

G-636 1027

M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

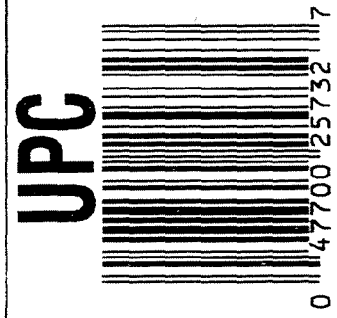
- INSTRUCTION BOOK 3518

DD FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5

G6361027



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



SERIAL NO.



12/10/2004 1:19:29 PM

Crib

33

Original

25732

M/24 7.62 NATO (RIFLE ONLY)



.MA25732

Shop Order: SWS5732 - DEC



.ABSWS5732 - DEC

Start Date: 10/12/2004

Finish Date: 12/17/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003544860

0560

Reassemble Action.

89SWS1



0003544861

0690

Pack Rifle

89SWS1



0003544872

0700

Stencil SWS Container

89SWS1



.OP0700

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6361027

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-29-04	RTZ
600	PROOF		12-29-04	A
607	CHECK HEADSPACE		12-29-04	A
610	DIS-ASSEMBLE GUN		12-30-04	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		1-3-05	CW
617	DRILL AND TAP SIGHT HOLES		12-30-04	TRW
620	APPLY COATINGS (BARREL ACTION)		1/8/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-12-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-12-05	RTZ
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-12-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-12-05	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>6.0</u>	<u>6.0</u>	<u>5.5</u>	1-21-05	RA		
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	<u>2.0</u>	<u>2.5</u>	<u>2.5</u>	1-21-05	RA		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	<u>1023</u>	<u>1023</u>	<u>1023</u>	1-21-05	RA		
	J) ASSEMBLE STOCK					1-12-05	RTL		
	K) ASSEMBLE SWIVEL STUDS								
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		N.A.						
	M) IRON SIGHT ALIGNMENT								
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER								
640	GALLERY TEST AND TARGET		PASS FAIL			1-14-05	AE		
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
645	INSPECT FOR LIVE AMMO					1-14-05	AE		
655	FINAL INSPECTION A) HEADSPACE								
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.83</u>	<u>2.82</u>	<u>2.91</u>	<u>2.82</u>	<u>2.88</u>	1-21-05	RA
	C) FUNCTION								
660	PACK					1-22-05	RA		

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6361027.___0
FILE DATE AND TIME: 01/14/2005 08:52

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

ERROR - NOT POSSIBLE TO REPORT SWS STATS ON DATA
WHERE TOTAL TARGETS ARE NOT EQUAL TO FIVE

AVE. MEAN 648

SERIAL NUMBER: G6361027. __0

TARGET NUMBER: 1

FILE DATE: 01/14/2005

FILE TIME: 08:52

POINT#	X	Y
1:	1.149	0.111
2:	0.018	-0.727
3:	0.065	0.115
4:	-0.181	0.000
5:	-0.999	0.654

X CENTROID: 0.010

Y CENTROID: 0.031

POA TO CENTROID: 0.032

HORZ SPREAD: 2.148

VERT SPREAD: 1.381

GROUP SPREAD: 2.216

MIN RADIUS: 0.101

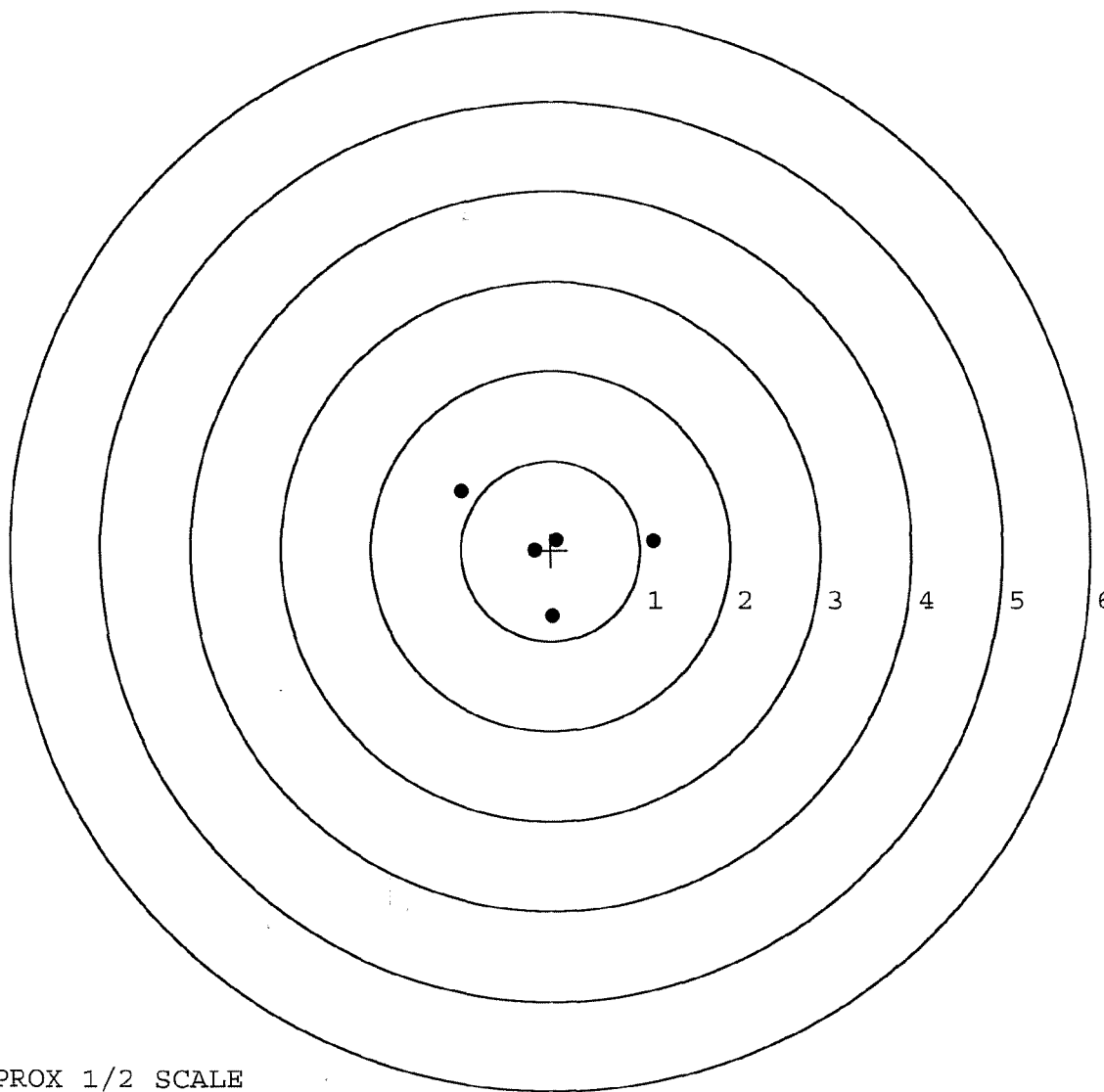
MAX RADIUS: 1.186

MEAN RADIUS: 0.676

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361027. 0

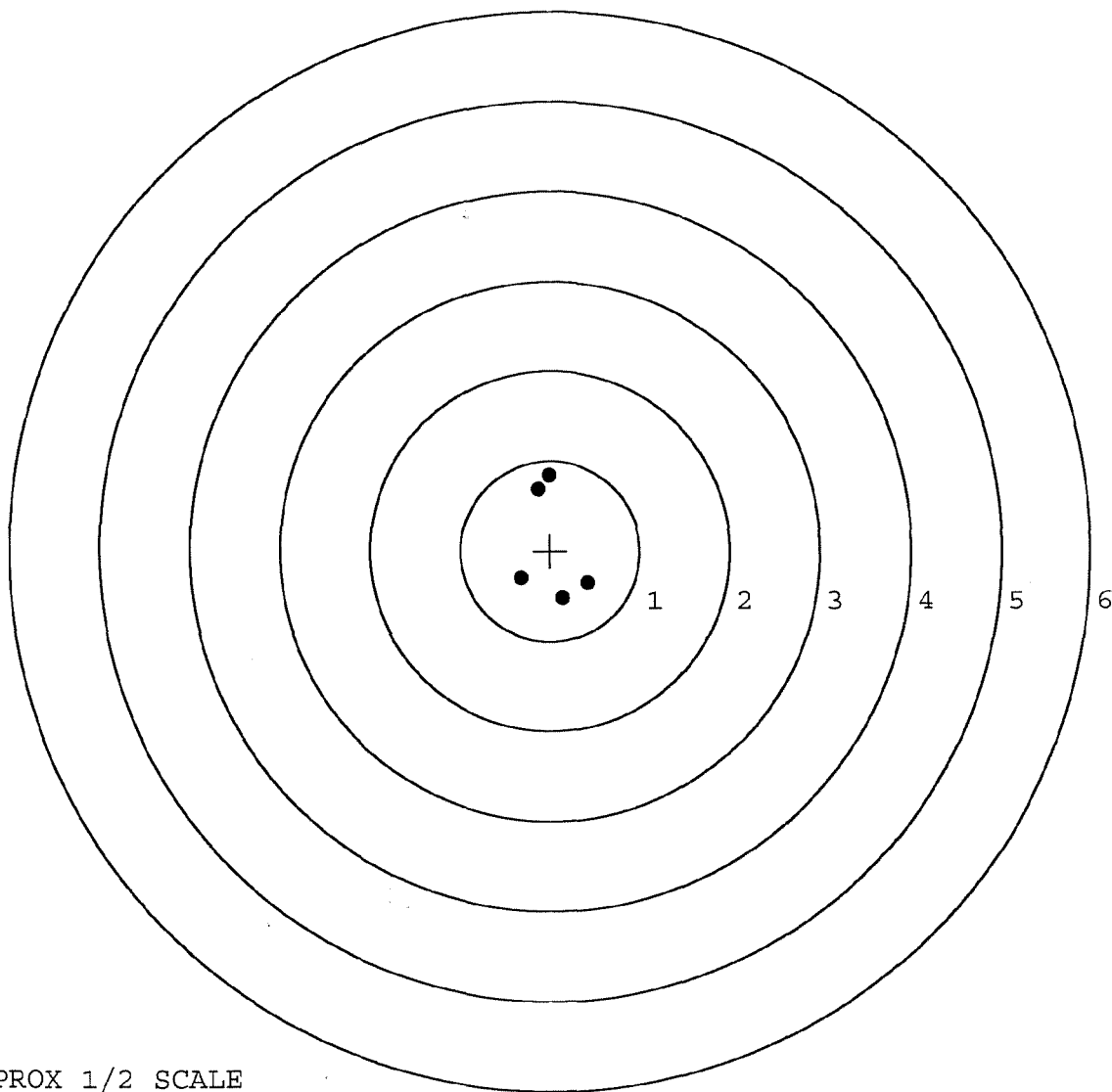
TARGET NUMBER: 2

FILE DATE: 01/14/2005

FILE TIME: 08:52

POINT#	X	Y
1:	0.416	-0.356
2:	0.135	-0.530
3:	-0.331	-0.300
4:	-0.136	0.682
5:	-0.015	0.837

X CENTROID: 0.014
Y CENTROID: 0.067
POA TO CENTROID: 0.068
HORZ SPREAD: 0.747
VERT SPREAD: 1.367
GROUP SPREAD: 1.375
MIN RADIUS: 0.503
MAX RADIUS: 0.771
MEAN RADIUS: 0.620
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE

AVERAGE PULL FORCE BETWEEN

SERIAL NO.

INITIAL **BARBER - M24 0082207**

2.50 LBS (plus or minus 0.50 LBS)

DATE

11-11-04

3.00 LBS (plus or minus 0.75 LBS)

TESTER

TRW

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.11	2.16		2.10	
PULL #2	2.12	2.41		2.26	
PULL #3	2.37	2.23		2.17	
PULL #4	2.42	2.25		2.15	
PULL #5	2.54	2.24		2.17	
TOTAL	11.56	11.29		10.85	
AVERAGE	2.31	2.25		2.17	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.17		
PULL #2	3.30	3.16		
PULL #3	3.20	3.07		
PULL #4	3.19	3.09		
PULL #5	3.15	3.24		
TOTAL	16.07	15.73		
AVERAGE	3.21	3.14		

	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	4.18	3.97		4.15
PULL #2	4.31	4.04		4.20
PULL #3	4.38	4.10		4.15
PULL #4	4.28	4.31		4.15
PULL #5	4.30	4.18		3.93
TOTAL	21.45	20.60		20.58
AVERAGE	4.29	4.12		4.11