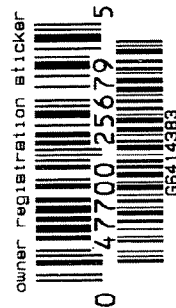
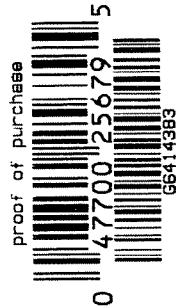


G 641 4383

**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

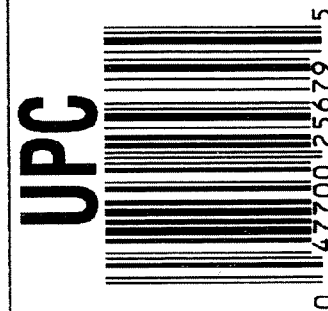


ORDER NO. **25679**

BARREL LENGTH **24"**

CAPACITY **6**

G6414383



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



ORDER 25679

M/24 7.62 NATO S.W.S.

UPC



SERIAL NO.



3/11/2005 9:25:01 AM

Crib

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 # G6414383

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RTL
600	PROOF		1-4-05	A
607	CHECK HEADSPACE	MAGNA - FLUX	1-4-05	A
610	DIS-ASSEMBLE GUN	INSPECTED	1-4-05	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	JAN 3 + 2005 OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		1-5-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1/16/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-18-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-18-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER			
	D) OIL FIRING PIN ASSEMBLY		2-1-05	RTL
	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>6 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>.023</u>	2-16-05	Ac
	J) ASSEMBLE STOCK		2-1-05	RT
	K) ASSEMBLE SWIVEL STUDS		2-18-05	Ac
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		2-1-05	RT
	M) IRON SIGHT ALIGNMENT		2-1-05	RT
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		2-1-05	RT
640	GALLERY TEST AND TARGET	<u>PASS</u> <u>FAIL</u>	2-4-05	Ac
	MALFUNCTION	CORRECTION	NA	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-4-05	Ac
655	FINAL INSPECTION A) HEADSPACE		2-16-05	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.24</u> <u>2.03</u> <u>2.32</u> <u>2.24</u> <u>2.53</u>	2-17-05	TRW
	C) FUNCTION		2-16-05	Ac
660	PACK		3/18/05	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 TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.51	2.60		2.21	
PULL #2	2.71	2.57		2.06	
PULL #3	2.70	2.45		2.00	
PULL #4	2.52	2.37		2.05	
PULL #5	2.41	2.32		2.12	
TOTAL	12.85	12.31		10.44	
AVERAGE	2.57	2.46		2.08	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.48		
PULL #2	3.51	3.21		
PULL #3	3.39	3.18		
PULL #4	3.22	3.16		
PULL #5	3.24	3.16		
TOTAL	16.84	16.19		
AVERAGE	3.36	3.23		

	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	4.25	4.56		4.44
PULL #2	4.12	4.31		4.31
PULL #3	4.14	4.22		4.35
PULL #4	4.16	4.11		4.38
PULL #5	4.20	4.07		4.35
TOTAL	20.87	21.27		21.83
AVERAGE	4.17	4.25		4.36

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414383.___0
FILE DATE AND TIME: 02/04/2005 07:48

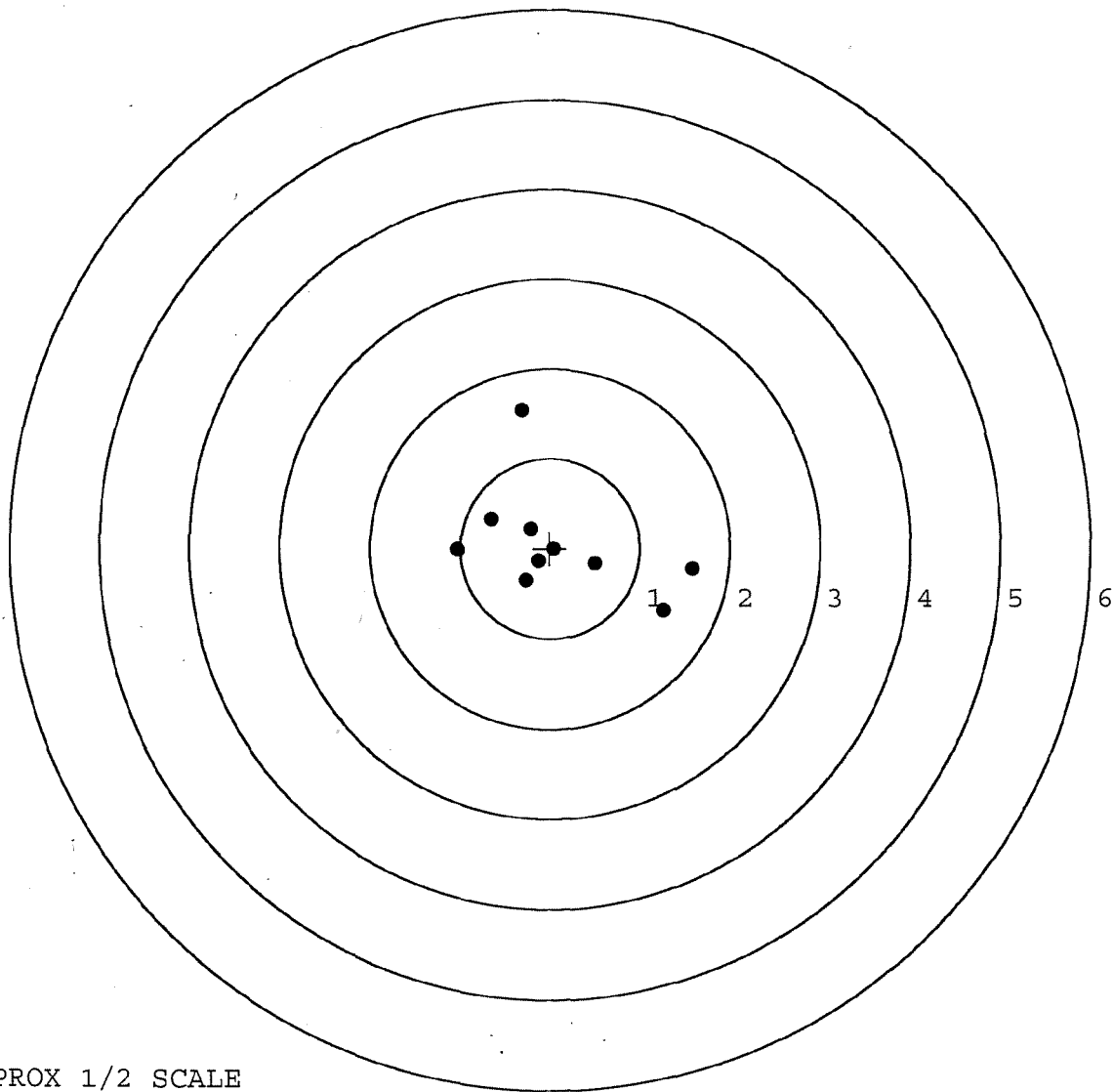
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.044
The Average Y Centroid of the Five Target Set:	-0.038
The Average Point of Impact of the Five Target Set:	0.058
The Average Mean Radius of the Five Target Set:	1.149
The Distance from POA to Centroid Target #1:	0.089
The Distance from Centroid Target #2 to Centroid Target #1:	0.464
The Distance from Centroid Target #3 to Centroid Target #1:	0.578
The Distance from Centroid Target #4 to Centroid Target #1:	0.250
The Distance from Centroid Target #5 to Centroid Target #1:	0.483

SERIAL NUMBER: G6414383: 0
TARGET NUMBER: 1
FILE DATE: 02/04/2005
FILE TIME: 07:48

X CENTROID: 0.077
Y CENTROID: 0.045
POA TO CENTROID: 0.089
HORZ SPREAD: 2.608
VERT SPREAD: 2.236
GROUP SPREAD: 2.734
MIN RADIUS: 0.066
MAX RADIUS: 1.542
MEAN RADIUS: 0.805
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.259	-0.699
2:	1.581	-0.228
3:	0.500	-0.167
4:	-0.314	1.537
5:	-1.027	-0.018
6:	-0.655	0.330
7:	-0.216	0.217
8:	0.042	-0.010
9:	-0.127	-0.145
10:	-0.272	-0.363



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414383: __0

TARGET NUMBER: 2

FILE DATE: 02/04/2005

FILE TIME: 07:48

POINT#	X	Y
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1:	-0.036	-2.663
----	--------	--------

2:	0.110	-2.490
----	-------	--------

3:	0.247	-1.138
----	-------	--------

4:	0.331	-0.678
----	-------	--------

5:	0.782	0.920
----	-------	-------

6:	-0.760	1.182
----	--------	-------

7:	0.226	0.325
----	-------	-------

8:	0.010	0.215
----	-------	-------

9:	-0.240	0.128
----	--------	-------

10:	-0.468	0.045
-----	--------	-------

X CENTROID: 0.020

Y CENTROID: -0.415

POA TO CENTROID: 0.416

HORZ SPREAD: 1.542

VERT SPREAD: 3.845

GROUP SPREAD: 3.913

MIN RADIUS: 0.407

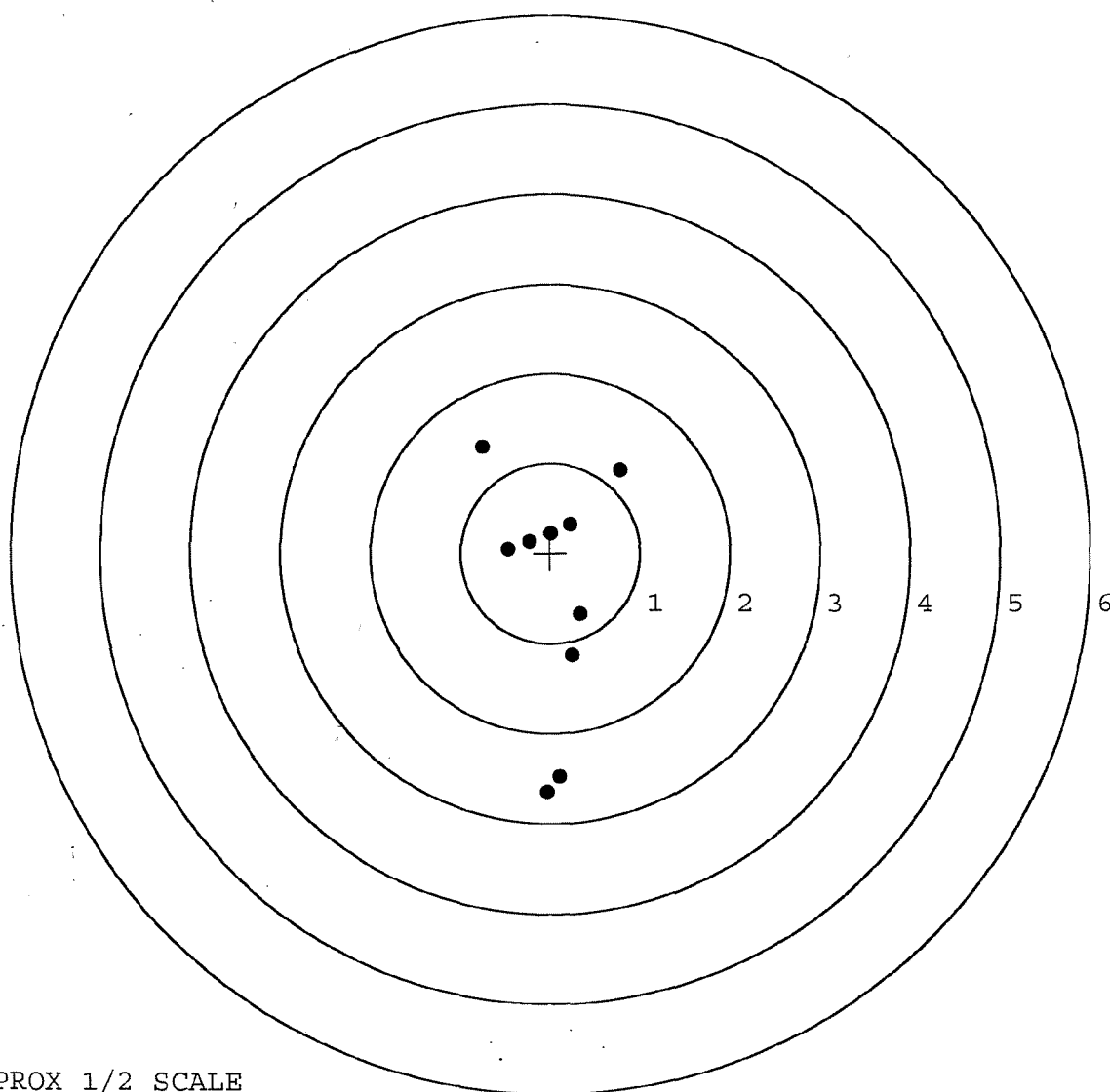
MAX RADIUS: 2.248

MEAN RADIUS: 1.148

IN 1 IN DIAMETER: 1

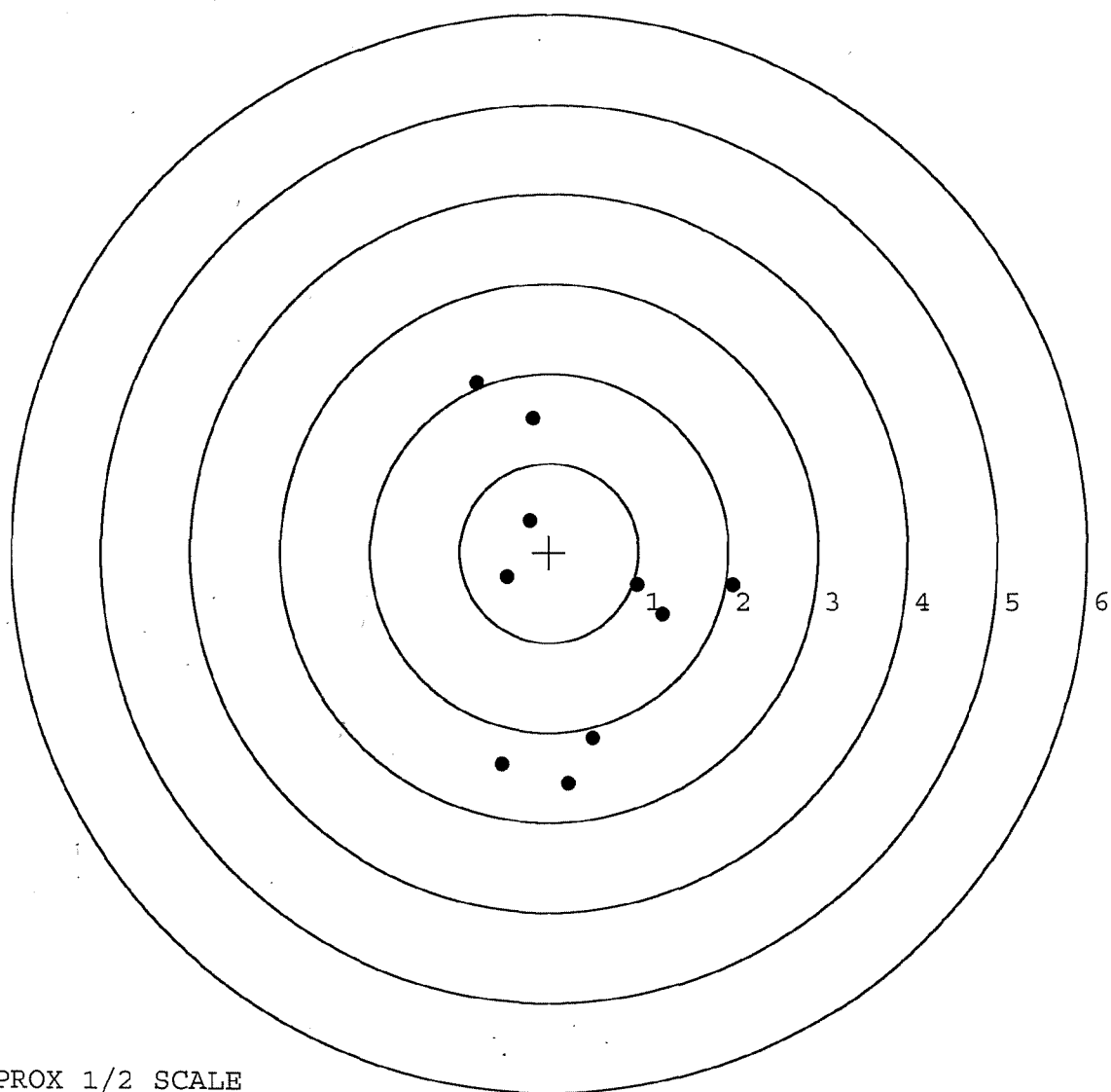
IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414383:___0	POINT#	X	Y
TARGET NUMBER: 3	1:	2.053	-0.367
FILE DATE: 02/04/2005	2:	1.262	-0.698
FILE TIME: 07:48	3:	0.981	-0.373
	4:	0.490	-2.069
X CENTROID: 0.278	5:	0.218	-2.570
Y CENTROID: -0.497	6:	-0.528	-2.364
POA TO CENTROID: 0.569	7:	-0.471	-0.285
HORZ SPREAD: 2.872	8:	-0.225	0.357
VERT SPREAD: 4.466	9:	-0.184	1.501
GROUP SPREAD: 4.585	10:	-0.819	1.896
MIN RADIUS: 0.714			
MAX RADIUS: 2.633			
MEAN RADIUS: 1.564			
# IN 1 IN DIAMETER: 0			
# IN 2 IN DIAMETER: 3			
# in 3 IN DIAMETER: 4			

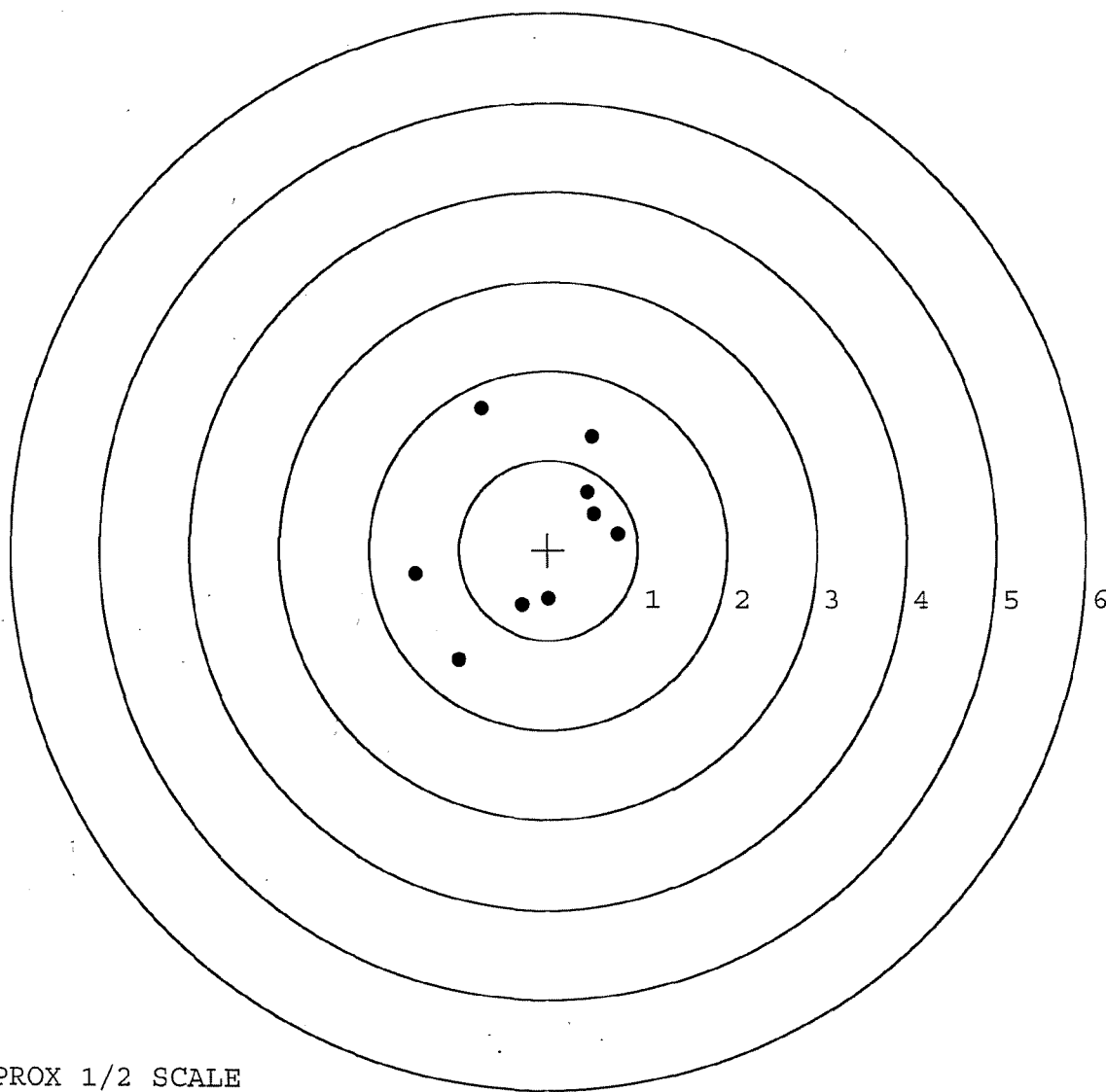


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414383: 0
TARGET NUMBER: 4
FILE DATE: 02/04/2005
FILE TIME: 07:48

POINT#	X	Y
1:	0.777	0.178
2:	0.513	0.398
3:	0.439	0.643
4:	0.000	-0.544
5:	-0.299	-0.609
6:	-1.002	-1.225
7:	-1.483	-0.272
8:	0.493	1.265
9:	-0.753	1.579

X CENTROID: -0.146
Y CENTROID: 0.157
POA TO CENTROID: 0.214
HORZ SPREAD: 2.260
VERT SPREAD: 2.804
GROUP SPREAD: 2.904
MIN RADIUS: 0.702
MAX RADIUS: 1.626
MEAN RADIUS: 1.082
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

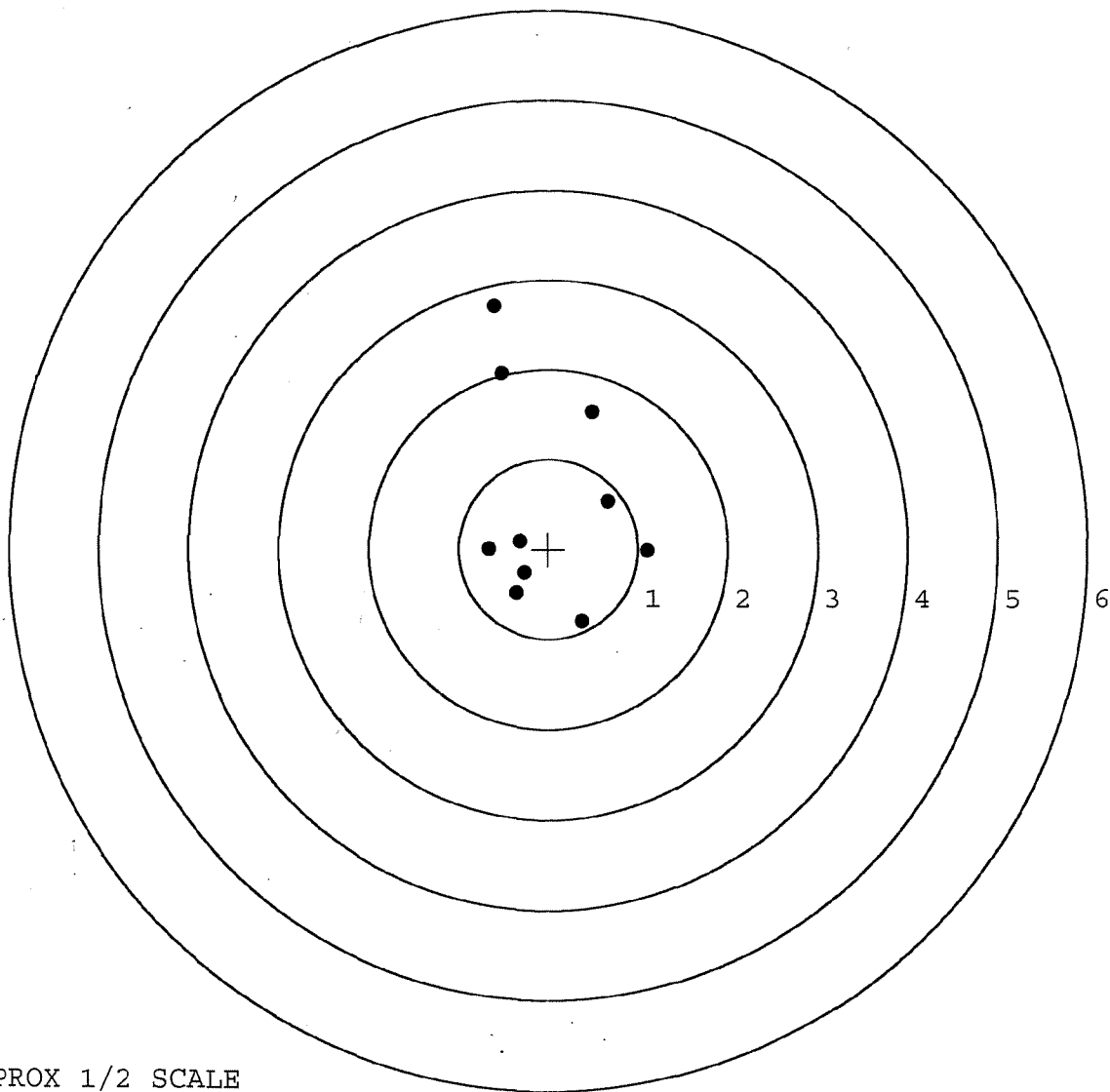


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414383: 0
TARGET NUMBER: 5
FILE DATE: 02/04/2005
FILE TIME: 07:48

POINT#	X	Y
1:	0.375	-0.812
2:	1.105	-0.023
3:	0.666	0.530
4:	-0.267	-0.262
5:	-0.357	-0.495
6:	-0.317	0.091
7:	-0.662	-0.001
8:	0.493	1.523
9:	-0.530	1.949
10:	-0.611	2.705

X CENTROID: -0.011
Y CENTROID: 0.521
POA TO CENTROID: 0.521
HORZ SPREAD: 1.767
VERT SPREAD: 3.517
GROUP SPREAD: 3.653
MIN RADIUS: 0.528
MAX RADIUS: 2.266
MEAN RADIUS: 1.147
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 8



TARGET APPROX 1/2 SCALE