G-639/1982

25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

.MA25716

Shop Order: SWS631059

.ABSWS631059

Start Date: 8/9/2004
Finish Date: 10/26/2004

0540 01PC001
Flat Black Powder Coat, Barrel and

0003451403

0560 89SWS1
Reassemble Action.

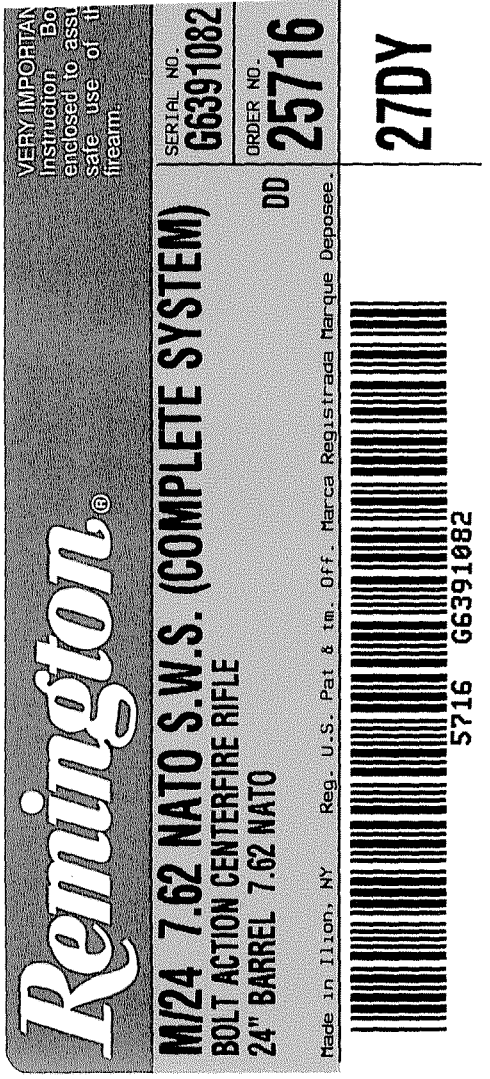
0003451404

0690 89SWS1
Pack Rifle

0003451397

0700 89SWS1
Stencil SWS Container

.OP0700



ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

UPC

0 47700 25716 7

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

UPC

0 47700 25716 7

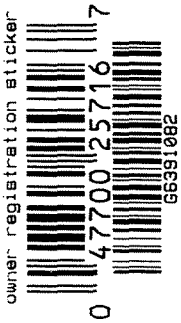
NO.

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

– INSTUCTION BOOK 3518

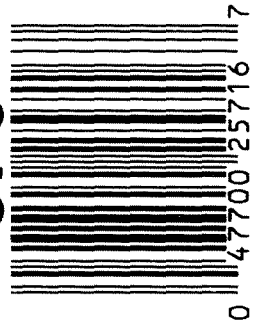
DD FORM



ORDER NO. 25716

BARREL LENGTH	24"
CAPACITY	6

G6391082



Original 36 crib

7/22/2004 3:21:04 PM

25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

.MA25716

Shop Order: SWS631055

.ABSWS631055

Start Date: 7/23/2004
Finish Date: 9/23/2004

0630 01PC00

Flat Black Powder Coat, Barrel and

0003338116

0640 89SWS1

Reassemble Action.

0003338117

0685 89SWS1

Attach Front and Rear Sight Assemblies

0003338122

0710 89SWS1

Pack Rifle & Stencil SWS Container

.OP0710

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6391082

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		6-15-04	RTL
600	PROOF		6-15-04	RTL
607	CHECK HEADSPACE		6-15-04	RTL
610	DIS-ASSEMBLE GUN		6-15-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR BS		
615	ROLLMARK CALIBER		6-16-04	SB
617	DRILL AND TAP SIGHT HOLES		6-15-04	RTL
620	APPLY COATINGS (BARREL ACTION)		6/28	HP
	(BOLT)		6/28	HP
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		7-7-04	RW
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-7-04	RW
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-7-04	RW
	D) OIL FIRING PIN ASSEMBLY		7-7-04	RW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		9-21-04	TKW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE [2 LBS MIN 10 LBS MAX]	7.5 8.0 7.0	8/16/04	DA
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	2.5 2.5 2.5	8/16/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.023 .025 .024	8/16/04	DA
	J) ASSEMBLE STOCK		7-8-04	RW
	K) ASSEMBLE SWIVEL STUDS		9-9-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-27-04	RTL
	M) IRON SIGHT ALIGNMENT		8-27-04	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-27-04	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	7-13-04	AC
	MALFUNCTION	CORRECTION	7-13-04	AC
	MALFUNCTION	CORRECTION	7-13-04	AC
	MALFUNCTION	CORRECTION	7-13-04	AC
	MALFUNCTION	CORRECTION	7-13-04	AC
645	INSPECT FOR LIVE AMMO		7-13-04	AC
