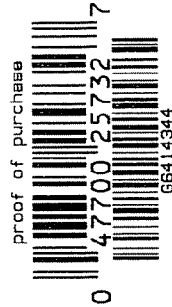


G-6414344

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

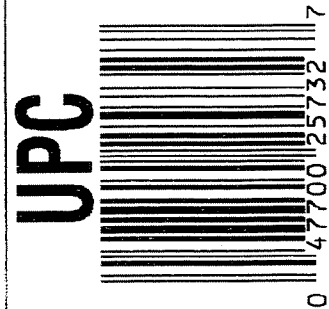
- INSTRUCTION BOOK 3518

DD FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5

G6414344



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 7:46 AM

Original

Original

25732

M/24 7.62 NATO (RIFLE ONLY)



.MA25732

Shop Order: SWS5732 - B



.ABSWS5732 - B

Start Date: 9/8/2004

Finish Date: 10/27/2004

0540

01PC001

Flat Black Powder Coat. Barrel and



0003512656

0560

89SWS1

Reassemble Action.



0003512657

0690

89SWS1

Pack Rifle



0003512668

0700

89SWS1

Stencil SWS Container



.OP0700

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414344

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-9-04	RTL
600	PROOF		11-9-04	RTL
607	CHECK HEADSPACE	MAGNA-FLUX	11-9-04	RT
610	DIS-ASSEMBLE GUN	INSPECTED	11-10-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	NOV 10 2004 OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		11/11/04	JS
617	DRILL AND TAP SIGHT HOLES		11-10-04	TRU
620	APPLY COATINGS (BARREL ACTION)		11/13	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11/29/04	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/29/04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/29/04	DA
	D) OIL FIRING PIN ASSEMBLY		12-1-04	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>7.5</u> <u>8.2</u> <u>8.2</u>	12/7/04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.2</u> <u>2.5</u> <u>3.2</u>	12/7/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.023</u>	12/7/04	DA
	J) ASSEMBLE STOCK		12-1-04	RTL
	K) ASSEMBLE SWIVEL STUDS		12-7-04	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S	NA	X	
	M) IRON SIGHT ALIGNMENT	NA		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER	NA		
640	GALLERY TEST AND TARGET	PASS FAIL	12-3-04	TRW
	MALFUNCTION	CORRECTION	NA	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		12-3-04	TRW
655	FINAL INSPECTION A) HEADSPACE		12-7-04	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.86</u> <u>2.89</u> <u>2.88</u> <u>2.53</u> <u>2.41</u>	12/7/04	DA
	C) FUNCTION		12-7-04	AC
660	PACK		12/8/04	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & FINAL

SERIAL NO.

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

TESTER

12-1-04

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.17	2.12		2.03	
PULL #2	2.59	2.44		2.05	
PULL #3	2.71	2.40		2.18	
PULL #4	2.73	2.30		2.14	
PULL #5	2.66	2.31		2.30	
TOTAL	12.86	11.57		10.70	
AVERAGE	2.57	2.31		2.14	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.16		
PULL #2	3.37	3.15		
PULL #3	3.33	3.14		
PULL #4	3.31	3.24		
PULL #5	3.41	3.22		
TOTAL	16.81	15.91		
AVERAGE	3.36	3.18		

	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	4.35	4.19		4.33
PULL #2	4.26	4.28		4.59
PULL #3	4.40	4.24		4.60
PULL #4	4.19	4.18		4.43
PULL #5	4.32	4.20		4.47
TOTAL	21.52	21.09		22.42
AVERAGE	4.30	4.21		4.48

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414344.___0
FILE DATE AND TIME: 12/03/2004 19:14

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.013
The Average Y Centroid of the Five Target Set:	0.113
The Average Point of Impact of the Five Target Set:	0.114
The Average Mean Radius of the Five Target Set:	0.778
The Distance from POA to Centroid Target #1:	0.220
The Distance from Centroid Target #2 to Centroid Target #1:	0.578
The Distance from Centroid Target #3 to Centroid Target #1:	0.221
The Distance from Centroid Target #4 to Centroid Target #1:	0.253
The Distance from Centroid Target #5 to Centroid Target #1:	0.392

SERIAL NUMBER: G6414344. 0

TARGET NUMBER: 1

FILE DATE: 12/03/2004

FILE TIME: 19:14

POINT#	X	Y
1:	1.065	-0.205
2:	0.825	0.231
3:	0.260	-0.645
4:	-0.257	-0.213
5:	-0.320	0.324
6:	-0.941	-0.079
7:	-1.171	-0.583
8:	-0.333	0.957
9:	-0.189	1.385
10:	-1.136	-1.337

X CENTROID: -0.220

Y CENTROID: -0.017

POA TO CENTROID: 0.220

HORZ SPREAD: 2.236

VERT SPREAD: 2.722

GROUP SPREAD: 2.882

MIN RADIUS: 0.200

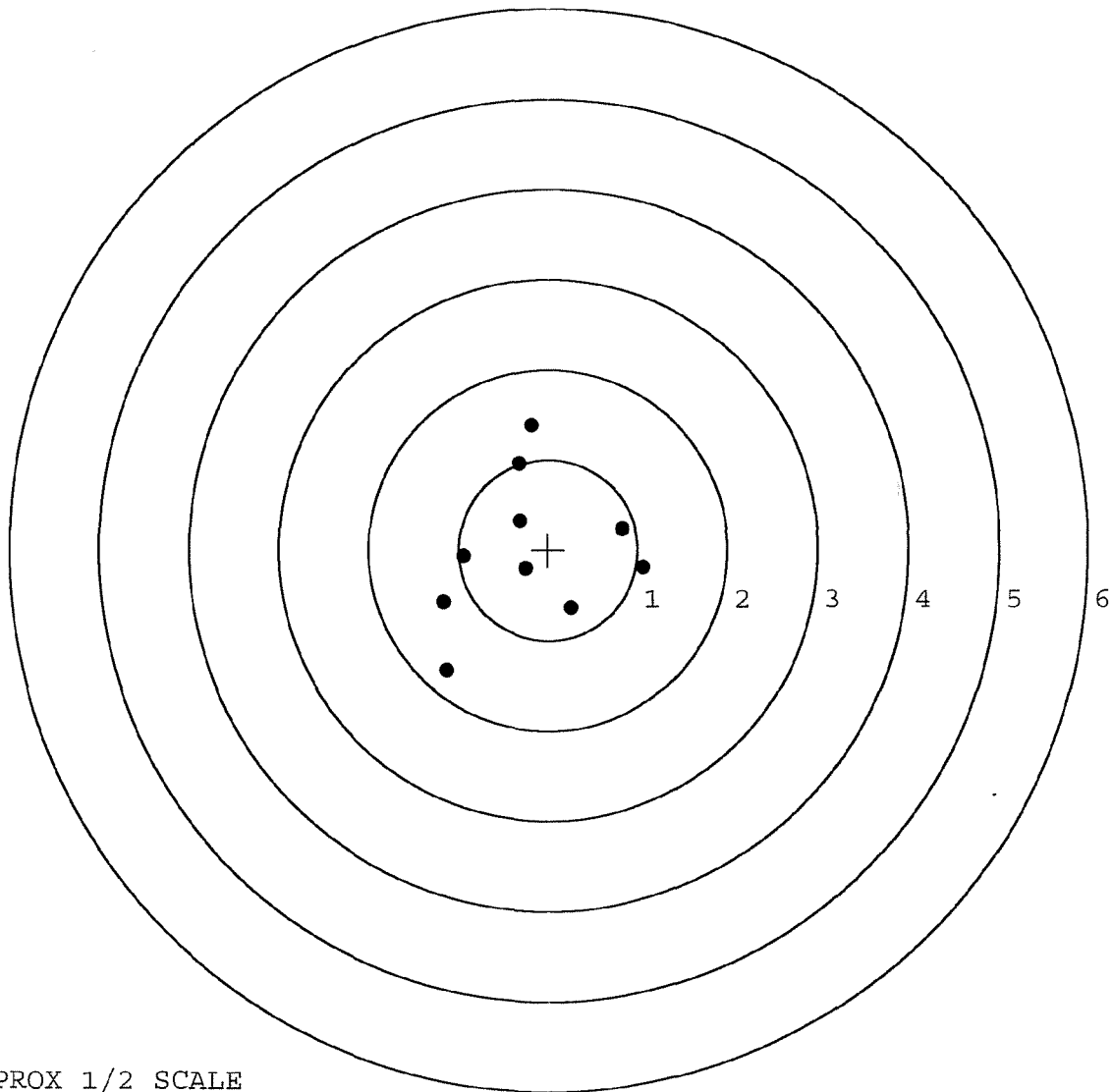
MAX RADIUS: 1.607

MEAN RADIUS: 0.954

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 5

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414344. 0

TARGET NUMBER: 2

FILE DATE: 12/03/2004

FILE TIME: 19:14

X CENTROID: 0.232

Y CENTROID: 0.343

POA TO CENTROID: 0.415

