G6361015

9/27/2004 10:33:18 AM

Original 22 Crib

25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

.MA25716

Shop Order: SWS631059

.ABSWS631059

Start Date: 8/9/2004
Finish Date: 10/26/2004

0540 01PC001
Flat Black Powder Coat, Barrel and

0003451403

0560 89SWS1
Reassemble Action.

0003451404

0690 89SWS1
Pack Rifle

0003451397

0700 89SWS1
Stencil SWS Container

.OP0700

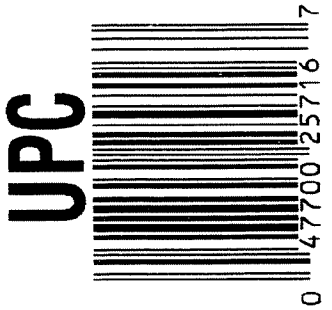
M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

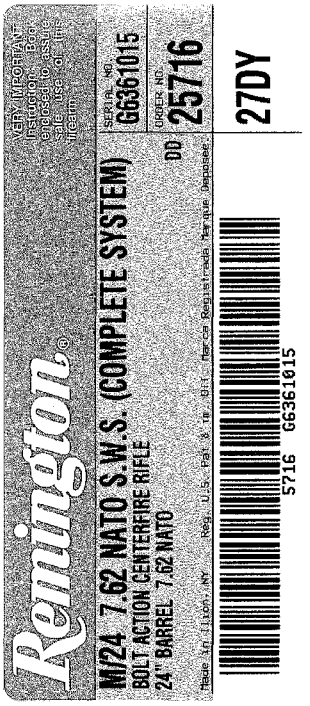
– INSTUCTION BOOK 3518

DD FORM

ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6361015





ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

UPC

0 47700 25716 7

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTI

UPC

0 47700 25716 7

SERIAL NO.

G63B1015

7/22/2004 3:21:04 PM

Original **30** crib

25716

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

.MA25716

Shop Order: SWS631055

.ABSWS631055

Start Date: 7/23/2004
Finish Date: 9/23/2004

0630 01PC001
Flat Black Powder Coat, Barrel and

0003338116

0640 89SWS1
Reassemble Action.

0003338117

0685 89SWS1
Attach Front and Rear Sight Assemblies

0003338122

0710 89SWS1
Pack Rifle & Stencil SWS Container

.OP0710

M-24

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G1a3601015

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	INSPECTED	6-15-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR BS		
615	ROLLMARK CALIBER		6-16-04	SB
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		7-6-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-6-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-6-04	RTL
	D) OIL FIRING PIN ASSEMBLY		9-6-04	TRW
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		9-21-04	TRW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE (2 LBS MIN 10 LBS MAX)	8.0 7.0 8.0	8/13/04	DA
CONT.	G) SAFETY OFF FORCE (2 LBS MIN)	2.5 2.5 2.5	8/13/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT (.020 MIN)	.025 .026 .026	8/13/04	DA
	J) ASSEMBLE STOCK		7-7-04	RTL
	K) ASSEMBLE SWIVEL STUDS		9-9-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-27-04	RTL
	M) IRON SIGHT ALIGNMENT		8-27-04	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-27-04	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	7-12-04	
	MALFUNCTION	CORRECTION	9-6-04	
	MALFUNCTION	CORRECTION	9-6-04	
	MALFUNCTION	CORRECTION	9-6-04	
	MALFUNCTION	CORRECTION	9-6-04	
645	INSPECT FOR LIVE AMMO		9-6-04	
655	FINAL INSPECTION A) HEADSPACE		9-9-04	RTL
	B) TRIGGER PULL (+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS)	2.77 2.79 2.74 2.80 2.72	8/13/04	DA
	C) FUNCTION		9-9-04	RTL
660	PACK		9/15/04	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 7-6-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.65	2.71		2.80	
PULL #2	2.77	2.76		2.74	
PULL #3	2.77	2.75		2.75	
PULL #4	2.70	2.81		2.74	
PULL #5	2.91	2.93		2.74	
TOTAL	13.80	13.96		13.77	
AVERAGE	2.76	2.79		2.75	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.12	3.15		
PULL #2	3.26	3.00		
PULL #3	3.31	3.10		
PULL #4	3.38	3.21		
PULL #5	3.35	3.27		
TOTAL	16.42	15.73		
AVERAGE	3.28	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	4.06		4.16
PULL #2	4.25	4.09		4.11
PULL #3	4.30	3.96		4.09
PULL #4	4.25	4.33		3.87
PULL #5	4.25	3.97		3.97
TOTAL	21.23	20.41		20.20
AVERAGE	4.24	4.08		4.04

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6361015.__0
FILE DATE AND TIME: 07/12/2004 06:58

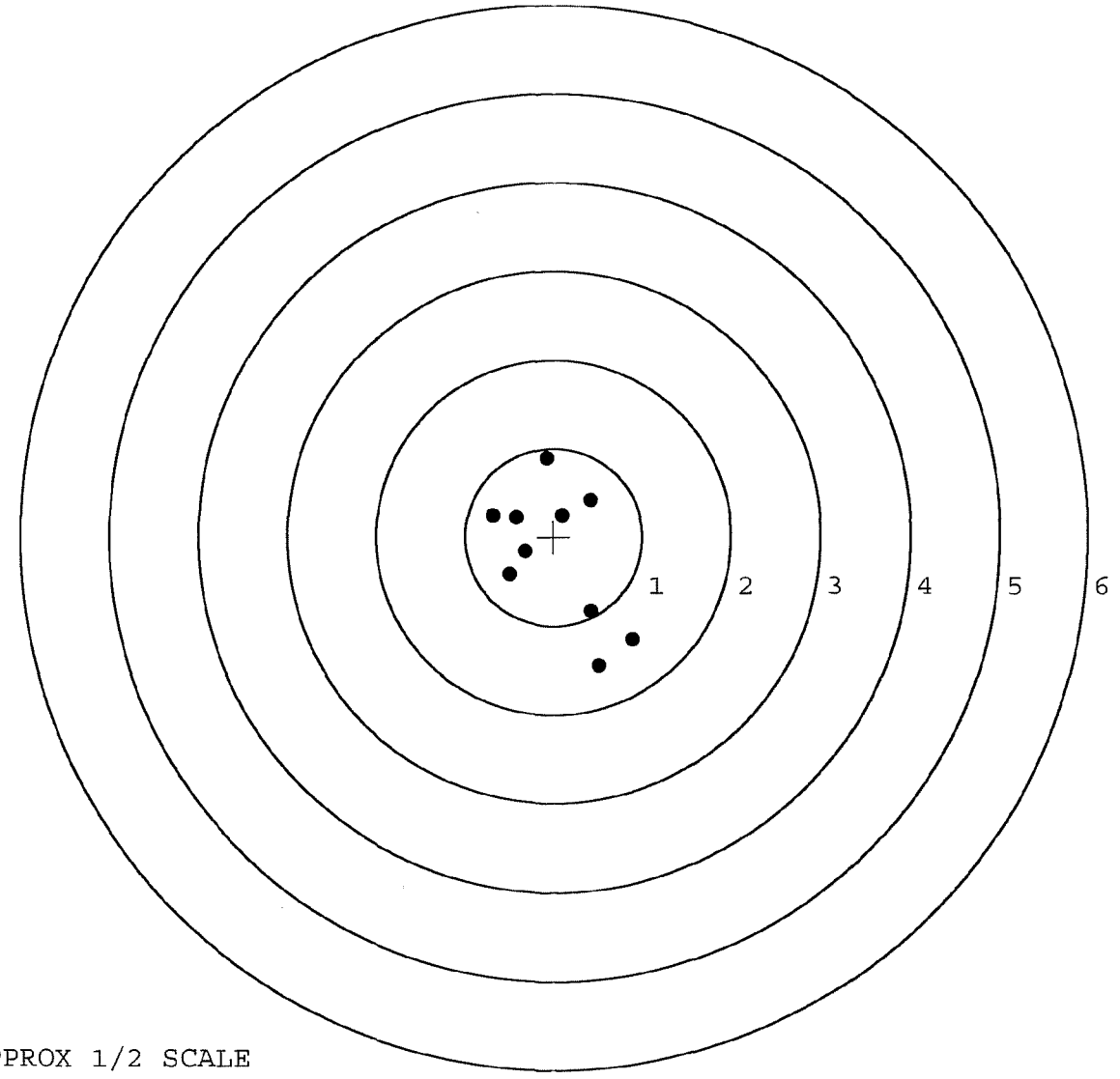
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.028
The Average Y Centroid of the Five Target Set:	-0.082
The Average Point of Impact of the Five Target Set:	0.087
The Average Mean Radius of the Five Target Set:	0.943
The Distance from POA to Centroid Target #1:	0.206
The Distance from Centroid Target #2 to Centroid Target #1:	0.179
The Distance from Centroid Target #3 to Centroid Target #1:	0.150
The Distance from Centroid Target #4 to Centroid Target #1:	0.097
The Distance from Centroid Target #5 to Centroid Target #1:	0.308

SERIAL NUMBER: G6361015.__0
TARGET NUMBER: 1
FILE DATE: 07/12/2004
FILE TIME: 06:58

X CENTROID:	0.032
Y CENTROID:	-0.204
POA TO CENTROID:	0.206
HORZ SPREAD:	1.578
VERT SPREAD:	2.344
GROUP SPREAD:	2.418
MIN RADIUS:	0.355
MAX RADIUS:	1.337
MEAN RADIUS:	0.804
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.889	-1.159
2:	0.510	-1.453
3:	0.421	-0.837
4:	-0.496	-0.427
5:	0.417	0.418
6:	0.095	0.244
7:	-0.085	0.891
8:	-0.421	0.218
9:	-0.689	0.235
10:	-0.321	-0.170

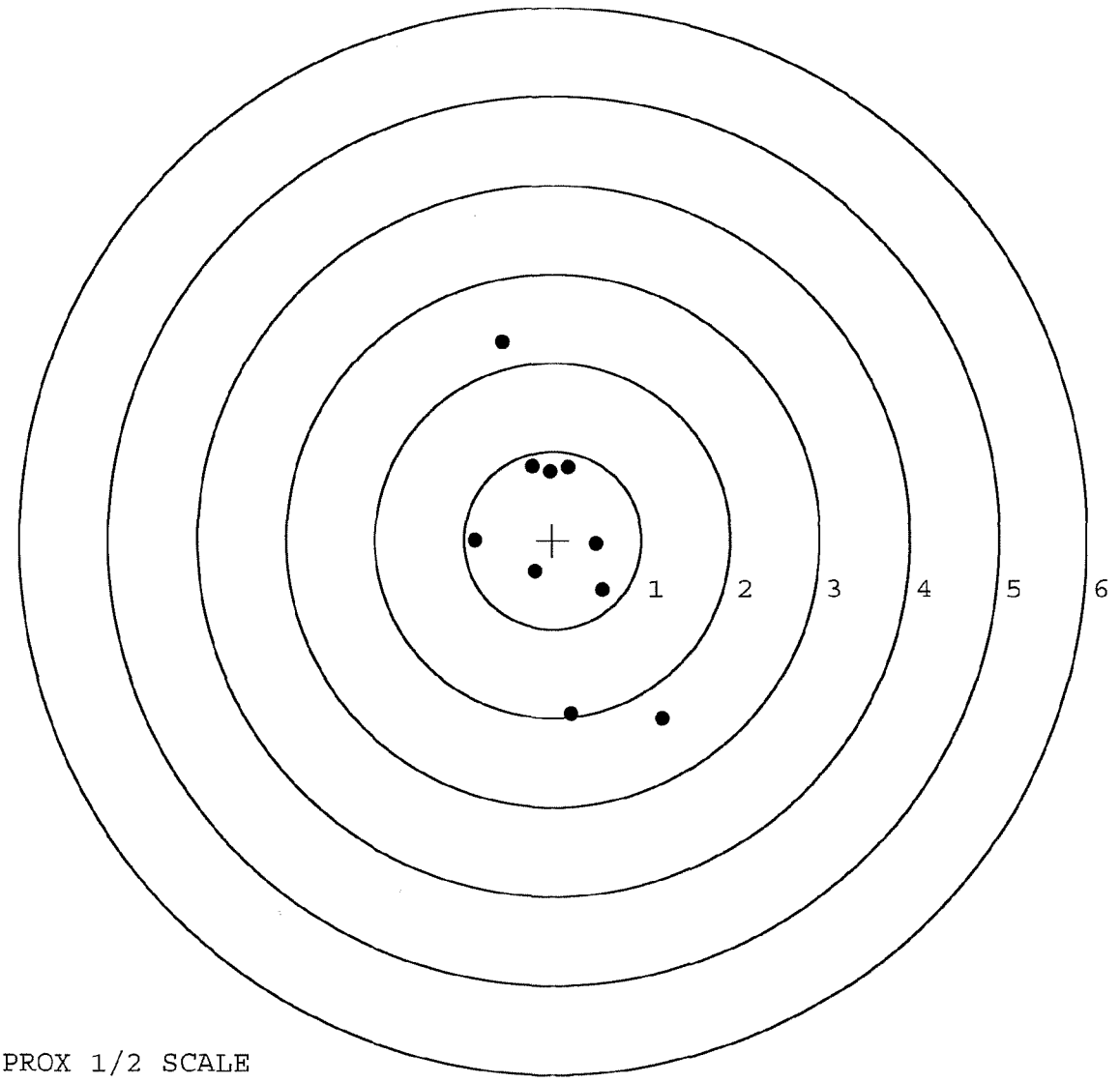


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361015.__0
TARGET NUMBER: 2
FILE DATE: 07/12/2004
FILE TIME: 06:58

X CENTROID:	0.075
Y CENTROID:	-0.031
POA TO CENTROID:	0.081
HORZ SPREAD:	2.117
VERT SPREAD:	4.248
GROUP SPREAD:	4.619
MIN RADIUS:	0.418
MAX RADIUS:	2.350
MEAN RADIUS:	1.169
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	7

POINT#	X	Y
1:	1.238	-2.020
2:	0.212	-1.966
3:	0.566	-0.561
4:	0.492	-0.046
5:	-0.205	-0.350
6:	-0.879	-0.008
7:	-0.235	0.831
8:	-0.039	0.770
9:	0.171	0.816
10:	-0.575	2.228

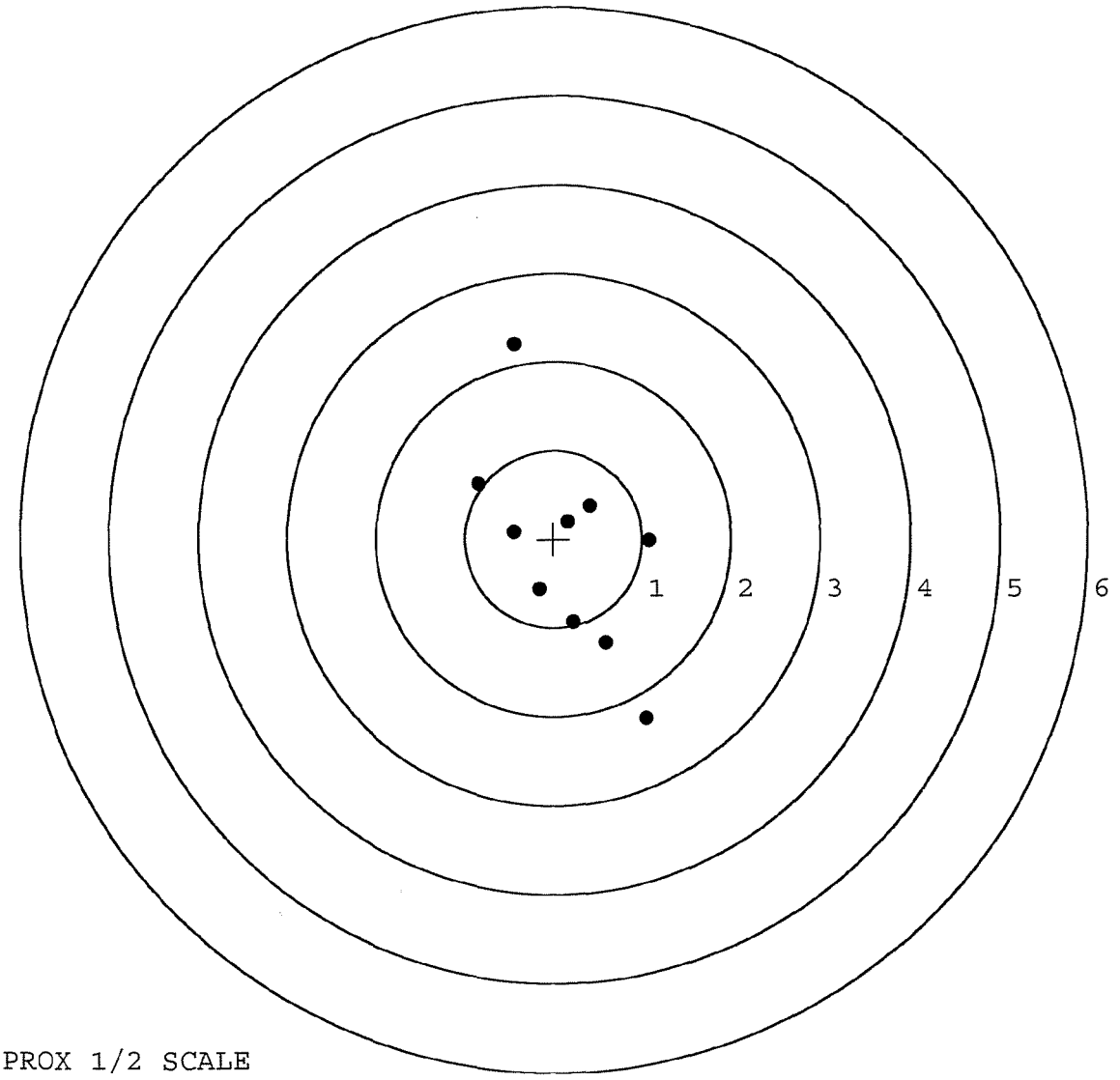


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361015.__0
TARGET NUMBER: 3
FILE DATE: 07/12/2004
FILE TIME: 06:58

X CENTROID:	0.160
Y CENTROID:	-0.125
POA TO CENTROID:	0.203
HORZ SPREAD:	1.935
VERT SPREAD:	4.220
GROUP SPREAD:	4.479
MIN RADIUS:	0.322
MAX RADIUS:	2.399
MEAN RADIUS:	1.073
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	1.049	-2.026
2:	0.600	-1.173
3:	0.225	-0.942
4:	-0.166	-0.571
5:	1.083	-0.017
6:	-0.453	0.082
7:	-0.852	0.623
8:	-0.453	2.194
9:	0.155	0.197
10:	0.409	0.382

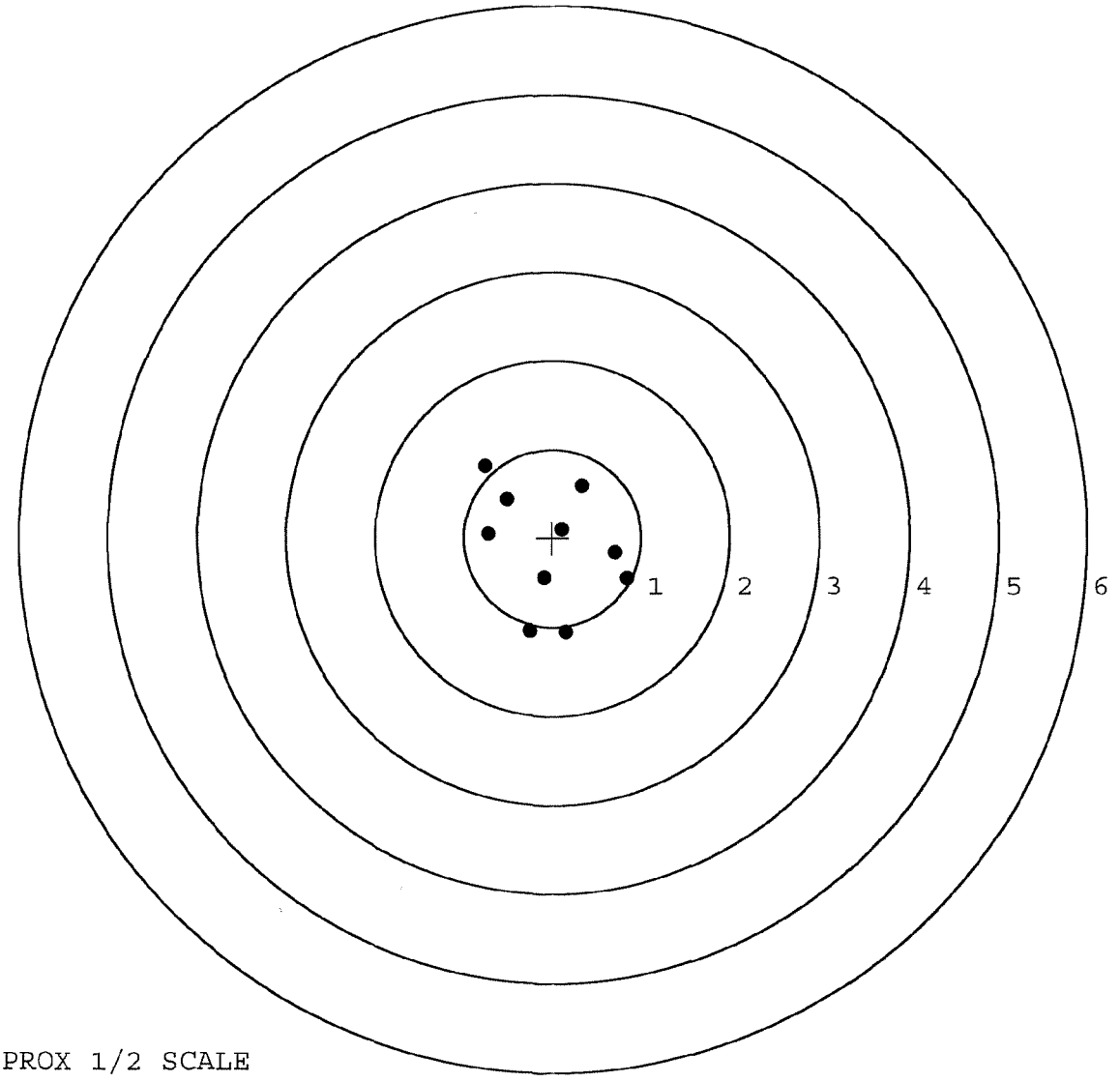


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361015.__0
TARGET NUMBER: 4
FILE DATE: 07/12/2004
FILE TIME: 06:58

X CENTROID:	-0.022
Y CENTROID:	-0.123
POA TO CENTROID:	0.125
HORZ SPREAD:	1.604
VERT SPREAD:	1.875
GROUP SPREAD:	2.085
MIN RADIUS:	0.258
MAX RADIUS:	1.192
MEAN RADIUS:	0.763
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.151	-1.064
2:	-0.265	-1.048
3:	-0.098	-0.458
4:	0.842	-0.465
5:	0.709	-0.173
6:	0.113	0.097
7:	0.328	0.589
8:	-0.517	0.438
9:	-0.720	0.043
10:	-0.762	0.811

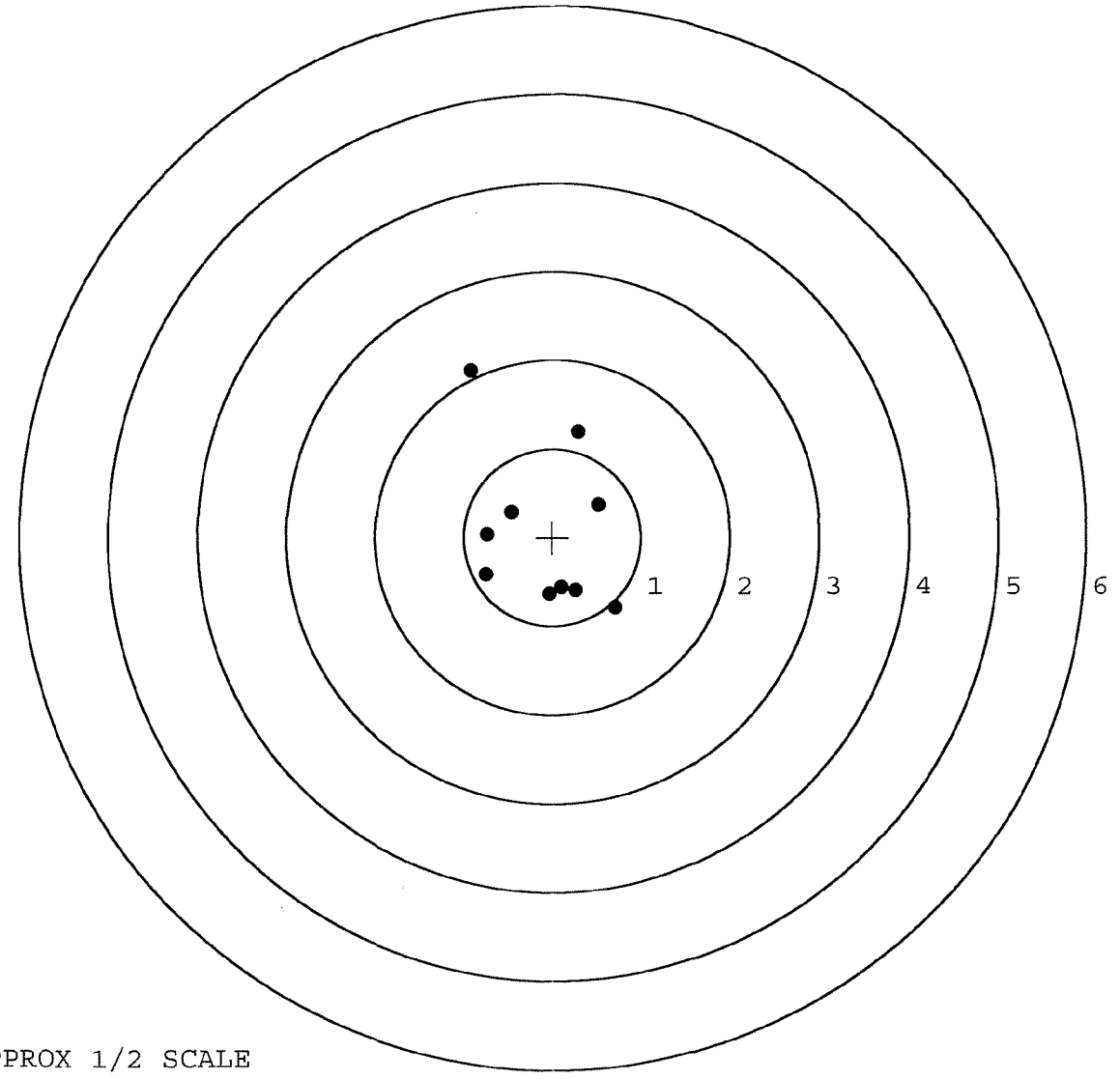


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6361015.__0
TARGET NUMBER: 5
FILE DATE: 07/12/2004
FILE TIME: 06:58

X CENTROID:	-0.103
Y CENTROID:	0.073
POA TO CENTROID:	0.126
HORZ SPREAD:	1.636
VERT SPREAD:	2.674
GROUP SPREAD:	3.135
MIN RADIUS:	0.424
MAX RADIUS:	1.984
MEAN RADIUS:	0.909
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.712	-0.795
2:	0.260	-0.606
3:	-0.038	-0.646
4:	-0.749	-0.422
5:	-0.737	0.036
6:	-0.467	0.290
7:	0.518	0.369
8:	0.288	1.192
9:	-0.924	1.879
10:	0.104	-0.571



TARGET APPROX 1/2 SCALE