

G-6414381

M/24 7.62 NATO S.W.S (SCOPE & SIGHTS)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM 1651

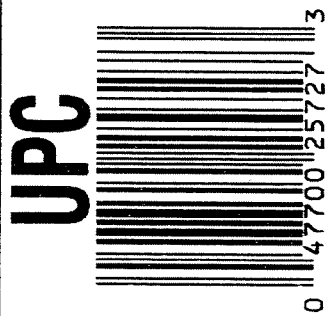


ORDER NO. **25727**

BARREL LENGTH **24"**

CAPACITY **5**

G6414381



ORDER — 25727

M/24 7.62 NATO S.W.S (SCOPE & SIGHTS

UPC



ORDER 25727

M/24 7.62 NATO S.W.S (SCOPE & SIGHTS

UPC



SERIAL NO.



66414381

12/10/2004 1:21:34 PM

Original

3

Crib

25727

M/24 7.62 NATO (RIFLE W/SCOPE&SIGHTS)



.MA25727

Shop Order: SWS667663A



.ABSWS667663A

Start Date: 12/17/2004

Finish Date: 1/12/2005

0540

Flat Black Powder Coat, Barrel and

01PC001



0003592015

0560

Reassemble Action.

89SWS1



0003592016

0690

Pack Rifle

89SWS1



0003592027

0700

Stencil SWS Container

89SWS1



.OP0700

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66414381

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		10-19-04	RTL
600	PROOF			
607	CHECK HEADSPACE		MAGNA-FLUX INSPECTED	
610	DIS-ASSEMBLE GUN		001 2 4 (00)	
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		OPERATOR	W
615	ROLLMARK CALIBER		10/27/04	B
617	DRILL AND TAP SIGHT HOLES		10-22-04	TRW
620	APPLY COATINGS (BARREL ACTION)		10/30	#0
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		11-9-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-9-04	LR
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-9-04	LR
	D) OIL FIRING PIN ASSEMBLY		11-9-04	LR
	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>	12-15-04	AC
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	12-15-04	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		12-17-04	RTZ
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.022</u> <u>.022</u>	12-15-04	A
	J) ASSEMBLE STOCK		11-9-04	RTZ
	K) ASSEMBLE SWIVEL STUDS		12-14-04	LR
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-14-04	LR
	M) IRON SIGHT ALIGNMENT		12-14-04	LR
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-14-04	RTZ
640	GALLERY TEST AND TARGET	PASS FAIL	12-14-04	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		12-14-04	TRW
655	FINAL INSPECTION A) HEADSPACE		12-17-04	RTZ
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.86</u> <u>2.94</u> <u>2.83</u> <u>2.75</u> <u>2.67</u>	12/15/04	DA
	C) FUNCTION		12-17-04	RTZ
660	PACK		12/17/04	DA

AVERAGE PULL FORCE BETWEEN
INITIAL **BARBER - M24 0151376**

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

8-9-04

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.38	2.39		2.69	
PULL #2	2.56	2.61		2.92	
PULL #3	2.65	2.86		2.84	
PULL #4	2.60	2.79		2.92	
PULL #5	2.59	2.67		2.72	
TOTAL	12.78	13.32		14.09	
AVERAGE	2.55	2.66		2.81	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.18		
PULL #2	3.22	3.23		
PULL #3	2.95	3.33		
PULL #4	3.41	3.22		
PULL #5	3.49	3.22		
TOTAL	16.25	16.18		
AVERAGE	3.25	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	4.39	4.10		4.36
PULL #2	4.42	4.32		4.42
PULL #3	4.45	4.30		4.39
PULL #4	4.21	4.36		4.43
PULL #5	4.39	4.32		4.47
TOTAL	21.86	21.40		22.07
AVERAGE	4.37	4.28		4.41

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414381. __0
FILE DATE AND TIME: 12/14/2004 11:25

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.008
The Average Y Centroid of the Five Target Set:	-0.058
The Average Point of Impact of the Five Target Set:	0.059
The Average Mean Radius of the Five Target Set:	0.687
The Distance from POA to Centroid Target #1:	0.022
The Distance from Centroid Target #2 to Centroid Target #1:	0.180
The Distance from Centroid Target #3 to Centroid Target #1:	0.078
The Distance from Centroid Target #4 to Centroid Target #1:	0.079
The Distance from Centroid Target #5 to Centroid Target #1:	0.261

BARBER - M24 0151378

SERIAL NUMBER: G6414381: 0

TARGET NUMBER: 1

FILE DATE: 12/14/2004

FILE TIME: 11:25

POINT#	X	Y
1:	0.664	0.427
2:	0.371	0.051
3:	0.566	0.735
4:	-0.003	0.213
5:	-0.187	0.067
6:	-0.213	-0.178
7:	0.095	-0.479
8:	-0.215	-0.691
9:	-0.284	-0.341
10:	-0.876	-0.013

X CENTROID: -0.008

Y CENTROID: -0.021

POA TO CENTROID: 0.022

HORZ SPREAD: 1.540

VERT SPREAD: 1.426

GROUP SPREAD: 1.626

MIN RADIUS: 0.199

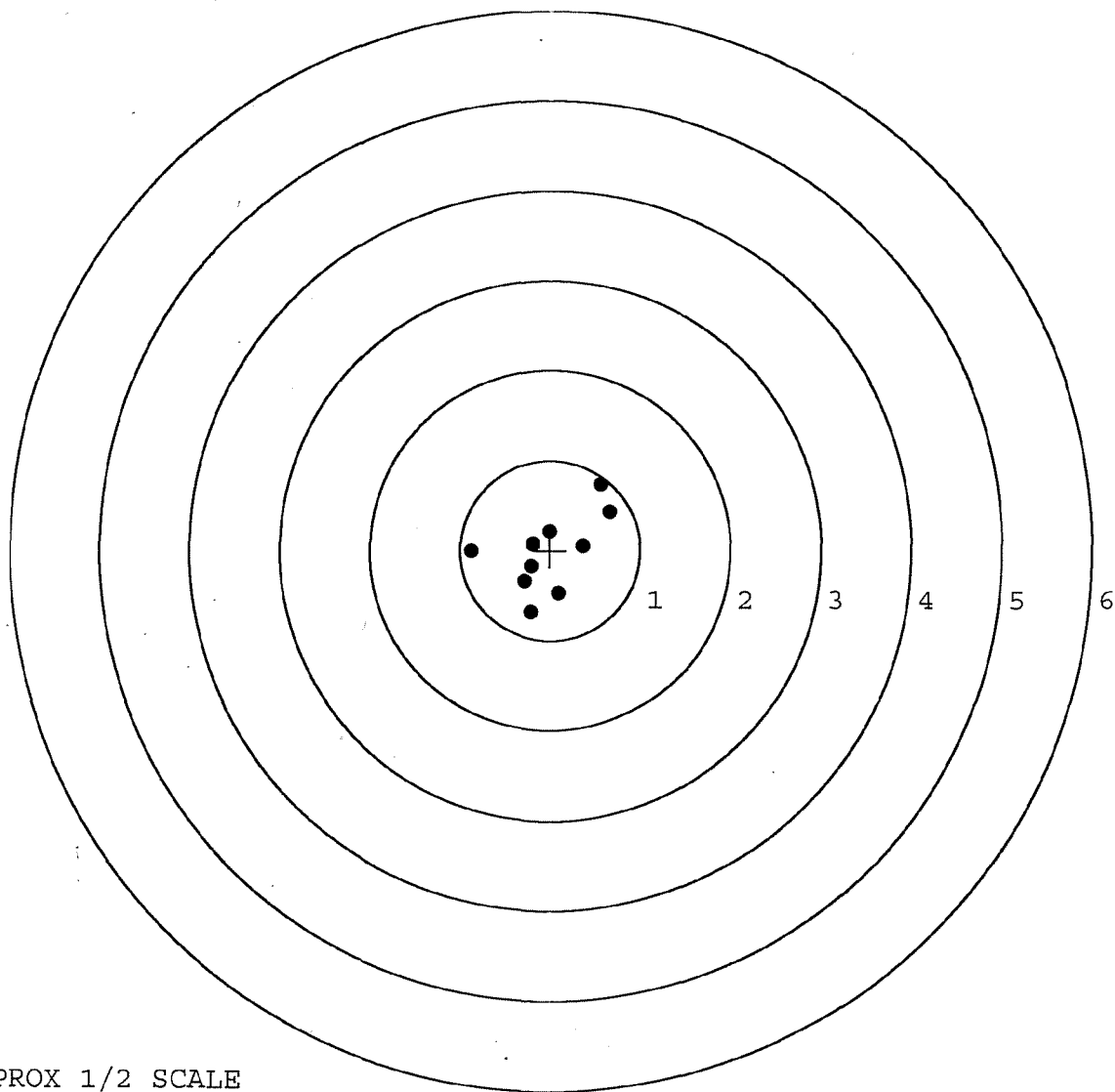
MAX RADIUS: 0.949

MEAN RADIUS: 0.530

IN 1 IN DIAMETER: 6

IN 2 IN DIAMETER: 10

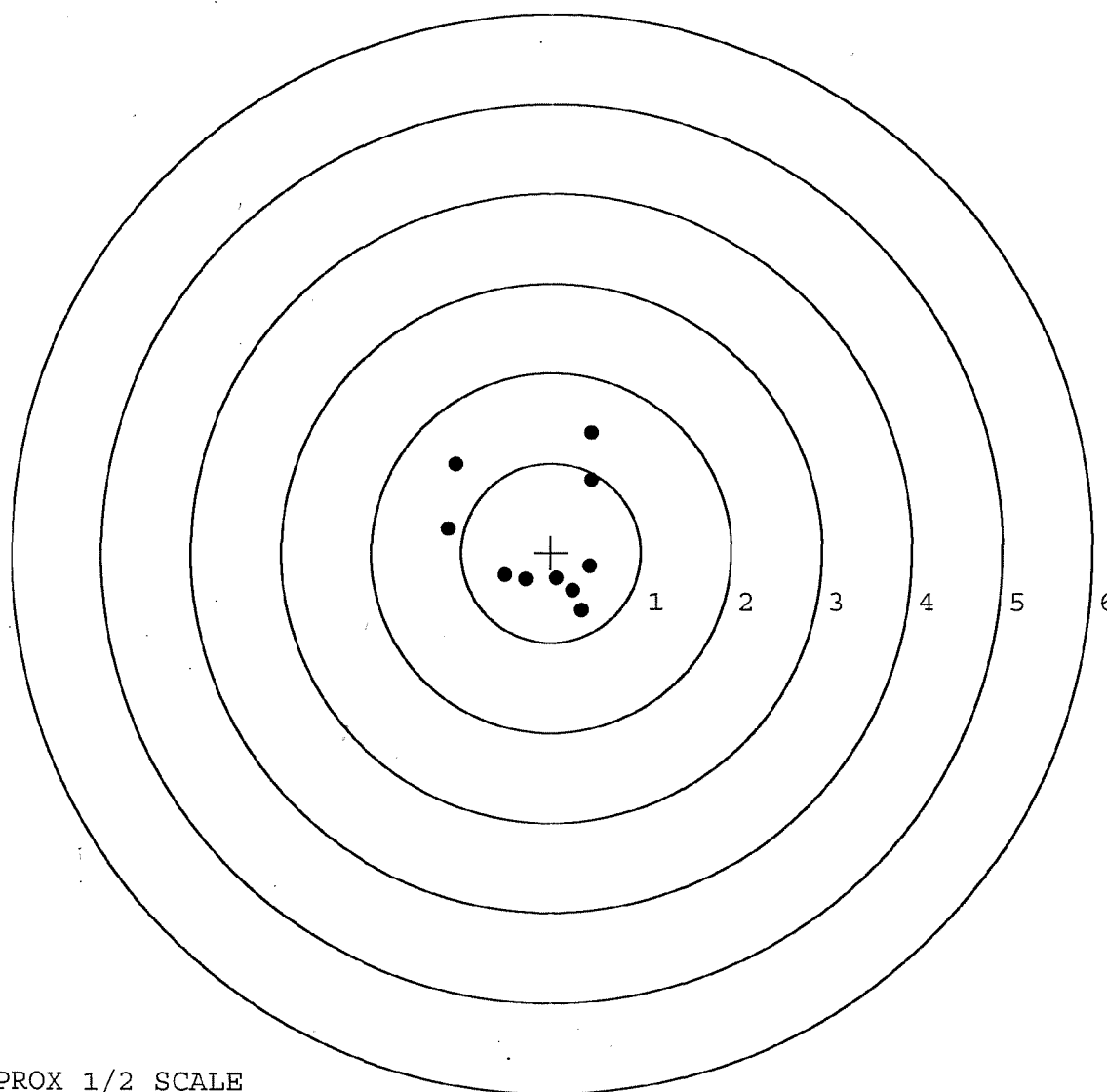
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0151379

SERIAL NUMBER: G6414381:___0	POINT#	X	Y
TARGET NUMBER: 2	1:	0.459	0.812
FILE DATE: 12/14/2004	2:	0.450	1.339
FILE TIME: 11:25	3:	-1.064	0.990
	4:	-1.153	0.270
X CENTROID: -0.102	5:	-0.519	-0.254
Y CENTROID: 0.132	6:	-0.283	-0.302
POA TO CENTROID: 0.167	7:	0.061	-0.292
HORZ SPREAD: 1.612	8:	0.436	-0.155
VERT SPREAD: 1.992	9:	0.246	-0.432
GROUP SPREAD: 1.995	10:	0.344	-0.653
MIN RADIUS: 0.455			
MAX RADIUS: 1.327			
MEAN RADIUS: 0.823			
# IN 1 IN DIAMETER: 2			
# IN 2 IN DIAMETER: 7			
# in 3 IN DIAMETER: 10			



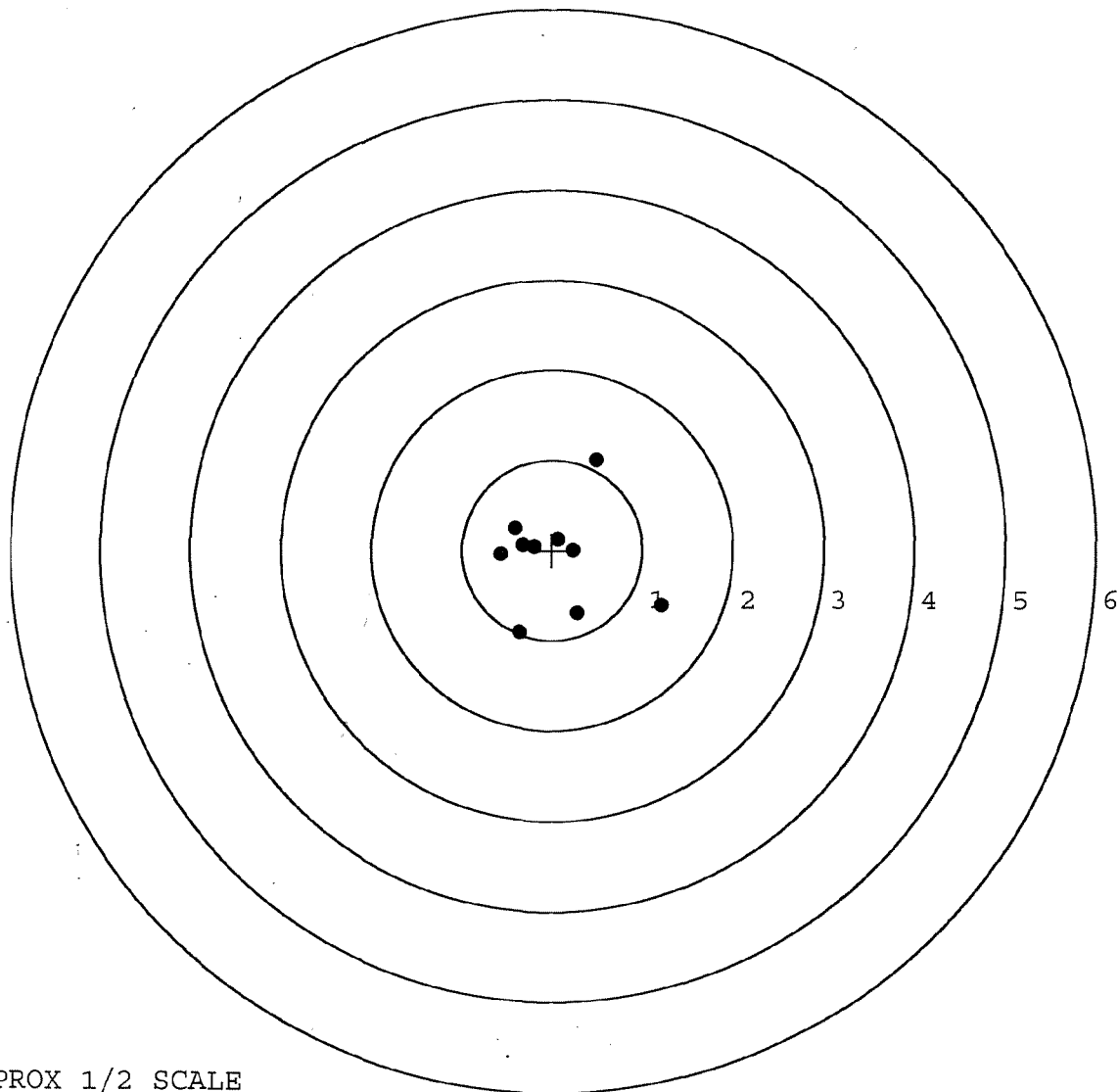
TARGET APPROX 1/2 SCALE

BARBER - M24 0151380

SERIAL NUMBER: G6414381: 0
 TARGET NUMBER: 3
 FILE DATE: 12/14/2004
 FILE TIME: 11:25

POINT#	X	Y
1:	1.210	-0.615
2:	0.282	-0.704
3:	-0.363	-0.916
4:	0.487	0.996
5:	0.237	0.002
6:	0.068	0.122
7:	-0.200	0.043
8:	-0.417	0.246
9:	-0.573	-0.047
10:	-0.323	0.063

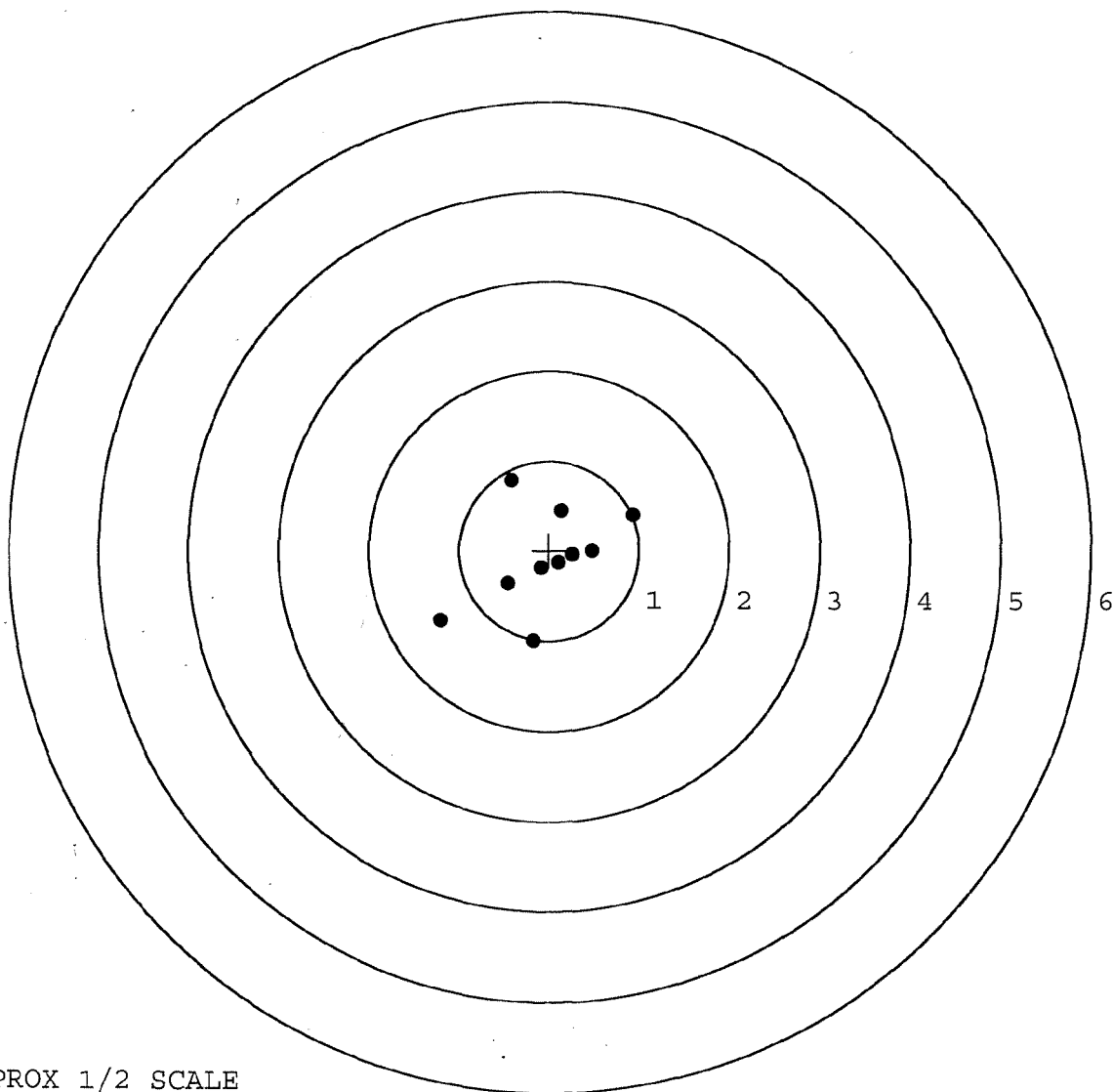
X CENTROID: 0.041
 Y CENTROID: -0.081
 POA TO CENTROID: 0.091
 HORZ SPREAD: 1.783
 VERT SPREAD: 1.912
 GROUP SPREAD: 1.871
 MIN RADIUS: 0.205
 MAX RADIUS: 1.285
 MEAN RADIUS: 0.630
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0151381

SERIAL NUMBER: G6414381: 0	POINT#	X	Y
TARGET NUMBER: 4	1:	-0.175	-1.013
FILE DATE: 12/14/2004	2:	-1.201	-0.781
FILE TIME: 11:25	3:	0.932	0.397
	4:	0.139	0.445
X CENTROID: -0.042	5:	-0.426	0.784
Y CENTROID: -0.093	6:	0.485	-0.002
POA TO CENTROID: 0.102	7:	0.265	-0.051
HORZ SPREAD: 2.133	8:	0.111	-0.136
VERT SPREAD: 1.797	9:	-0.093	-0.197
GROUP SPREAD: 2.437	10:	-0.455	-0.373
MIN RADIUS: 0.116			
MAX RADIUS: 1.348			
MEAN RADIUS: 0.651			
# IN 1 IN DIAMETER: 4			
# IN 2 IN DIAMETER: 8			
# in 3 IN DIAMETER: 10			

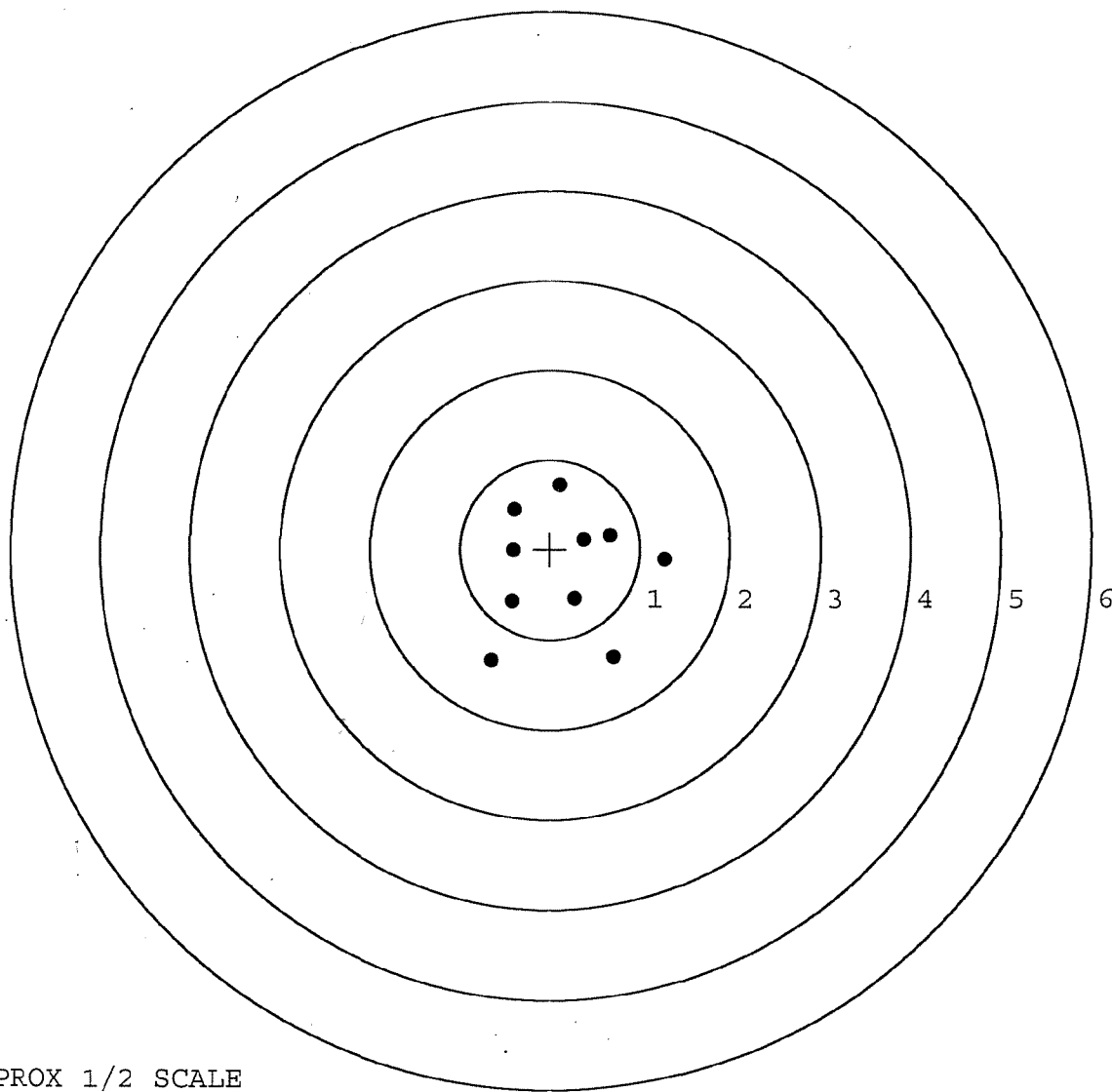


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414381: 0
 TARGET NUMBER: 5
 FILE DATE: 12/14/2004
 FILE TIME: 11:25

POINT#	X	Y
1:	0.708	-1.196
2:	1.268	-0.124
3:	0.664	0.150
4:	0.378	0.102
5:	0.277	-0.549
6:	-0.658	-1.233
7:	-0.423	-0.577
8:	-0.412	-0.018
9:	-0.402	0.444
10:	0.107	0.716

X CENTROID: 0.151
 Y CENTROID: -0.228
 POA TO CENTROID: 0.274
 HORZ SPREAD: 1.926
 VERT SPREAD: 1.949
 GROUP SPREAD: 2.222
 MIN RADIUS: 0.344
 MAX RADIUS: 1.290
 MEAN RADIUS: 0.800
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE