

G-6410320

10/26/2004 7:48:11 AM

Crib

Original

25732

M/24 7.62 NATO (RIFLE ONLY)



.MA25732

Shop Order: SWS5732 - B



.ABWS5732 - B

Start Date: 9/8/2004

Finish Date: 10/27/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003512656

0560

Reassemble Action.

89SWS1



0003512657

0690

Pack Rifle

89SWS1



0003512668

0700

Stencil SWS Container

89SWS1



.OP0700

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

G6410320



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



SERIAL NO.



M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6410320

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		8-24-04	RTZ
600	PROOF		8-24-04	RTZ
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	8-24-04	RTZ
610	DIS-ASSEMBLE GUN	AUG 25 2004	8-24-04	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>[Signature]</u>		
615	ROLLMARK CALIBER		8/25/04	B
617	DRILL AND TAP SIGHT HOLES		8-24-04	TELW
620	APPLY COATINGS (BARREL ACTION)		9/7	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		9/23/04	RA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		9/23/04	RA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		9/23/04	RA
	D) OIL FIRING PIN ASSEMBLY		10-11-04	RTZ
	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>7.0</u> <u>6.0</u> <u>6.5</u>	10-20-04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.0</u> <u>2.0</u>	10-20-04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1.024</u> <u>1.024</u> <u>1.024</u>	10-20-04	DA
	J) ASSEMBLE STOCK		10-11-04	RTL
	K) ASSEMBLE SWIVEL STUDS		10-26-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		NA	DA
	M) IRON SIGHT ALIGNMENT		NA	DA
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		NA	DA
640	GALLERY TEST AND TARGET	PASS FAIL	10-12-04	X
	MALFUNCTION <i>MCW</i>	CORRECTION <i>OK</i>	10-18-04	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
	MALFUNCTION	CORRECTION	NA	TRW
645	INSPECT FOR LIVE AMMO		10/20/04	Ac
655	FINAL INSPECTION A) HEADSPACE		10-26-04	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.43</u> <u>2.55</u> <u>2.46</u> <u>2.39</u> <u>2.43</u>	10-20-04	DA
	C) FUNCTION		10-26-04	RTL
660	PACK		10/20/04	DA

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. _____

DATE 10-11-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.31	2.50		2.11	
PULL #2	2.35	2.17		2.00	
PULL #3	2.31	2.39		2.08	
PULL #4	2.37	2.34		2.11	
PULL #5	2.07	2.26		2.43	
TOTAL	11.45	11.66		10.73	
AVERAGE	2.29	2.33		2.14	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.39		
PULL #2	3.14	2.99		
PULL #3	3.24	3.08		
PULL #4	3.13	3.05		
PULL #5	2.93	2.97		
TOTAL	15.84	15.48		
AVERAGE	3.16	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	4.41	4.28		4.37
PULL #2	4.31	4.23		4.15
PULL #3	4.50	4.12		4.11
PULL #4	4.23	4.23		4.09
PULL #5	4.24	4.16		4.13
TOTAL	21.69	21.02		20.85
AVERAGE	4.33	4.20		4.17

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410320.___0

FILE DATE AND TIME: 10/12/2004 09:47

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

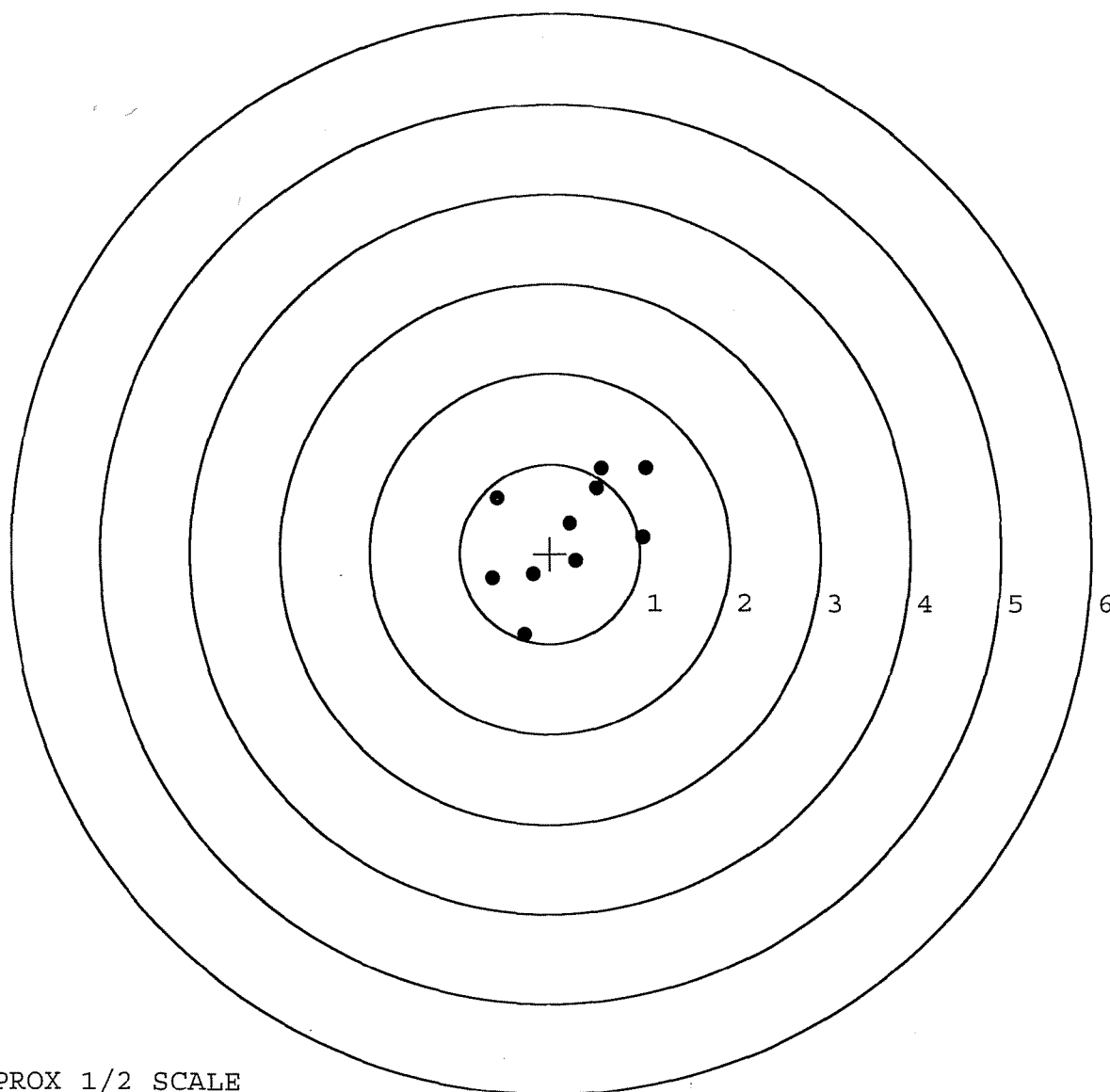
The Average X Centroid of the Five Target Set:	0.093
The Average Y Centroid of the Five Target Set:	0.190
The Average Point of Impact of the Five Target Set:	0.212
The Average Mean Radius of the Five Target Set:	0.667
The Distance from POA to Centroid Target #1:	0.302
The Distance from Centroid Target #2 to Centroid Target #1:	0.374
The Distance from Centroid Target #3 to Centroid Target #1:	0.136
The Distance from Centroid Target #4 to Centroid Target #1:	0.091
The Distance from Centroid Target #5 to Centroid Target #1:	0.268

SERIAL NUMBER: G6410320. 0
TARGET NUMBER: 1
FILE DATE: 10/12/2004
FILE TIME: 09:47

X CENTROID: 0.197
Y CENTROID: 0.228
POA TO CENTROID: 0.302
HORZ SPREAD: 1.701
VERT SPREAD: 1.860
GROUP SPREAD: 2.293
MIN RADIUS: 0.111
MAX RADIUS: 1.228
MEAN RADIUS: 0.750

IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.572	0.958
2:	0.514	0.732
3:	1.058	0.957
4:	1.027	0.182
5:	0.221	0.337
6:	0.289	-0.085
7:	-0.594	0.614
8:	-0.643	-0.279
9:	-0.190	-0.230
10:	-0.284	-0.902



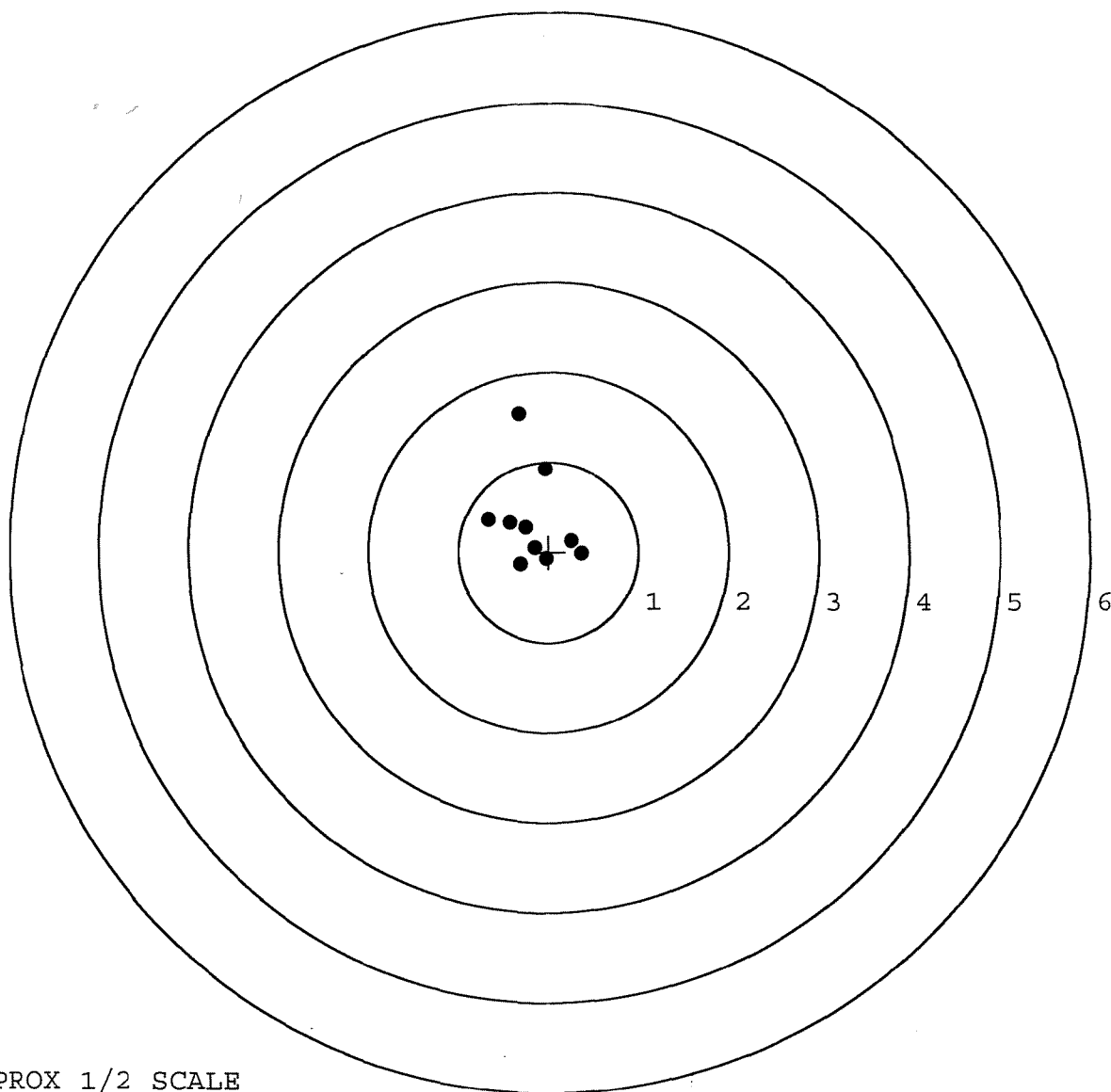
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410320. 0
TARGET NUMBER: 2
FILE DATE: 10/12/2004
FILE TIME: 09:47

