

G 6410273

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

G6410273

UPC



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M/24 7.62 NATO (RIFLE ONLY)

UPC



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M/24 7.62 NATO (RIFLE ONLY)

UPC



SERIAL NO.



25732

M/24 7.62 NATO (RIFLE ONLY)



.MA25732

Shop Order: SWS5732 - NOV



.ABSWS5732 - NOV

Start Date: 10/4/2004

Finish Date: 11/18/2004

0540

01PC001

Flat Black Powder Coat, Barrel and



0003516940

0560

89SWS1

Reassemble Action.



0003516941

0690

89SWS1

Pack Rifle



0003516952

0700

89SWS1

Stencil SWS Container



.OP0700

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66410273

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-29-04	RTL
600	PROOF		12-29-04	A
607	CHECK HEADSPACE		12-29-04	RTZ
610	DIS-ASSEMBLE GUN		12-30-04	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		12-30-04	RTZ
615	ROLLMARK CALIBER		1-3-05	CW
617	DRILL AND TAP SIGHT HOLES		12-30-04	TRLW
620	APPLY COATINGS (BARREL ACTION)		1/8/05	HP
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		1-12-05	RA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-12-05	RA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-13-05	RR
	D) OIL FIRING PIN ASSEMBLY		1-13-05	RR
	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>6.9</u> <u>7.2</u> <u>7.0</u>		
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.9</u> <u>3.4</u> <u>2.5</u>		
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1.022</u> <u>.021</u> <u>1.022</u>		
	J) ASSEMBLE STOCK		1-13-05	RTL
	K) ASSEMBLE SWIVEL STUDS		1-22-05	RL
	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			
	GALLERY TEST AND			
640	TARGET	PASS FAIL	1-13-05	TRW
	MALFUNCTION <i>Off over live rd.</i>	CORRECTION <i>OK</i>	1-21-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-13-05	TRW
655	FINAL INSPECTION A) HEADSPACE		1-22-05	RL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.34</u> <u>2.22</u> <u>2.31</u> <u>2.36</u>	1-22-05	RTA
	C) FUNCTION		1-22-05	RTA
660	PACK		1-24-05	RTA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
BARBER - M24 0149547
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

11-9-04

TESTER

TRL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.41	2.45		2.12	
PULL #2	2.45	2.60		2.11	
PULL #3	2.65	2.78		2.06	
PULL #4	2.41	2.81		2.04	
PULL #5	2.64	2.78		2.02	
TOTAL	12.56	13.42		10.35	
AVERAGE	2.51	2.68		2.07	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.00		
PULL #2	3.22	3.26		
PULL #3	3.38	3.19		
PULL #4	3.29	3.05		
PULL #5	3.20	3.05		
TOTAL	16.48	15.55		
AVERAGE	3.29	3.11		

	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	4.06		4.15
PULL #2	4.26	4.27		3.85
PULL #3	4.22	4.19		3.97
PULL #4	4.28	4.19		3.99
PULL #5	4.15	4.30		4.15
TOTAL	21.09	21.01		20.11
AVERAGE	4.21	4.20		4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410273.___0
FILE DATE AND TIME: 01/13/2005 10:47

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 .794

BARBER - M24 0149549

SERIAL NUMBER: G6410273. __0

TARGET NUMBER: 1

FILE DATE: 01/13/2005

FILE TIME: 10:47

POINT#	X	Y
1:	0.509	-0.482
2:	-0.389	-1.015
3:	-0.420	-0.111
4:	-0.038	0.392
5:	0.103	1.055

X CENTROID: -0.047

Y CENTROID: -0.032

POA TO CENTROID: 0.057

HORZ SPREAD: 0.929

VERT SPREAD: 2.070

GROUP SPREAD: 2.128

MIN RADIUS: 0.381

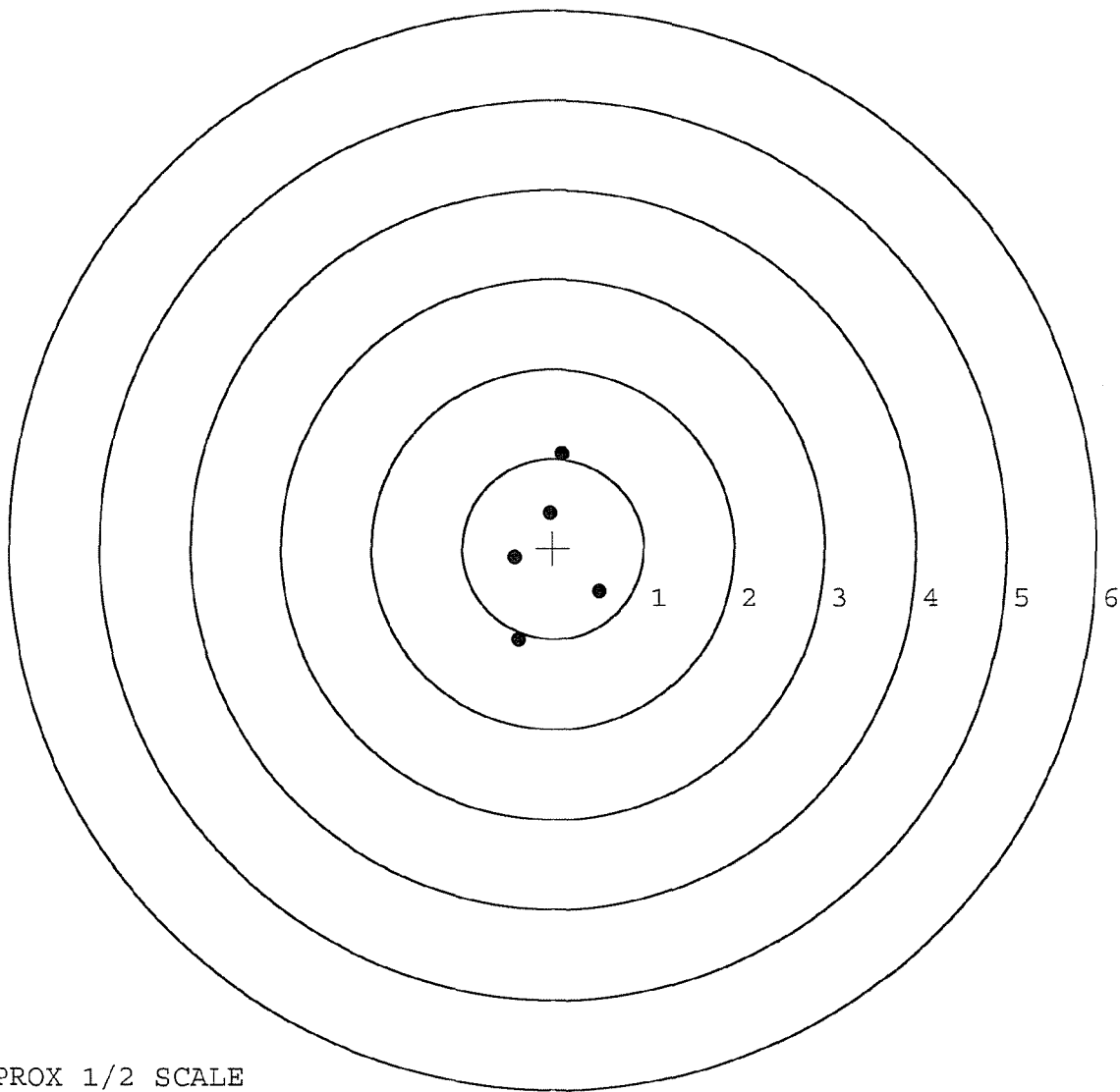
MAX RADIUS: 1.097

MEAN RADIUS: 0.732

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 3

in 3 IN DIAMETER: 5



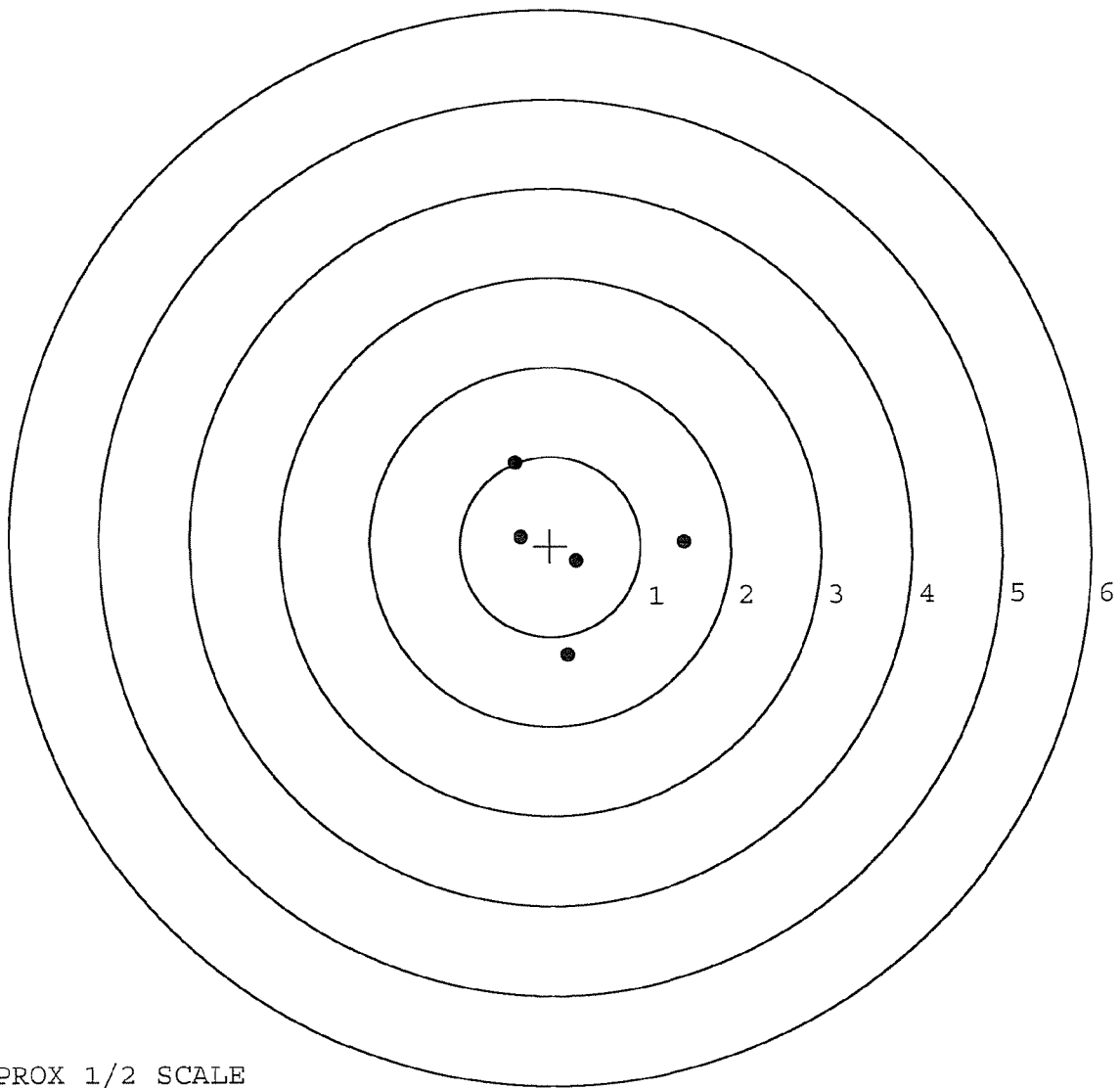
TARGET APPROX 1/2 SCALE

BARBER - M24 0149550

SERIAL NUMBER: G6410273. __0
TARGET NUMBER: 2
FILE DATE: 01/13/2005
FILE TIME: 10:47

POINT#	X	Y
1:	1.485	0.037
2:	0.181	-1.212
3:	0.277	-0.170
4:	-0.327	0.099
5:	-0.390	0.930

X CENTROID: 0.245
Y CENTROID: -0.063
POA TO CENTROID: 0.253
HORZ SPREAD: 1.875
VERT SPREAD: 2.142
GROUP SPREAD: 2.077
MIN RADIUS: 0.111
MAX RADIUS: 1.244
MEAN RADIUS: 0.856
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 2
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE