

G-636 0963

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM 200348

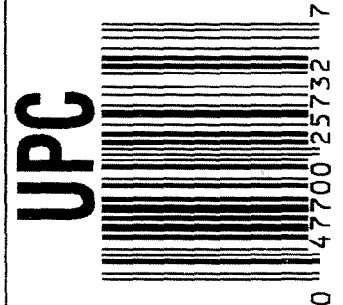


ORDER NO. **25732**

BARREL LENGTH **24"**

CAPACITY **5**

G6360963





ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



SERIAL NO.



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G62360963

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-1-04	RJL
600	PROOF		4-1-04	RJL
607	CHECK HEADSPACE	MAGNA-FLUX/	4-1-04	RJL
610	DIS-ASSEMBLE GUN	INSPECTED	4-1-04	RJL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>RJL</u>		
615	ROLLMARK CALIBER		4/5/04	ds
617	DRILL AND TAP SIGHT HOLES		4-2-04	TRW
620	APPLY COATINGS (BARREL ACTION)		4-7	TA
	(BOLT)		4-7	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		5-6-04	RJL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		5-6-04	LR
	C) INSPECT EJECTOR HOLE FOR CHAMFER		5-6-04	RJL
	D) OIL FIRING PIN ASSEMBLY		5-6-04	RJL
	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>7.25</u> <u>7.25</u> <u>8.0</u>	5-11-04	RTL
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.25</u> <u>3.0</u> <u>2.25</u>	5-11-04	RTL
	H) TRIGGER PULL TEST AND RETAINABILITY		5-11-04	RTL
	I) FIRING PIN INDENT .020 MIN	<u>0.24</u> <u>0.24</u> <u>0.23</u>	5-11-04	RTL
	J) ASSEMBLE STOCK		5-16-04	RTL
	K) ASSEMBLE SWIVEL STUDS		5-12-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	PASS FAIL	5-10-04	TRW
	MALFUNCTION	CORRECTION	5-10-04	TRW
	MALFUNCTION	CORRECTION	5-10-04	TRW
	MALFUNCTION	CORRECTION	5-10-04	TRW
	MALFUNCTION	CORRECTION	5-10-04	TRW
645	INSPECT FOR LIVE AMMO		5-10-04	TRW
655	FINAL INSPECTION A) HEADSPACE		5-12-04	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.66</u> <u>2.67</u> <u>2.77</u> <u>2.71</u> <u>2.67</u>	5/11/04	DA
	C) FUNCTION		5-12-04	RTL
660	PACK		5/12/04	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

BARBER M24 0083109

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

TESTER

4-28-04

RW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.34	2.35		2.30	
PULL #2	2.39	2.31		2.30	
PULL #3	2.34	2.34		2.25	
PULL #4	2.43	2.34		2.22	
PULL #5	2.43	2.32		2.26	
TOTAL	11.93	11.66		11.33	
AVERAGE	2.39	2.33		2.27	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.01	3.10		
PULL #2	3.10	3.11		
PULL #3	3.19	3.15		
PULL #4	3.12	3.00		
PULL #5	3.11	3.09		
TOTAL	15.53	15.45		
AVERAGE	3.11	3.09		

	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	4.23		4.14
PULL #2	4.09	4.19		4.29
PULL #3	4.29	4.17		4.19
PULL #4	4.31	4.18		4.25
PULL #5	4.25	4.13		4.22
TOTAL	21.26	20.90		21.09
AVERAGE	4.25	4.18		4.22

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360963.__0
FILE DATE AND TIME: 05/10/2004 10:23

