

G6414361

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

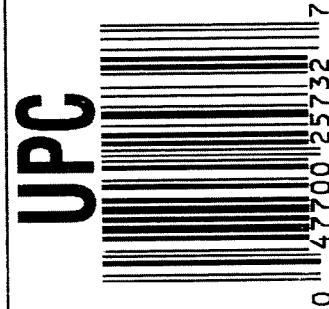
- INSTRUCTION BOOK 3518

DD FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5

G6414361



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC

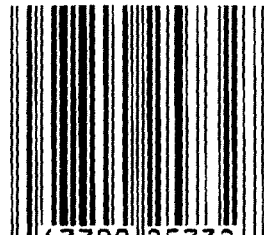


0 47700 25732 7

ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



0 47700 25732 7

SERIAL NO.



66414361

10/27/2004 11:07:03 AM

Original

91

Original

25732

M/24 7.62 NATO (RIFLE ONLY)



.MA25732

Shop Order: SWS5732 - NOV



.ABSWS5732 - NOV

Start Date: 10/4/2004

Finish Date: 11/18/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003516940

0560

Reassemble Action.

89SWS1



0003516941

0690

Pack Rifle

89SWS1



0003516952

0700

Stencil SWS Container

89SWS1



.OP0700

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414361

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-27-04	RTZ
600	PROOF		12-28-04	A
607	CHECK HEADSPACE		12-28-04	A
610	DIS-ASSEMBLE GUN		12-28-04	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		DEC 27 2004 OPERATOR	JO
615	ROLLMARK CALIBER		12-29-04	AS
617	DRILL AND TAP SIGHT HOLES		12-28-04	TRW
620	APPLY COATINGS (BARREL ACTION)		1/5/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-10-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-10-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-21-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-11-05	RTZ
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

OP #	OPERATION NAME	BARBER - M24 0150952	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE	2 LBS MIN 10 LBS MAX	<u>5.5</u> <u>6.5</u> <u>5.5</u>	1-21-05	DA
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>3.0</u> <u>3.5</u> <u>3.5</u>	1-21-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>1.024</u> <u>1.023</u> <u>1.0245</u>	1-21-05	DA
	J) ASSEMBLE STOCK			1-11-05	RT
	K) ASSEMBLE SWIVEL STUDS			1-21-05	RT
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		N.A.		
	M) IRON SIGHT ALIGNMENT				
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				
	GALLERY TEST AND				
640	TARGET		PASS FAIL	1-20-05	TRW
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
	MALFUNCTION		CORRECTION		
645	INSPECT FOR LIVE AMMO			1-20-05	TRW
655	FINAL INSPECTION A) HEADSPACE			1-21-05	RT
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.92</u> <u>2.92</u> <u>2.83</u> <u>2.89</u> <u>2.92</u>	1-21-05	DA
	C) FUNCTION			1-21-05	RT
660	PACK			1-22-05	DA

AVERAGE PULL FORCE BETWEEN

SERIAL NO.

INITIAL TESTS
BARBER - M24 0150953

2.50 LBS (plus or minus 0.50 LBS)

DATE 11-15-04

3.00 LBS (plus or minus 0.75 LBS)

TESTER TRW

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.50	2.71		2.72	
PULL #2	2.71	2.70		2.72	
PULL #3	2.61	2.69		2.70	
PULL #4	2.62	2.73		2.70	
PULL #5	2.65	2.69		2.72	
TOTAL	13.09	13.52		13.56	
AVERAGE	2.61	2.70		2.71	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.46		
PULL #2	3.45	3.41		
PULL #3	3.38	3.35		
PULL #4	3.43	3.34		
PULL #5	3.49	3.28		
TOTAL	17.23	16.84		
AVERAGE	3.44	3.36		

	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	4.37	4.30		4.21
PULL #2	4.32	4.25		4.17
PULL #3	4.18	4.22		4.42
PULL #4	4.45	4.17		4.23
PULL #5	4.11	4.19		4.27
TOTAL	21.43	21.13		21.30
AVERAGE	4.28	4.22		4.26

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414361. __0
FILE DATE AND TIME: 01/20/2005 09:11

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 .748

SERIAL NUMBER: G6414361. __ 0

TARGET NUMBER: 1

FILE DATE: 01/20/2005

FILE TIME: 09:11

POINT#	X	Y
1:	1.315	0.424
2:	-0.078	-0.912
3:	-0.178	-0.364
4:	0.118	0.165
5:	-0.010	1.391

X CENTROID: 0.233

Y CENTROID: 0.141

POA TO CENTROID: 0.273

HORZ SPREAD: 1.493

VERT SPREAD: 2.303

GROUP SPREAD: 2.304

MIN RADIUS: 0.118

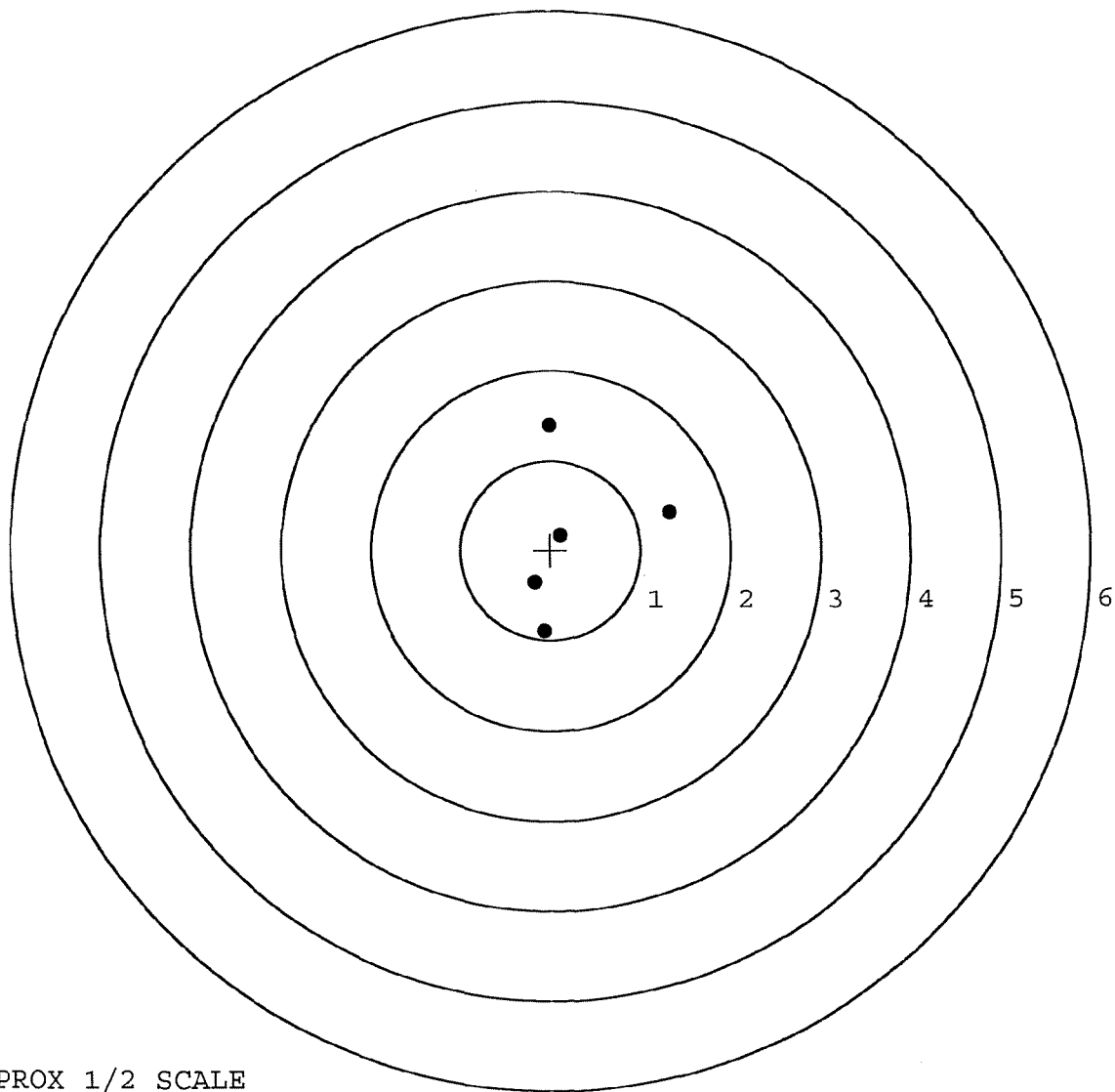
MAX RADIUS: 1.274

MEAN RADIUS: 0.852

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 2

in 3 IN DIAMETER: 5

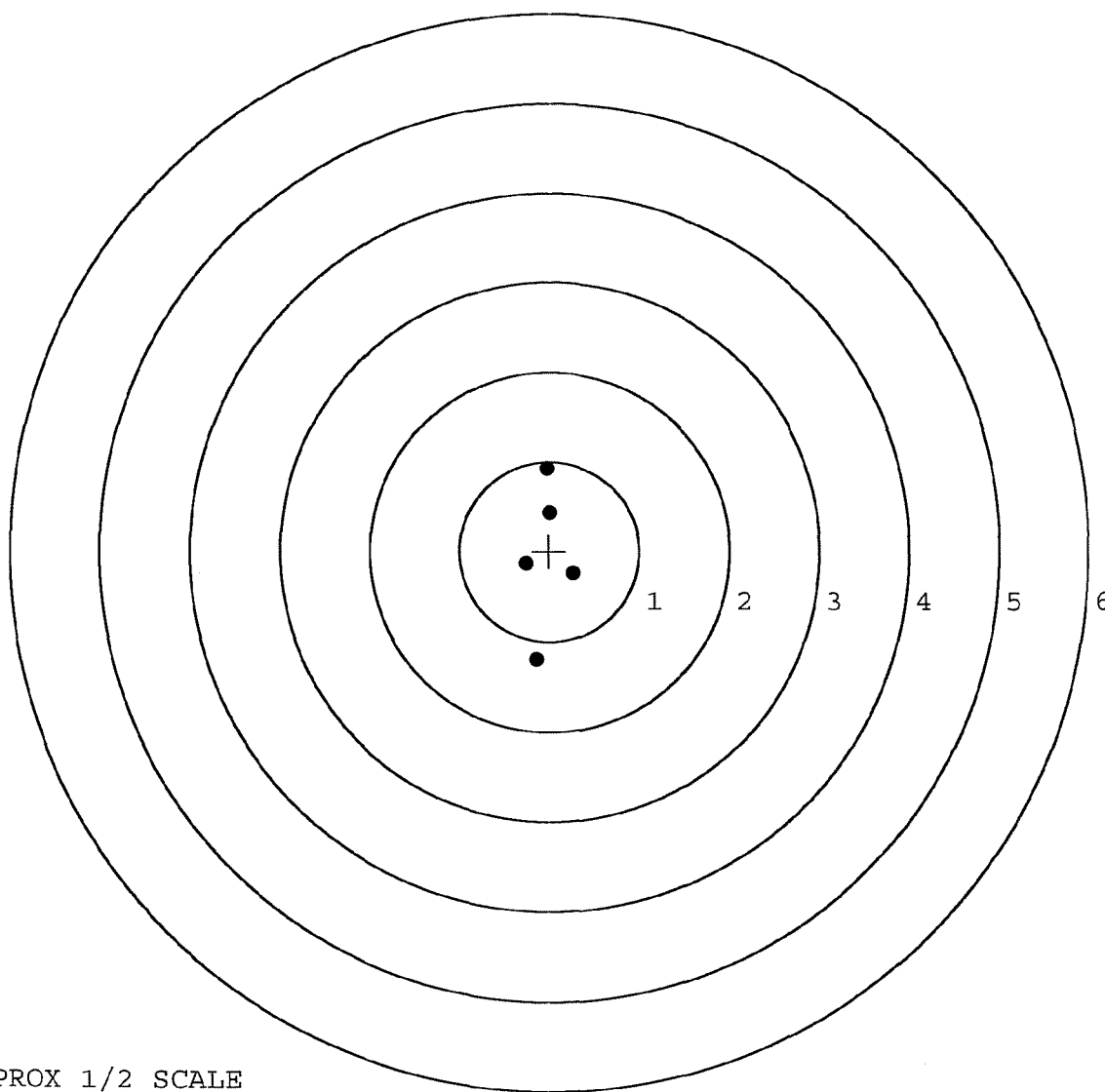


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414361. __ 0
 TARGET NUMBER: 2
 FILE DATE: 01/20/2005
 FILE TIME: 09:11

POINT#	X	Y
1:	-0.142	-1.201
2:	0.273	-0.253
3:	-0.255	-0.146
4:	0.001	0.433
5:	-0.028	0.921

X CENTROID: -0.030
 Y CENTROID: -0.049
 POA TO CENTROID: 0.058
 HORZ SPREAD: 0.528
 VERT SPREAD: 2.122
 GROUP SPREAD: 2.125
 MIN RADIUS: 0.245
 MAX RADIUS: 1.157
 MEAN RADIUS: 0.644
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 4
 # in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE