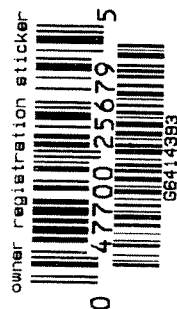


G-6414393

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



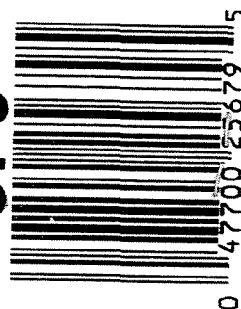
ORDER NO. 25679

BARREL LENGTH 24"

CAPACITY 6

G6414393

UPC



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

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 # ~~G6414398~~ G6414393 TRW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-3-05	RTZ
600	PROOF		1-4-05	TRW
607	CHECK HEADSPACE	MAGNA - FLUX INSPECTED	1-4-05	TRW
610	DIS-ASSEMBLE GUN	JAN 07 2005	1-4-05	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR 		
615	ROLLMARK CALIBER		1-7-05	CW
617	DRILL AND TAP SIGHT HOLES		1-4-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1-4-05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-14-05	RA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-14-05	RA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-14-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		2-9-05	RTZ
	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>7 lbs</u> <u>7 lbs</u> <u>7 lbs</u>	3-29-05	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	3-29-05	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.026</u> <u>.026</u> <u>.026</u>	3-29-05	AC
	J) ASSEMBLE STOCK		2-9-05	RTL
	K) ASSEMBLE SWIVEL STUDS		3-29-05	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	<u>PASS</u> FAIL	2-10-05	AC
	MALFUNCTION <i>FPO</i>	CORRECTION <i>OK</i>	2-10-05	AC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		2-10-05	TRW
655	FINAL INSPECTION A) HEADSPACE		3-29-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.48</u> <u>2.86</u> <u>2.68</u> <u>2.71</u> <u>2.68</u>	3-29-05	TRW
	C) FUNCTION		3-29-05	AC
660	PACK		3/30/05	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.

G 6414393

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	2.56	2.24		2.23	
PULL #2	2.71	2.29		2.30	
PULL #3	2.86	2.32		2.30	
PULL #4	2.24	2.50		2.31	
PULL #5	2.57	2.42		2.27	
TOTAL	12.94	11.77		11.41	
AVERAGE	2.58	2.35		2.28	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.32		
PULL #2	3.43	3.24		
PULL #3	3.40	3.20		
PULL #4	3.41	3.20		
PULL #5	3.29	3.29		
TOTAL	16.75	16.25		
AVERAGE	3.35	3.25		

	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	4.24	4.19		4.18
PULL #2	4.25	4.23		4.31
PULL #3	4.24	4.14		4.29
PULL #4	4.15	4.21		4.26
PULL #5	4.25	4.19		4.30
TOTAL	21.13	20.96		21.34
AVERAGE	4.22	4.19		4.26

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414393.___0

FILE DATE AND TIME: 02/10/2005 08:37

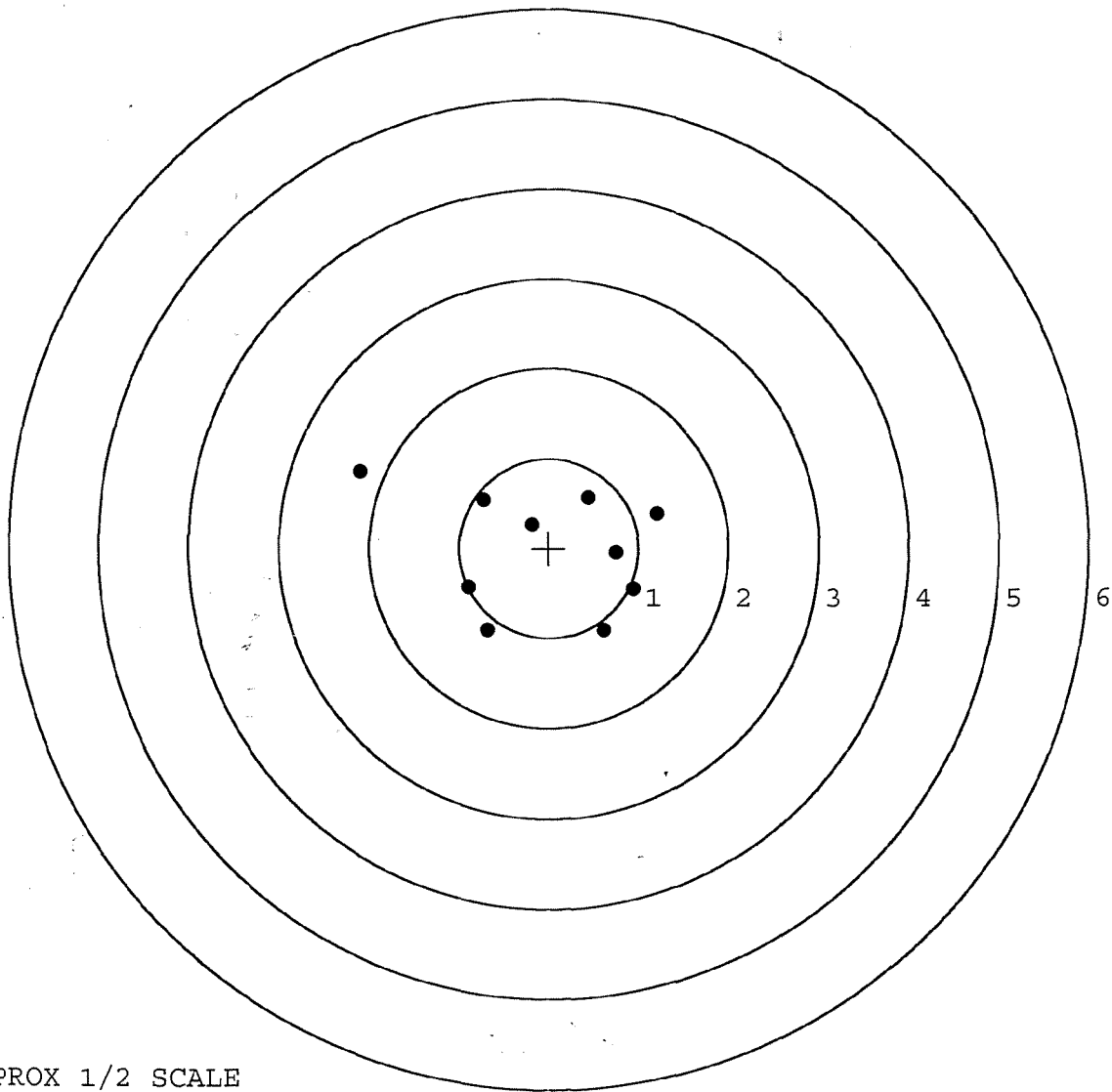
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.126
The Average Y Centroid of the Five Target Set:	-0.065
The Average Point of Impact of the Five Target Set:	0.142
The Average Mean Radius of the Five Target Set:	0.887
The Distance from POA to Centroid Target #1:	0.066
The Distance from Centroid Target #2 to Centroid Target #1:	0.138
The Distance from Centroid Target #3 to Centroid Target #1:	0.105
The Distance from Centroid Target #4 to Centroid Target #1:	0.136
The Distance from Centroid Target #5 to Centroid Target #1:	0.036

SERIAL NUMBER: G6414393: 0
TARGET NUMBER: 1
FILE DATE: 02/10/2005
FILE TIME: 08:37

X CENTROID: -0.064
Y CENTROID: -0.016
POA TO CENTROID: 0.066
HORZ SPREAD: 3.300
VERT SPREAD: 1.774
GROUP SPREAD: 3.333
MIN RADIUS: 0.307
MAX RADIUS: 2.210
MEAN RADIUS: 1.058
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.615	-0.920
2:	0.941	-0.458
3:	0.757	-0.050
4:	1.204	0.389
5:	0.446	0.573
6:	-0.193	0.263
7:	-0.687	-0.920
8:	-0.897	-0.434
9:	-0.731	0.546
10:	-2.096	0.854



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414393: 0

TARGET NUMBER: 2

FILE DATE: 02/10/2005

FILE TIME: 08:37

POINT#	X	Y
1:	1.015	-0.789
2:	1.176	0.711
3:	0.219	-0.790
4:	0.030	-0.398
5:	-0.275	-0.418
6:	-0.093	0.826
7:	-0.429	0.224
8:	-0.622	0.358
9:	-1.050	-0.195
10:	-1.491	-0.746

X CENTROID: -0.152

Y CENTROID: -0.122

POA TO CENTROID: 0.195

HORZ SPREAD: 2.667

VERT SPREAD: 1.616

GROUP SPREAD: 3.039

MIN RADIUS: 0.321

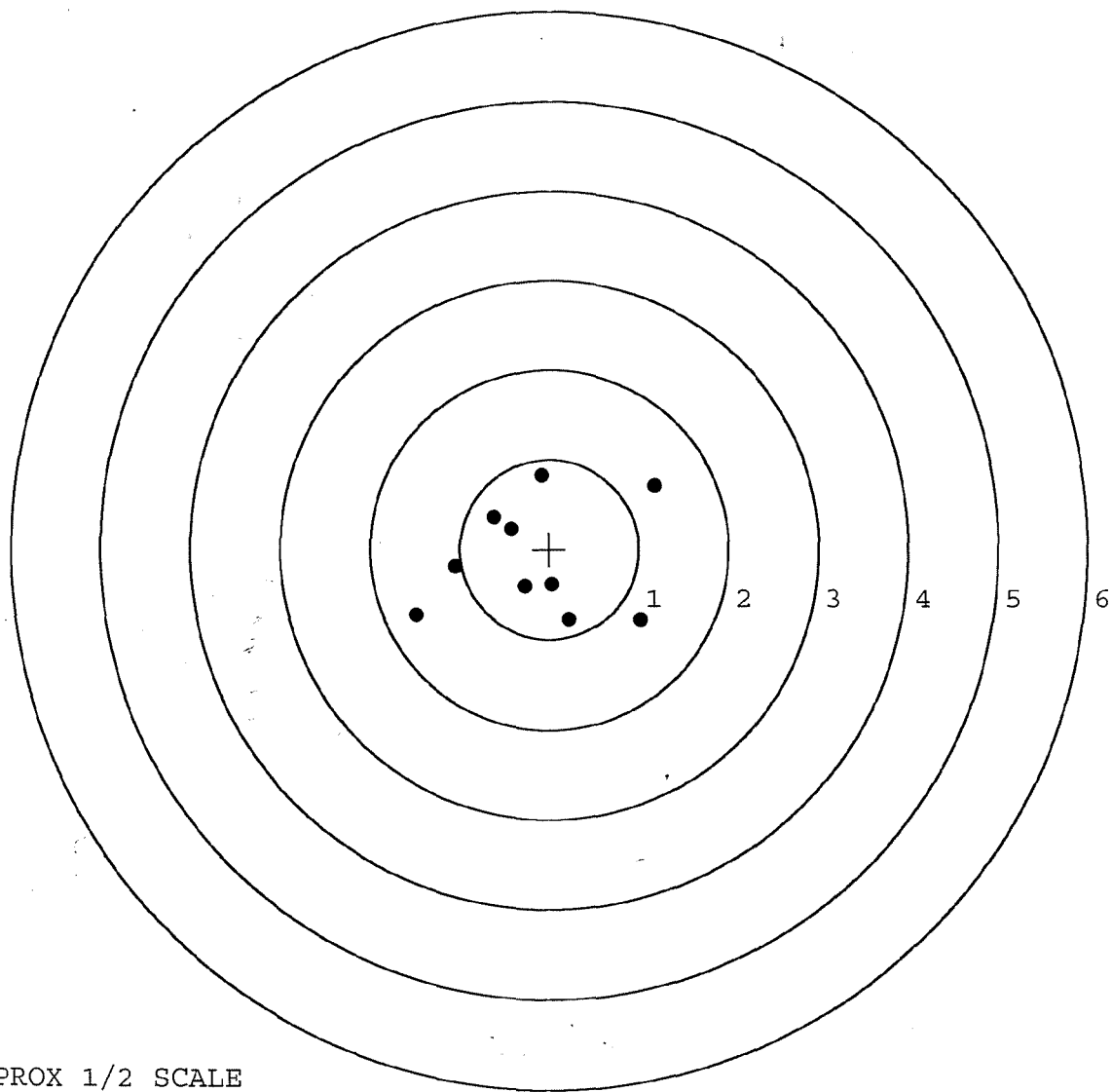
MAX RADIUS: 1.567

MEAN RADIUS: 0.877

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414393: __0

TARGET NUMBER: 3

FILE DATE: 02/10/2005

FILE TIME: 08:37

POINT#	X	Y
1:	1.279	0.240
2:	0.982	0.407
3:	0.577	0.253
4:	0.545	-0.529
5:	-0.253	-0.583
6:	-0.622	-0.461
7:	-1.109	-0.706
8:	-0.650	-0.053
9:	-0.668	0.328
10:	-1.538	0.294

X CENTROID: -0.146

Y CENTROID: -0.081

POA TO CENTROID: 0.167

HORZ SPREAD: 2.817

VERT SPREAD: 1.113

GROUP SPREAD: 2.818

MIN RADIUS: 0.505

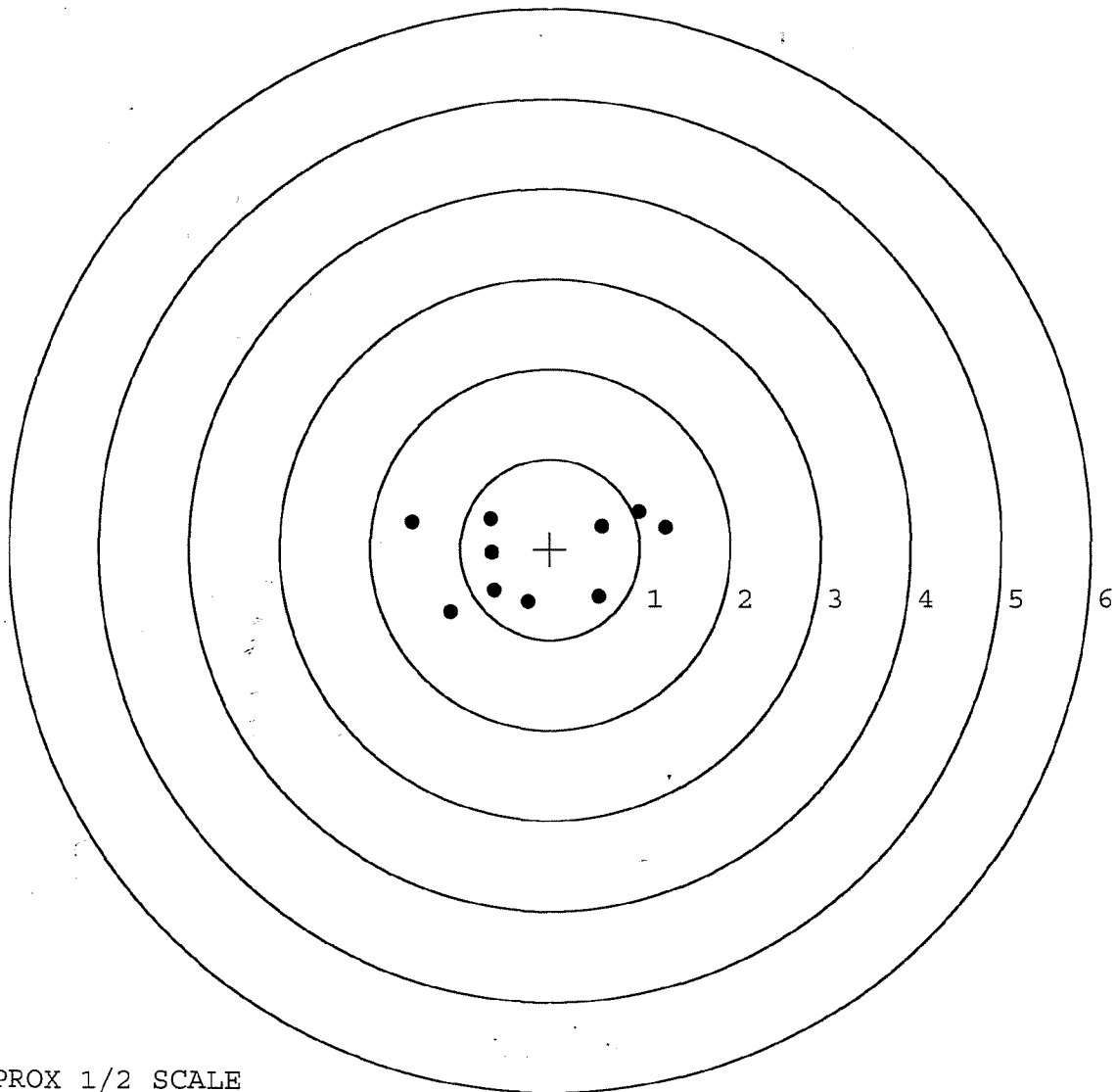
MAX RADIUS: 1.460

MEAN RADIUS: 0.919

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

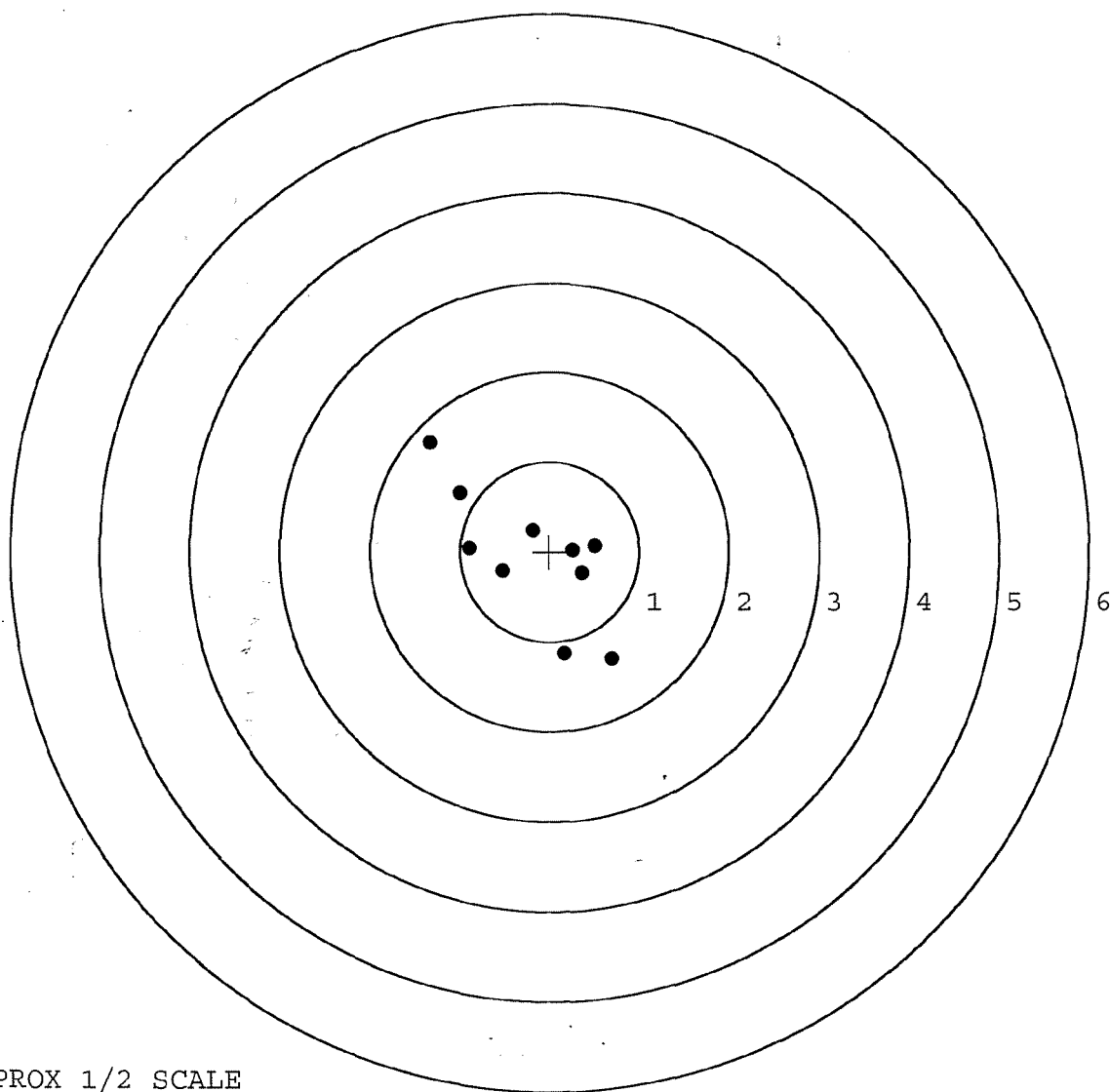


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414393: __0
TARGET NUMBER: 4
FILE DATE: 02/10/2005
FILE TIME: 08:37

POINT#	X	Y
1:	0.706	-1.188
2:	0.167	-1.139
3:	-0.522	-0.220
4:	-0.193	0.235
5:	-0.897	0.041
6:	-1.001	0.653
7:	-1.332	1.209
8:	0.508	0.071
9:	0.263	0.014
10:	0.361	-0.237

X CENTROID: -0.194
Y CENTROID: -0.056
POA TO CENTROID: 0.202
HORZ SPREAD: 2.038
VERT SPREAD: 2.397
GROUP SPREAD: 3.146
MIN RADIUS: 0.291
MAX RADIUS: 1.702
MEAN RADIUS: 0.849
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

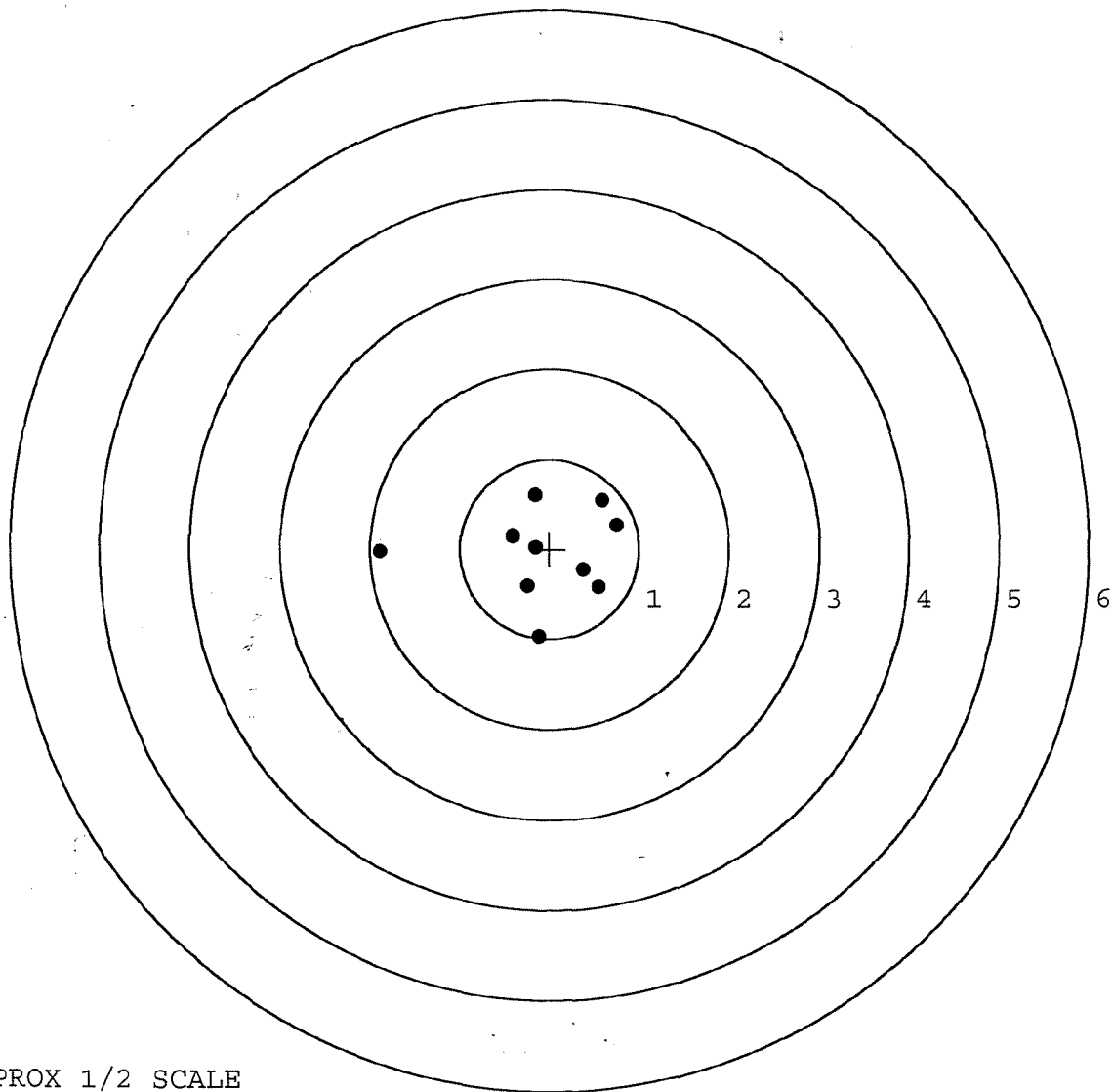


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414393: __0
TARGET NUMBER: 5
FILE DATE: 02/10/2005
FILE TIME: 08:37

X CENTROID: -0.075
Y CENTROID: -0.050
POA TO CENTROID: 0.090
HORZ SPREAD: 2.640
VERT SPREAD: 1.589
GROUP SPREAD: 2.657
MIN RADIUS: 0.109
MAX RADIUS: 1.817
MEAN RADIUS: 0.732
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.748	0.269
2:	0.592	0.550
3:	-0.166	0.604
4:	0.548	-0.424
5:	0.375	-0.233
6:	-0.125	-0.985
7:	-0.252	-0.417
8:	-0.155	0.023
9:	-0.419	0.144
10:	-1.892	-0.033



TARGET APPROX 1/2 SCALE