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

ERROR - NOT POSSIBLE TO REPORT SWS STATS ON DATA
WHERE TOTAL TARGETS ARE NOT EQUAL TO FIVE

Ave. MEAN - .586

SERIAL NUMBER: G6360963. 0

TARGET NUMBER: 1

FILE DATE: 05/10/2004

FILE TIME: 10:23

POINT#	X	Y
1:	-0.009	-0.630
2:	-0.130	-0.884
3:	0.229	0.179
4:	0.073	0.365
5:	-0.516	0.498

X CENTROID: -0.071

Y CENTROID: -0.094

POA TO CENTROID: 0.118

HORZ SPREAD: 0.745

VERT SPREAD: 1.382

GROUP SPREAD: 1.435

MIN RADIUS: 0.406

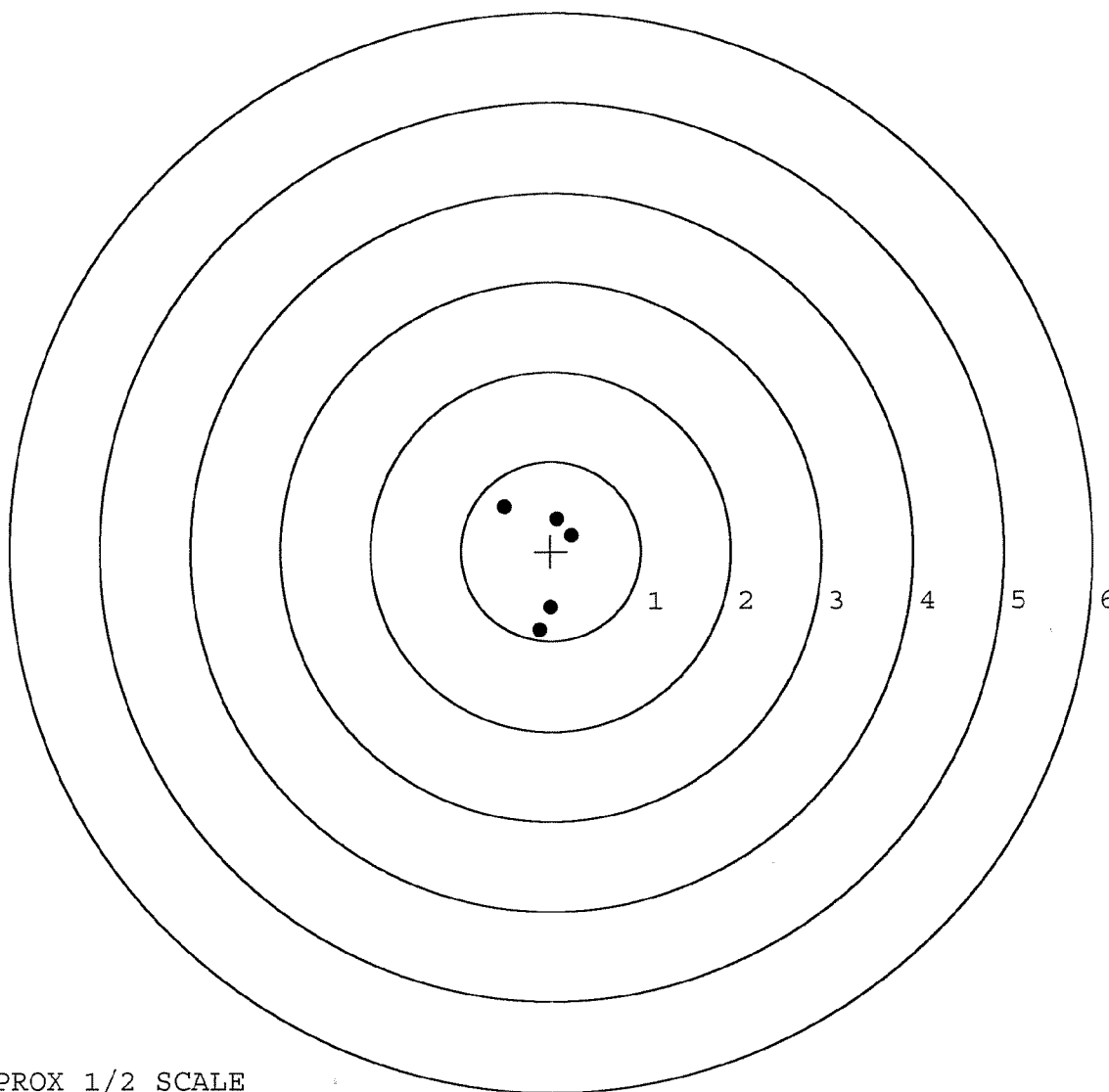
MAX RADIUS: 0.792

MEAN RADIUS: 0.592

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360963. 0

TARGET NUMBER: 2

FILE DATE: 05/10/2004

FILE TIME: 10:23

POINT#	X	Y
1:	0.605	-0.326
2:	-0.123	-0.714
3:	-0.336	0.024
4:	-0.229	0.499
5:	-0.022	0.570

X CENTROID: -0.021

Y CENTROID: 0.011

POA TO CENTROID: 0.024

HORZ SPREAD: 0.941

VERT SPREAD: 1.284

GROUP SPREAD: 1.288

MIN RADIUS: 0.315

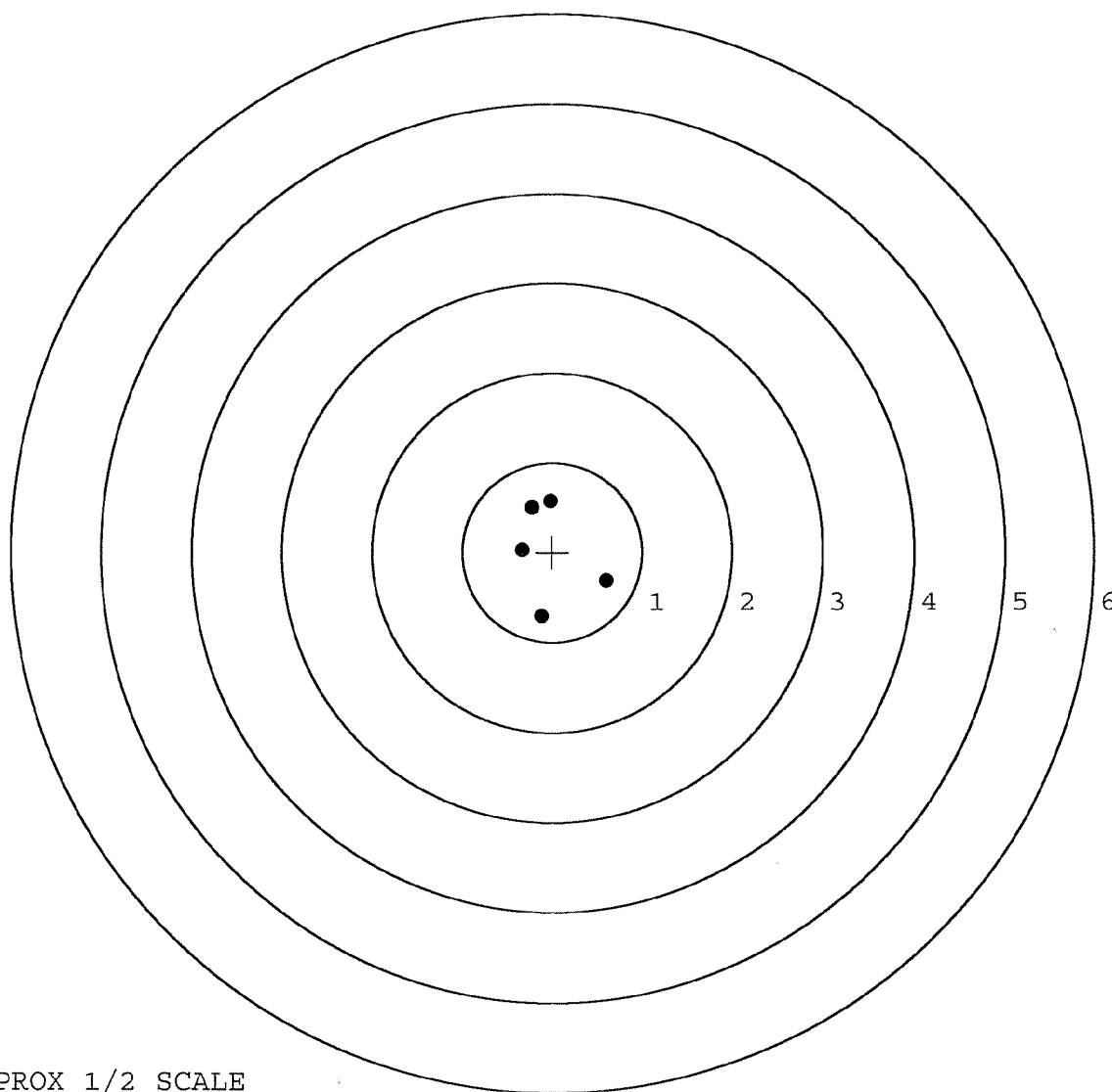
MAX RADIUS: 0.732

MEAN RADIUS: 0.570

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE