

6360863

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

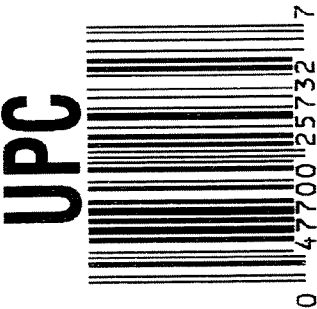
- INSTRUCTION BOOK 3518

DD FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5

G6360863



ORDER 25732
M/24 7.62 NATO (RIFLE ONLY)

UPC



ORDER 25732
M/24 7.62 NATO (RIFLE ONLY)

UPC



SERIAL NO.



10/26/2004 7:48:11 AM

Crib

2

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

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G636 0863

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	OKL NCR 		
615	ROLLMARK CALIBER		6-16-04	JB
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		10-12-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		10-12-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		10-12-04	RTL
	D) OIL FIRING PIN ASSEMBLY		10-12-04	RTL
	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>8.2</u>	<u>8.2</u>	<u>8.2</u>	10-21-04	DA
CONT.	G) SAFETY OFF FORCE	2 LBS MIN	<u>3.2</u>	<u>3.2</u>	<u>3.2</u>	10-21-04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY						
	I) FIRING PIN INDENT	.020 MIN	<u>.024</u>	<u>.024</u>	<u>.023</u>	10-21-04	DA
	J) ASSEMBLE STOCK					10-12-04	RTZ
	K) ASSEMBLE SWIVEL STUDS					10-26-04	RTZ
	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		10-15-04	TRW
	MALFUNCTION <i>Bolt Release sticks</i>		CORRECTION	OK		10-19-04	TRW
	MALFUNCTION <i>MCW</i>		CORRECTION	OK		10-19-04 10-19-04	TRW
	MALFUNCTION		CORRECTION			NA	TRW
	MALFUNCTION		CORRECTION			NA	TRW
645	INSPECT FOR LIVE AMMO					10-15-04	TRW
655	FINAL INSPECTION A) HEADSPACE					10-26-04	RTZ
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.67</u>	<u>2.80</u>	<u>2.79</u> <u>2.55</u> <u>2.51</u>	10-21-04	DA
	C) FUNCTION					10-26-04	RTZ
660	PACK					10/28/04	DA

AVERAGE PULL FORCE BETWEEN
 INITIAL & CYCLE TESTS
BARBER - M24 0084038
 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 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	2.43	2.54		2.47	
PULL #2	2.34	2.46		2.38	
PULL #3	2.29	2.46		2.43	
PULL #4	2.22	2.43		2.35	
PULL #5	2.23	2.29		2.33	
TOTAL	11.51	12.18		11.96	
AVERAGE	2.30	2.43		2.39	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.13		
PULL #2	3.23	3.16		
PULL #3	3.27	3.07		
PULL #4	3.04	3.07		
PULL #5	3.20	3.01		
TOTAL	15.86	15.44		
AVERAGE	3.17	3.08		

	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	4.28	4.25		4.41
PULL #2	4.16	4.09		4.38
PULL #3	4.22	4.16		4.32
PULL #4	4.22	4.13		4.39
PULL #5	4.20	4.60		4.37
TOTAL	21.08	21.23		21.87
AVERAGE	4.21	4.24		4.37

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360863.___0

FILE DATE AND TIME: 10/15/2004 07:05

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.004
The Average Y Centroid of the Five Target Set:	0.031
The Average Point of Impact of the Five Target Set:	0.032
The Average Mean Radius of the Five Target Set:	0.664
The Distance from POA to Centroid Target #1:	0.095
The Distance from Centroid Target #2 to Centroid Target #1:	0.200
The Distance from Centroid Target #3 to Centroid Target #1:	0.221
The Distance from Centroid Target #4 to Centroid Target #1:	0.161
The Distance from Centroid Target #5 to Centroid Target #1:	0.177

