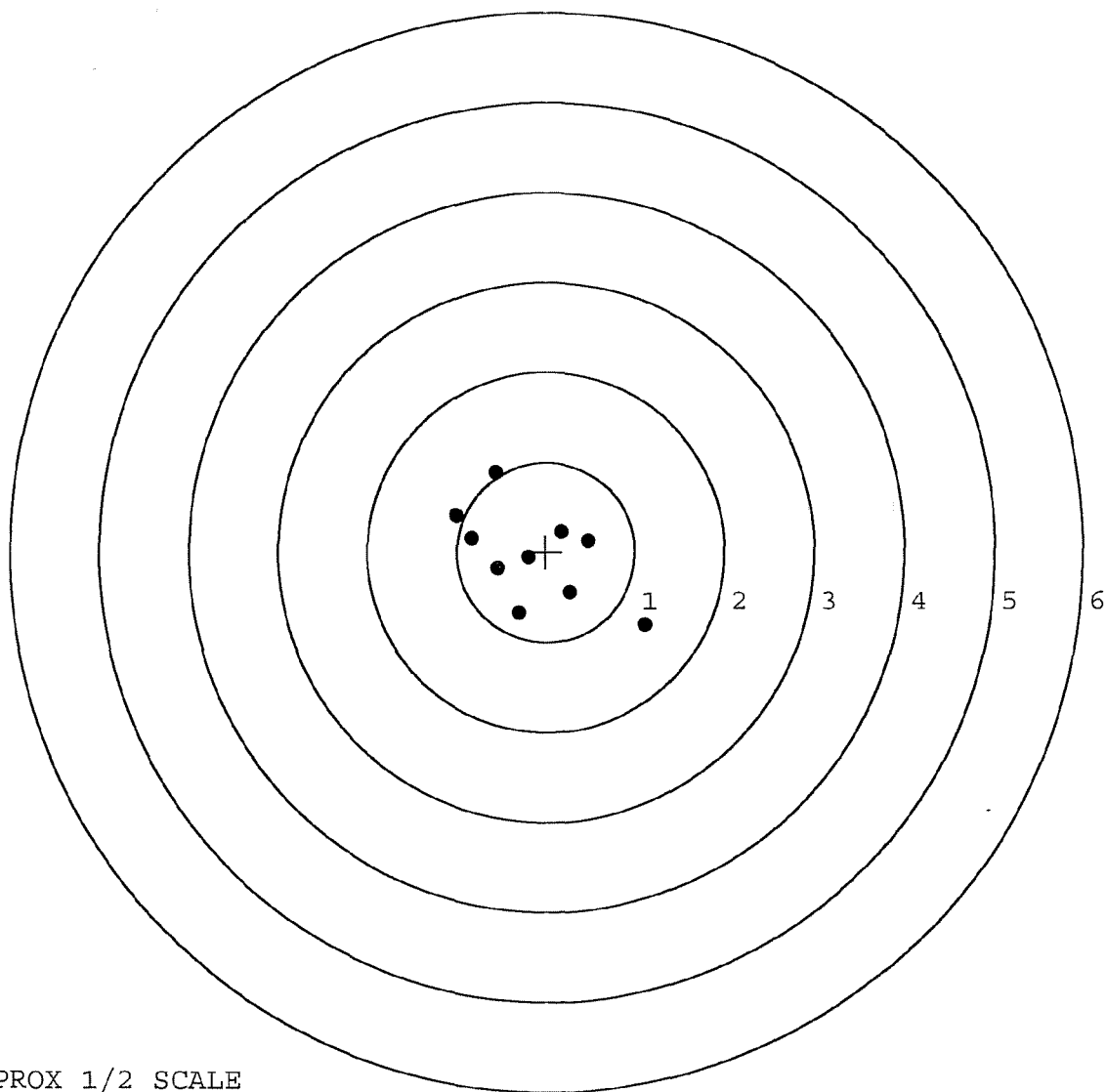
MAX RADIUS: 1.473

MEAN RADIUS: 0.696

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 8

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE