

66414410 Z

**ORDER 25679**

M/24 7.62 NATO S.W.S.

**UPC**



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**UPC**



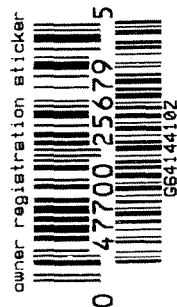
SERIAL NO.



**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 BIPOD ASSB

**DD FORM 96253**

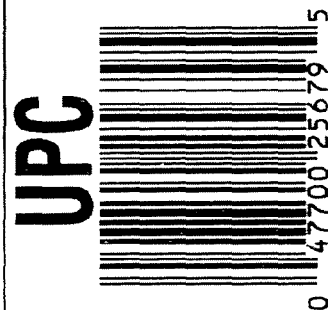


**ORDER NO. 25679**

**BARREL LENGTH 24"**

**CAPACITY 6**

**G6414410Z**



3/11/2006 9:25:01 AM

Chib

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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 # G6414410 Z

| OP #         | OPERATION NAME                                                 | READINGS                  | DATE    | INITIAL |
|--------------|----------------------------------------------------------------|---------------------------|---------|---------|
| 575 &<br>580 | ASSEMBLE ACTION<br>AND STOCK                                   |                           | 1-3-05  | RTZ     |
| 600          | PROOF                                                          |                           | 1-4-05  | A       |
| 607          | CHECK HEADSPACE                                                | MAGNA - FLUX              | 1-4-05  | K       |
| 610          | DIS-ASSEMBLE GUN                                               | INSPECTED                 | 1-4-05  | RTZ     |
| 612          | MAGNAFLUX BBL ACTION<br>MAGNAFLUX BOLT                         | JAN 3 2005<br>OPERATOR BS |         |         |
| 615          | ROLLMARK CALIBER                                               |                           | 1-5-05  | CW      |
| 617          | DRILL AND TAP<br>SIGHT HOLES                                   |                           | 1-4-05  | TRW     |
| 620          | APPLY COATINGS<br>(BARREL ACTION)                              |                           | 1-4-05  | HP      |
|              | (BOLT)                                                         |                           |         |         |
| 625          | FINAL ASSEMBLY                                                 |                           |         |         |
|              | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                            |                           | 1-15-05 | DA      |
|              | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD |                           | 1-15-05 | DA      |
|              | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                         |                           | 1-15-05 | RTZ     |
|              | D) OIL FIRING PIN ASSEMBLY                                     |                           | 1-31-05 | RTZ     |
|              | 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>8 lbs</u> <u>8 lbs</u> <u>8.16s</u>                      | 2-16-05 | Ac      |
| CONT. |                                                                          |                                                             |         |         |
|       | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>2 lbs</u> <u>2 lbs</u> <u>2 lbs</u>                      | 2-16-05 | Ac      |
|       | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|       | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.022</u> <u>.022</u> <u>.022</u>                         | 2-16-05 | Ac      |
|       | J) ASSEMBLE STOCK                                                        |                                                             | 1-31-05 | RTL     |
|       | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 2-18-05 | Ac      |
|       | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 |                                                             | 1-31-05 | RTL     |
|       | M) IRON SIGHT<br>ALIGNMENT                                               |                                                             | 1-31-05 | RTL     |
|       | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                             | 1-31-05 | RTL     |
| 640   | GALLERY TEST AND<br>TARGET                                               | <div>PASS</div> <div>FAIL</div>                             | 2-3-05  | Ac      |
|       | MALFUNCTION <i>Bolt Rel. sticks</i>                                      | CORRECTION <i>OK</i> <sup>AC</sup> 2-16-05                  | 2-3-05  | Ac      |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 645   | INSPECT FOR LIVE AMMO                                                    |                                                             | 2-3-05  | Ac      |
| 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>2.79</u> <u>2.88</u> <u>2.95</u> <u>2.96</u> <u>2.91</u> | 2-16-05 | TRW     |
|       | C) FUNCTION                                                              |                                                             | 2-16-05 | Ac      |
| 660   | PACK                                                                     |                                                             |         |         |

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 441 4410 Z

DATE

1-18-05

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 | 2.58                | 2.65                        |                                   | 2.54  |          |
| PULL #2 | 2.50                | 2.63                        |                                   | 2.60  |          |
| PULL #3 | 2.41                | 2.74                        |                                   | 2.71  |          |
| PULL #4 | 2.69                | 2.68                        |                                   | 2.65  |          |
| PULL #5 | 2.65                | 2.67                        |                                   | 2.62  |          |
| TOTAL   | 12.83               | 13.37                       |                                   | 13.12 |          |
| AVERAGE | 2.56                | 2.67                        |                                   | 2.62  |          |

|         | 3.00 LBS<br>INITIAL | 3.00 LBS AFTER<br>20 CYCLES |  | COMMENTS |
|---------|---------------------|-----------------------------|--|----------|
| PULL #1 | 3.23                | 3.14                        |  |          |
| PULL #2 | 3.10                | 3.06                        |  |          |
| PULL #3 | 3.26                | 3.08                        |  |          |
| PULL #4 | 3.28                | 3.23                        |  |          |
| PULL #5 | 3.27                | 3.09                        |  |          |
| TOTAL   | 16.14               | 15.60                       |  |          |
| AVERAGE | 3.22                | 3.12                        |  |          |

|         | 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 | 4.22                | 4.21                        |                                   | 4.40                                    |
| PULL #2 | 4.45                | 4.14                        |                                   | 4.18                                    |
| PULL #3 | 4.48                | 4.36                        |                                   | 4.20                                    |
| PULL #4 | 4.22                | 4.22                        |                                   | 4.25                                    |
| PULL #5 | 4.35                | 4.27                        |                                   | 4.07                                    |
| TOTAL   | 21.72               | 21.20                       |                                   | 21.10                                   |
| AVERAGE | 4.34                | 4.24                        |                                   | 4.22                                    |

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414410 Z 0  
FILE DATE AND TIME: 02/03/2005 09:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

|                                                             |        |
|-------------------------------------------------------------|--------|
| The Average X Centroid of the Five Target Set:              | -0.018 |
| The Average Y Centroid of the Five Target Set:              | -0.033 |
| The Average Point of Impact of the Five Target Set:         | 0.037  |
| The Average Mean Radius of the Five Target Set:             | 0.576  |
| The Distance from POA to Centroid Target #1:                | 0.064  |
| The Distance from Centroid Target #2 to Centroid Target #1: | 0.110  |
| The Distance from Centroid Target #3 to Centroid Target #1: | 0.074  |
| The Distance from Centroid Target #4 to Centroid Target #1: | 0.099  |
| The Distance from Centroid Target #5 to Centroid Target #1: | 0.043  |

SERIAL NUMBER: G6414410. \_\_0

TARGET NUMBER: 1

FILE DATE: 02/03/2005

FILE TIME: 09:22

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.207  | -0.724 |
| 2:     | 0.813  | -0.548 |
| 3:     | 0.755  | -0.011 |
| 4:     | 0.257  | 0.211  |
| 5:     | -0.071 | -0.063 |
| 6:     | -0.733 | -0.380 |
| 7:     | -0.942 | 0.120  |
| 8:     | -0.290 | 0.435  |
| 9:     | -0.604 | 0.420  |
| 10:    | 0.046  | 0.072  |

X CENTROID: 0.044

Y CENTROID: -0.047

POA TO CENTROID: 0.064

HORZ SPREAD: 2.149

VERT SPREAD: 1.159

GROUP SPREAD: 2.309

MIN RADIUS: 0.116

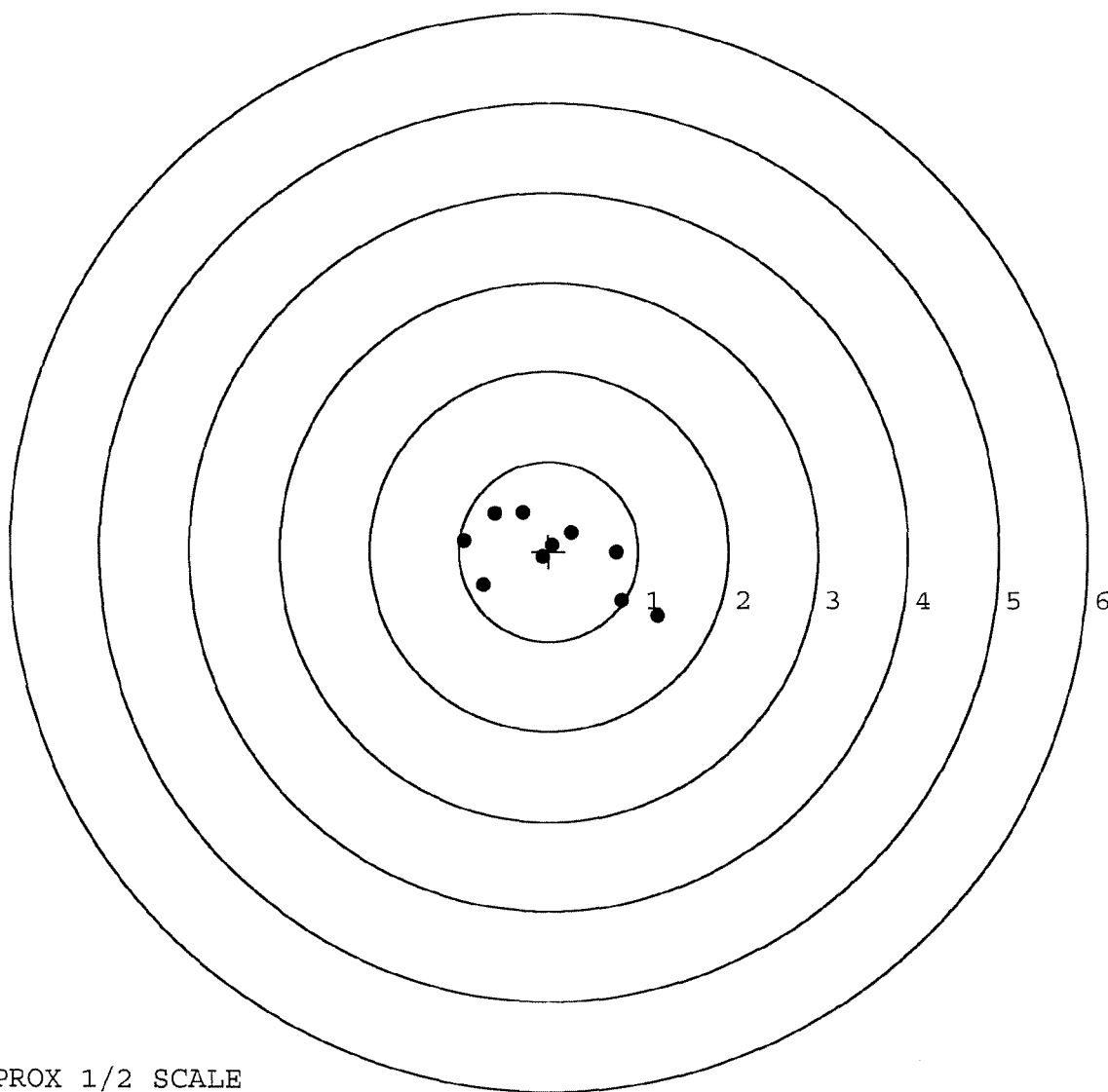
MAX RADIUS: 1.346

MEAN RADIUS: 0.678

# IN 1 IN DIAMETER: 3

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414410.\_\_\_0

TARGET NUMBER: 2

FILE DATE: 02/03/2005

FILE TIME: 09:22

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.383  | -0.592 |
| 2:     | 0.202  | -0.335 |
| 3:     | -0.245 | -0.503 |
| 4:     | -0.658 | -0.188 |
| 5:     | -0.330 | -0.021 |
| 6:     | -0.075 | -0.066 |
| 7:     | 0.409  | 0.172  |
| 8:     | -0.025 | 0.393  |
| 9:     | -0.133 | 1.012  |
| 10:    | -0.185 | -0.264 |

X CENTROID: -0.066

Y CENTROID: -0.039

POA TO CENTROID: 0.077

HORZ SPREAD: 1.067

VERT SPREAD: 1.604

GROUP SPREAD: 1.685

MIN RADIUS: 0.028

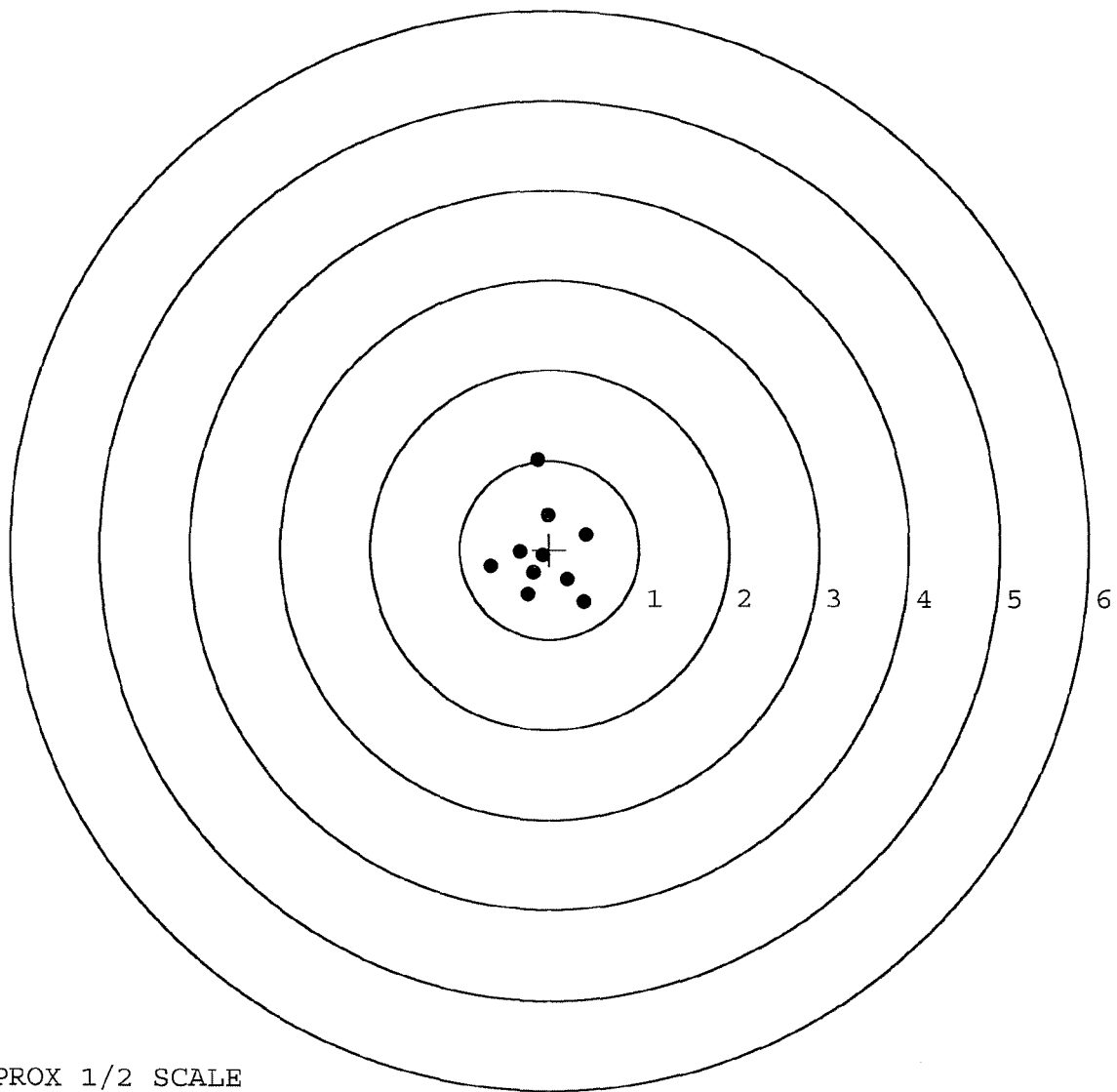
MAX RADIUS: 1.053

MEAN RADIUS: 0.477

# IN 1 IN DIAMETER: 6

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10

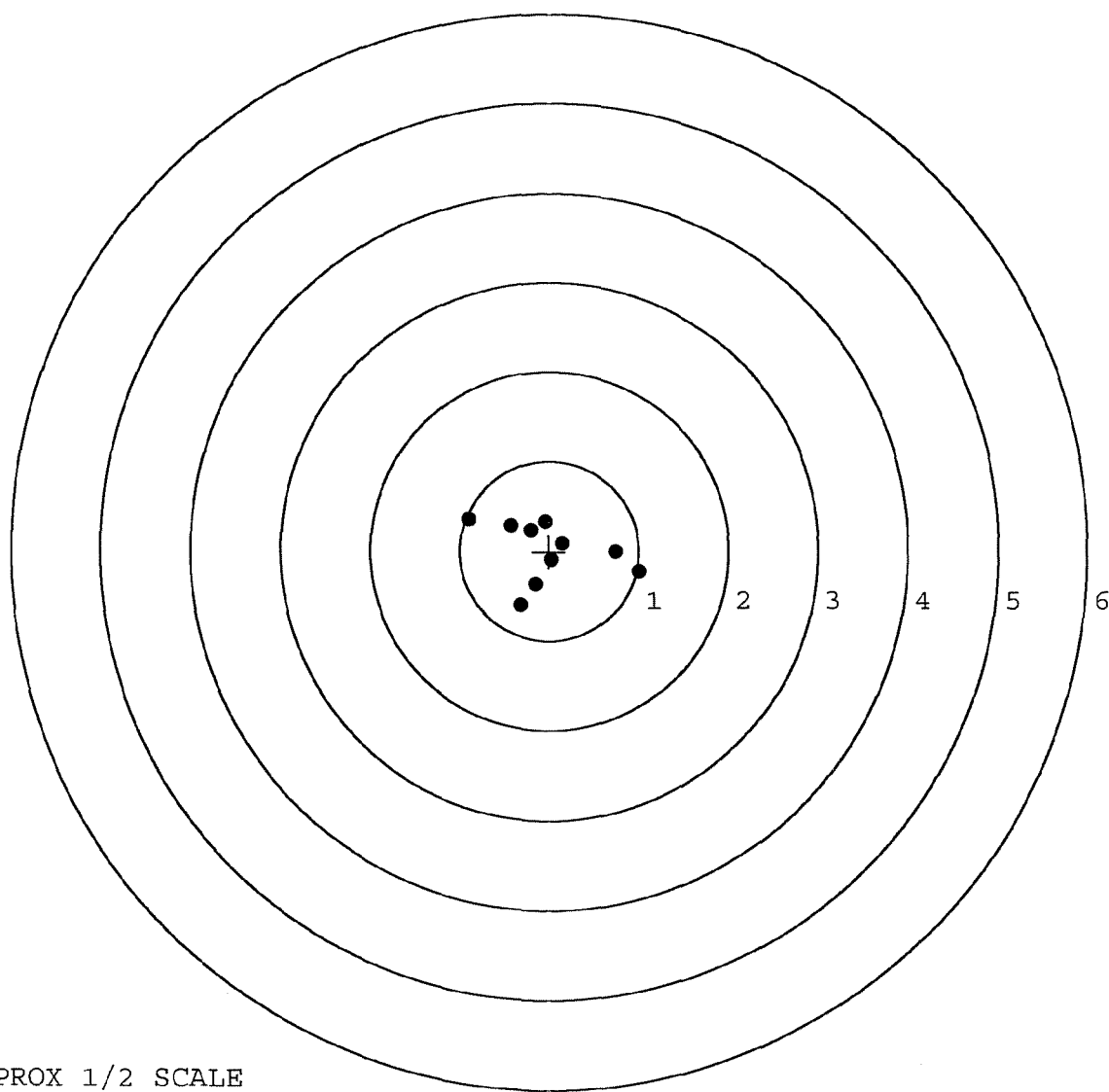


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414410. \_\_0  
TARGET NUMBER: 3  
FILE DATE: 02/03/2005  
FILE TIME: 09:22

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 1.006  | -0.227 |
| 2:     | 0.744  | -0.010 |
| 3:     | -0.325 | -0.608 |
| 4:     | -0.156 | -0.369 |
| 5:     | -0.902 | 0.354  |
| 6:     | 0.029  | -0.096 |
| 7:     | 0.148  | 0.087  |
| 8:     | -0.051 | 0.333  |
| 9:     | -0.210 | 0.238  |
| 10:    | -0.431 | 0.285  |

X CENTROID: -0.015  
Y CENTROID: -0.001  
POA TO CENTROID: 0.015  
HORZ SPREAD: 1.908  
VERT SPREAD: 0.962  
GROUP SPREAD: 1.994  
MIN RADIUS: 0.104  
MAX RADIUS: 1.045  
MEAN RADIUS: 0.528  
# IN 1 IN DIAMETER: 5  
# IN 2 IN DIAMETER: 9  
# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414410. \_\_0

TARGET NUMBER: 4

FILE DATE: 02/03/2005

FILE TIME: 09:22

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.363  | -0.910 |
| 2:     | 0.140  | -0.595 |
| 3:     | -0.402 | -0.731 |
| 4:     | -0.822 | -0.470 |
| 5:     | 0.523  | 0.811  |
| 6:     | 0.054  | -0.106 |
| 7:     | 0.180  | 0.090  |
| 8:     | 0.089  | 0.556  |
| 9:     | -0.149 | 0.621  |
| 10:    | -0.503 | 0.475  |

X CENTROID: -0.053

Y CENTROID: -0.026

POA TO CENTROID: 0.059

HORZ SPREAD: 1.345

VERT SPREAD: 1.721

GROUP SPREAD: 1.857

MIN RADIUS: 0.133

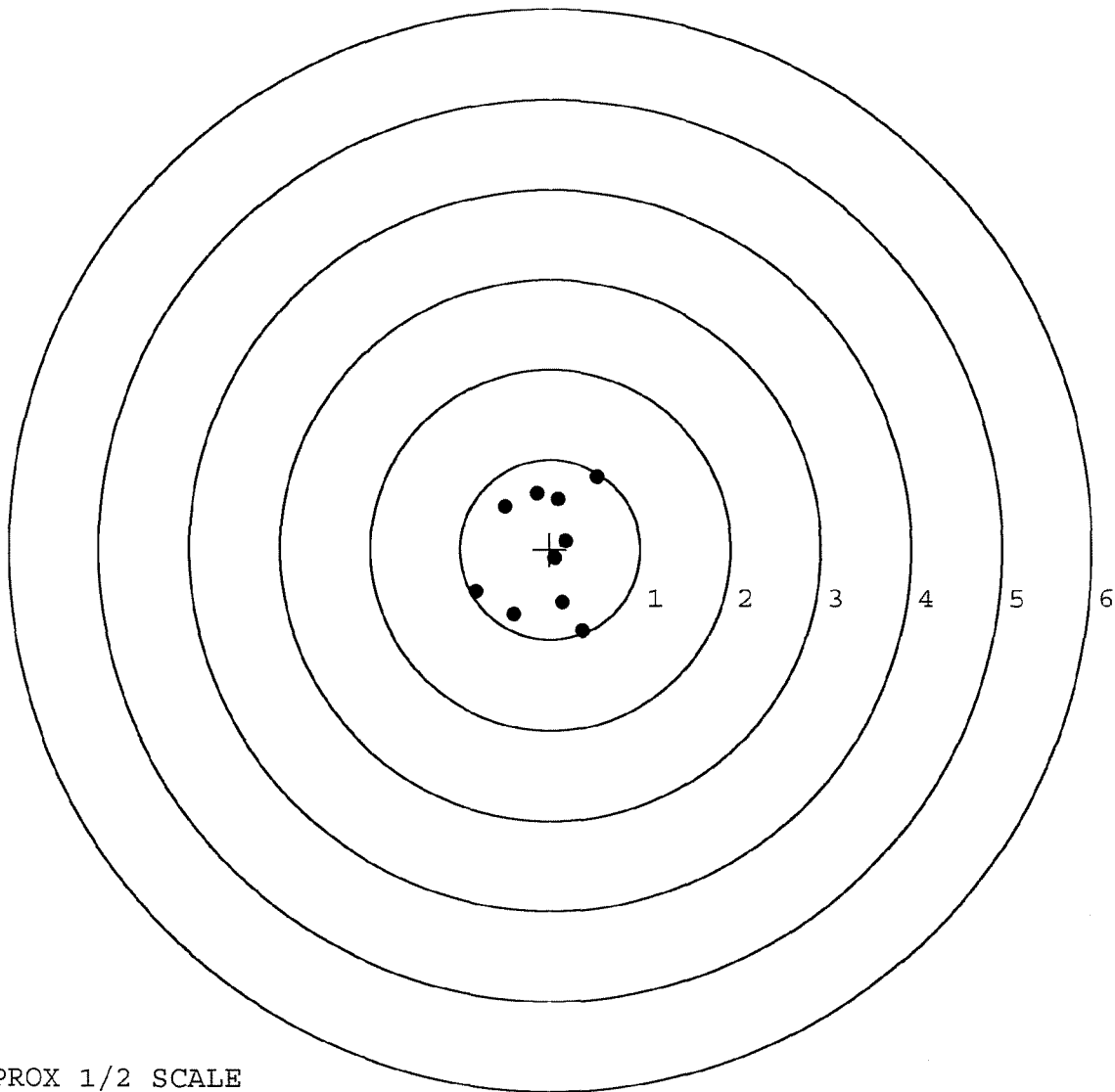
MAX RADIUS: 1.016

MEAN RADIUS: 0.659

# IN 1 IN DIAMETER: 2

# IN 2 IN DIAMETER: 9

# in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414410. 0

TARGET NUMBER: 5

FILE DATE: 02/03/2005

FILE TIME: 09:22

X CENTROID: 0.001

Y CENTROID: -0.051

POA TO CENTROID: 0.051

HORZ SPREAD: 1.662

VERT SPREAD: 1.135

GROUP SPREAD: 1.760

MIN RADIUS: 0.136

MAX RADIUS: 0.925

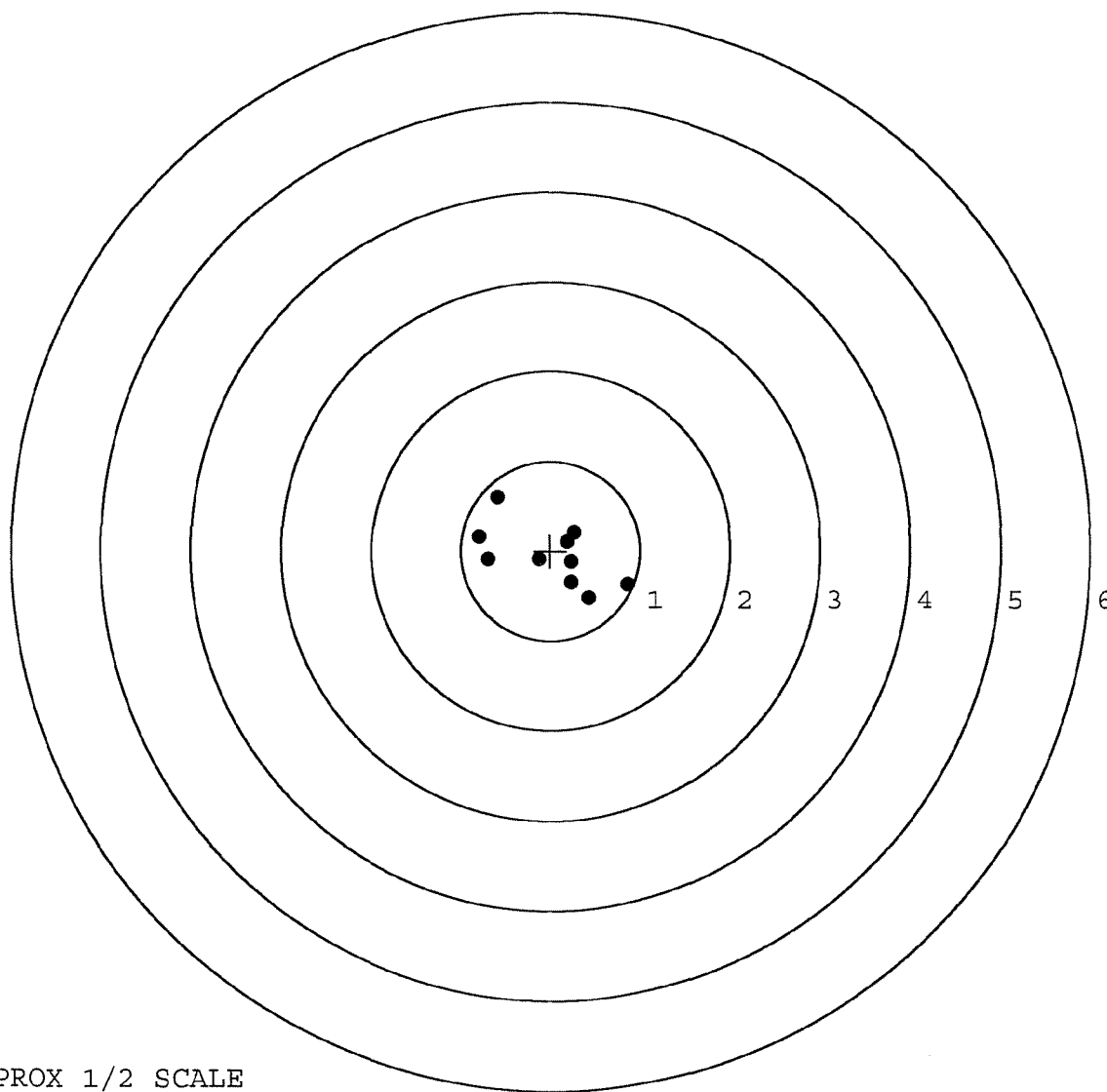
MEAN RADIUS: 0.537

# IN 1 IN DIAMETER: 5

# IN 2 IN DIAMETER: 10

# in 3 IN DIAMETER: 10

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.864  | -0.383 |
| 2:     | -0.695 | -0.096 |
| 3:     | -0.798 | 0.163  |
| 4:     | -0.595 | 0.602  |
| 5:     | 0.269  | 0.213  |
| 6:     | 0.187  | 0.104  |
| 7:     | -0.128 | -0.094 |
| 8:     | 0.238  | -0.357 |
| 9:     | 0.430  | -0.533 |
| 10:    | 0.235  | -0.124 |



TARGET APPROX 1/2 SCALE