HORZ SPREAD: 1.541

VERT SPREAD: 2.384

GROUP SPREAD: 2.431

MIN RADIUS: 0.248

MAX RADIUS: 1.368

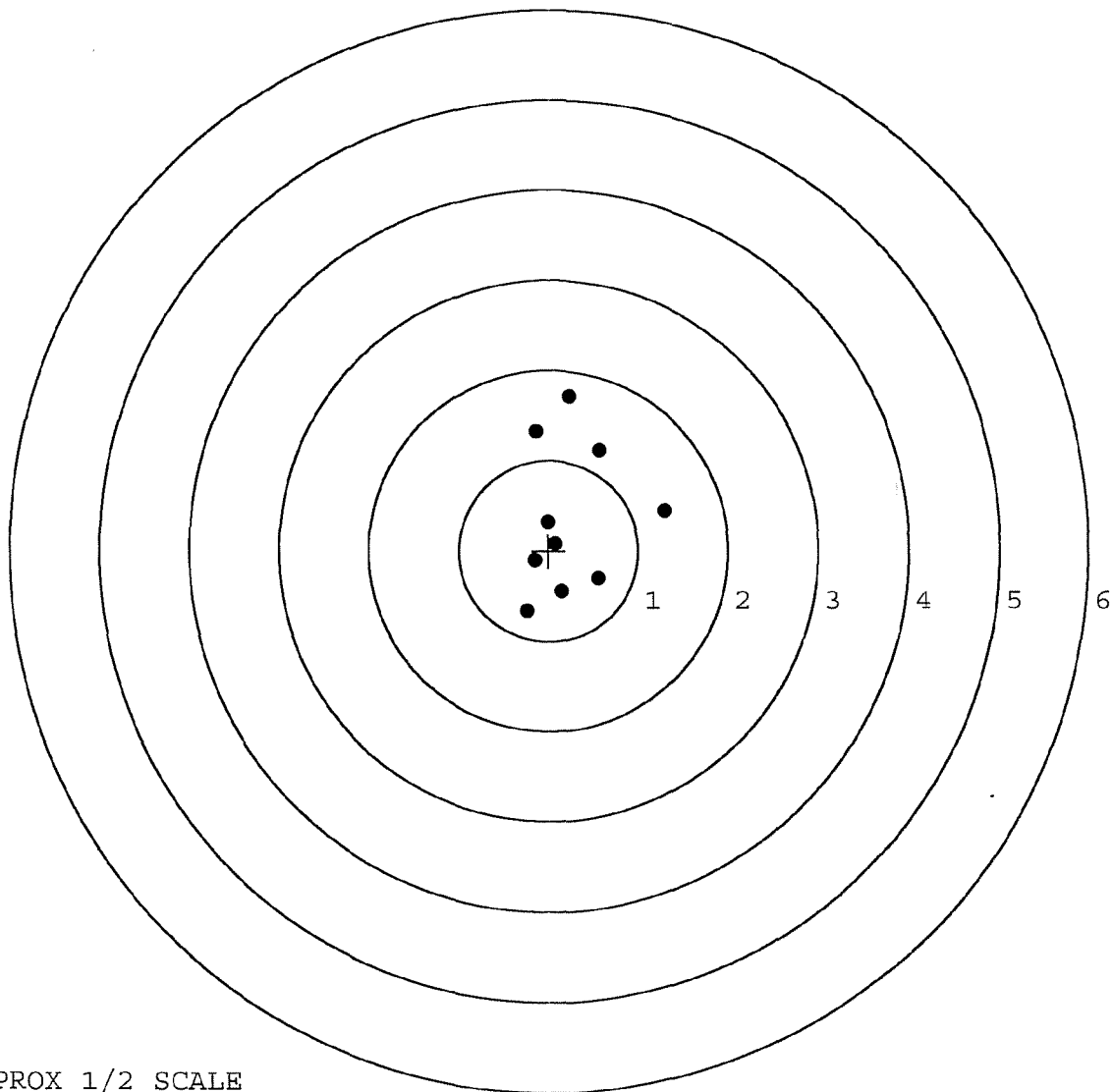
MEAN RADIUS: 0.811

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.300	0.435
2:	0.569	1.107
3:	-0.143	1.317
4:	0.233	1.711
5:	0.559	-0.303
6:	0.145	-0.447
7:	-0.241	-0.673
8:	-0.159	-0.108
9:	0.076	0.078
10:	-0.014	0.316



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414344. __0

TARGET NUMBER: 3

FILE DATE: 12/03/2004

FILE TIME: 19:14

X CENTROID: -0.010

Y CENTROID: -0.084

POA TO CENTROID: 0.084

HORZ SPREAD: 1.529

VERT SPREAD: 1.843

GROUP SPREAD: 1.906

MIN RADIUS: 0.153

MAX RADIUS: 0.983

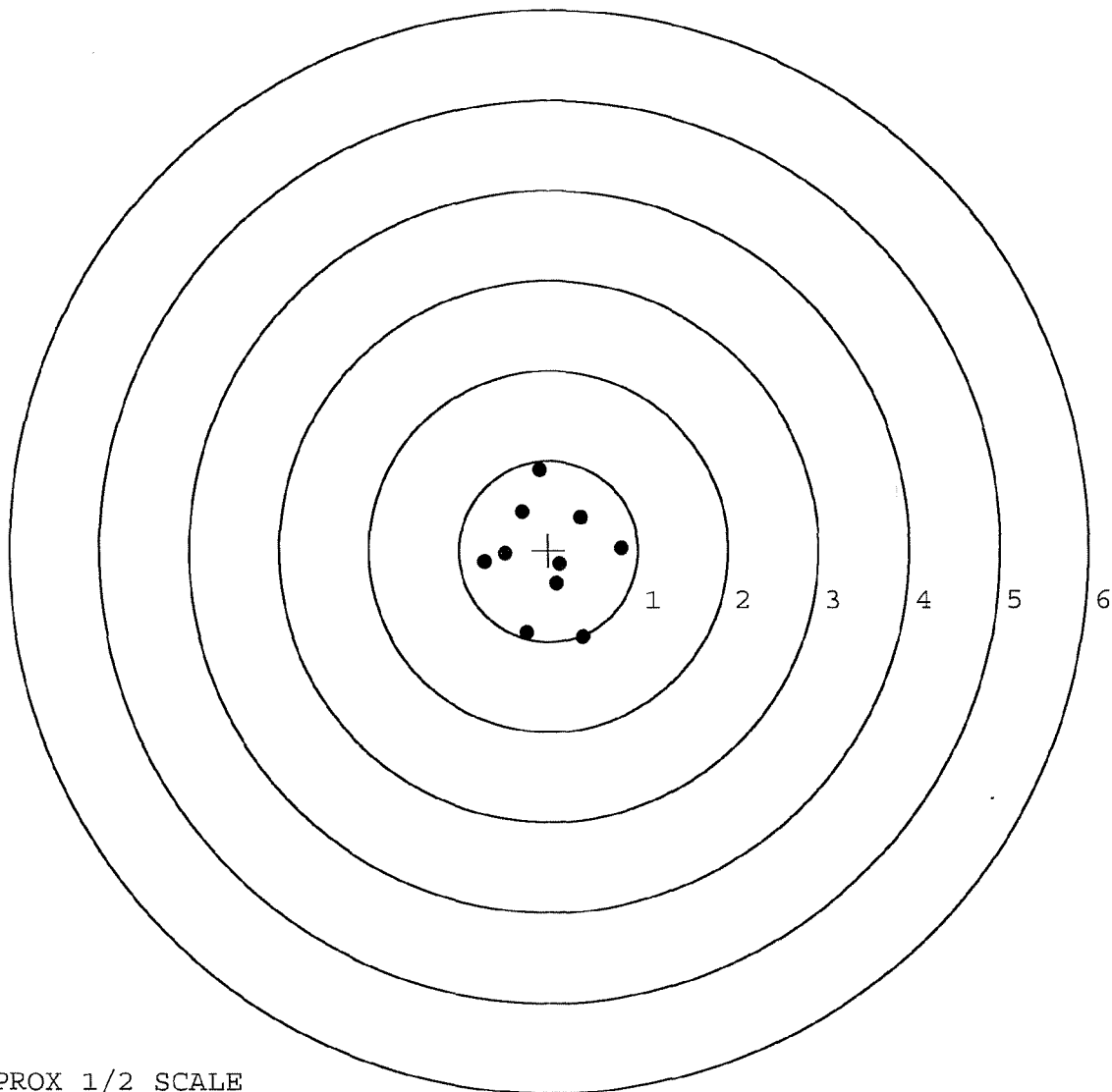
MEAN RADIUS: 0.645

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.382	-0.949
2:	-0.248	-0.909
3:	0.815	0.022
4:	0.355	0.370
5:	-0.105	0.894
6:	-0.303	0.432
7:	-0.493	-0.037
8:	-0.714	-0.131
9:	0.124	-0.159
10:	0.092	-0.372

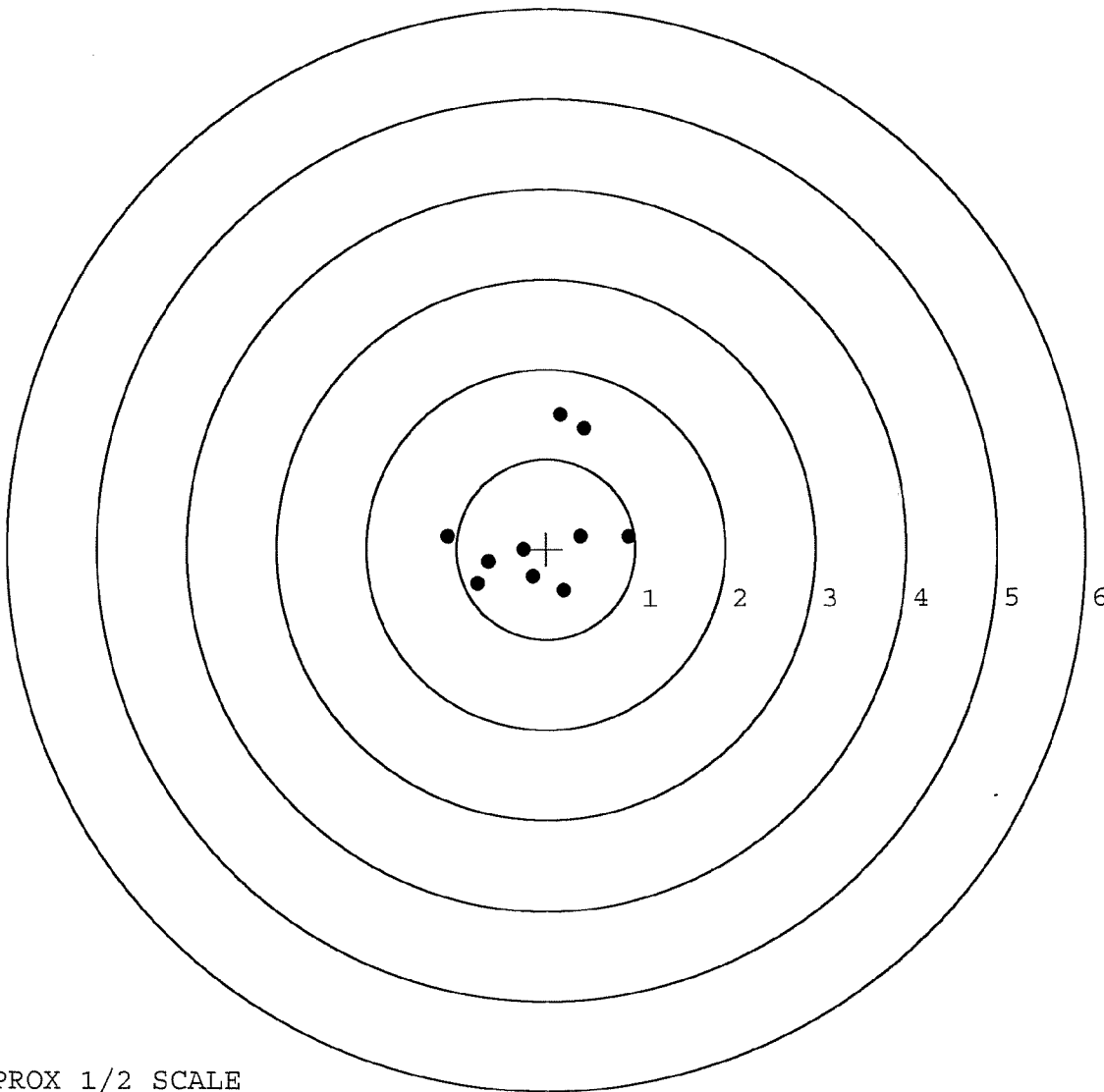


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414344. __ 0
 TARGET NUMBER: 4
 FILE DATE: 12/03/2004
 FILE TIME: 19:14

X CENTROID: -0.081
 Y CENTROID: 0.196
 POA TO CENTROID: 0.212
 HORZ SPREAD: 2.021
 VERT SPREAD: 1.965
 GROUP SPREAD: 2.101
 MIN RADIUS: 0.272
 MAX RADIUS: 1.326
 MEAN RADIUS: 0.812
 # IN 1 IN DIAMETER: 2
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.431	1.344
2:	0.164	1.499
3:	0.924	0.138
4:	0.384	0.145
5:	0.195	-0.466
6:	-0.152	-0.309
7:	-0.258	-0.011
8:	-0.641	-0.142
9:	-0.765	-0.385
10:	-1.097	0.143



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414344. 0

TARGET NUMBER: 5

FILE DATE: 12/03/2004

FILE TIME: 19:14

X CENTROID: 0.145

Y CENTROID: 0.127

POA TO CENTROID: 0.193

HORZ SPREAD: 1.680

VERT SPREAD: 1.519

GROUP SPREAD: 1.850

MIN RADIUS: 0.160

MAX RADIUS: 1.210

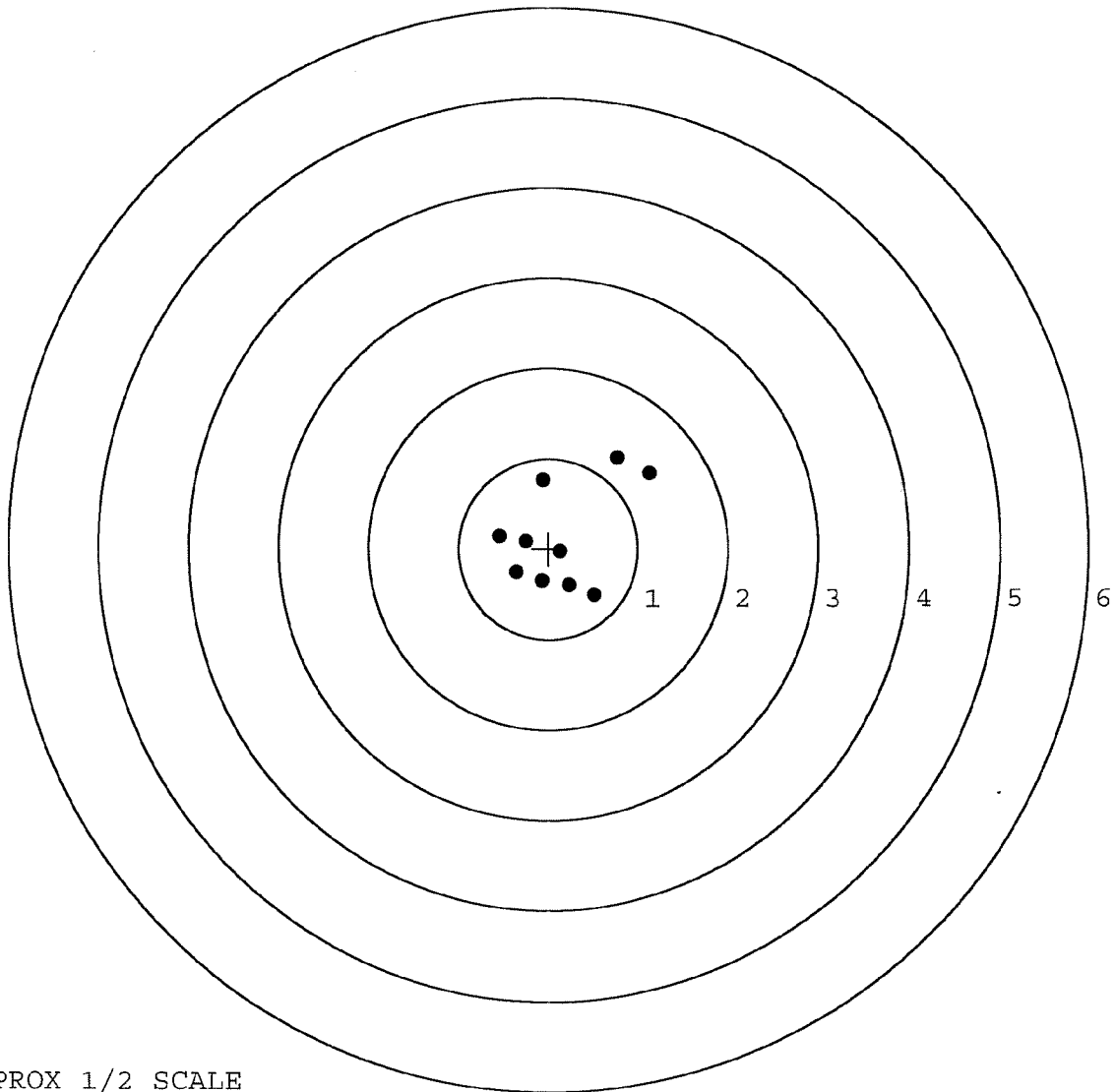
MEAN RADIUS: 0.667

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.127	0.834
2:	0.771	1.007
3:	-0.063	0.763
4:	-0.553	0.145
5:	-0.259	0.083
6:	0.128	-0.032
7:	0.510	-0.512
8:	0.233	-0.405
9:	-0.080	-0.354
10:	-0.363	-0.263



TARGET APPROX 1/2 SCALE