G 6360 847

9/27/2004 10:33:18 AM

Original 56 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

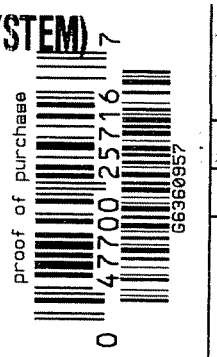
0700 89SWS1
Stencil SWS Container

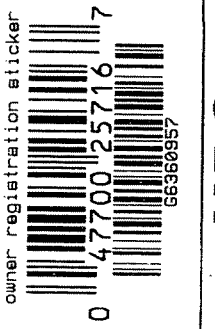
.OP0700

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

– INSTUCTION BOOK 3518

DD FORM

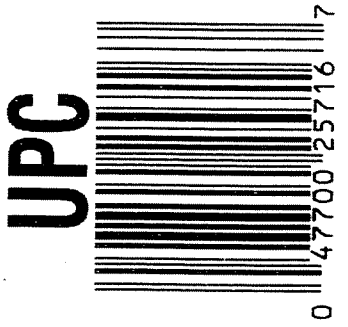


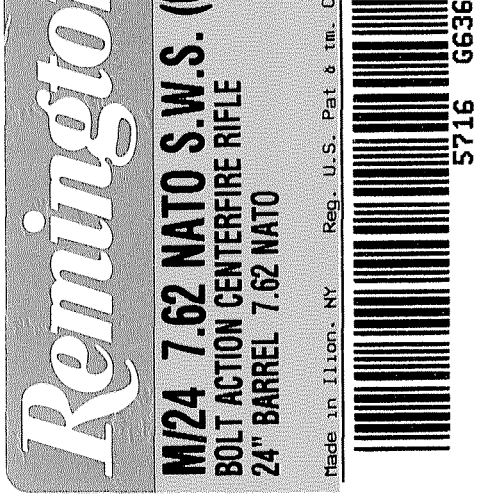


ORDER NO. 25716

BARREL LENGTH	24"
CAPACITY	6

G6360957





ORDER 25716

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

UPC

ORDER 25716

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

UPC

7/22/2004 3:21:04 PM

55

Original .crb

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 # C63600957

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	MAGNA-FLUX INSPECTED	6-15-04	RTL
610	DIS-ASSEMBLE GUN		6-15-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR		
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	RTL 7-6-04 ~~7-7-04~~		TRW
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-6-04	TRW
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-6-04	TRW
	D) OIL FIRING PIN ASSEMBLY		7-6-04	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]	6.0 5.5 6.0	9/9/04	DA
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	3.0 3.0 2.5	9/9/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.026 .024 .024	9/9/04	DA
	J) ASSEMBLE STOCK		8-23-04	RW
	K) ASSEMBLE SWIVEL STUDS		9-16-04	RTR
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-23-04	RW
	M) IRON SIGHT ALIGNMENT		8-23-04	RW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-23-04	RW
640	GALLERY TEST AND TARGET	PASS FAIL	8-25-04	TRW
	MALFUNCTION	CORRECTION	8-25-04	TRW
	MALFUNCTION	CORRECTION	8-25-04	TRW
	MALFUNCTION	CORRECTION	8-25-04	TRW
	MALFUNCTION	CORRECTION	8-25-04	TRW
645	INSPECT FOR LIVE AMMO		8-25-04	TRW
655	FINAL INSPECTION A) HEADSPACE		9-16-04	RTR
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.16 2.16 2.45 2.24 2.41	9/9/04	DA
	C) FUNCTION		9-16-04	RTR
660	PACK		9-21-04	AC

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)

DATE 8-20-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.12	2.47		2.41	
PULL #2	2.35	2.84		2.45	
PULL #3	2.56	2.53		2.56	
PULL #4	2.50	2.60		2.50	
PULL #5	2.57	2.54		2.76	
TOTAL	12.10	12.98		12.68	
AVERAGE	2.42	2.59		2.53	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.07		
PULL #2	3.47	3.17		
PULL #3	3.43	3.53		
PULL #4	3.20	3.53		
PULL #5	3.12	3.39		
TOTAL	16.35	16.69		
AVERAGE	3.27	3.33		

	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	4.09	4.11		4.01
PULL #2	4.12	4.05		4.11
PULL #3	4.09	4.03		4.17
PULL #4	4.12	4.02		4.10
PULL #5	3.77	3.98		4.19
TOTAL	20.19	20.19		20.58
AVERAGE	4.03	4.03		4.11

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360957.__0
FILE DATE AND TIME: 08/25/2004 08:08

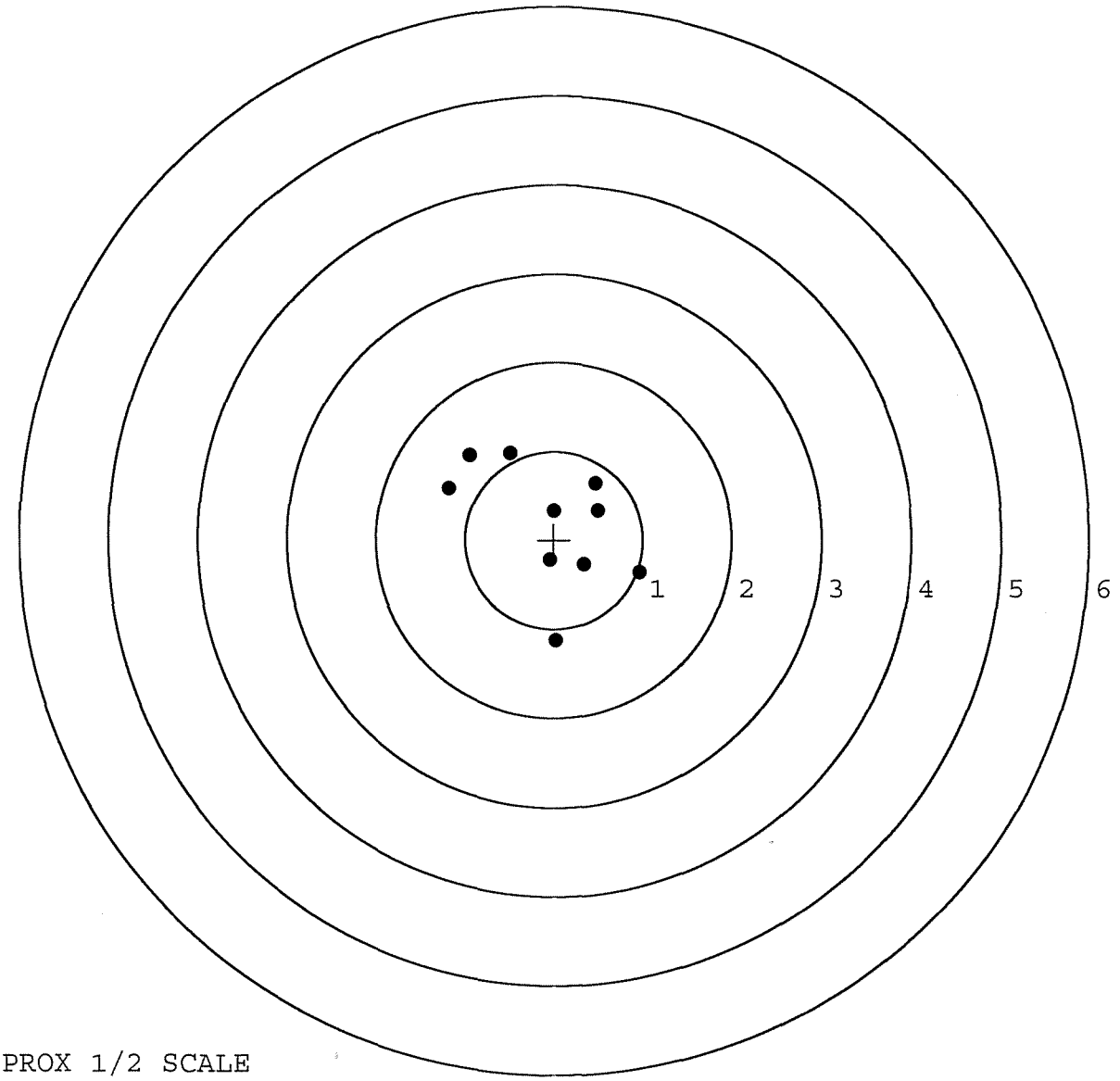
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.027
The Average Y Centroid of the Five Target Set:	-0.069
The Average Point of Impact of the Five Target Set:	0.074
The Average Mean Radius of the Five Target Set:	0.917
The Distance from POA to Centroid Target #1:	0.186
The Distance from Centroid Target #2 to Centroid Target #1:	0.429
The Distance from Centroid Target #3 to Centroid Target #1:	0.220
The Distance from Centroid Target #4 to Centroid Target #1:	0.489
The Distance from Centroid Target #5 to Centroid Target #1:	0.208

SERIAL NUMBER: G6360957.__0
TARGET NUMBER: 1
FILE DATE: 08/25/2004
FILE TIME: 08:08

X CENTROID:	-0.039
Y CENTROID:	0.182
POA TO CENTROID:	0.186
HORZ SPREAD:	2.142
VERT SPREAD:	2.125
GROUP SPREAD:	2.310
MIN RADIUS:	0.155
MAX RADIUS:	1.322
MEAN RADIUS:	0.819
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.961	-0.367
2:	0.024	-1.139
3:	0.335	-0.277
4:	-0.052	-0.230
5:	0.006	0.330
6:	0.495	0.337
7:	0.464	0.641
8:	-0.495	0.986
9:	-0.948	0.957
10:	-1.181	0.580

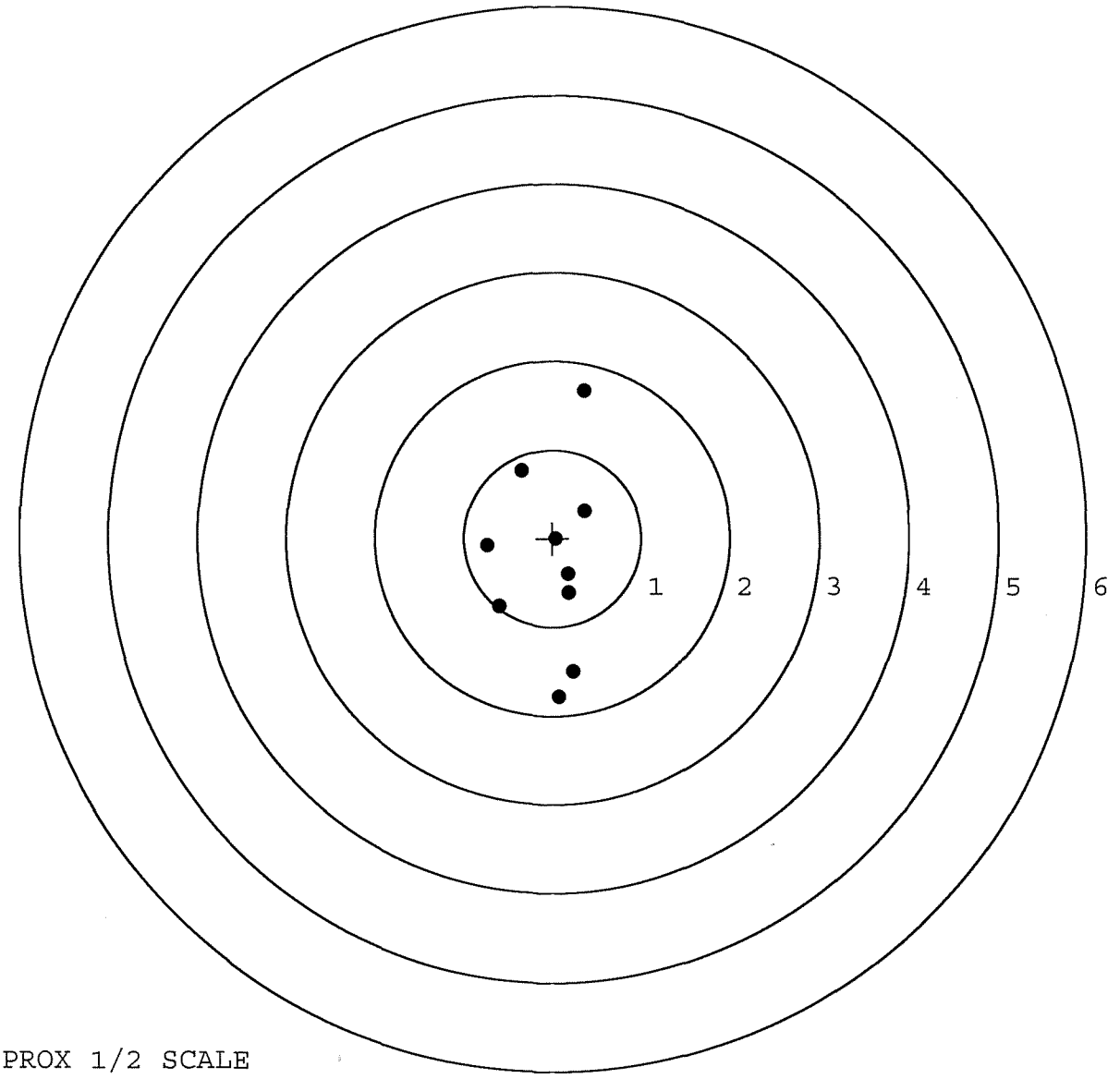


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360957.__0
TARGET NUMBER: 2
FILE DATE: 08/25/2004
FILE TIME: 08:08

X CENTROID:	-0.027
Y CENTROID:	-0.247
POA TO CENTROID:	0.249
HORZ SPREAD:	1.099
VERT SPREAD:	3.448
GROUP SPREAD:	3.459
MIN RADIUS:	0.245
MAX RADIUS:	1.946
MEAN RADIUS:	0.897
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.078	-1.788
2:	0.235	-1.506
3:	-0.605	-0.775
4:	0.184	-0.622
5:	0.177	-0.413
6:	0.039	-0.011
7:	0.363	0.313
8:	-0.736	-0.093
9:	-0.360	0.760
10:	0.358	1.660

