G1310984

9/27/2004 10:33:18 AM

Original **8** 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.

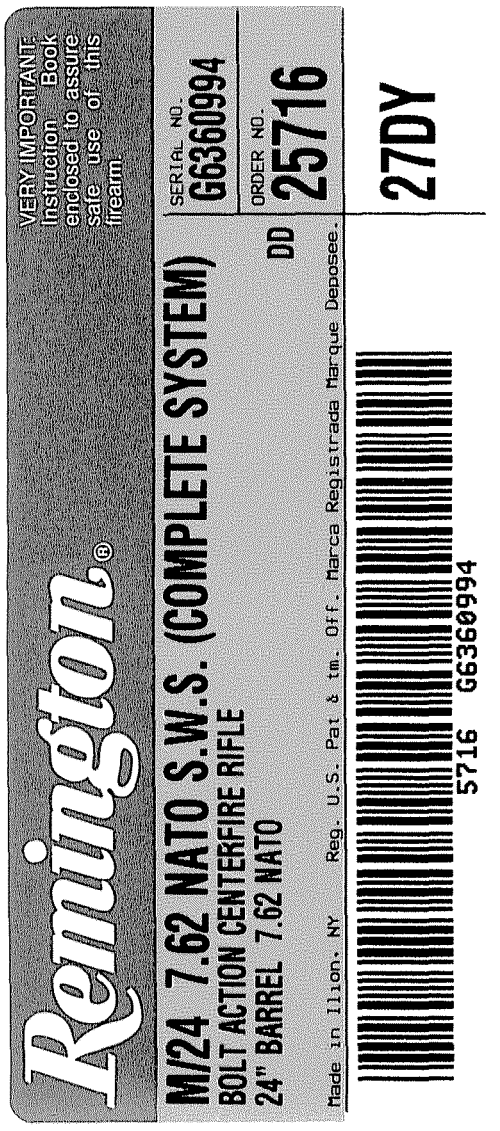
0003451404

0690 89SWS1
Pack Rifle

0003451397

0700 89SWS1
Stencil SWS Container

.OP0700



ORDER 25716

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

UPC

0 47700 25716 7

ORDER 25716

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

UPC

0 47700 25716 7

SERIAL NO.

G6360994

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

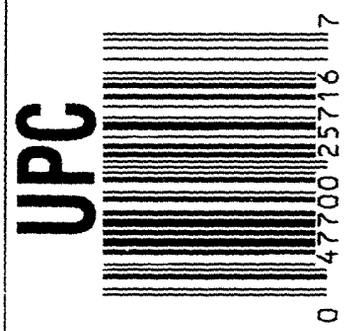
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

– INSTUCTION BOOK 3518

DD FORM

ORDER NO.	25716
BARREL LENGTH	24"
CAPACITY	6

G6360994



7/22/2004 3:21:04 PM

Original 43 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

0000338116

0640 89SWS1
Reassemble Action.

0000338117

0685 89SWS1
Attach Front and Rear Sight Assemblies

0000338122

0710 89SWS1
Pack Rifle & Stencil SWS Container

.OP0710

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G63609944

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		4-6-04	RTL
600	PROOF		4-6-04	RTL
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	4-6-04	RTL
610	DIS-ASSEMBLE GUN		4-6-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR RL		
615	ROLLMARK CALIBER		4/8/04	RB
617	DRILL AND TAP SIGHT HOLES		4-8-04	TRW
620	APPLY COATINGS (BARREL ACTION)		5-7	TA
	(BOLT)		5-7	TA
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		6-1-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-1-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6-1-04	RTL
	D) OIL FIRING PIN ASSEMBLY		6-1-04	RTL
	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]	6.0 6.5 6.5	6/4/04	DA
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	2.0 2.0 2.0	6/4/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.020 .021 .020	6/4/04	DA
	J) ASSEMBLE STOCK		6-1-04	RTL
	K) ASSEMBLE SWIVEL STUDS		8-30-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-30-04	RTL
	M) IRON SIGHT ALIGNMENT		8-30-04	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-30-04	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	6-1-04	AC
	MALFUNCTION	CORRECTION	6-1-04	AC
	MALFUNCTION	CORRECTION	6-1-04	AC
	MALFUNCTION	CORRECTION	6-1-04	AC
	MALFUNCTION	CORRECTION	6-1-04	AC
645	INSPECT FOR LIVE AMMO		6-1-04	AC
655	FINAL INSPECTION A) HEADSPACE		9.2004	RTL
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.59 2.63 2.73 2.58 2.60	6/3/04	DA
	C) FUNCTION		6-3-04	DAW
660	PACK		9/7/04	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 5-26-04

TESTER RW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.33	2.30		2.37	
PULL #2	2.31	2.39		2.37	
PULL #3	2.39	2.19		2.37	
PULL #4	2.43	2.35		2.34	
PULL #5	2.25	2.36		2.44	
TOTAL	11.71	11.59		11.89	
AVERAGE	2.34	2.32		2.38	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.04	3.18		
PULL #2	3.14	3.15		
PULL #3	3.29	3.18		
PULL #4	3.33	3.29		
PULL #5	3.31	3.24		
TOTAL	16.11	16.04		
AVERAGE	3.22	3.21		

	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	4.33	4.25		4.31
PULL #2	4.26	4.25		4.39
PULL #3	4.23	4.21		4.43
PULL #4	4.32	4.34		4.43
PULL #5	4.29	4.21		4.36
TOTAL	21.43	21.26		21.92
AVERAGE	4.29	4.25		4.38

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360994.__0
FILE DATE AND TIME: 06/01/2004 10:37

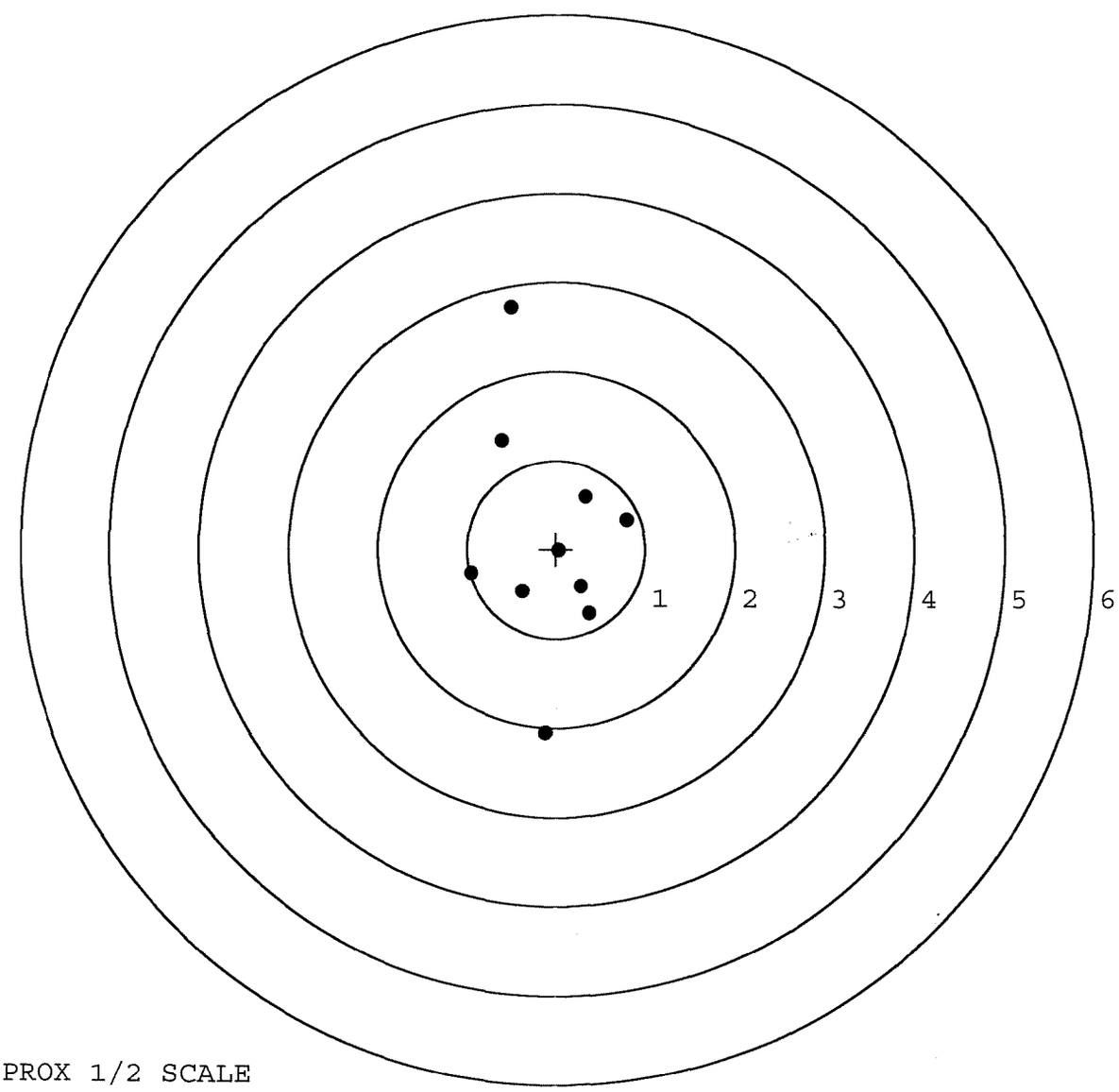
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.011
The Average Y Centroid of the Five Target Set:	-0.034
The Average Point of Impact of the Five Target Set:	0.036
The Average Mean Radius of the Five Target Set:	0.874
The Distance from POA to Centroid Target #1:	0.116
The Distance from Centroid Target #2 to Centroid Target #1:	0.292
The Distance from Centroid Target #3 to Centroid Target #1:	0.159
The Distance from Centroid Target #4 to Centroid Target #1:	0.170
The Distance from Centroid Target #5 to Centroid Target #1:	0.432

SERIAL NUMBER: G6360994.__0
TARGET NUMBER: 1
FILE DATE: 06/01/2004
FILE TIME: 10:37

X CENTROID:	-0.076
Y CENTROID:	0.088
POA TO CENTROID:	0.116
HORZ SPREAD:	1.742
VERT SPREAD:	4.781
GROUP SPREAD:	4.798
MIN RADIUS:	0.152
MAX RADIUS:	2.666
MEAN RADIUS:	1.092
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-0.517	2.717
2:	-0.609	1.227
3:	0.330	0.592
4:	0.793	0.327
5:	0.031	-0.020
6:	-0.379	-0.480
7:	-0.949	-0.279
8:	0.281	-0.426
9:	0.377	-0.716
10:	-0.119	-2.064

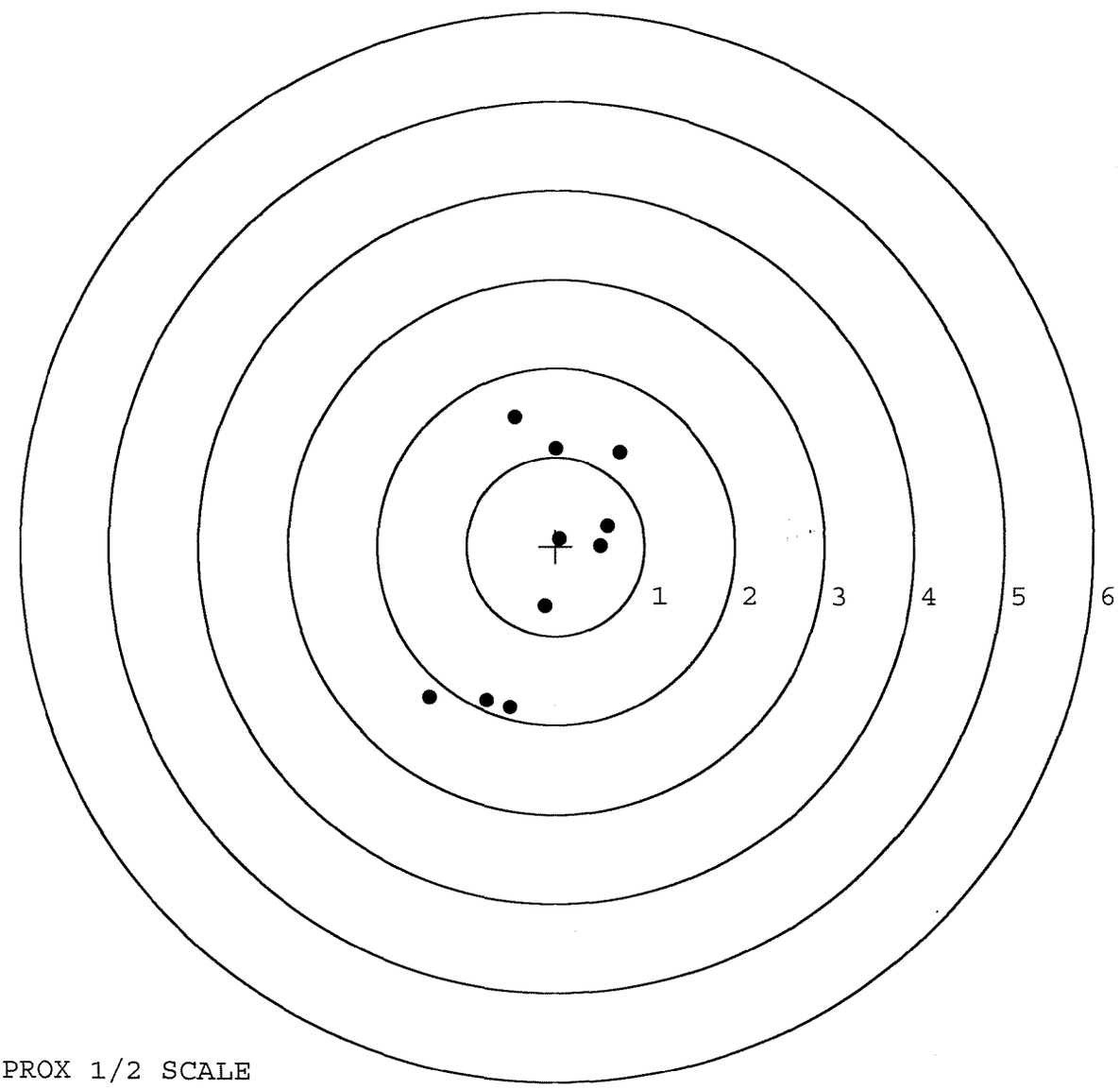


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360994.__0
TARGET NUMBER: 2
FILE DATE: 06/01/2004
FILE TIME: 10:37

X CENTROID:	-0.144
Y CENTROID:	-0.196
POA TO CENTROID:	0.243
HORZ SPREAD:	2.141
VERT SPREAD:	3.255
GROUP SPREAD:	3.483
MIN RADIUS:	0.333
MAX RADIUS:	1.964
MEAN RADIUS:	1.210
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	4
# in 3 IN DIAMETER:	5

POINT#	X	Y
1:	-0.466	1.453
2:	-0.004	1.094
3:	0.721	1.058
4:	0.042	0.080
5:	0.583	0.231
6:	0.508	0.008
7:	-0.120	-0.670
8:	-0.507	-1.802
9:	-0.773	-1.723
10:	-1.420	-1.689

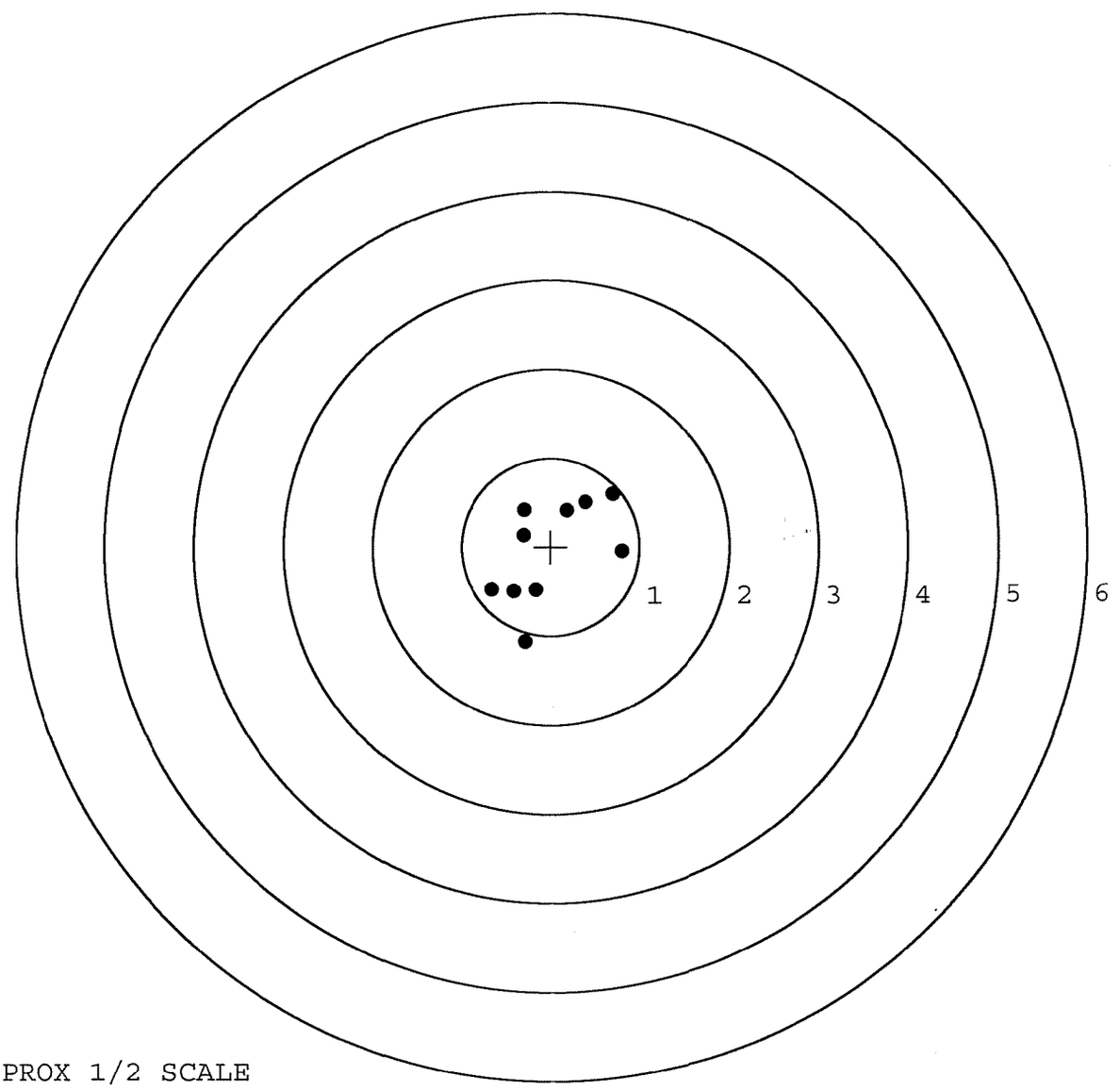


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360994.__0
TARGET NUMBER: 3
FILE DATE: 06/01/2004
FILE TIME: 10:37

X CENTROID:	-0.006
Y CENTROID:	-0.055
POA TO CENTROID:	0.056
HORZ SPREAD:	1.469
VERT SPREAD:	1.669
GROUP SPREAD:	1.943
MIN RADIUS:	0.349
MAX RADIUS:	1.054
MEAN RADIUS:	0.678
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.804	-0.060
2:	0.703	0.599
3:	0.398	0.500
4:	0.180	0.408
5:	-0.295	0.417
6:	-0.301	0.130
7:	-0.665	-0.483
8:	-0.419	-0.501
9:	-0.171	-0.493
10:	-0.292	-1.070

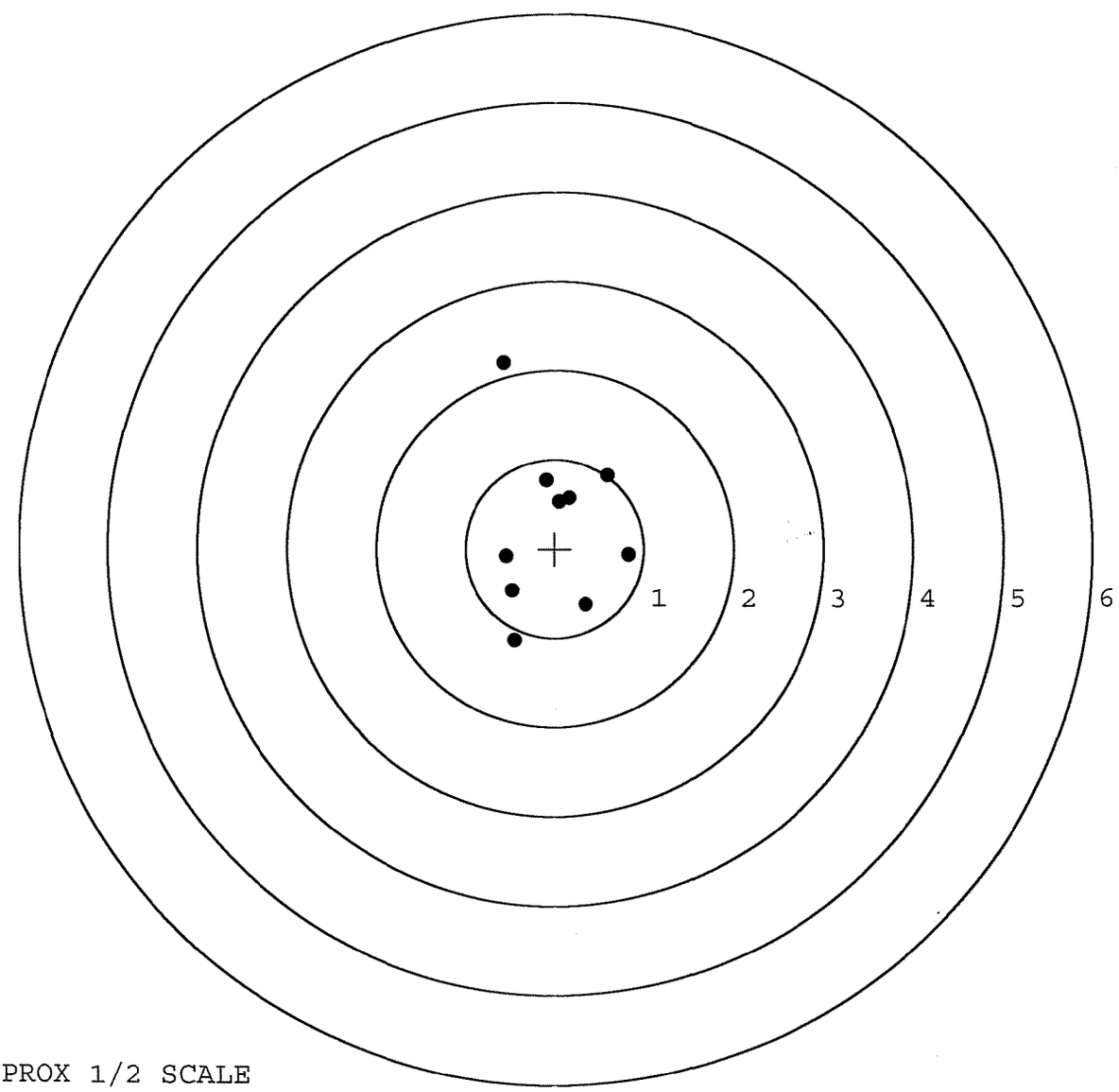


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360994.__0
TARGET NUMBER: 4
FILE DATE: 06/01/2004
FILE TIME: 10:37

X CENTROID:	-0.014
Y CENTROID:	0.246
POA TO CENTROID:	0.247
HORZ SPREAD:	1.407
VERT SPREAD:	3.115
GROUP SPREAD:	3.118
MIN RADIUS:	0.287
MAX RADIUS:	1.923
MEAN RADIUS:	0.861
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.600	0.814
2:	0.165	0.560
3:	-0.098	0.761
4:	-0.574	2.086
5:	-0.545	-0.085
6:	-0.476	-0.467
7:	-0.448	-1.029
8:	0.348	-0.633
9:	0.833	-0.069
10:	0.052	0.526

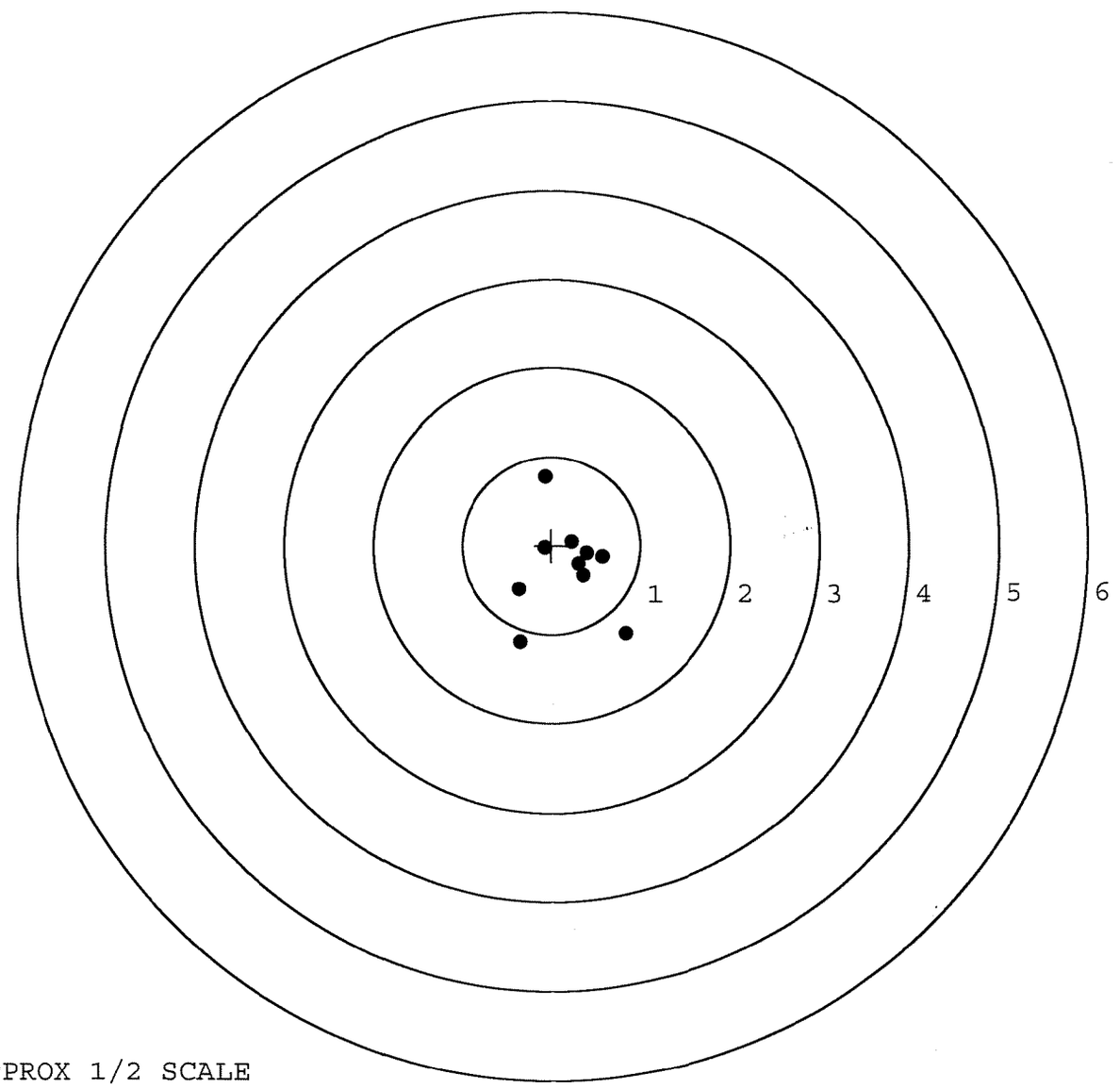


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360994.__0
TARGET NUMBER: 5
FILE DATE: 06/01/2004
FILE TIME: 10:37

X CENTROID:	0.186
Y CENTROID:	-0.255
POA TO CENTROID:	0.316
HORZ SPREAD:	1.201
VERT SPREAD:	1.868
GROUP SPREAD:	1.993
MIN RADIUS:	0.133
MAX RADIUS:	1.064
MEAN RADIUS:	0.531
# IN 1 IN DIAMETER:	6
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.068	0.778
2:	-0.074	-0.028
3:	-0.366	-0.497
4:	-0.353	-1.090
5:	0.835	-0.999
6:	0.579	-0.129
7:	0.363	-0.338
8:	0.232	0.045
9:	0.402	-0.087
10:	0.311	-0.209



TARGET APPROX 1/2 SCALE