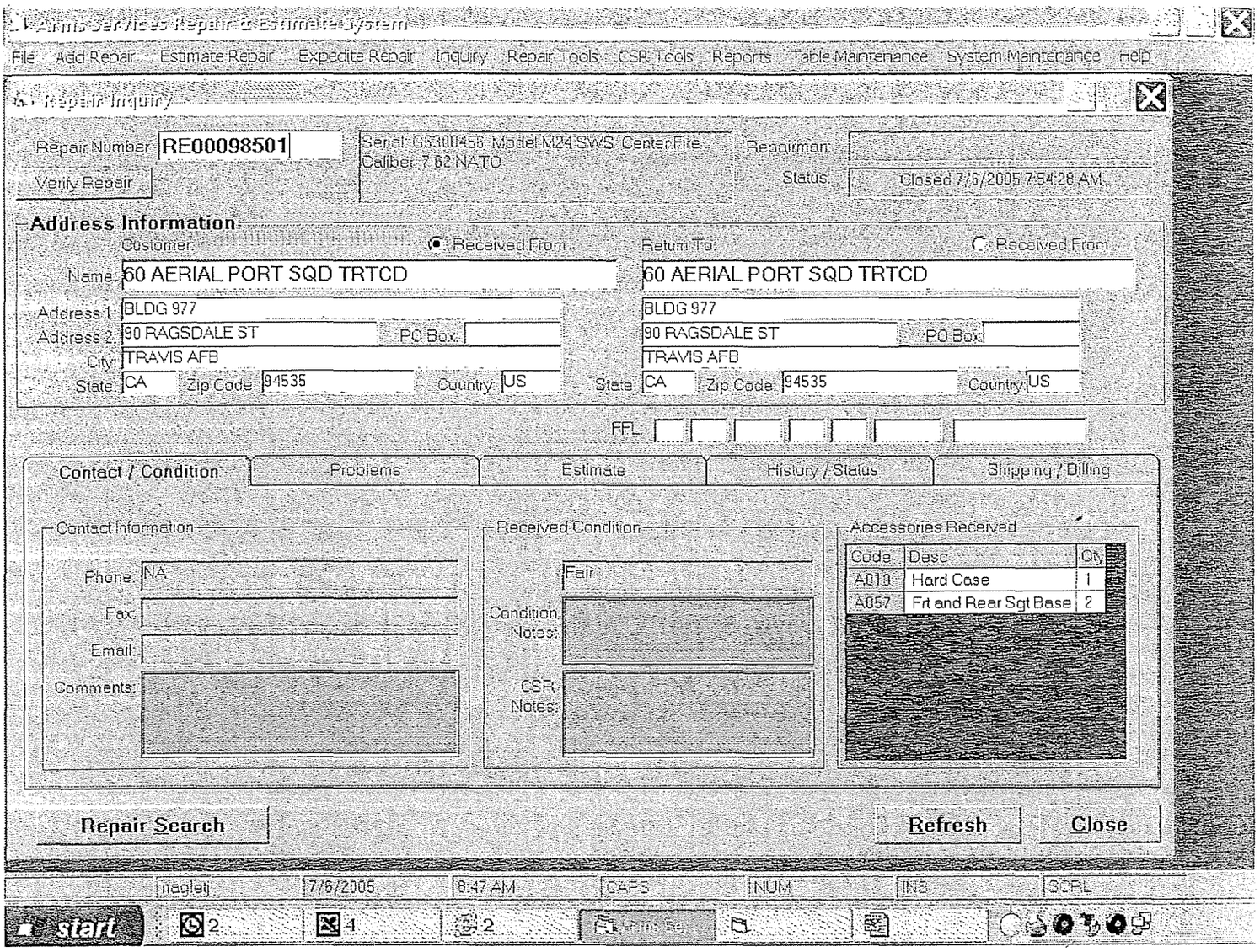
G63004576


Arms Services 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 RE00098501
Verify Repair
Serial: G6300456 Model M24 SWS Center Fire Caliber 7.62 NATO
Repairman:
Status: Closed 7/6/2005 7:54:28 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
negletj 7/6/2005 8:47 AM CAPS NUM INS SCRL
start


Serial Number: G63000456
Model: M24 SWS
RE00098501

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

R & E NUMBER	98501		
SERIAL NUMBER	C6300456		
LOG-IN DATE	7-6-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIA
550	DIS-ASSEMBLE GUN	7-14-05	RTL
560 A	RE-BARREL		
B	DRILL AND TAP		
575	ASSEMBLE		
600	PROOF	N.A.	
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST	8-23-05	WB
620	APPLY COATINGS	8/25/05	RB
625 A	FINAL ASSEMBLY	9-2-05	RTL
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

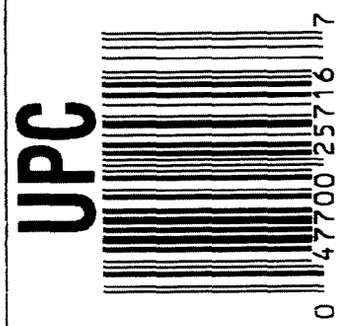
– INSTUCTION BOOK 3518

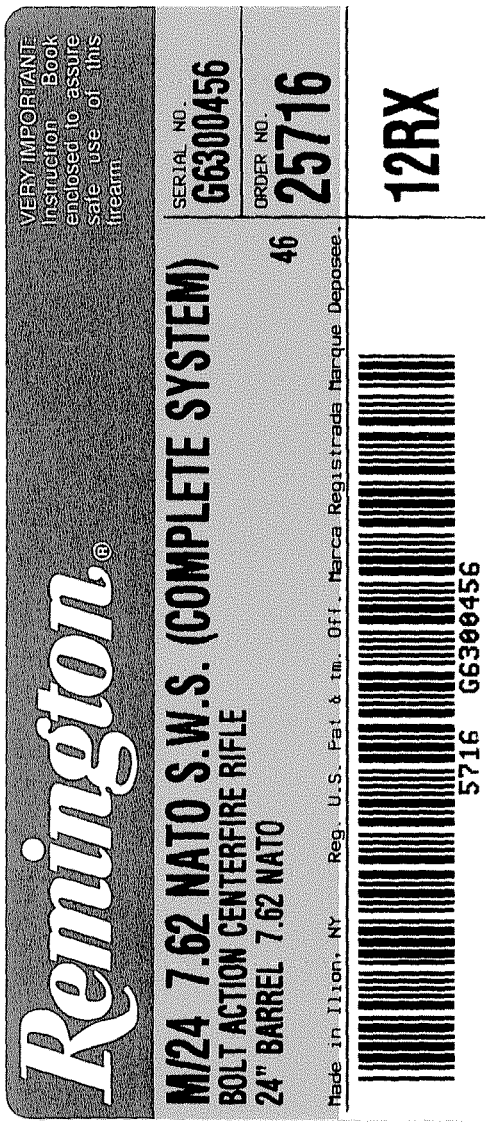
46 FORM

ORDER NO. 25716

BARREL LENGTH	24"
CAPACITY	6

G6300456





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.

G6300456

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6300456

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		5/19/03	RTL
600	PROOF		5-20-03	AC
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED MAY 23 2003 OPERATOR	5/21/03	RTL
610	DIS-ASSEMBLE GUN		5/21/03	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		5/27/03	KB
617	DRILL AND TAP SIGHT HOLES		5-22-03	TRW
620	APPLY COATINGS (BARREL ACTION)		6-11	TA
	(BOLT)		6-11	TA
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		7-1-03	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-1-03	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-1-03	DA
	D) OIL FIRING PIN ASSEMBLY		7-1-03	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)	7 7 7	11-8-03	RW
CONT.	G) SAFETY OFF FORCE (2 LBS MIN)	2 2.5 2	11-8-03	RW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT (.020 MIN)	.022 .0225 .023	11-8-03	RW
	J) ASSEMBLE STOCK		7/3/03	RW
	K) ASSEMBLE SWIVEL STUDS		11-8-03	RW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		7/3/03	RW
	M) IRON SIGHT ALIGNMENT		7/3/03	RW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		7/3/03	RW
640	GALLERY TEST AND TARGET	PASS FAIL	7-3-03	AC
	MALFUNCTION	CORRECTION	7-3-03	AC
	MALFUNCTION	CORRECTION	7-3-03	AC
	MALFUNCTION	CORRECTION	7-3-03	AC
	MALFUNCTION	CORRECTION	7-3-03	AC
645	INSPECT FOR LIVE AMMO		7-3-03	AC
655	FINAL INSPECTION A) HEADSPACE		11-8-03	RW
	B) TRIGGER PULL (+/- .5 LBS, MIN 2.50 LBS, MAX 4.0 LBS)	2.31 2.21 2.14 2.28 2.25	11-8-03	RW
	C) FUNCTION		11-8-03	RW
660	PACK		11/10/03	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 8-26-03

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.69	2.31		2.12	
PULL #2	2.56	2.69		2.03	
PULL #3	2.47	2.57		2.34	
PULL #4	2.53	2.49		2.14	
PULL #5	2.39	2.38		2.34	
TOTAL	12.64	12.44		10.97	
AVERAGE	2.52	2.48		2.19	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.38		
PULL #2	3.08	3.24		
PULL #3	3.07	3.21		
PULL #4	3.08	3.33		
PULL #5	3.30	3.19		
TOTAL	15.64	16.35		
AVERAGE	3.12	3.27		

	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	4.19	4.01		4.38
PULL #2	4.24	4.20		4.17
PULL #3	4.18	4.32		4.31
PULL #4	4.04	4.22		4.19
PULL #5	4.06	4.42		4.18
TOTAL	20.71	21.17		TRW [redacted] 21.23
AVERAGE	4.14	4.23		4.24

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6300456.__0
FILE DATE AND TIME: 07/03/2003 06:29

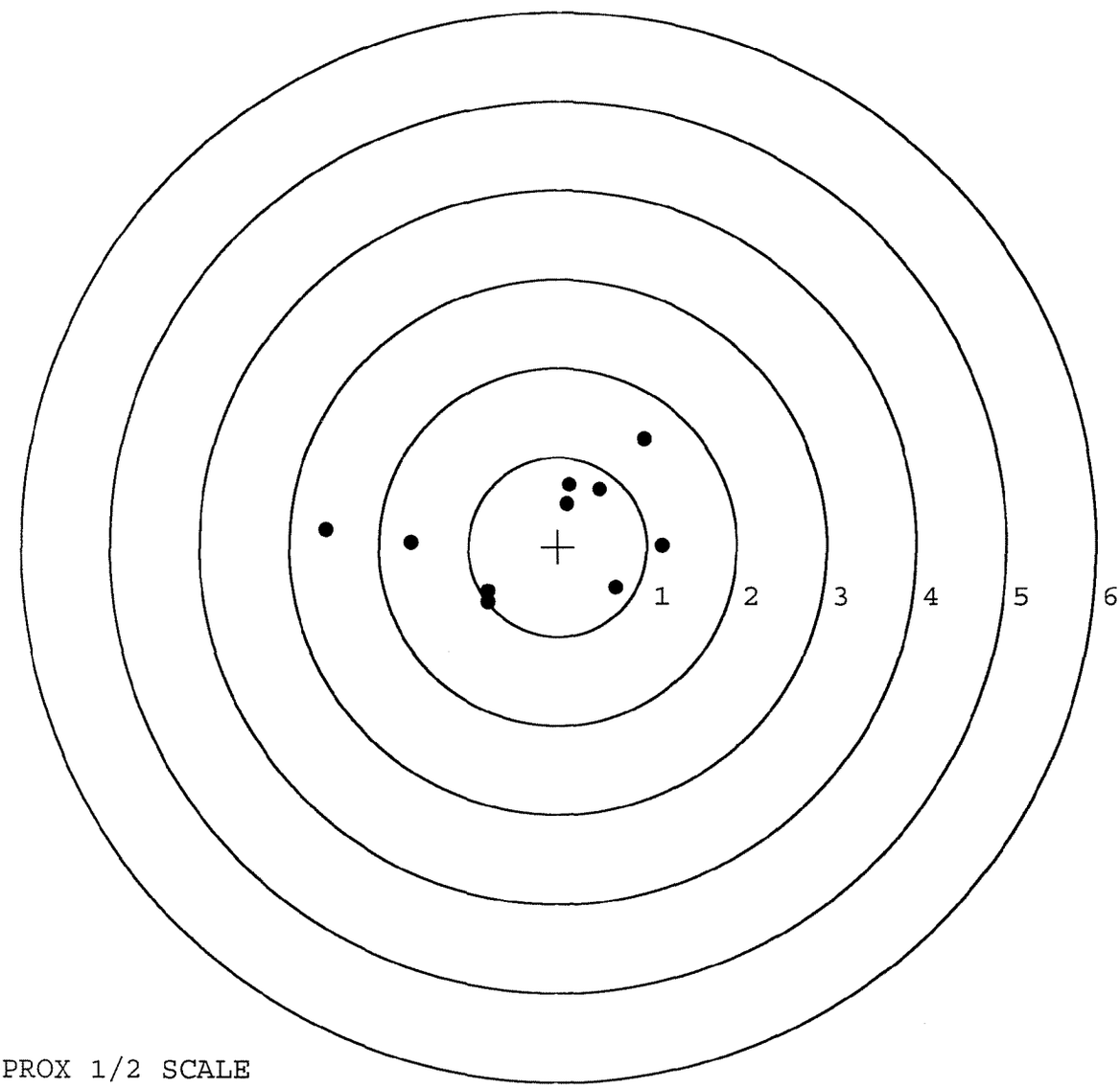
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.006
The Average Y Centroid of the Five Target Set:	0.030
The Average Point of Impact of the Five Target Set:	0.031
The Average Mean Radius of the Five Target Set:	0.790
The Distance from POA to Centroid Target #1:	0.286
The Distance from Centroid Target #2 to Centroid Target #1:	0.461
The Distance from Centroid Target #3 to Centroid Target #1:	0.316
The Distance from Centroid Target #4 to Centroid Target #1:	0.245
The Distance from Centroid Target #5 to Centroid Target #1:	0.332

SERIAL NUMBER: G6300456.__0
TARGET NUMBER: 1
FILE DATE: 07/03/2003
FILE TIME: 06:29

X CENTROID:	-0.232
Y CENTROID:	0.167
POA TO CENTROID:	0.286
HORZ SPREAD:	3.764
VERT SPREAD:	1.830
GROUP SPREAD:	3.767
MIN RADIUS:	0.455
MAX RADIUS:	2.366
MEAN RADIUS:	1.162
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.963	1.204
2:	0.129	0.692
3:	0.467	0.644
4:	0.102	0.476
5:	1.166	0.020
6:	0.657	-0.456
7:	-0.781	-0.626
8:	-0.781	-0.506
9:	-1.641	0.045
10:	-2.598	0.177

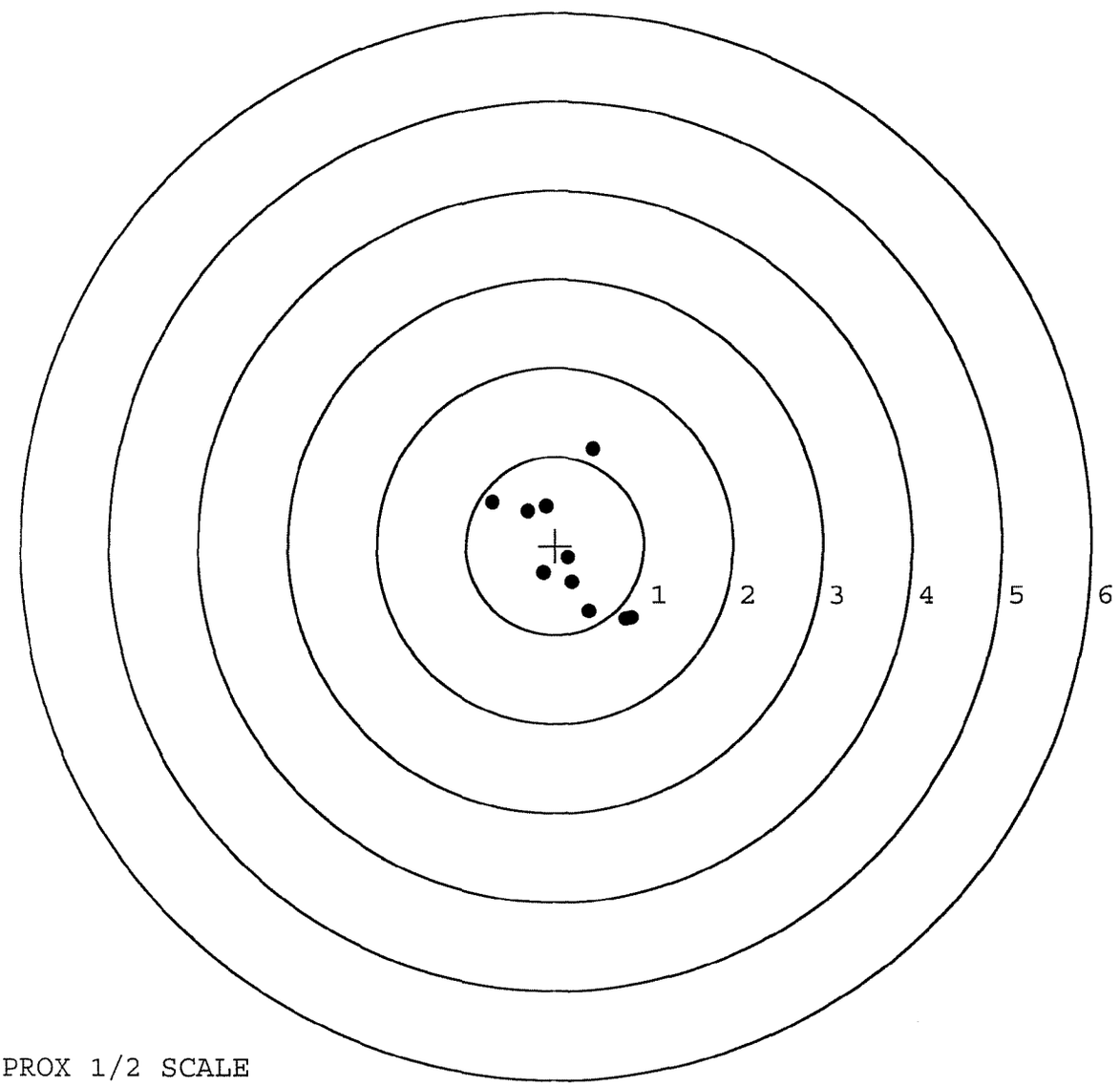


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300456.__0
TARGET NUMBER: 2
FILE DATE: 07/03/2003
FILE TIME: 06:29

X CENTROID:	0.158
Y CENTROID:	-0.080
POA TO CENTROID:	0.177
HORZ SPREAD:	1.574
VERT SPREAD:	1.915
GROUP SPREAD:	1.950
MIN RADIUS:	0.050
MAX RADIUS:	1.204
MEAN RADIUS:	0.693
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.430	1.092
2:	-0.709	0.489
3:	-0.311	0.393
4:	-0.101	0.441
5:	0.865	-0.808
6:	0.381	-0.738
7:	0.199	-0.410
8:	-0.129	-0.309
9:	0.151	-0.130
10:	0.799	-0.823

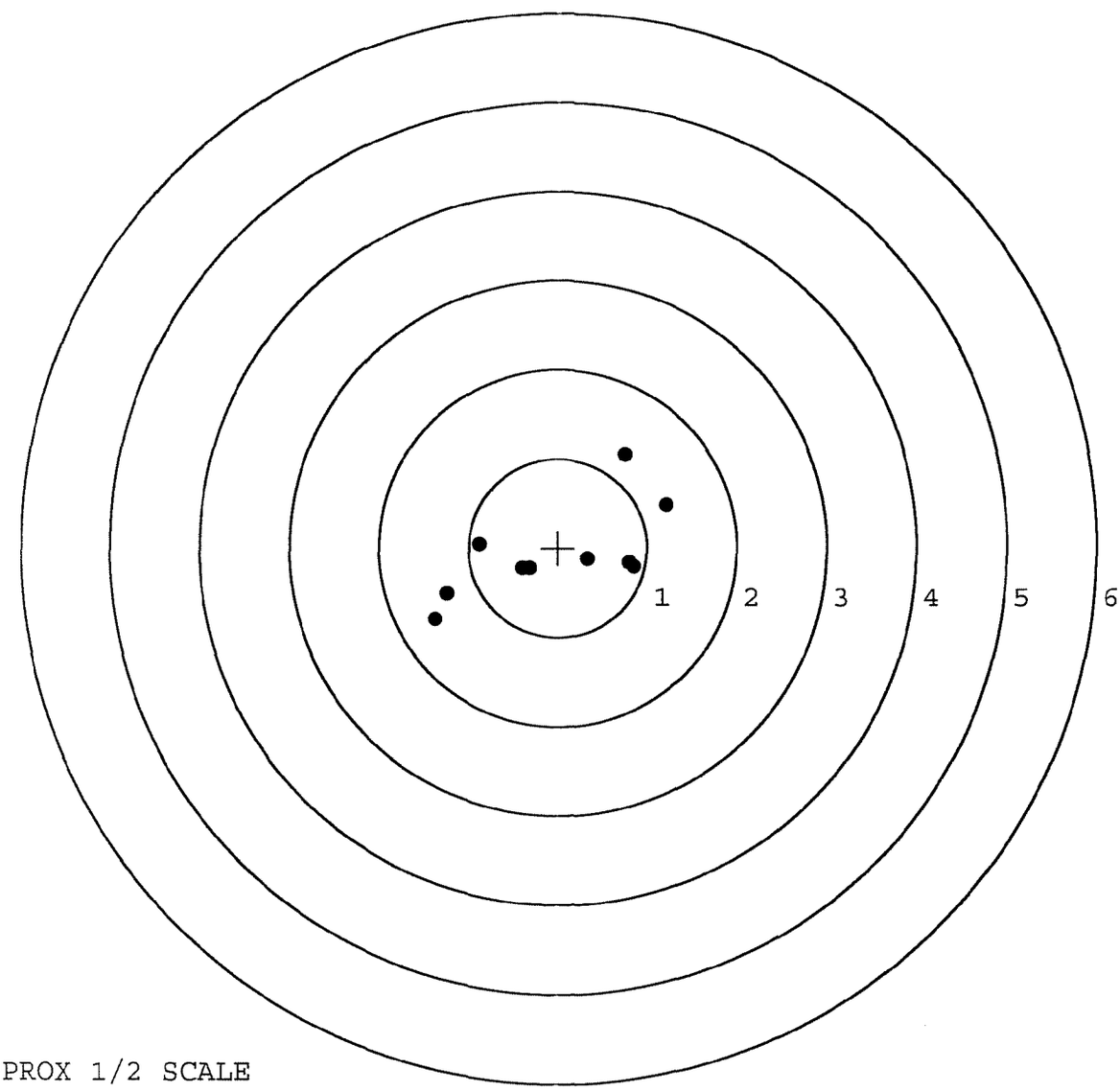


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300456.__0
TARGET NUMBER: 3
FILE DATE: 07/03/2003
FILE TIME: 06:29

X CENTROID:	-0.023
Y CENTROID:	-0.070
POA TO CENTROID:	0.074
HORZ SPREAD:	2.576
VERT SPREAD:	1.855
GROUP SPREAD:	2.882
MIN RADIUS:	0.331
MAX RADIUS:	1.533
MEAN RADIUS:	0.924
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-1.367	-0.807
2:	-1.240	-0.524
3:	-0.882	0.046
4:	-0.395	-0.231
5:	0.336	-0.120
6:	0.806	-0.164
7:	1.209	0.486
8:	0.758	1.048
9:	0.859	-0.208
10:	-0.315	-0.227

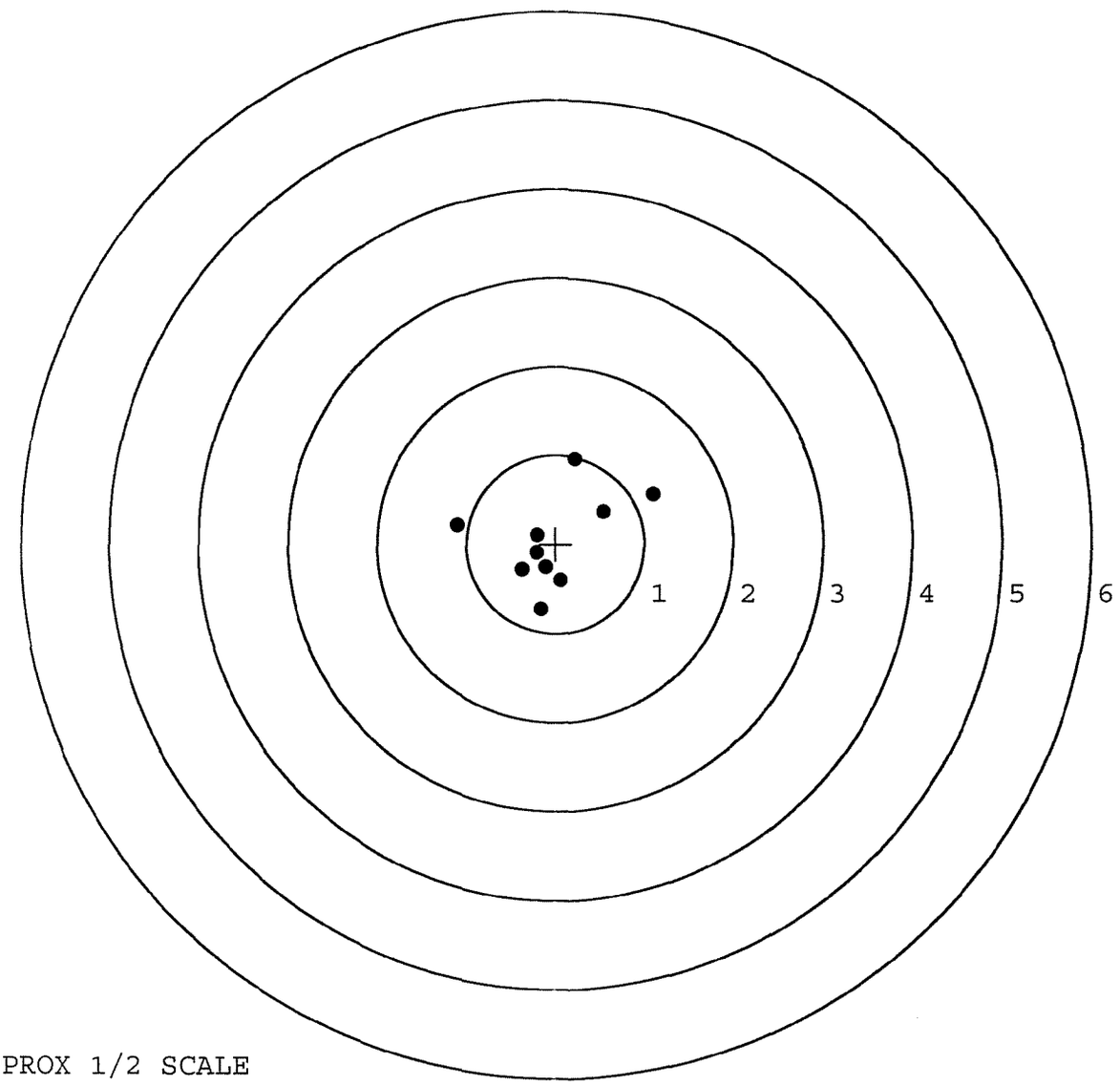


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300456.__0
TARGET NUMBER: 4
FILE DATE: 07/03/2003
FILE TIME: 06:29

X CENTROID:	-0.024
Y CENTROID:	0.037
POA TO CENTROID:	0.044
HORZ SPREAD:	2.207
VERT SPREAD:	1.692
GROUP SPREAD:	2.235
MIN RADIUS:	0.193
MAX RADIUS:	1.238
MEAN RADIUS:	0.640
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.224	0.955
2:	0.546	0.365
3:	1.100	0.555
4:	-1.107	0.201
5:	-0.208	0.094
6:	-0.216	-0.103
7:	0.064	-0.411
8:	-0.160	-0.737
9:	-0.374	-0.290
10:	-0.107	-0.263

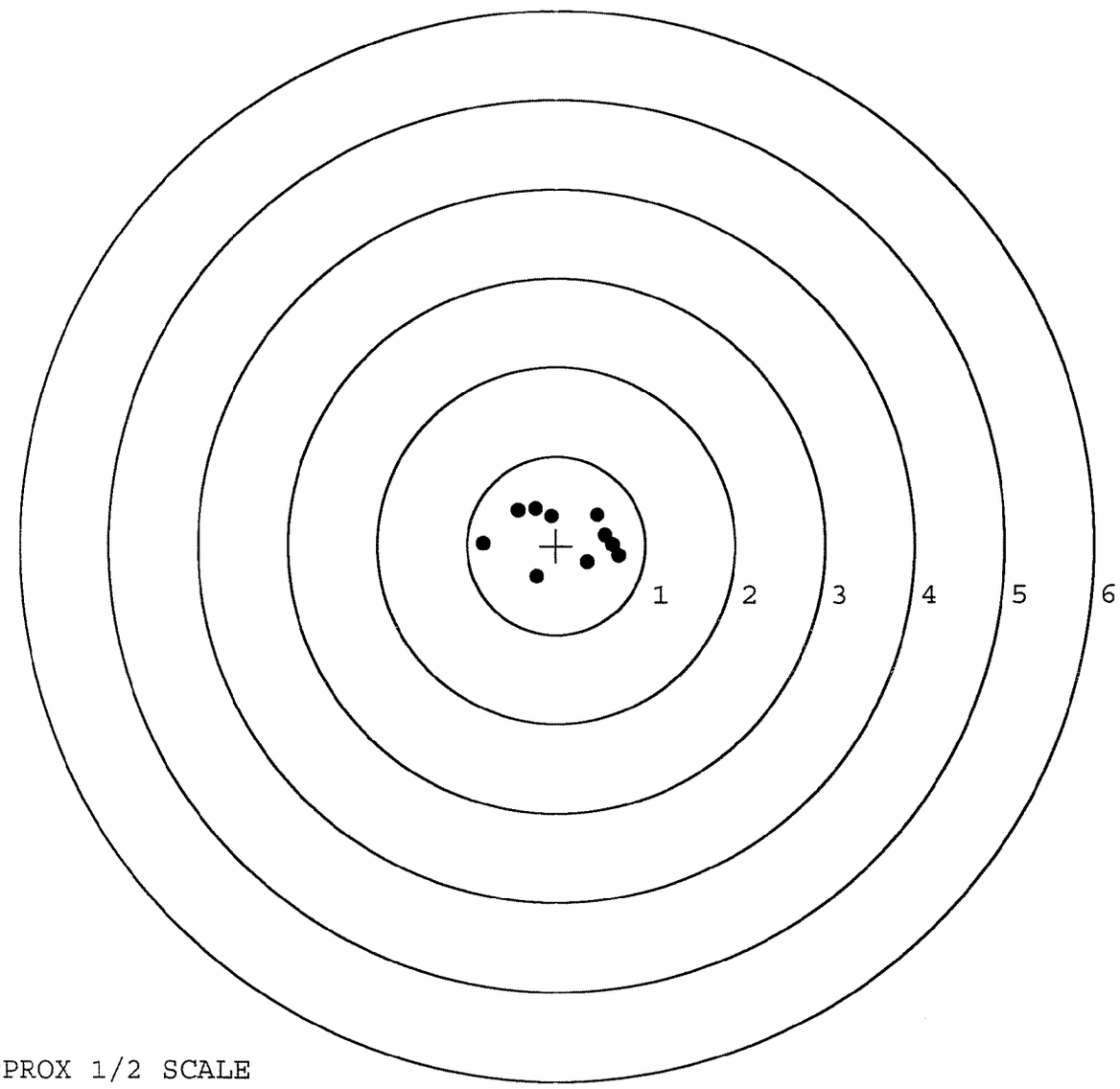


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300456.__0
TARGET NUMBER: 5
FILE DATE: 07/03/2003
FILE TIME: 06:29

X CENTROID:	0.093
Y CENTROID:	0.098
POA TO CENTROID:	0.135
HORZ SPREAD:	1.529
VERT SPREAD:	0.772
GROUP SPREAD:	1.536
MIN RADIUS:	0.274
MAX RADIUS:	0.919
MEAN RADIUS:	0.529
# IN 1 IN DIAMETER:	5
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.823	0.024
2:	-0.428	0.395
3:	-0.239	0.419
4:	-0.057	0.327
5:	0.461	0.344
6:	0.550	0.117
7:	0.706	-0.118
8:	0.352	-0.190
9:	-0.222	-0.353
10:	0.634	0.012



TARGET APPROX 1/2 SCALE