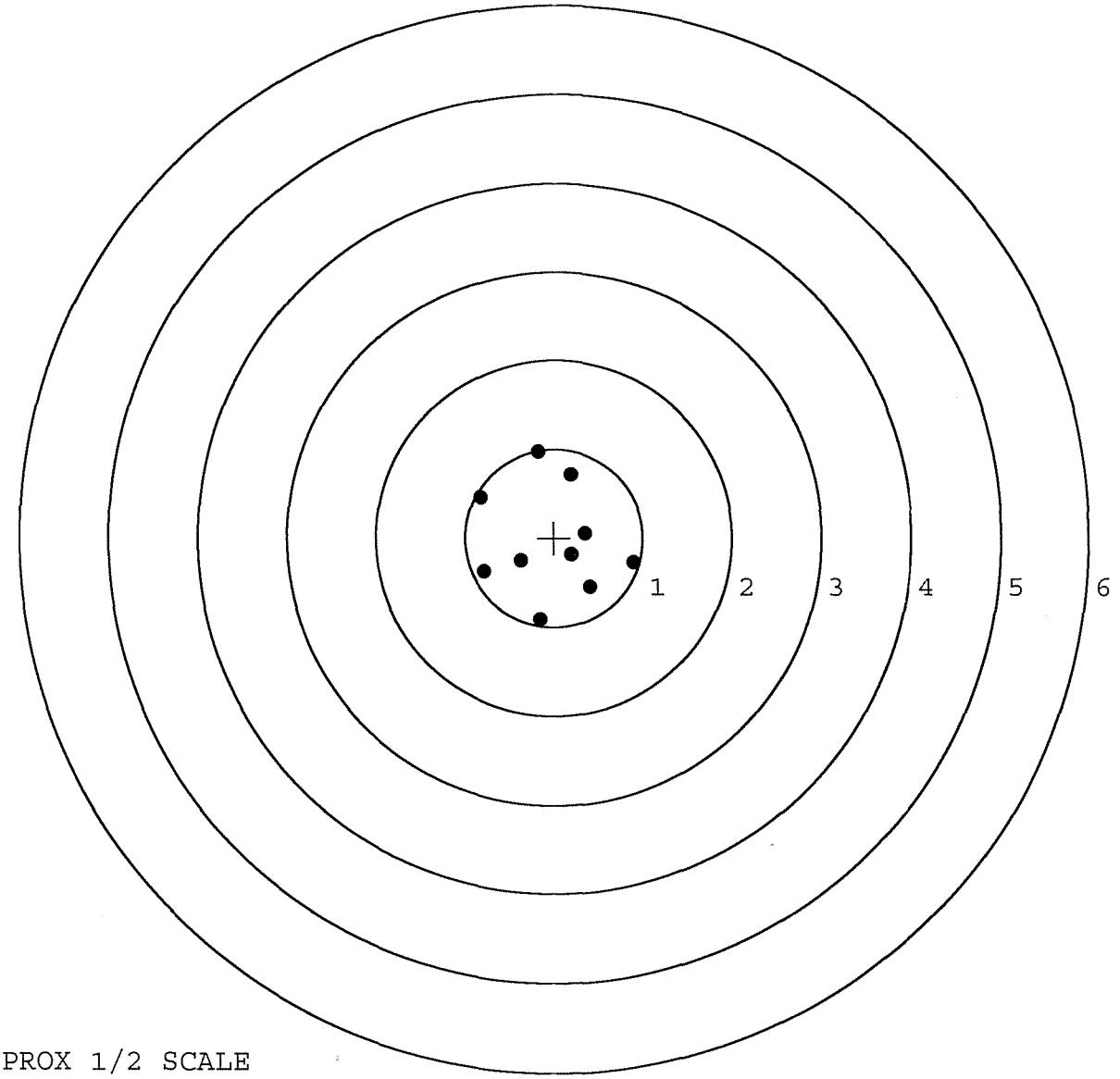


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360957.__0
TARGET NUMBER: 3
FILE DATE: 08/25/2004
FILE TIME: 08:08

X CENTROID:	-0.031
Y CENTROID:	-0.038
POA TO CENTROID:	0.049
HORZ SPREAD:	1.726
VERT SPREAD:	1.896
GROUP SPREAD:	1.896
MIN RADIUS:	0.274
MAX RADIUS:	1.019
MEAN RADIUS:	0.717
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.158	-0.926
2:	0.401	-0.549
3:	0.894	-0.276
4:	0.196	-0.192
5:	0.348	0.056
6:	0.191	0.713
7:	-0.181	0.970
8:	-0.832	0.454
9:	-0.790	-0.376
10:	-0.379	-0.258

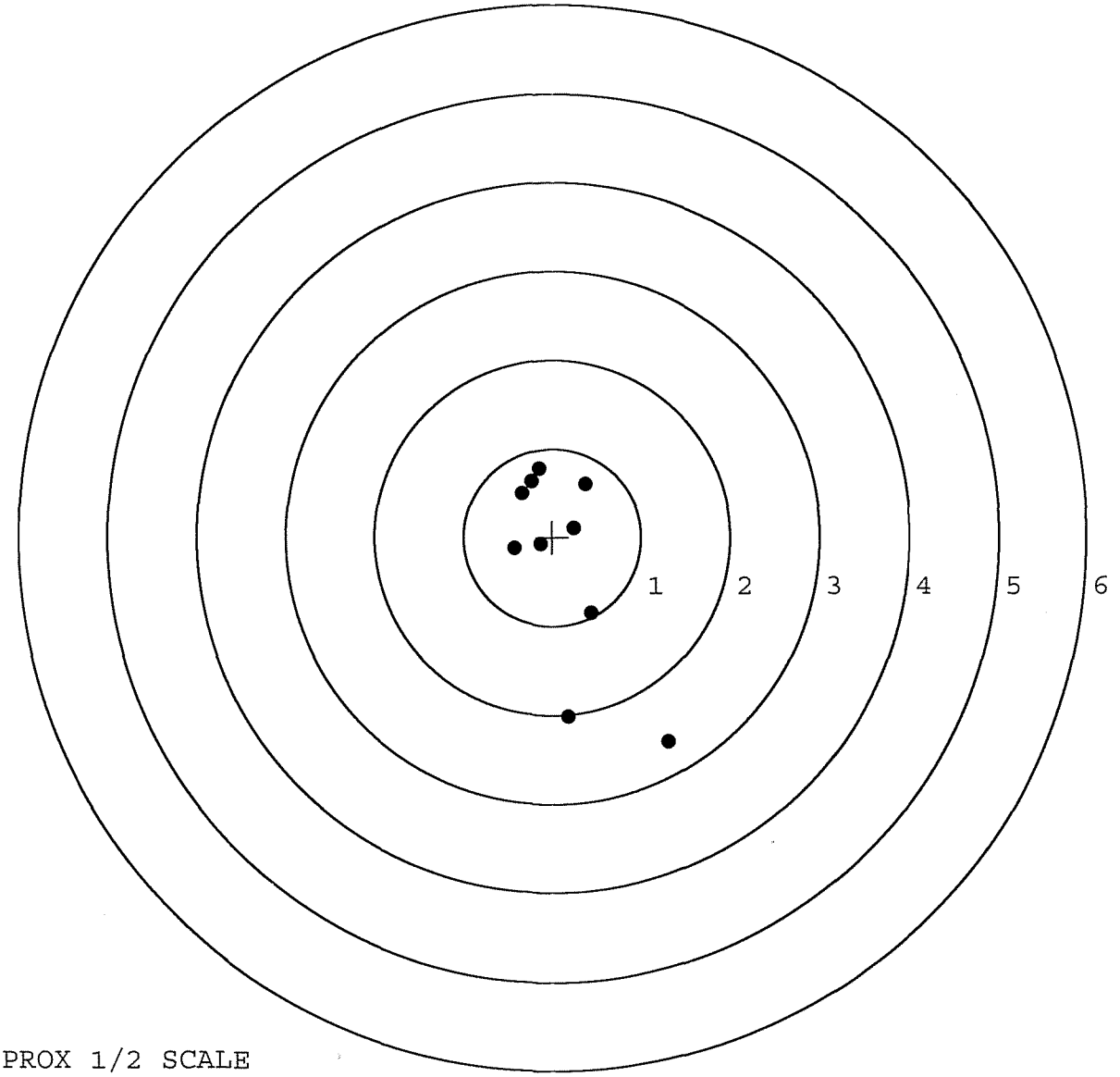


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360957.__0
TARGET NUMBER: 4
FILE DATE: 08/25/2004
FILE TIME: 08:08

X CENTROID:	0.122
Y CENTROID:	-0.280
POA TO CENTROID:	0.305
HORZ SPREAD:	1.741
VERT SPREAD:	3.074
GROUP SPREAD:	3.405
MIN RADIUS:	0.327
MAX RADIUS:	2.347
MEAN RADIUS:	0.994
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	1.309	-2.305
2:	0.185	-2.022
3:	0.436	-0.859
4:	0.244	0.101
5:	0.368	0.602
6:	-0.156	0.769
7:	-0.246	0.630
8:	-0.348	0.496
9:	-0.138	-0.082
10:	-0.432	-0.128

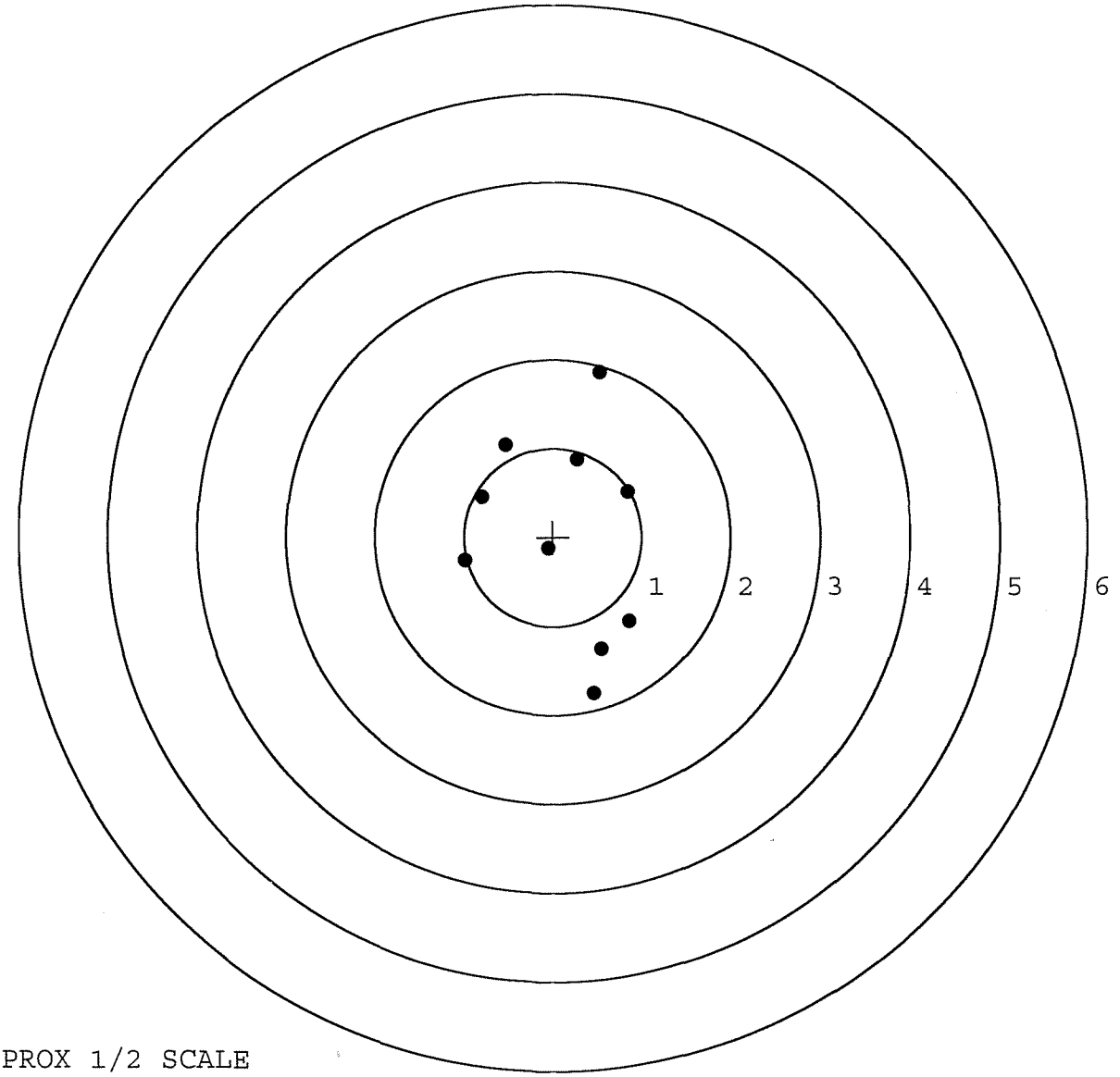


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360957.__0
TARGET NUMBER: 5
FILE DATE: 08/25/2004
FILE TIME: 08:08

X CENTROID:	0.111
Y CENTROID:	0.038
POA TO CENTROID:	0.118
HORZ SPREAD:	1.847
VERT SPREAD:	3.615
GROUP SPREAD:	3.616
MIN RADIUS:	0.237
MAX RADIUS:	1.868
MEAN RADIUS:	1.158
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	3
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.858	-0.941
2:	0.541	-1.258
3:	0.466	-1.757
4:	-0.054	-0.132
5:	0.834	0.509
6:	0.267	0.878
7:	-0.804	0.447
8:	-0.989	-0.261
9:	-0.537	1.034
10:	0.531	1.858



TARGET APPROX 1/2 SCALE