BARBER - M24 0084040

SERIAL NUMBER: G6360863. __0

TARGET NUMBER: 1

FILE DATE: 10/15/2004

FILE TIME: 07:05

POINT#	X	Y
1:	0.512	-1.284
2:	-0.044	-0.791
3:	-0.537	-0.714
4:	0.616	1.062
5:	0.477	0.315
6:	0.212	0.118
7:	0.036	0.021
8:	-0.255	0.681
9:	-0.492	0.479
10:	-1.077	0.890

X CENTROID: -0.055

Y CENTROID: 0.078

POA TO CENTROID: 0.095

HORZ SPREAD: 1.693

VERT SPREAD: 2.346

GROUP SPREAD: 2.693

MIN RADIUS: 0.107

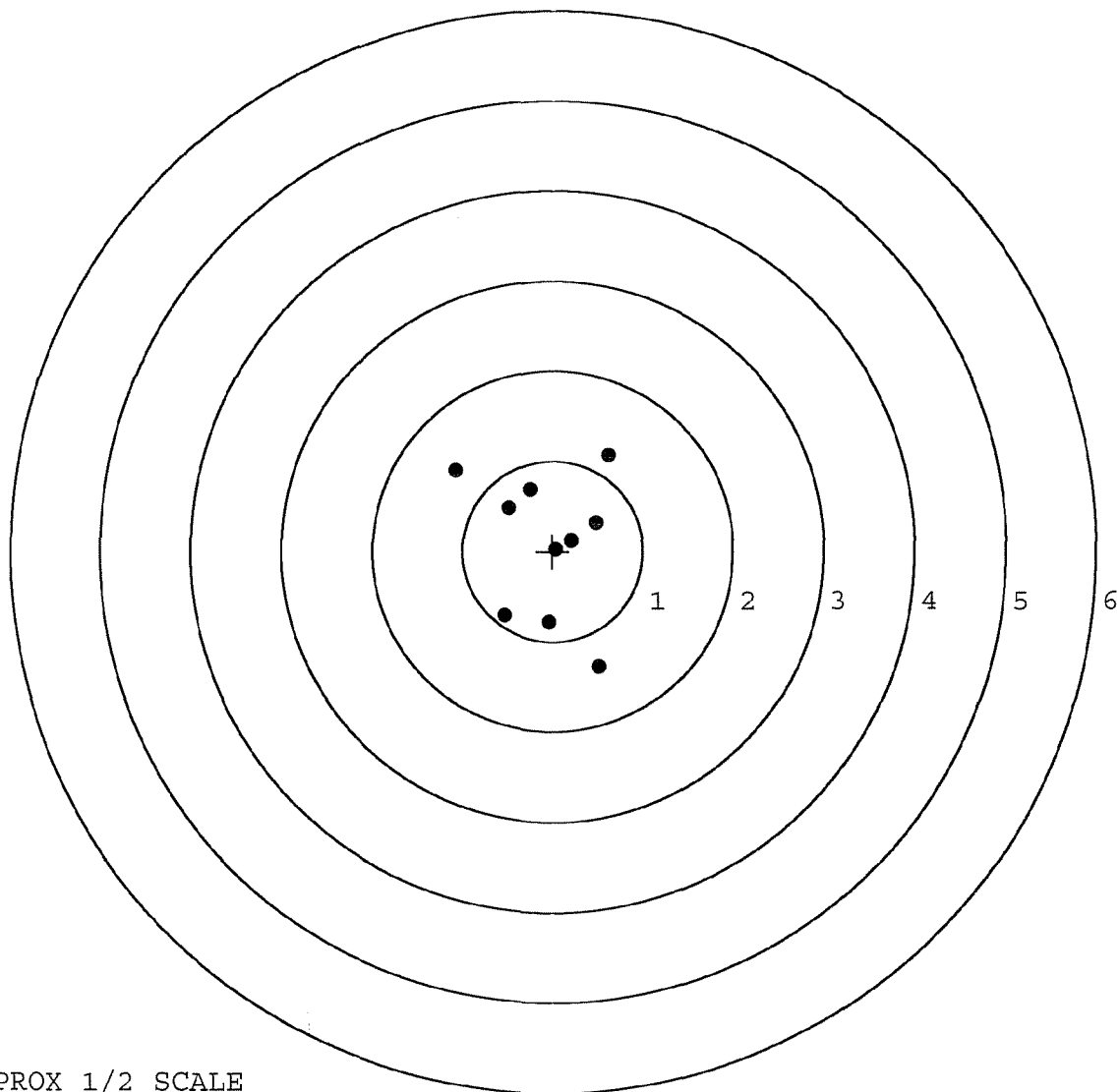
MAX RADIUS: 1.475

MEAN RADIUS: 0.796

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



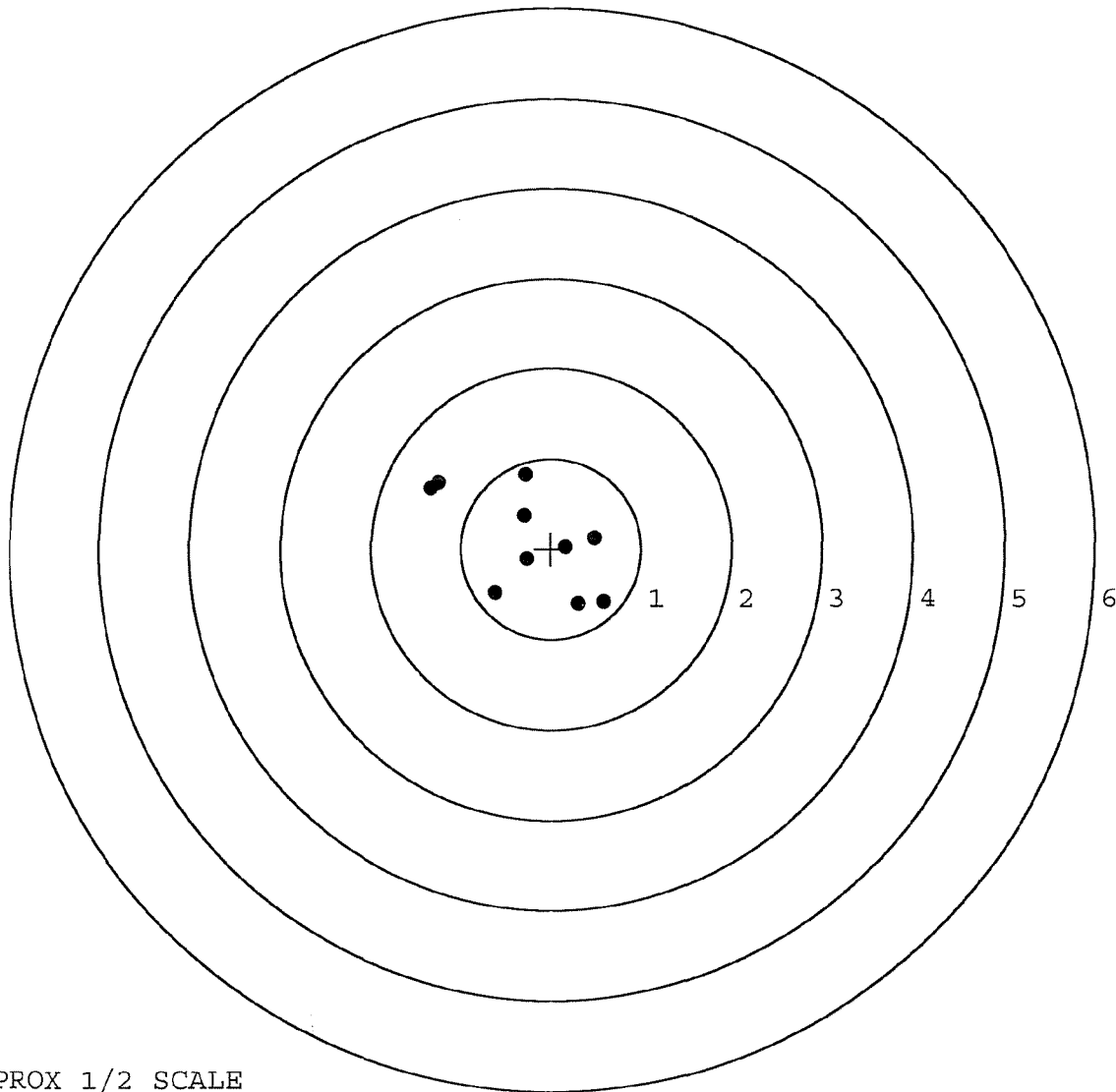
TARGET APPROX 1/2 SCALE

BARBER - M24 0084041

SERIAL NUMBER: G6360863. __0
 TARGET NUMBER: 2
 FILE DATE: 10/15/2004
 FILE TIME: 07:05

POINT#	X	Y
1:	0.585	-0.591
2:	0.306	-0.608
3:	0.478	0.122
4:	0.163	0.022
5:	-0.269	-0.117
6:	-0.620	-0.489
7:	-1.344	0.669
8:	-1.258	0.739
9:	-0.301	0.370
10:	-0.289	0.822

X CENTROID: -0.255
 Y CENTROID: 0.094
 POA TO CENTROID: 0.272
 HORZ SPREAD: 1.929
 VERT SPREAD: 1.430
 GROUP SPREAD: 2.304
 MIN RADIUS: 0.211
 MAX RADIUS: 1.232
 MEAN RADIUS: 0.747
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0084042

SERIAL NUMBER: G6360863. 0

TARGET NUMBER: 3

FILE DATE: 10/15/2004

FILE TIME: 07:05

POINT#	X	Y
1:	-0.337	-1.092
2:	0.073	-0.921
3:	-0.014	-0.543
4:	0.258	1.122
5:	0.450	0.519
6:	0.680	0.313
7:	0.144	0.404
8:	0.292	0.086
9:	-0.115	-0.126
10:	0.038	0.125

X CENTROID: 0.147

Y CENTROID: -0.011

POA TO CENTROID: 0.147

HORZ SPREAD: 1.017

VERT SPREAD: 2.214

GROUP SPREAD: 2.293

MIN RADIUS: 0.174

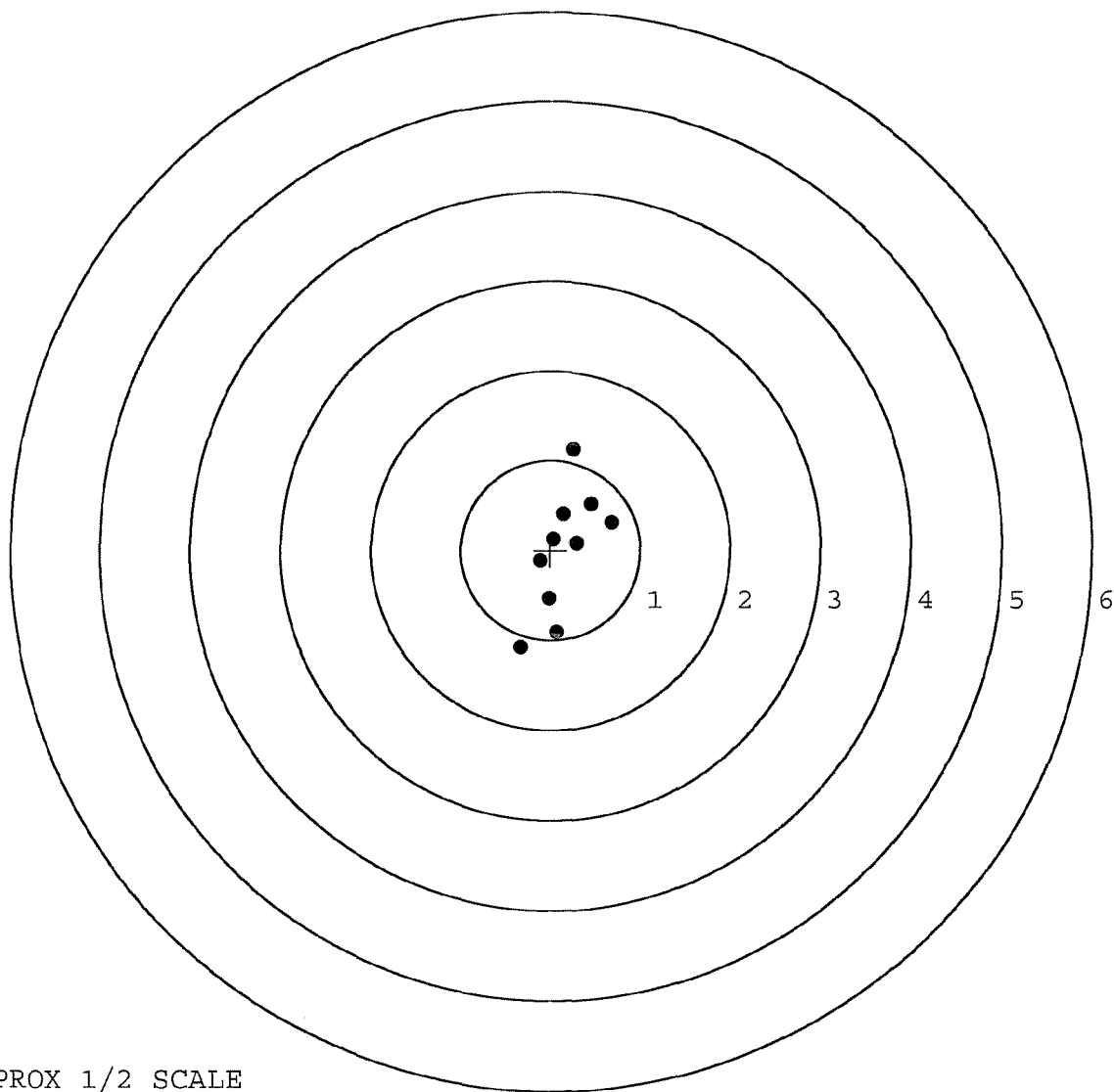
MAX RADIUS: 1.184

MEAN RADIUS: 0.608

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



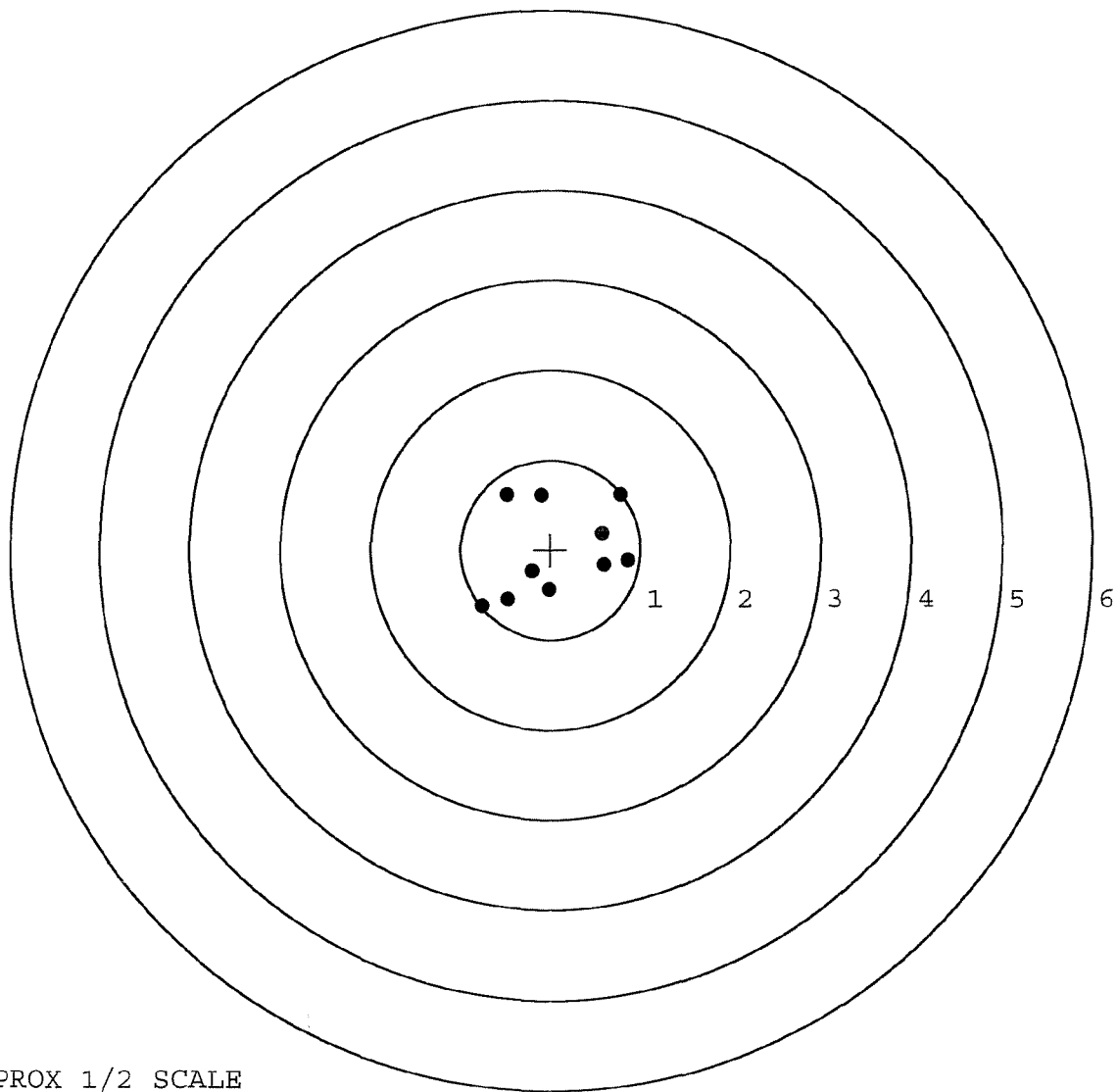
TARGET APPROX 1/2 SCALE

BARBER - M24 0084043

SERIAL NUMBER: G6360863. 0
 TARGET NUMBER: 4
 FILE DATE: 10/15/2004
 FILE TIME: 07:05

POINT#	X	Y
1:	0.860	-0.122
2:	0.597	-0.169
3:	0.572	0.184
4:	0.779	0.614
5:	-0.111	0.607
6:	-0.491	0.607
7:	-0.209	-0.246
8:	-0.014	-0.451
9:	-0.474	-0.566
10:	-0.762	-0.634

X CENTROID: 0.075
 Y CENTROID: -0.018
 POA TO CENTROID: 0.077
 HORZ SPREAD: 1.622
 VERT SPREAD: 1.248
 GROUP SPREAD: 1.983
 MIN RADIUS: 0.364
 MAX RADIUS: 1.039
 MEAN RADIUS: 0.693
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



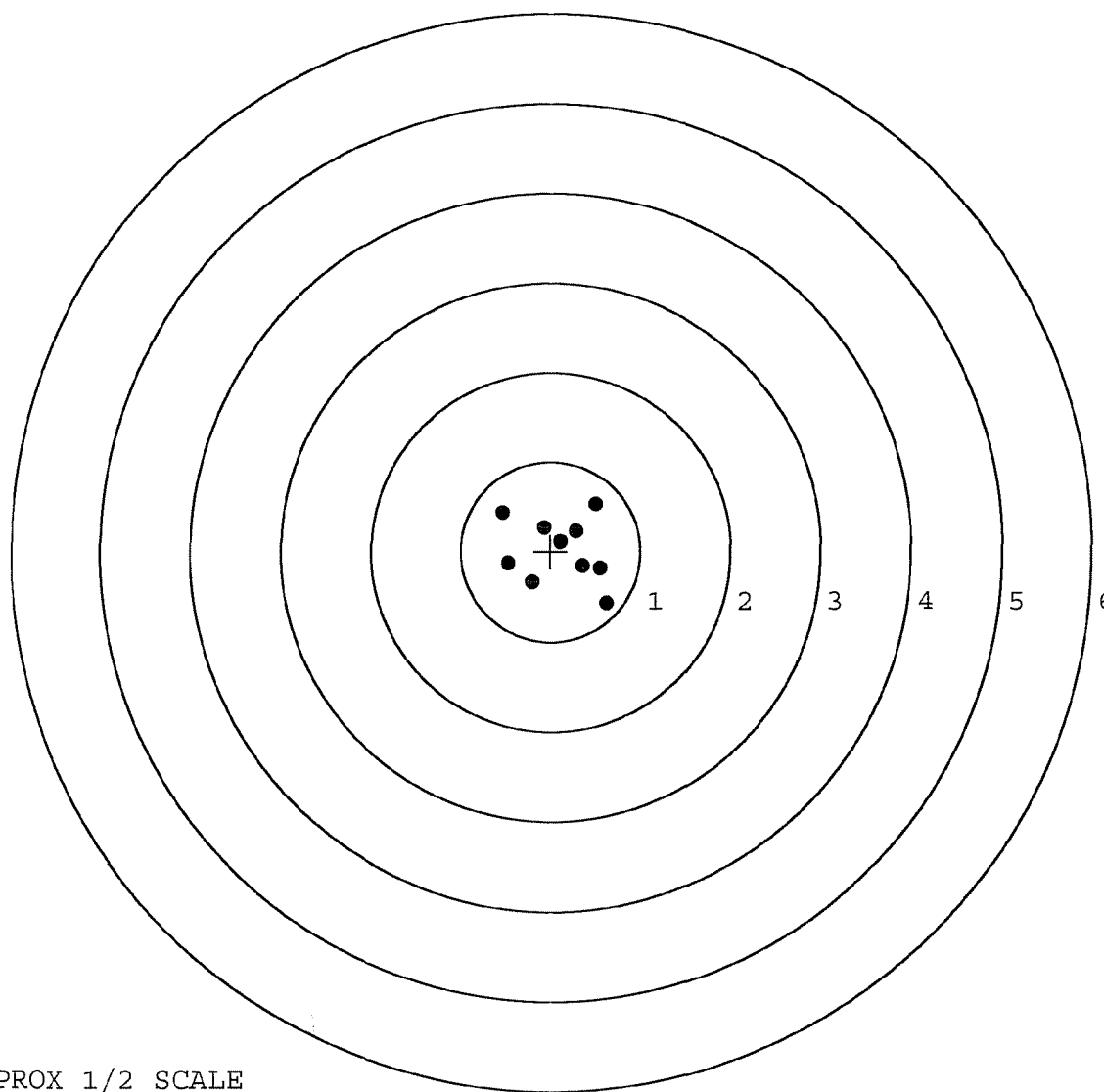
TARGET APPROX 1/2 SCALE

BARBER - M24 0084044

SERIAL NUMBER: G6360863. __0
 TARGET NUMBER: 5
 FILE DATE: 10/15/2004
 FILE TIME: 07:05

POINT#	X	Y
1:	0.623	-0.576
2:	0.496	0.525
3:	-0.544	0.427
4:	-0.474	-0.134
5:	-0.209	-0.342
6:	-0.081	0.265
7:	0.274	0.220
8:	0.105	0.111
9:	0.357	-0.164
10:	0.553	-0.191

X CENTROID: 0.110
 Y CENTROID: 0.014
 POA TO CENTROID: 0.111
 HORZ SPREAD: 1.167
 VERT SPREAD: 1.101
 GROUP SPREAD: 1.539
 MIN RADIUS: 0.097
 MAX RADIUS: 0.782
 MEAN RADIUS: 0.474
 # IN 1 IN DIAMETER: 6
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE