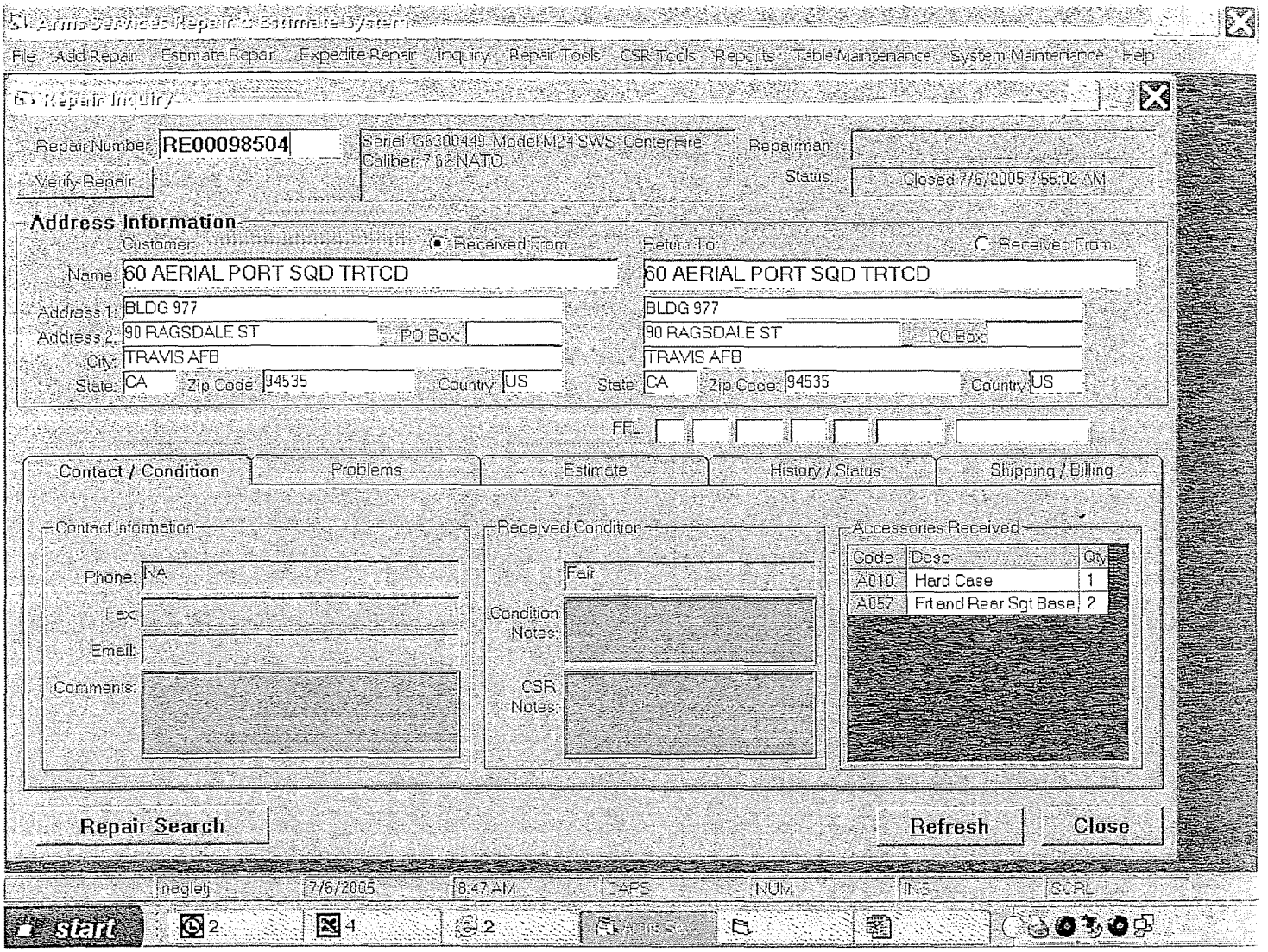
G 6300449


Arms Service Repair & Estimate System
File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help
Repair Inquiry
Repair Number: RE00098504
Verify Repair
Serial: G63300449 Model: M24 SWS Center Fire Caliber: 7.62 NATO
Repairman:
Status: Closed 7/6/2005 7:55:02 AM
Address Information
Customer: Received From
Name: 60 AERIAL PORT SQD TRTCD
Address 1: BLDG 977
Address 2: 90 RAGSDALE ST PO Box:
City: TRAVIS AFB
State: CA Zip Code: 94535 Country: US
Return To: Received From
60 AERIAL PORT SQD TRTCD
BLDG 977
90 RAGSDALE ST PO Box:
TRAVIS AFB
State: CA Zip Code: 94535 Country: US
FFL:
Contact / Condition
Problems
Estimate
History / Status
Shipping / Billing
Contact Information
Phone: NA
Fax:
Email:
Comments:
Received Condition
Fair
Condition Notes:
CSR Notes:
Accessories Received
Code Desc Qty
A010 Hard Case 1
A057 Frt and Rear Sgt Base 2
Repair Search
Refresh
Close
nagletj 7/6/2005 8:47 AM CAPS NUM INS SCRL
start


Serial Number:
G63300449
Model: M24 SWS
RE00098504

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	98504		
SERIAL NUMBER	SG6300449		
LOG-IN DATE	7-6-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIA
550	DIS-ASSEMBLE GUN	7-15-05	RTC
560 A	RE-BARREL		
B	DRILL AND TAP		
575	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST	8-23-05	LB
620	APPLY COATINGS	8/25/05	RB
625 A	FINAL ASSEMBLY	9-2-05	RTC
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	9-2-05	AC
D	SAFETY "OFF" FORCE	9-2-05	AC
E	FIRING PIN INDENT	9-2-05	AC
640	TARGET		
655	FINAL INSPECT	9-2-05	AC
660	PACK	9-2-05	DA
		SHIP DATE	
	QAR INSPECTION DATE		

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

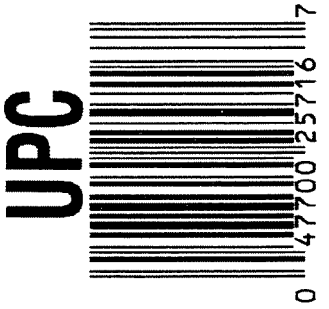
– INSTUCTION BOOK 3518

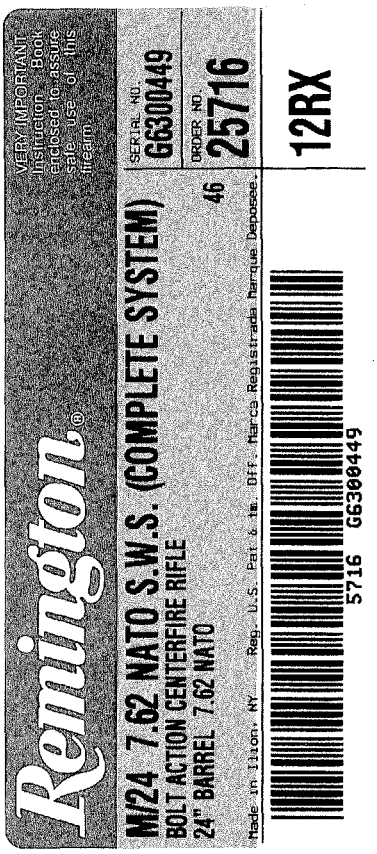
46 FORM

ORDER NO. 25716

BARREL LENGTH	24"
CAPACITY	6

G6300449





ORDER 25716

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

UPC

0 47700 25716 7

ORDER 25716

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

UPC

0 47700 25716 7

SERIAL NO.

G6300449

M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6300449

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		5/15/03	RTL
600	PROOF		5-19-03	AC
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED MAY 20 2003 OPERATOR	5-19-03	AC
610	DIS-ASSEMBLE GUN		5/20/03	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		5/27/03	KB
617	DRILL AND TAP SIGHT HOLES		5-20-03	TRW
620	APPLY COATINGS (BARREL ACTION)		6-8	TA
	(BOLT)		6-8	TA
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		6-12-03	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-12-03	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6-12-03	DA
	D) OIL FIRING PIN ASSEMBLY		6-12-03	DA
	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)	5.0 6.0 5.0	7-9-03	DA
CONT.	G) SAFETY OFF FORCE (2 LBS MIN)	2.0 2.5 2.5	7-9-03	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT (.020 MIN)	.024 .022 .022	7-9-03	DA
	J) ASSEMBLE STOCK		6-17-03	RTL
	K) ASSEMBLE SWIVEL STUDS		11-7-03	RW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		6-17-03	RTL
	M) IRON SIGHT ALIGNMENT		6-17-03	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6-17-03	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	6-18-03	
	MALFUNCTION	CORRECTION	6-18-03	
	MALFUNCTION	CORRECTION	6-18-03	
	MALFUNCTION	CORRECTION	6-18-03	
	MALFUNCTION	CORRECTION	6-18-03	
645	INSPECT FOR LIVE AMMO		6-18-03	
655	FINAL INSPECTION A) HEADSPACE		11-7-03	RW
	B) TRIGGER PULL (+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS)	2.84 2.83 2.87 2.86 2.85	7-9-03	DA
	C) FUNCTION		11-7-03	RW
660	PACK		11/8/03	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 6-11-03

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.42	2.46		2.66	
PULL #2	2.39	2.44		2.62	
PULL #3	2.20	2.40		2.63	
PULL #4	2.35	2.46		2.65	
PULL #5	2.37	2.45		2.61	
TOTAL	11.73	12.21		13.17	
AVERAGE	2.34	2.44		2.63	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.41		
PULL #2	3.39	3.48		
PULL #3	3.41	3.34		
PULL #4	3.40	3.33		
PULL #5	3.43	3.37		
TOTAL	16.96	16.93		
AVERAGE	3.39	3.38		

	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	4.30	4.31		4.27
PULL #2	4.35	4.36		4.31
PULL #3	4.32	4.37		4.38
PULL #4	4.38	4.30		4.40
PULL #5	4.37	4.42		4.45
TOTAL	21.72	21.76		21.81
AVERAGE	4.34	4.35		4.36

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6300449.__0
FILE DATE AND TIME: 06/18/2003 07:00

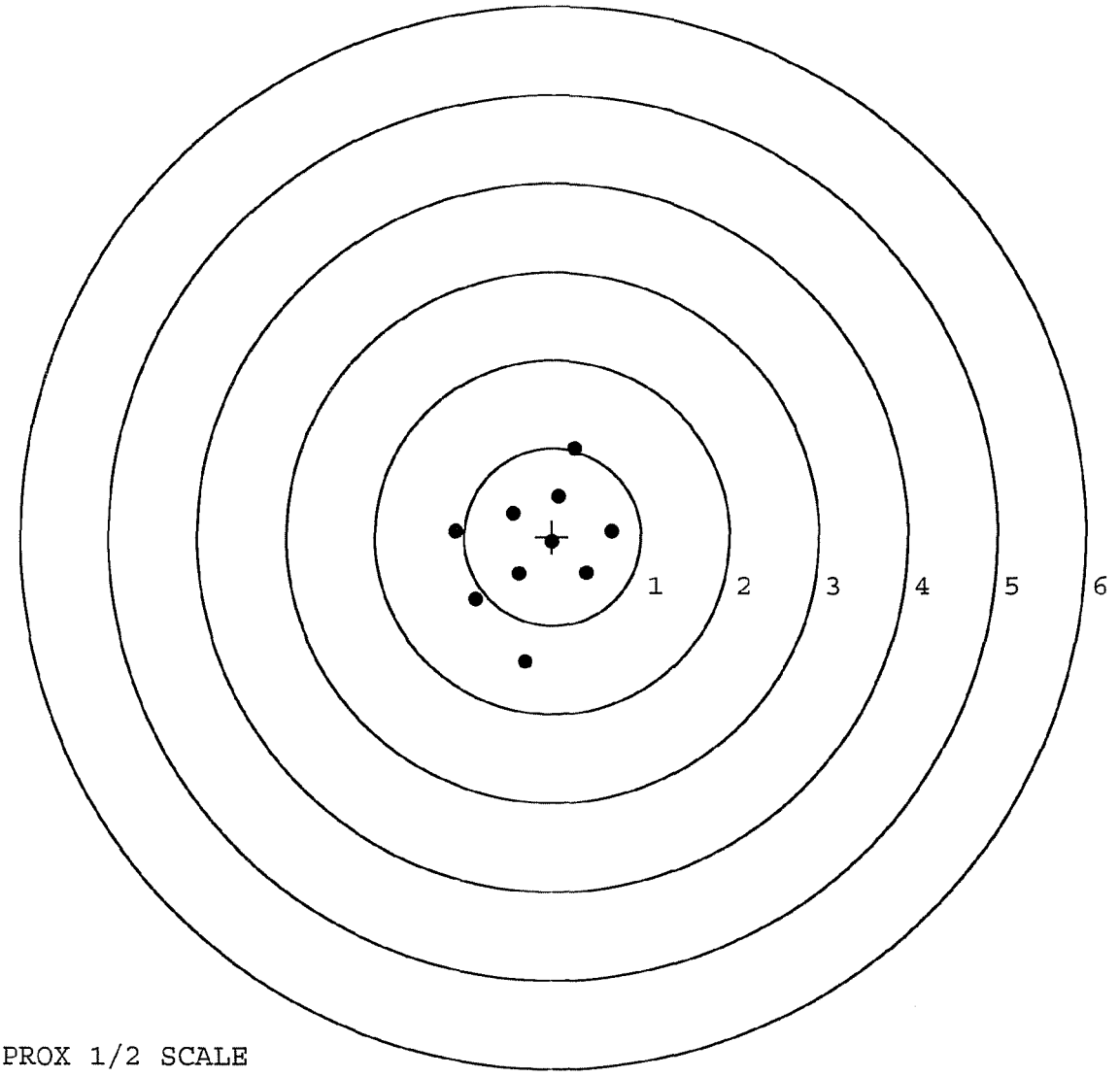
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.075
The Average Y Centroid of the Five Target Set:	-0.007
The Average Point of Impact of the Five Target Set:	0.075
The Average Mean Radius of the Five Target Set:	0.640
The Distance from POA to Centroid Target #1:	0.210
The Distance from Centroid Target #2 to Centroid Target #1:	0.306
The Distance from Centroid Target #3 to Centroid Target #1:	0.286
The Distance from Centroid Target #4 to Centroid Target #1:	0.103
The Distance from Centroid Target #5 to Centroid Target #1:	0.191

SERIAL NUMBER: G6300449.__0
TARGET NUMBER: 1
FILE DATE: 06/18/2003
FILE TIME: 07:00

X CENTROID:	-0.172
Y CENTROID:	-0.120
POA TO CENTROID:	0.210
HORZ SPREAD:	1.766
VERT SPREAD:	2.413
GROUP SPREAD:	2.476
MIN RADIUS:	0.176
MAX RADIUS:	1.306
MEAN RADIUS:	0.748
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.302	-1.419
2:	-0.870	-0.710
3:	-1.097	0.057
4:	-0.452	0.266
5:	-0.006	-0.061
6:	0.669	0.061
7:	0.255	0.994
8:	0.067	0.448
9:	0.388	-0.409
10:	-0.376	-0.424

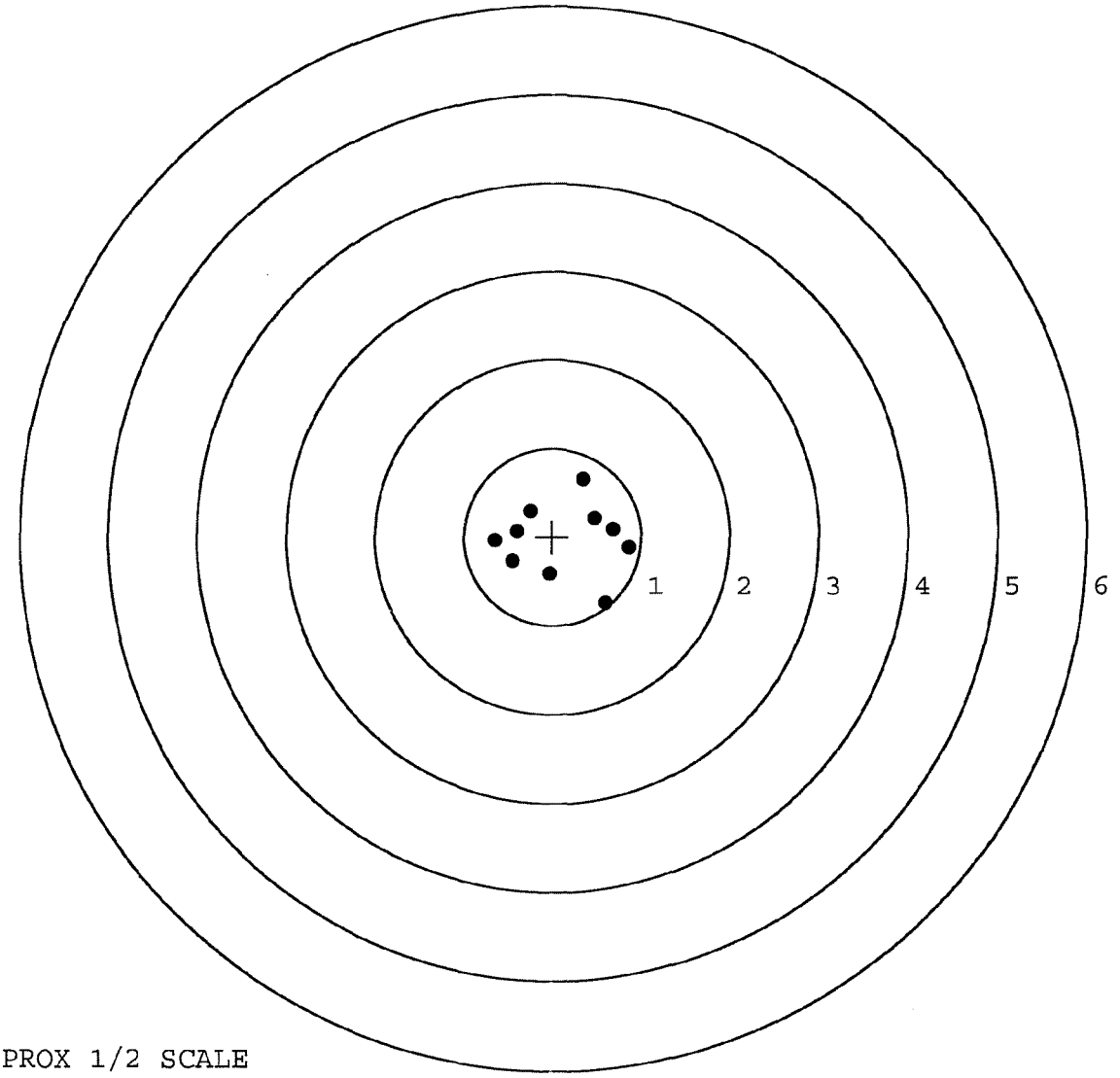


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300449.__0
TARGET NUMBER: 2
FILE DATE: 06/18/2003
FILE TIME: 07:00

X CENTROID:	0.120
Y CENTROID:	-0.031
POA TO CENTROID:	0.124
HORZ SPREAD:	1.522
VERT SPREAD:	1.411
GROUP SPREAD:	1.443
MIN RADIUS:	0.423
MAX RADIUS:	0.870
MEAN RADIUS:	0.619
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.606	-0.753
2:	0.872	-0.124
3:	0.682	0.092
4:	0.474	0.217
5:	0.350	0.658
6:	-0.029	-0.426
7:	-0.650	-0.042
8:	-0.451	-0.278
9:	-0.248	0.287
10:	-0.403	0.063

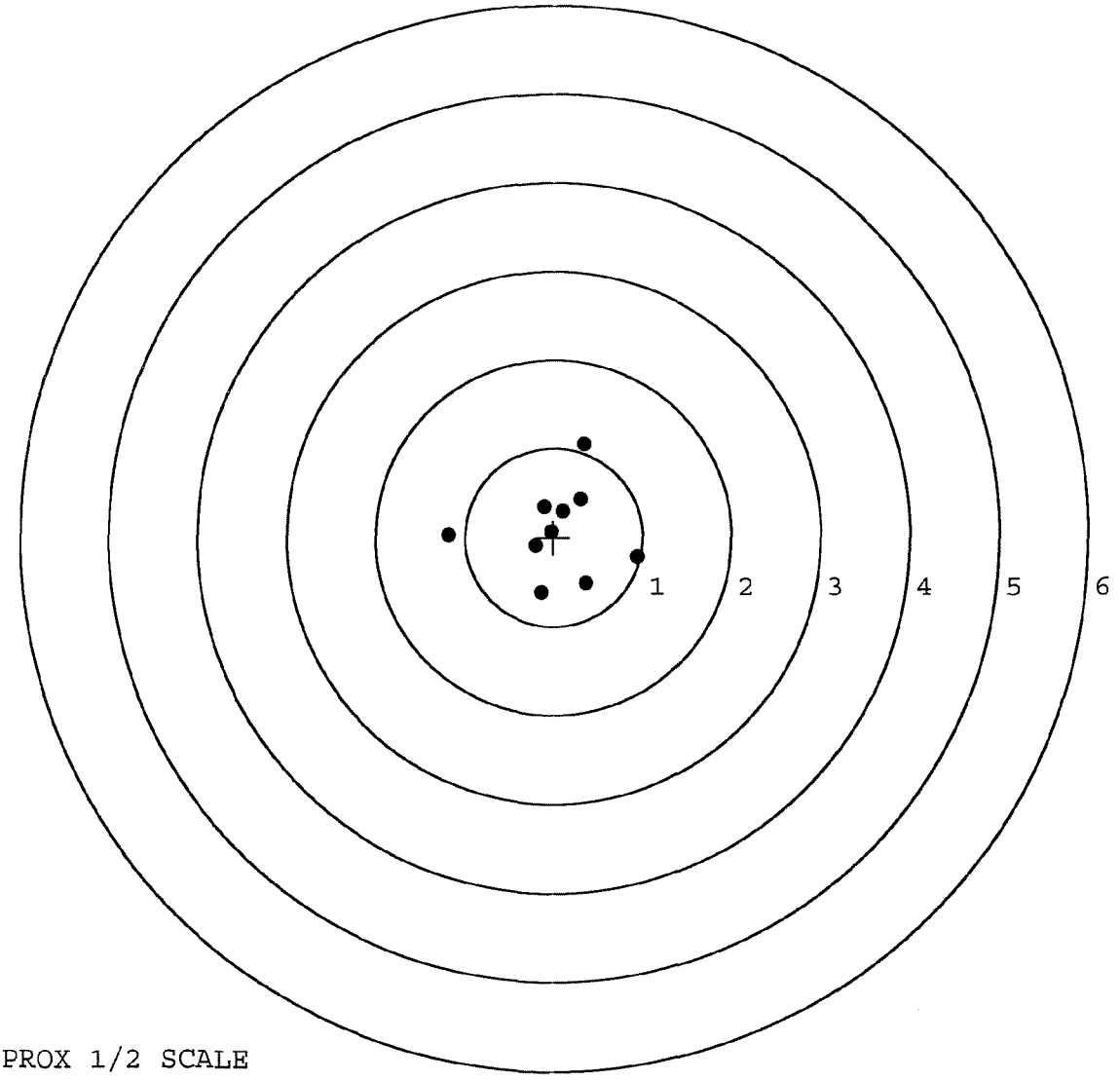


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300449.__0
TARGET NUMBER: 3
FILE DATE: 06/18/2003
FILE TIME: 07:00

X CENTROID:	0.040
Y CENTROID:	0.072
POA TO CENTROID:	0.082
HORZ SPREAD:	2.136
VERT SPREAD:	1.668
GROUP SPREAD:	2.150
MIN RADIUS:	0.063
MAX RADIUS:	1.232
MEAN RADIUS:	0.593
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.945	-0.224
2:	0.368	-0.518
3:	-0.138	-0.624
4:	-1.191	0.025
5:	-0.204	-0.100
6:	0.342	1.044
7:	0.305	0.426
8:	-0.113	0.340
9:	0.106	0.287
10:	-0.022	0.062

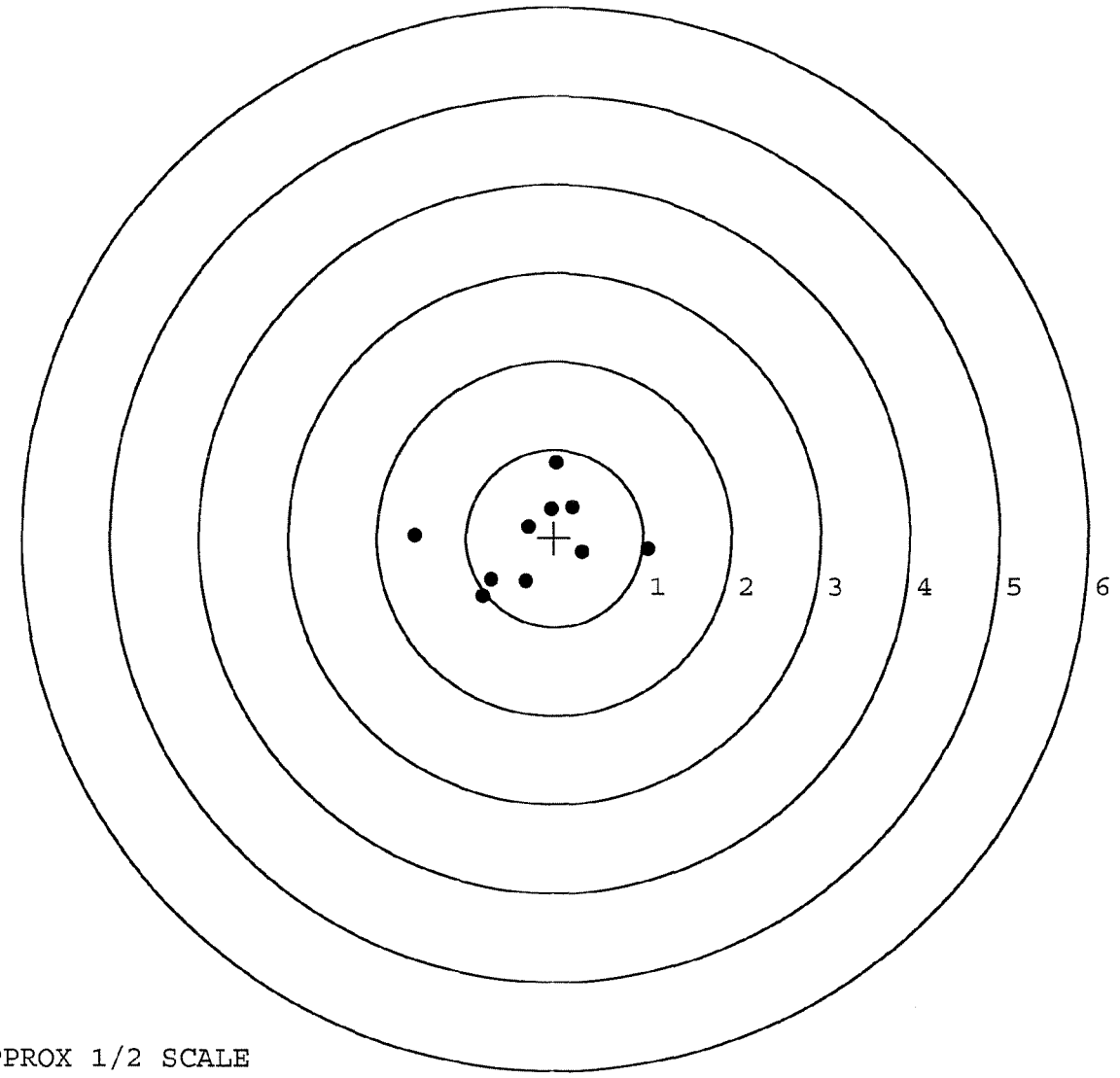


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300449.__0
TARGET NUMBER: 4
FILE DATE: 06/18/2003
FILE TIME: 07:00

X CENTROID:	-0.215
Y CENTROID:	-0.025
POA TO CENTROID:	0.217
HORZ SPREAD:	2.628
VERT SPREAD:	1.519
GROUP SPREAD:	2.632
MIN RADIUS:	0.171
MAX RADIUS:	1.356
MEAN RADIUS:	0.725
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	1.058	-0.130
2:	0.316	-0.165
3:	0.201	0.352
4:	-0.040	0.325
5:	0.025	0.853
6:	-0.294	0.126
7:	-0.323	-0.499
8:	-0.714	-0.474
9:	-0.811	-0.666
10:	-1.570	0.023

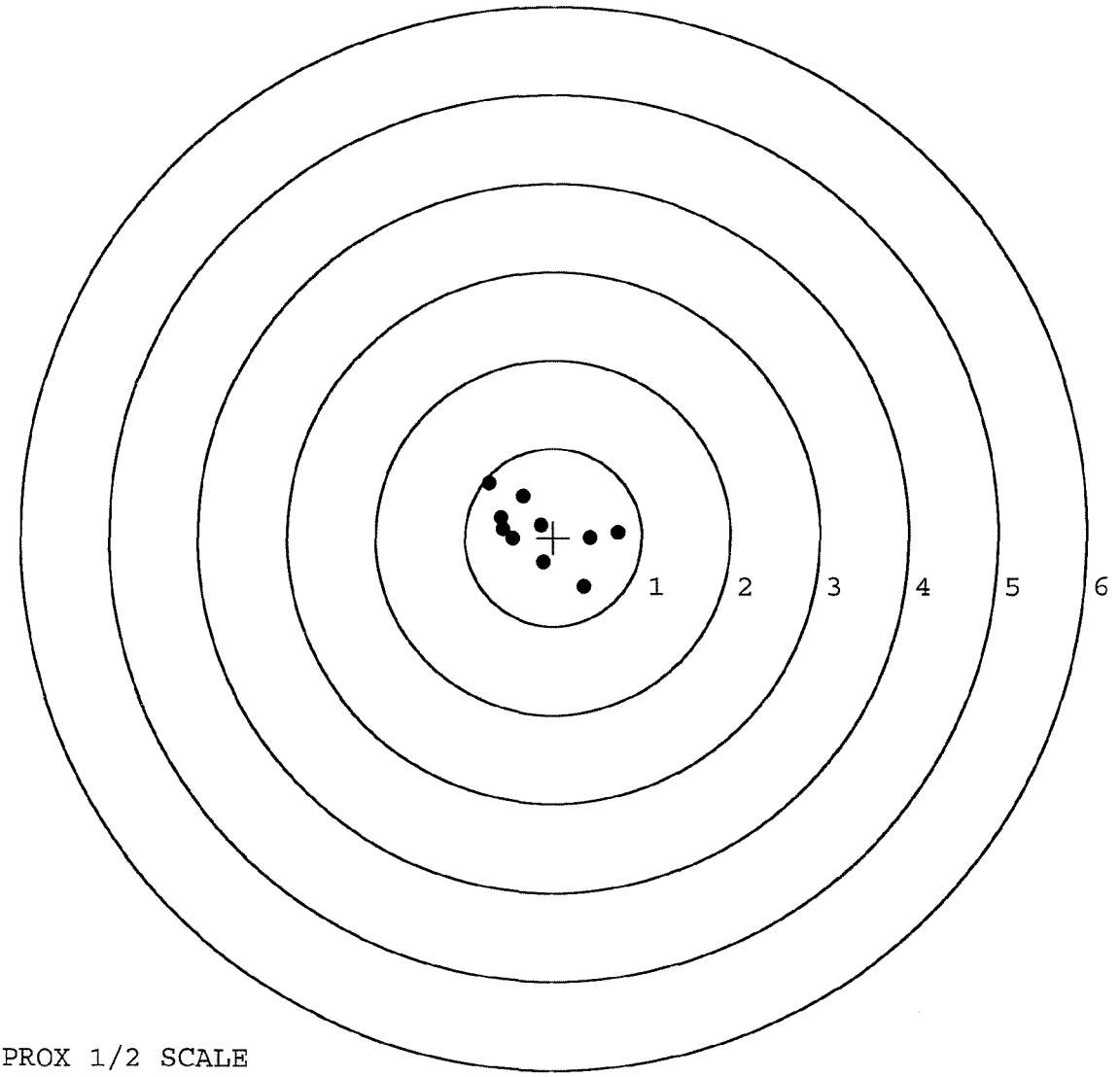


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300449.__0
TARGET NUMBER: 5
FILE DATE: 06/18/2003
FILE TIME: 07:00

X CENTROID:	-0.146
Y CENTROID:	0.069
POA TO CENTROID:	0.162
HORZ SPREAD:	1.460
VERT SPREAD:	1.157
GROUP SPREAD:	1.558
MIN RADIUS:	0.069
MAX RADIUS:	0.879
MEAN RADIUS:	0.513
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.351	-0.555
2:	0.733	0.058
3:	0.414	-0.007
4:	-0.113	-0.286
5:	-0.143	0.138
6:	-0.460	-0.022
7:	-0.579	0.087
8:	-0.594	0.219
9:	-0.727	0.602
10:	-0.342	0.461



TARGET APPROX 1/2 SCALE