655	FINAL INSPECTION A) HEADSPACE		9-9-04	RTL
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.90 2.93 2.84 2.84 2.92	8/16/04	DA
	C) FUNCTION		9-9-04	RTL
660	PACK		9/15/04	DA

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)

DATE 7-1-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.27	2.19		2.42	
PULL #2	2.28	2.42		2.33	
PULL #3	2.34	2.47		2.24	
PULL #4	2.21	2.46		2.52	
PULL #5	2.31	2.59		2.11	
TOTAL	11.41	12.13		11.62	
AVERAGE	2.28	2.42		2.32	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.06	3.10		
PULL #2	3.33	3.14		
PULL #3	3.24	3.33		
PULL #4	3.42	3.12		
PULL #5	3.11	3.06		
TOTAL	16.16	15.75		
AVERAGE	3.23	3.15		

	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	4.16	4.10		4.47
PULL #2	4.23	4.16		4.35
PULL #3	4.21	4.38		4.36
PULL #4	4.62	4.11		4.32
PULL #5	4.36	4.25		4.36
TOTAL	21.58	21.00		21.86
AVERAGE	4.31	4.20		4.37

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6391082.__0
FILE DATE AND TIME: 07/13/2004 06:40

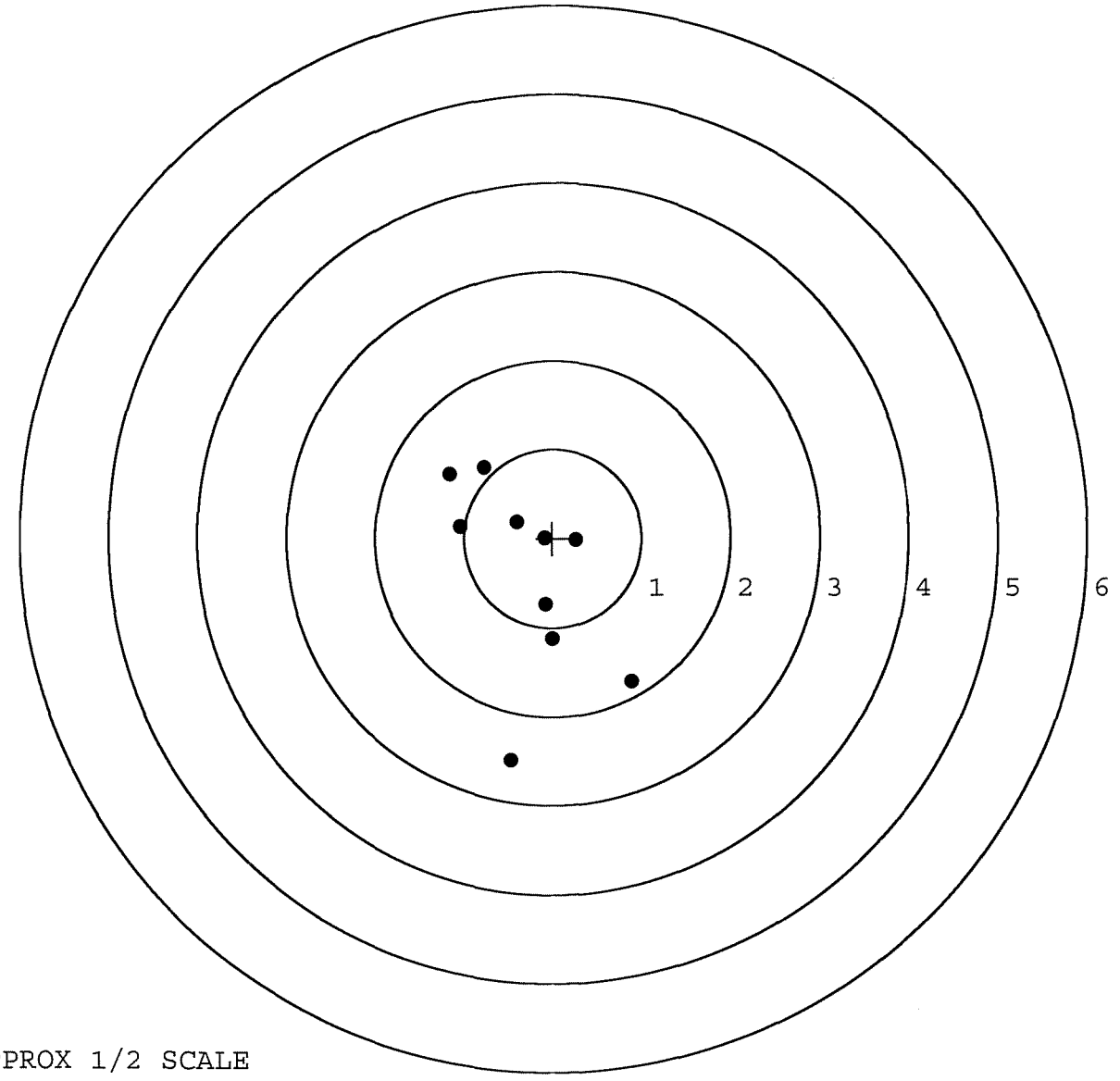
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.014
The Average Y Centroid of the Five Target Set:	-0.117
The Average Point of Impact of the Five Target Set:	0.118
The Average Mean Radius of the Five Target Set:	0.846
The Distance from POA to Centroid Target #1:	0.506
The Distance from Centroid Target #2 to Centroid Target #1:	0.826
The Distance from Centroid Target #3 to Centroid Target #1:	0.617
The Distance from Centroid Target #4 to Centroid Target #1:	0.340
The Distance from Centroid Target #5 to Centroid Target #1:	0.443

SERIAL NUMBER: G6391082.__0
TARGET NUMBER: 1
FILE DATE: 07/13/2004
FILE TIME: 06:40

X CENTROID:	-0.287
Y CENTROID:	-0.417
POA TO CENTROID:	0.506
HORZ SPREAD:	2.048
VERT SPREAD:	3.291
GROUP SPREAD:	3.305
MIN RADIUS:	0.386
MAX RADIUS:	2.086
MEAN RADIUS:	1.034
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-0.774	0.796
2:	-1.043	0.133
3:	-1.161	0.720
4:	-0.401	0.185
5:	-0.090	-0.002
6:	0.261	-0.023
7:	-0.082	-0.744
8:	0.004	-1.129
9:	0.887	-1.611
10:	-0.472	-2.495

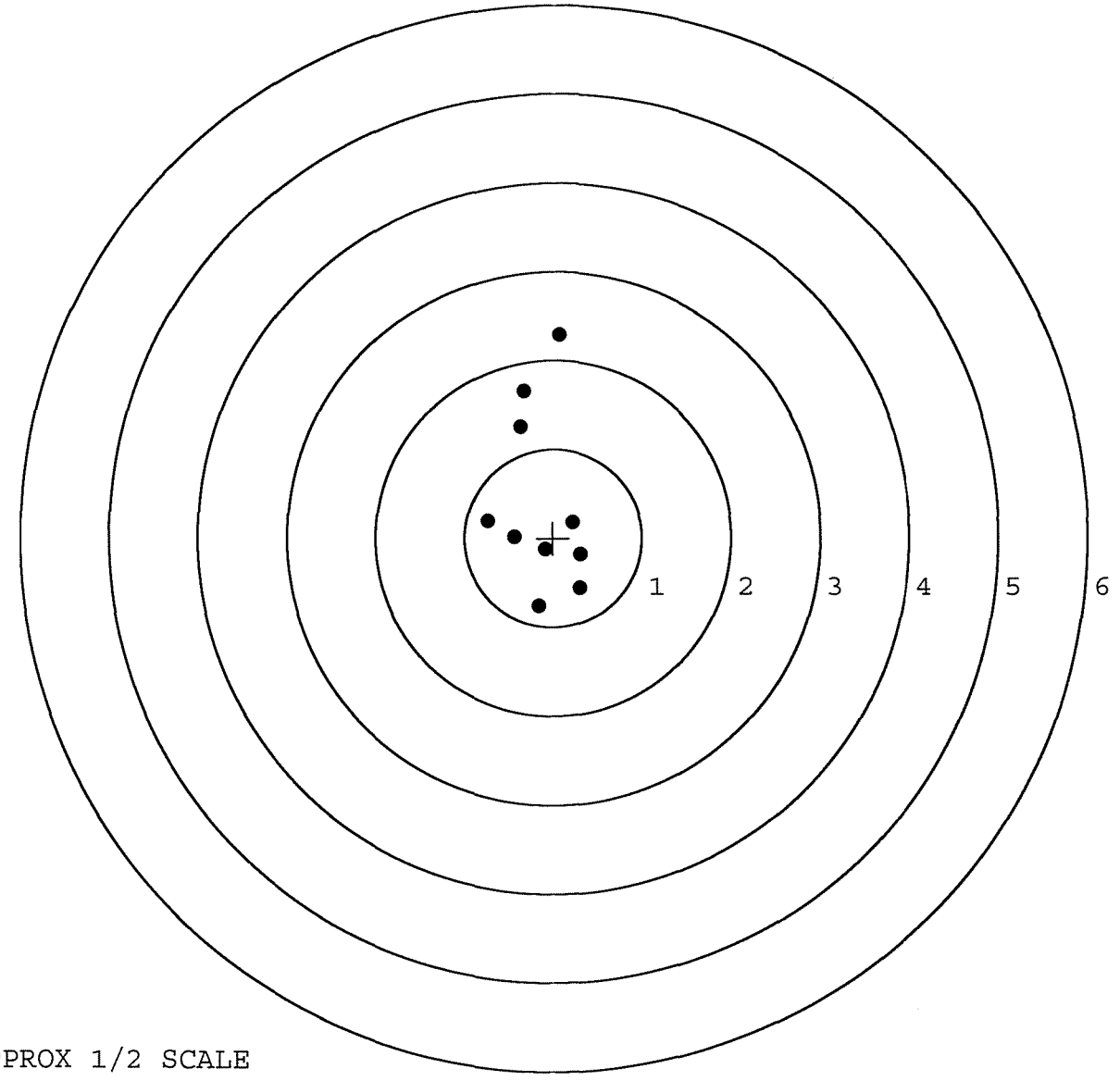


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391082.__0
TARGET NUMBER: 2
FILE DATE: 07/13/2004
FILE TIME: 06:40

X CENTROID:	-0.122
Y CENTROID:	0.393
POA TO CENTROID:	0.411
HORZ SPREAD:	1.048
VERT SPREAD:	3.053
GROUP SPREAD:	3.062
MIN RADIUS:	0.407
MAX RADIUS:	1.898
MEAN RADIUS:	0.907
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.073	2.281
2:	-0.337	1.652
3:	-0.367	1.252
4:	-0.735	0.194
5:	-0.440	0.019
6:	0.223	0.176
7:	-0.088	-0.129
8:	0.313	-0.181
9:	0.304	-0.566
10:	-0.164	-0.772

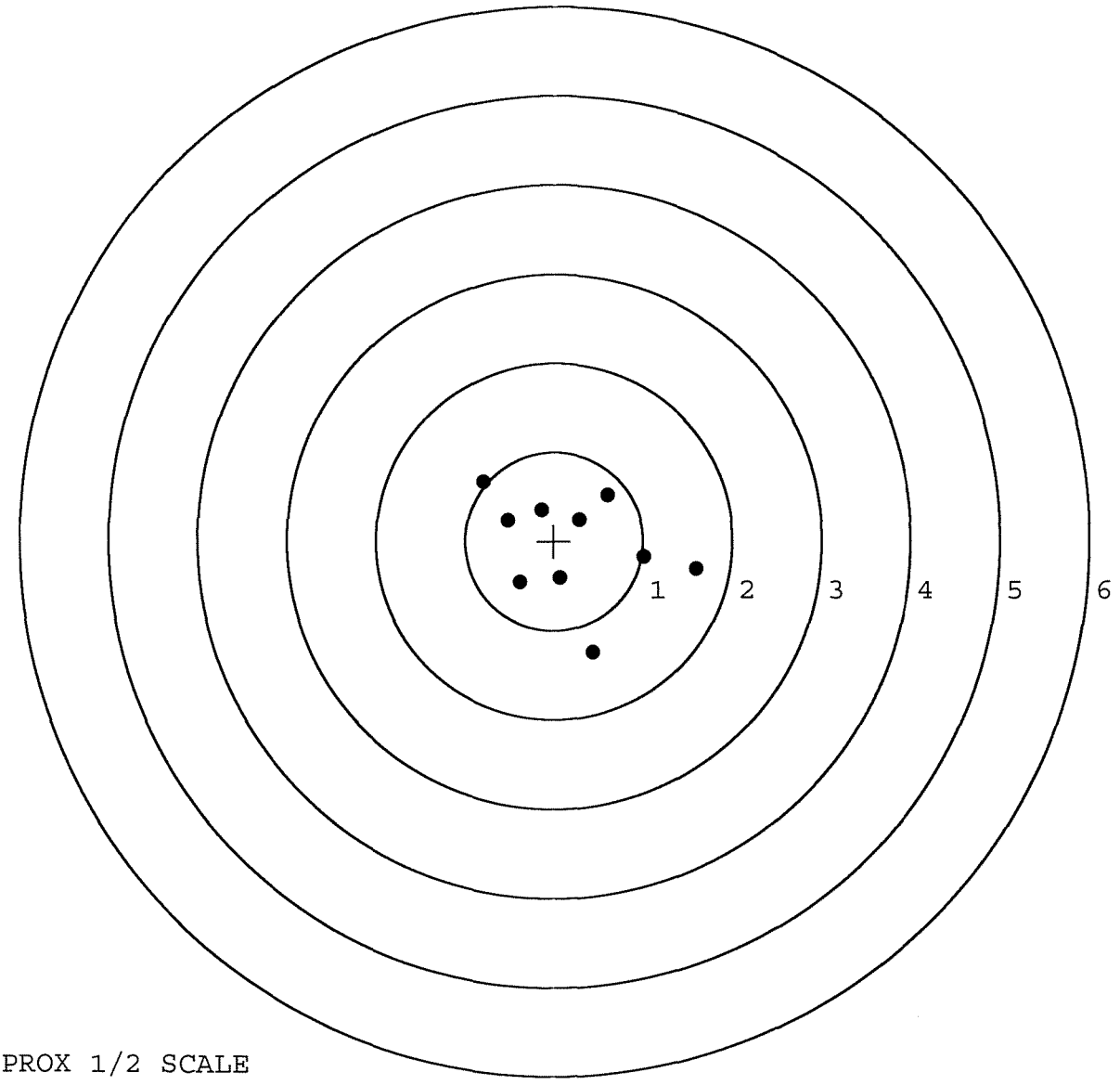


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391082.__0
TARGET NUMBER: 3
FILE DATE: 07/13/2004
FILE TIME: 06:40

X CENTROID:	0.217
Y CENTROID:	-0.061
POA TO CENTROID:	0.225
HORZ SPREAD:	2.395
VERT SPREAD:	1.925
GROUP SPREAD:	2.590
MIN RADIUS:	0.311
MAX RADIUS:	1.403
MEAN RADIUS:	0.812
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.798	0.673
2:	-0.514	0.239
3:	-0.142	0.353
4:	0.282	0.243
5:	0.601	0.515
6:	-0.383	-0.465
7:	0.069	-0.417
8:	0.444	-1.252
9:	1.010	-0.186
10:	1.597	-0.314

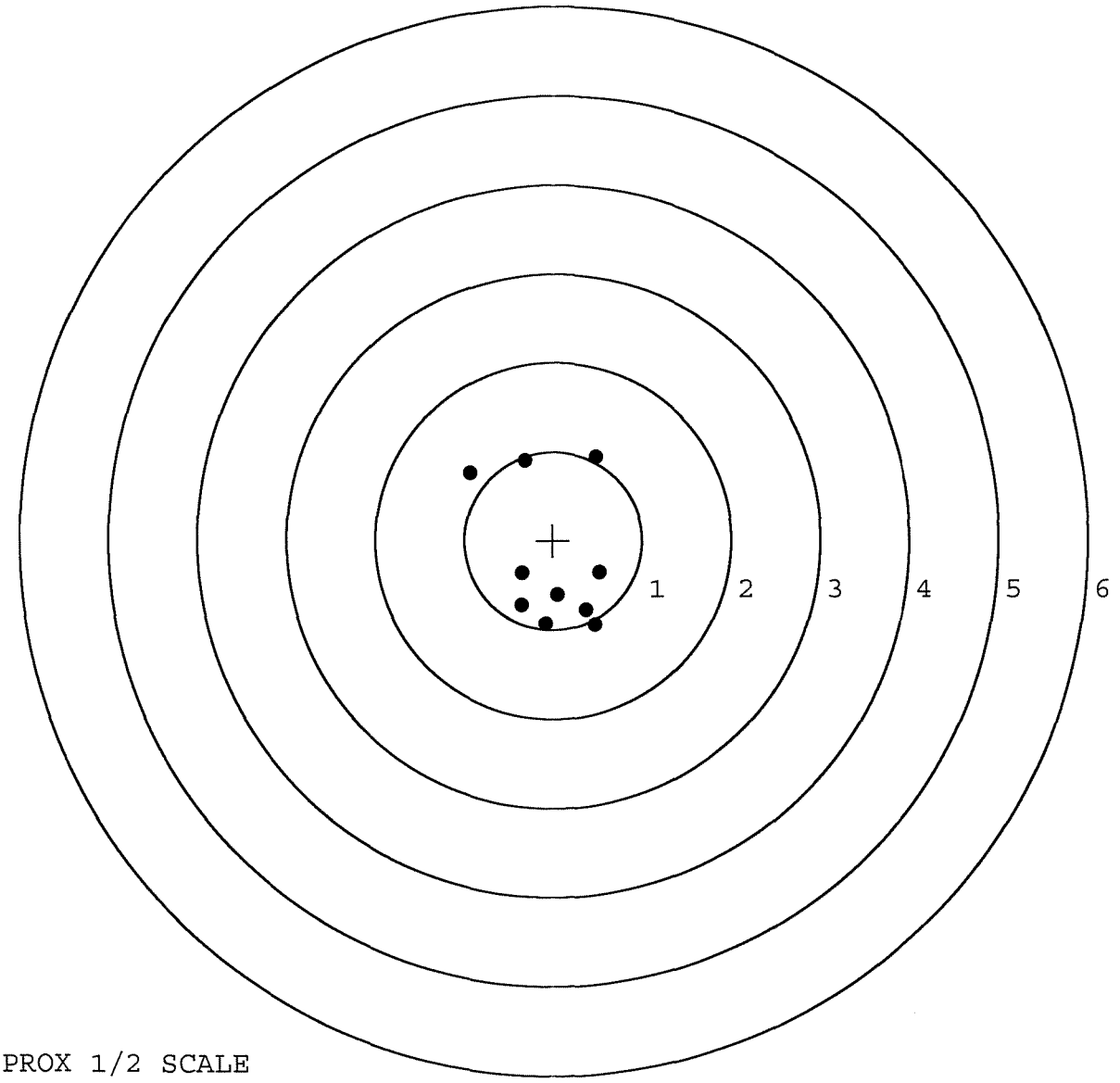


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391082.__0
TARGET NUMBER: 4
FILE DATE: 07/13/2004
FILE TIME: 06:40

X CENTROID:	-0.015
Y CENTROID:	-0.214
POA TO CENTROID:	0.214
HORZ SPREAD:	1.461
VERT SPREAD:	1.892
GROUP SPREAD:	2.225
MIN RADIUS:	0.367
MAX RADIUS:	1.348
MEAN RADIUS:	0.802
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.485	0.944
2:	-0.318	0.902
3:	-0.940	0.766
4:	0.521	-0.361
5:	0.478	-0.948
6:	0.372	-0.782
7:	-0.348	-0.368
8:	-0.358	-0.729
9:	0.047	-0.617
10:	-0.085	-0.946

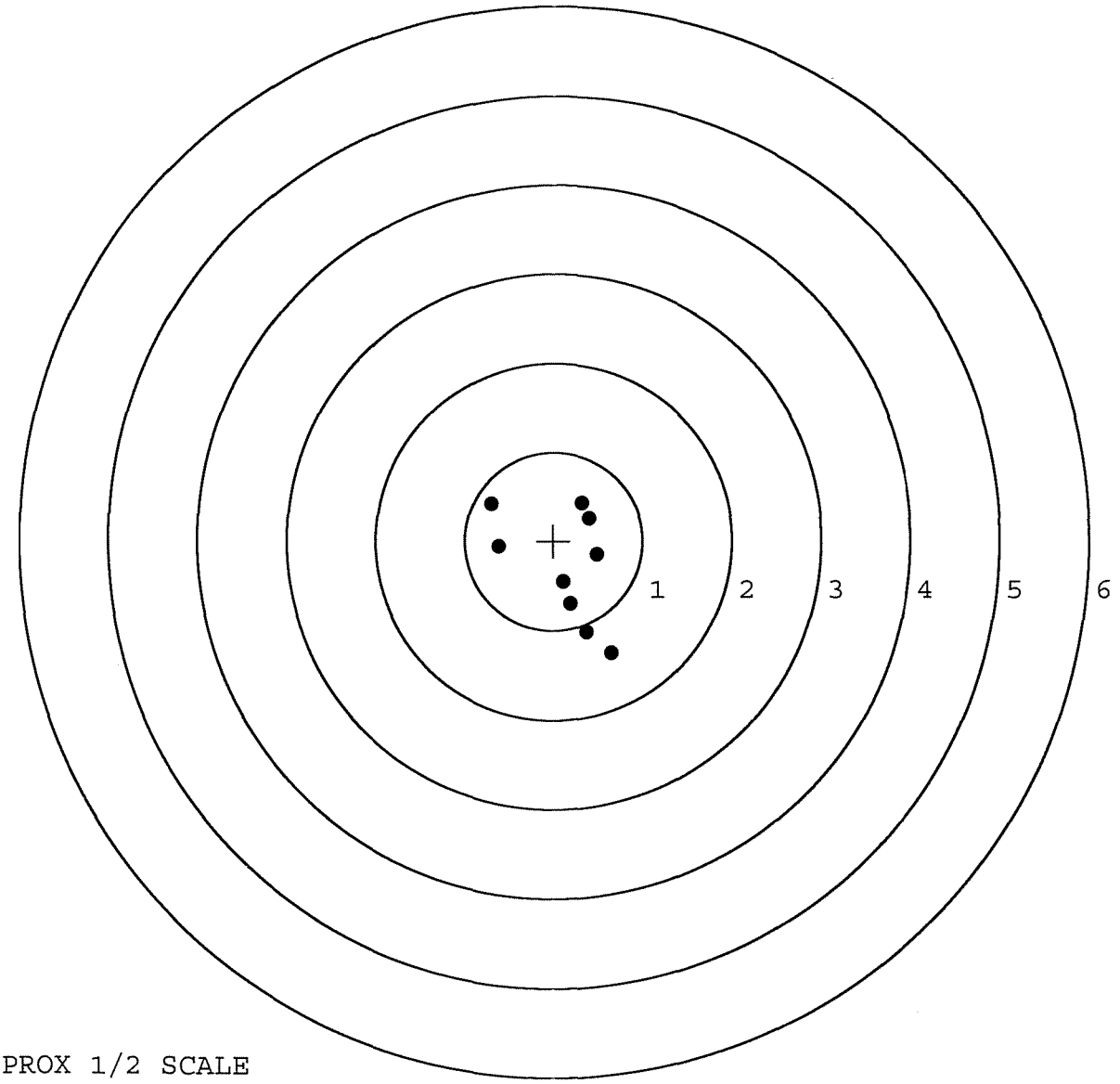


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391082.__0
TARGET NUMBER: 5
FILE DATE: 07/13/2004
FILE TIME: 06:40

X CENTROID:	0.136
Y CENTROID:	-0.284
POA TO CENTROID:	0.315
HORZ SPREAD:	1.361
VERT SPREAD:	1.685
GROUP SPREAD:	2.162
MIN RADIUS:	0.182
MAX RADIUS:	1.102
MEAN RADIUS:	0.676
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.319	0.430
2:	0.404	0.255
3:	0.487	-0.154
4:	0.113	-0.465
5:	0.187	-0.708
6:	0.378	-1.021
7:	0.657	-1.255
8:	-0.618	-0.066
9:	-0.704	0.425



TARGET APPROX 1/2 SCALE