X CENTROID: -0.161
Y CENTROID: 0.335
POA TO CENTROID: 0.371
HORZ SPREAD: 1.041
VERT SPREAD: 1.676
GROUP SPREAD: 1.715
MIN RADIUS: 0.111
MAX RADIUS: 1.215
MEAN RADIUS: 0.502

IN 1 IN DIAMETER: 6
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.336	1.537
2:	-0.046	0.922
3:	-0.670	0.356
4:	-0.427	0.320
5:	0.257	0.125
6:	0.371	-0.026
7:	-0.033	-0.077
8:	-0.316	-0.139
9:	-0.158	0.052
10:	-0.255	0.276

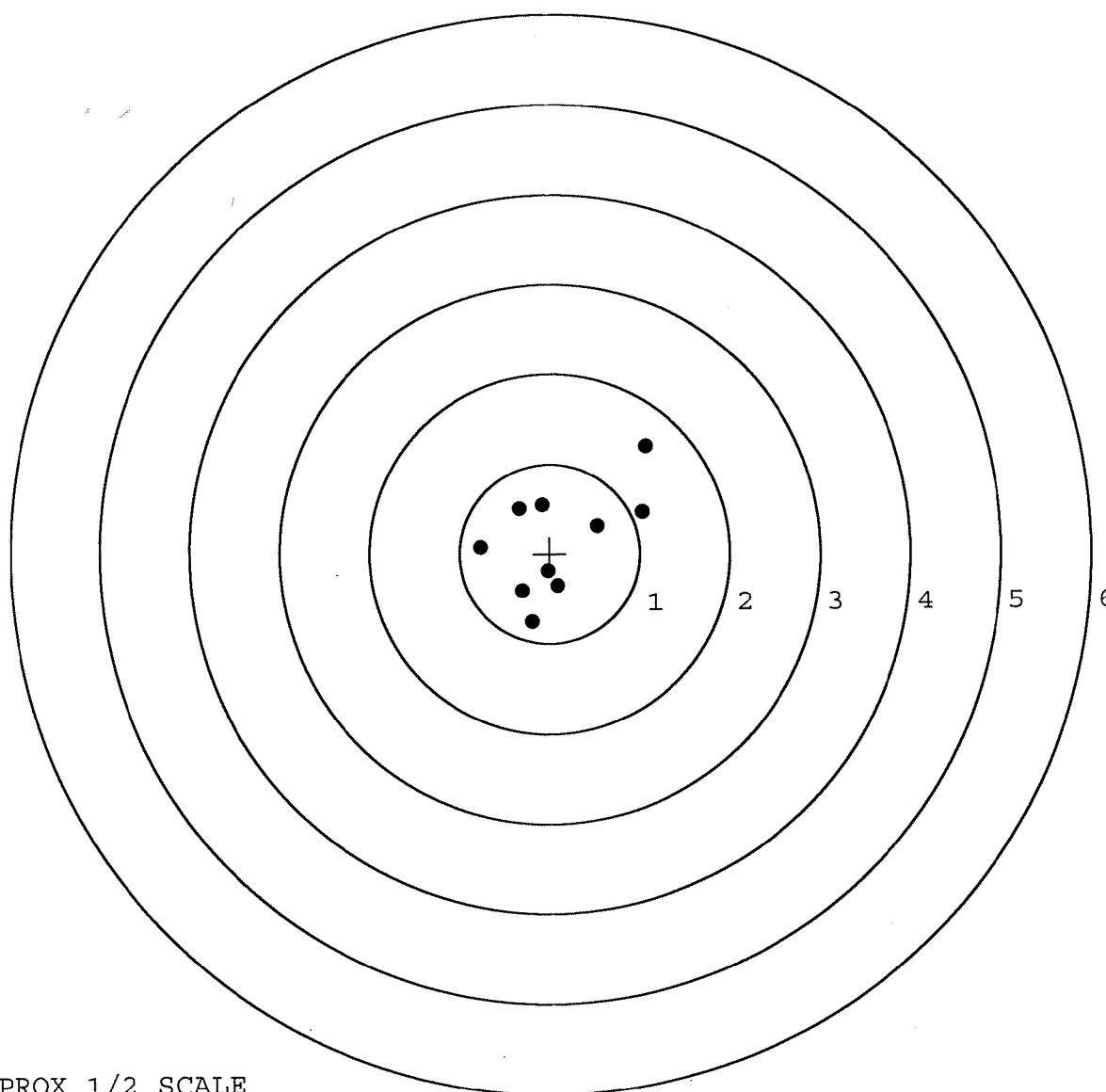


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410320. 0
TARGET NUMBER: 3
FILE DATE: 10/12/2004
FILE TIME: 09:47

X CENTROID: 0.101
Y CENTROID: 0.133
POA TO CENTROID: 0.166
HORZ SPREAD: 1.846
VERT SPREAD: 1.952
GROUP SPREAD: 2.332
MIN RADIUS: 0.353
MAX RADIUS: 1.435
MEAN RADIUS: 0.726
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.073	1.188
2:	1.030	0.459
3:	0.537	0.300
4:	-0.081	0.540
5:	-0.334	0.501
6:	-0.773	0.077
7:	-0.026	-0.197
8:	0.093	-0.362
9:	-0.311	-0.417
10:	-0.202	-0.764

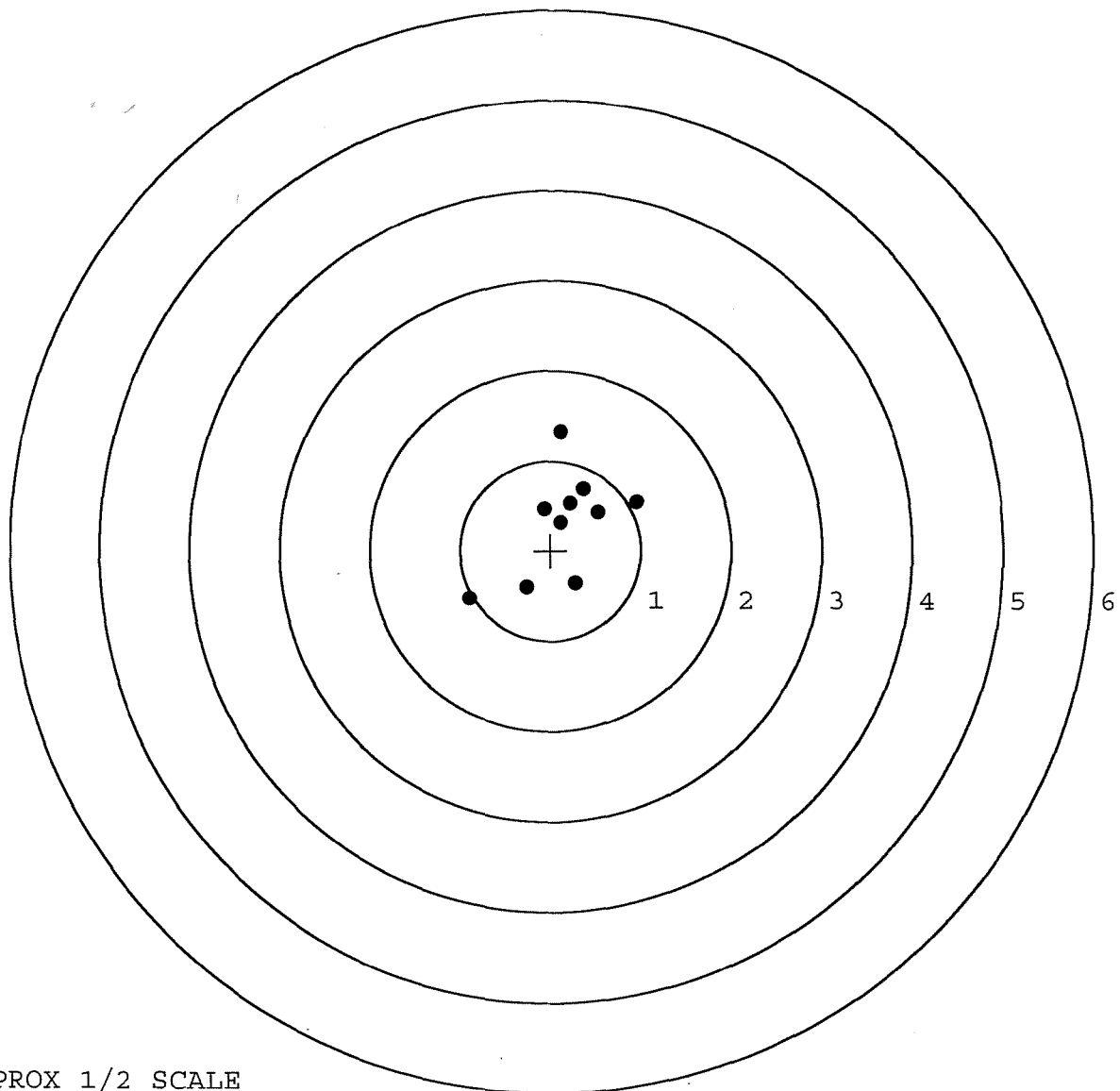


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410320. 0
TARGET NUMBER: 4
FILE DATE: 10/12/2004
FILE TIME: 09:47

POINT#	X	Y
1:	0.110	1.320
2:	0.949	0.534
3:	0.363	0.682
4:	0.222	0.524
5:	0.531	0.424
6:	-0.072	0.458
7:	0.115	0.309
8:	-0.895	-0.534
9:	-0.266	-0.413
10:	0.286	-0.362

X CENTROID: 0.134
Y CENTROID: 0.294
POA TO CENTROID: 0.323
HORZ SPREAD: 1.844
VERT SPREAD: 1.854
GROUP SPREAD: 2.131
MIN RADIUS: 0.024
MAX RADIUS: 1.321
MEAN RADIUS: 0.608
IN 1 IN DIAMETER: 5
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

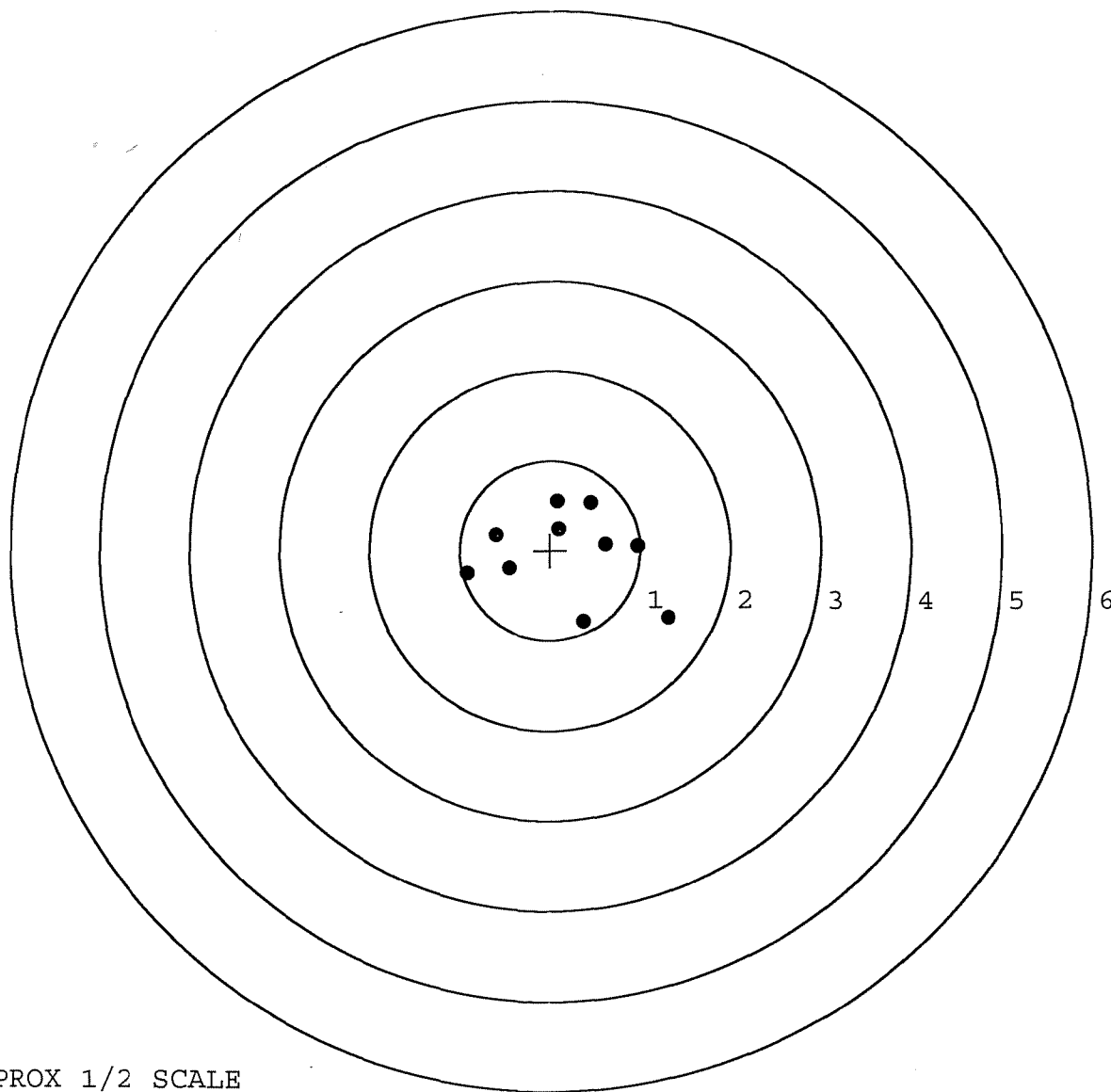


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410320. __0
TARGET NUMBER: 5
FILE DATE: 10/12/2004
FILE TIME: 09:47

X CENTROID: 0.193
Y CENTROID: -0.039
POA TO CENTROID: 0.197
HORZ SPREAD: 2.227
VERT SPREAD: 1.350
GROUP SPREAD: 2.283
MIN RADIUS: 0.297
MAX RADIUS: 1.326
MEAN RADIUS: 0.747
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.601	0.173
2:	-0.919	-0.254
3:	-0.451	-0.204
4:	0.376	-0.797
5:	1.308	-0.758
6:	0.969	0.052
7:	0.620	0.071
8:	0.456	0.530
9:	0.083	0.553
10:	0.094	0.240



TARGET APPROX 1/2 SCALE