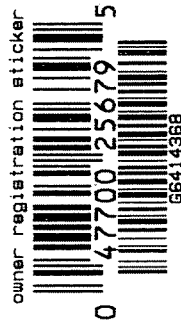


G-6414368

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

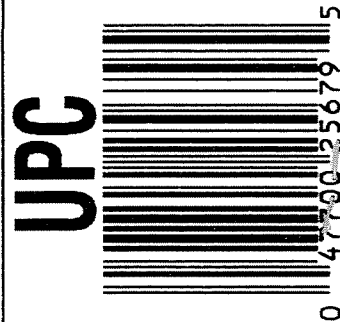
98606 - M-24 OPERATORS MANUAL
96229 - SWS SLING STRAP ASSEMBLY
96117 - TRS BI POD ASSB

DD FORM 96253



ORDER NO.	25679
BARREL LENGTH	24"
CAPACITY	6

G6414368



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



SERIAL NO.



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

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6H14368

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 11 2005 OPERATOR BS		
615	ROLLMARK CALIBER		1-5-05	CV
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1/10/05	TRW
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		1-18-05	WA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-18-05	GA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-18-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		2-8-05	RTZ
	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		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	3-21-05	AC
	J) ASSEMBLE STOCK		2-9-05	RTL
	K) ASSEMBLE SWIVEL STUDS		3-21-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-9-05	RTL
	M) IRON SIGHT ALIGNMENT		2-9-05	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-9-05	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	2-10-05	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-11-05	TRW
655	FINAL INSPECTION A) HEADSPACE		3-21-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.84</u> <u>2.85</u> <u>2.84</u> <u>2.80</u> <u>2.88</u>	3-21-05	TRW
	C) FUNCTION		3-21-05	AC
660	PACK		3/29/05	RA

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. G6717568
 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	2.32	2.77		2.34	
PULL #2	2.22	2.80		2.31	
PULL #3	2.14	2.66		2.27	
PULL #4	2.70	2.77		2.30	
PULL #5	2.66	2.62		2.29	
TOTAL	12.04	13.62		11.51	
AVERAGE	2.40	2.72		2.30	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.29	3.12		
PULL #2	3.28	3.10		
PULL #3	3.37	3.14		
PULL #4	3.26	3.12		
PULL #5	3.35	3.13		
TOTAL	16.55	15.61		
AVERAGE	3.31	3.12		

	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	4.10		4.02
PULL #2	4.28	4.18		4.59
PULL #3	4.24	4.11		4.61
PULL #4	4.25	4.18		4.36
PULL #5	4.21	4.06		4.27
TOTAL	21.30	20.63		21.85
AVERAGE	4.26	4.12		4.37

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414368.___0

FILE DATE AND TIME: 02/11/2005 09:29

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

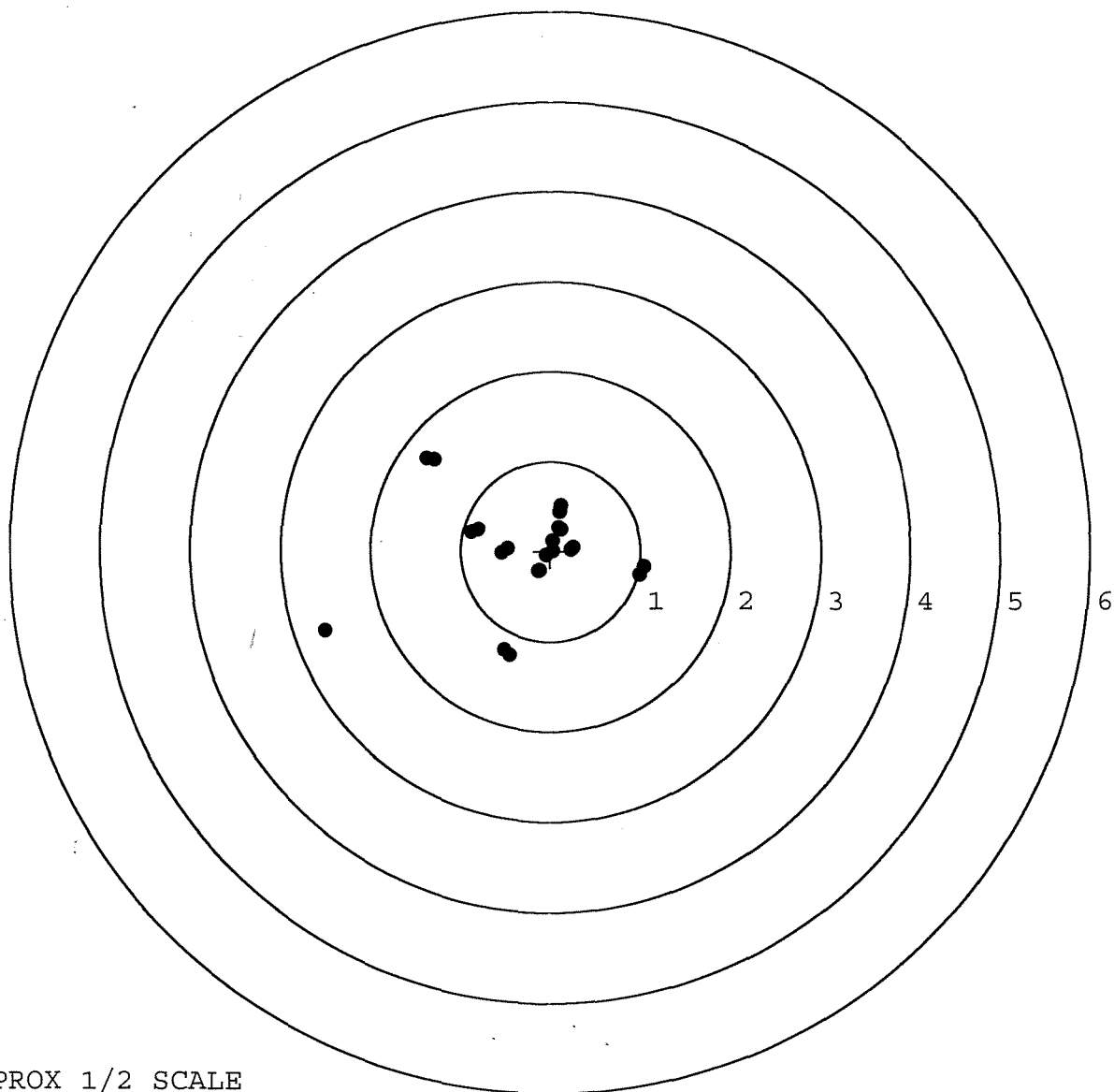
The Average X Centroid of the Five Target Set:	-0.099
The Average Y Centroid of the Five Target Set:	-0.093
The Average Point of Impact of the Five Target Set:	0.135
The Average Mean Radius of the Five Target Set:	0.843
The Distance from POA to Centroid Target #1:	0.280
The Distance from Centroid Target #2 to Centroid Target #1:	0.177
The Distance from Centroid Target #3 to Centroid Target #1:	0.302
The Distance from Centroid Target #4 to Centroid Target #1:	0.334
The Distance from Centroid Target #5 to Centroid Target #1:	0.229

SERIAL NUMBER: G6414368. 0
TARGET NUMBER: 1
FILE DATE: 02/11/2005
FILE TIME: 09:29

X CENTROID: -0.280
Y CENTROID: 0.003
POA TO CENTROID: 0.280
HORZ SPREAD: 3.540
VERT SPREAD: 2.185
GROUP SPREAD: 3.611
MIN RADIUS: 0.199
MAX RADIUS: 2.395
MEAN RADIUS: 0.752
IN 1 IN DIAMETER: 9
IN 2 IN DIAMETER: 15
in 3 IN DIAMETER: 20

POINT#	X	Y
1:	1.037	-0.176
2:	-0.455	-1.155
3:	-2.503	-0.887
4:	-1.379	1.030
5:	-0.885	0.217
6:	-0.545	-0.025
7:	-0.122	-0.214
8:	0.227	0.016
9:	0.033	0.116
10:	0.124	0.245
11:	0.105	0.435
12:	-0.048	-0.052
13:	-0.516	-1.098
14:	0.993	-0.262

POINT#	X	Y
15:	-0.477	0.031
16:	-0.813	0.246
17:	-1.289	1.014
18:	0.114	0.508
19:	0.094	0.261
20:	0.256	0.045
21:	0.030	-0.002
22:	-0.134	-0.224



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414368. 0

TARGET NUMBER: 2

FILE DATE: 02/11/2005

FILE TIME: 09:29

X CENTROID: -0.112

Y CENTROID: -0.051

POA TO CENTROID: 0.123

HORZ SPREAD: 1.811

VERT SPREAD: 1.274

GROUP SPREAD: 1.888

MIN RADIUS: 0.200

MAX RADIUS: 1.116

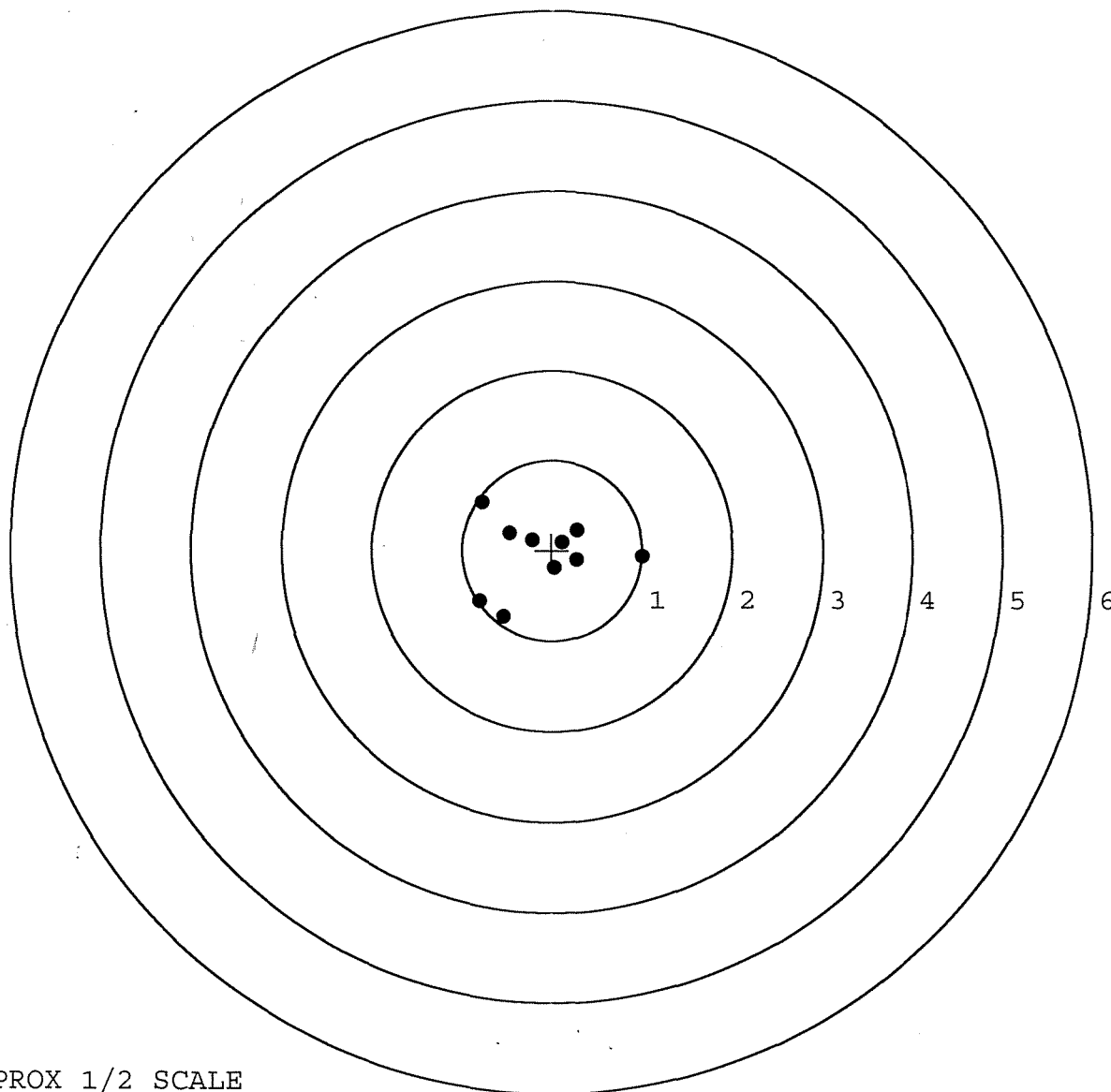
MEAN RADIUS: 0.566

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.004	-0.072
2:	-0.546	-0.740
3:	-0.807	-0.561
4:	-0.784	0.534
5:	-0.468	0.194
6:	-0.219	0.118
7:	0.280	0.227
8:	0.116	0.089
9:	0.277	-0.106
10:	0.030	-0.195



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414368. 0

TARGET NUMBER: 3

FILE DATE: 02/11/2005

FILE TIME: 09:29

X CENTROID: 0.007

Y CENTROID: -0.091

POA TO CENTROID: 0.091

HORZ SPREAD: 3.099

VERT SPREAD: 2.216

GROUP SPREAD: 3.369

MIN RADIUS: 0.293

MAX RADIUS: 1.876

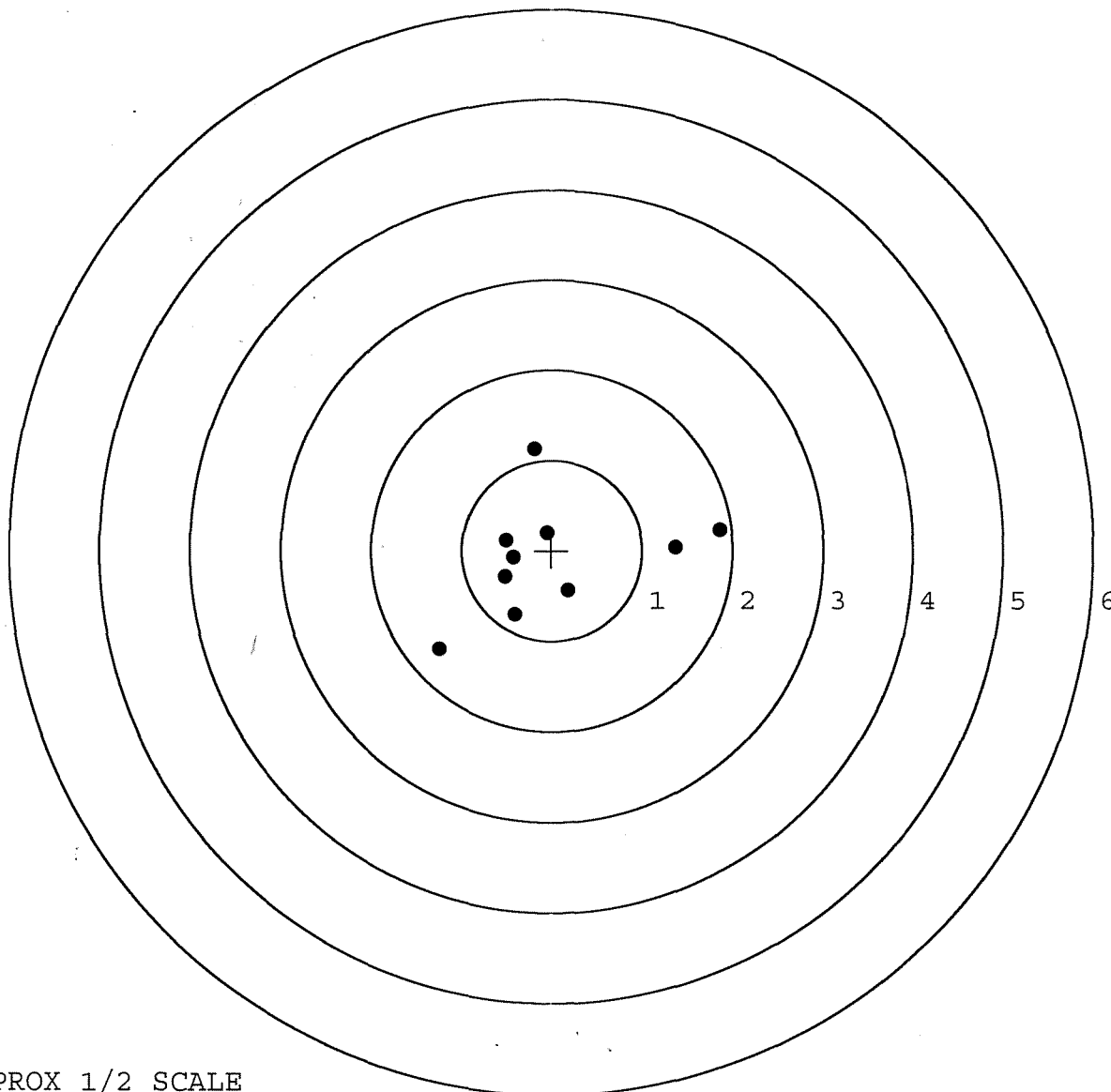
MEAN RADIUS: 0.905

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.856	0.227
2:	1.370	0.045
3:	0.180	-0.445
4:	-0.413	-0.710
5:	-1.243	-1.095
6:	-0.190	1.121
7:	-0.048	0.197
8:	-0.504	0.117
9:	-0.423	-0.076
10:	-0.514	-0.289



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414368. 0

TARGET NUMBER: 4

FILE DATE: 02/11/2005

FILE TIME: 09:29

X CENTROID: -0.033

Y CENTROID: -0.222

POA TO CENTROID: 0.224

HORZ SPREAD: 3.517

VERT SPREAD: 2.406

GROUP SPREAD: 3.704

MIN RADIUS: 0.261

MAX RADIUS: 2.243

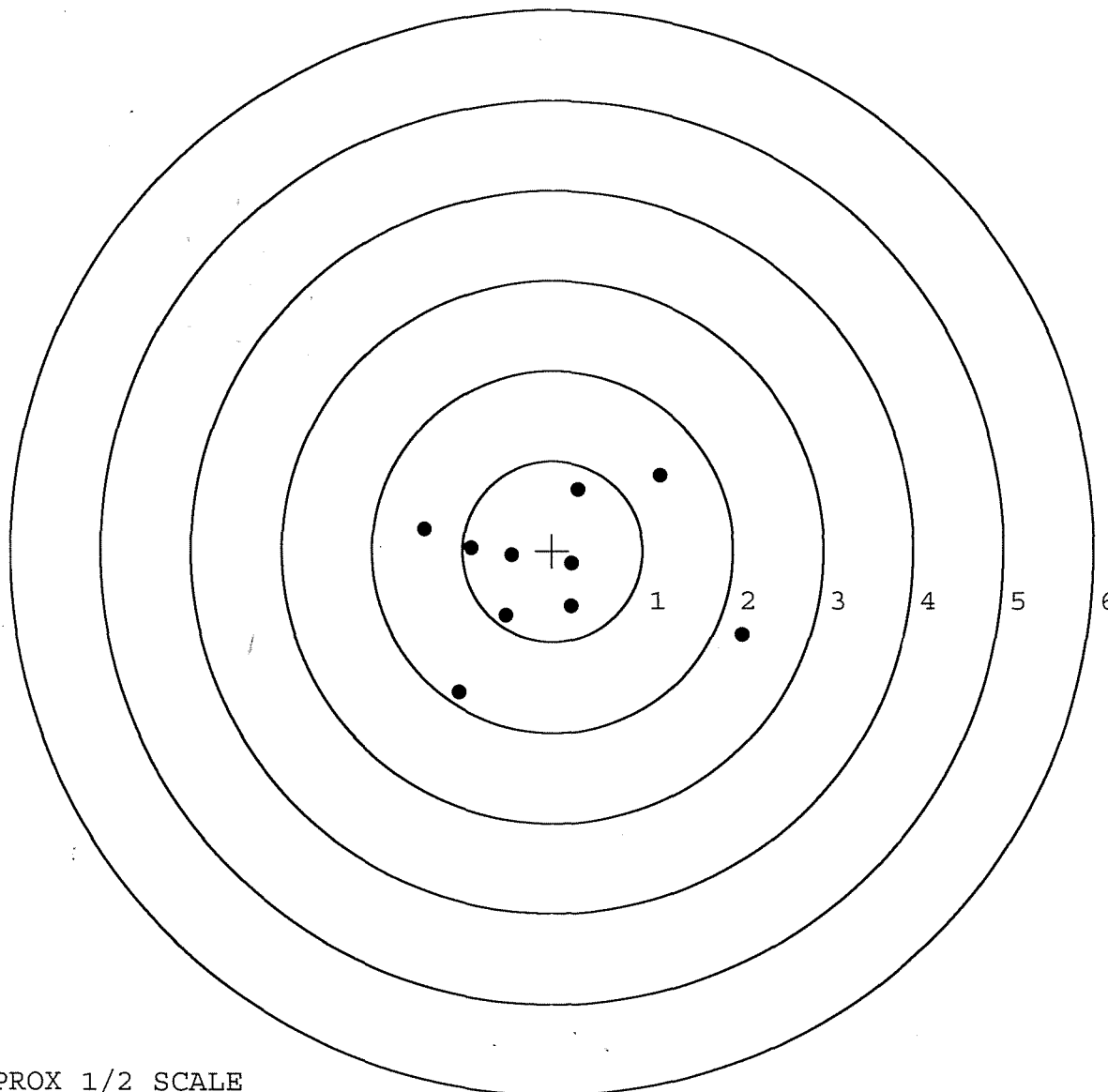
MEAN RADIUS: 1.072

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.191	0.840
2:	0.285	0.683
3:	0.214	-0.138
4:	0.207	-0.611
5:	-0.516	-0.716
6:	-0.448	-0.053
7:	-0.904	0.034
8:	-1.421	0.234
9:	-1.034	-1.566
10:	2.096	-0.927

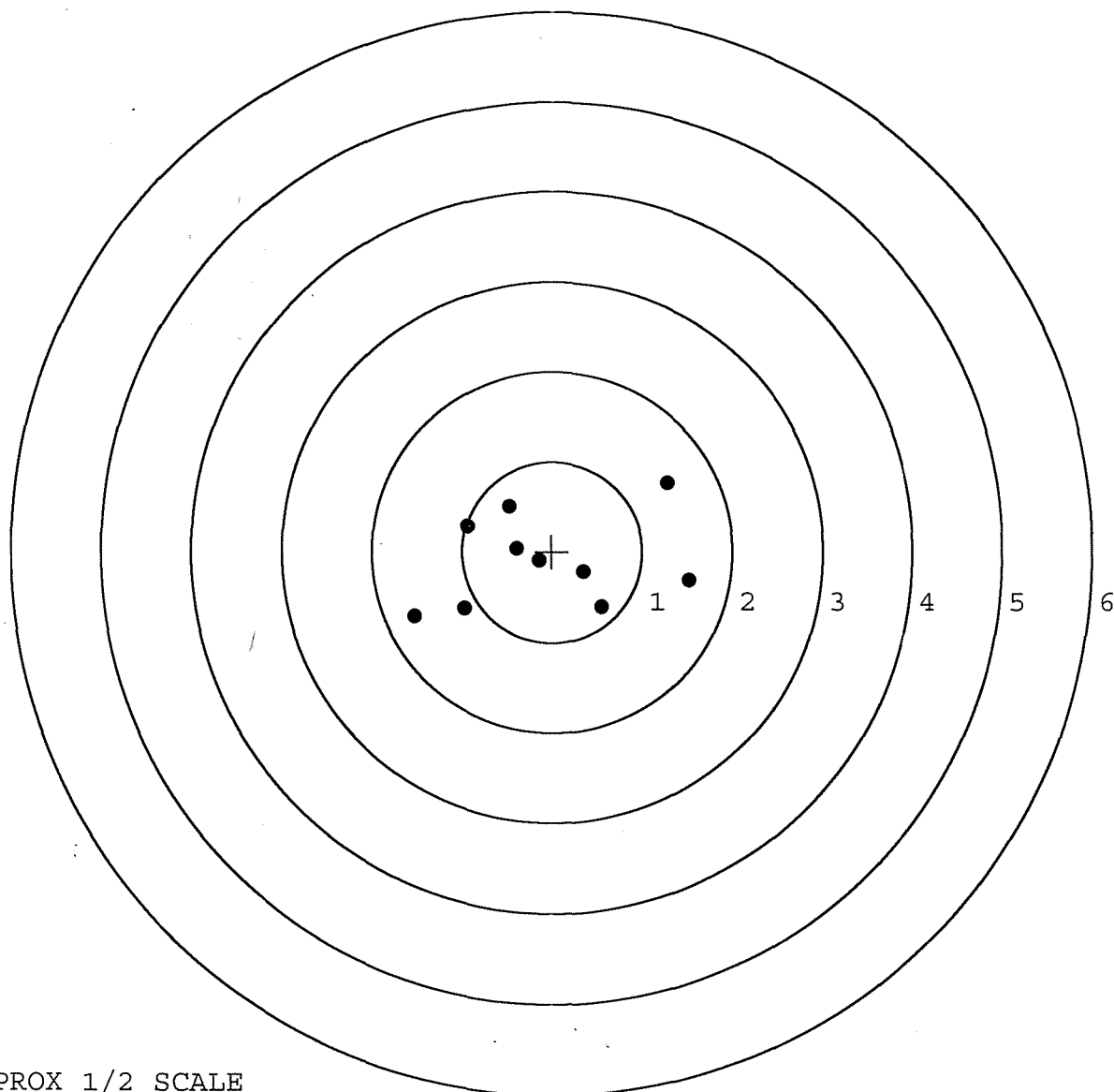


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414368. 0
TARGET NUMBER: 5
FILE DATE: 02/11/2005
FILE TIME: 09:29

X CENTROID: -0.076
Y CENTROID: -0.102
POA TO CENTROID: 0.127
HORZ SPREAD: 3.052
VERT SPREAD: 1.480
GROUP SPREAD: 3.078
MIN RADIUS: 0.069
MAX RADIUS: 1.610
MEAN RADIUS: 0.918
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.520	-0.315
2:	1.277	0.763
3:	0.552	-0.613
4:	0.351	-0.225
5:	-0.145	-0.103
6:	-0.390	0.035
7:	-0.474	0.501
8:	-0.941	0.285
9:	-0.977	-0.628
10:	-1.532	-0.717



TARGET APPROX 1/2 SCALE