

G6360900

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 06360900

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		2-17-04	RW
600	PROOF		2-17-04	RW
607	CHECK HEADSPACE		2-17-04	RW
610	DIS-ASSEMBLE GUN		2-17-04	RW
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	INSPECTED FEB 24 2004 OPERATOR <u>RK</u>		
615	ROLLMARK CALIBER		2/25/04	LB
617	DRILL AND TAP SIGHT HOLES		2-20-04	TRW
620	APPLY COATINGS (BARREL ACTION)		3-5	TA
	(BOLT)		3-5	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3/22/04	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3/22/04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3/22/04	DA
	D) OIL FIRING PIN ASSEMBLY		3/22/04	DA
	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>8⁰</u> <u>8⁰</u> <u>8⁰</u>	5-24-04	RR
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2⁰</u> <u>2⁰</u> <u>2⁰</u>	5-24-04	RR
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.021</u> <u>.021</u>	5-24-04	RR
	J) ASSEMBLE STOCK		4-23-04	RR
	K) ASSEMBLE SWIVEL STUDS		6-9-04	FW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		4-23-04	RR
	M) IRON SIGHT ALIGNMENT		4-23-04	RR
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		4-23-04	RR
640	GALLERY TEST AND TARGET	PASS FAIL	5-3-04	TRW
	MALFUNCTION	CORRECTION	5-3-04	TRW
	MALFUNCTION	CORRECTION	5-3-04	TRW
	MALFUNCTION	CORRECTION	5-3-04	TRW
	MALFUNCTION	CORRECTION	5-3-04	TRW
645	INSPECT FOR LIVE AMMO		5-3-04	TRW
655	FINAL INSPECTION A) HEADSPACE		6-9-04	FW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.88</u> <u>2.90</u> <u>2.91</u> <u>2.93</u> <u>2.86</u>	5/24/07	DA
	C) FUNCTION		6-9-04	FW
660	PACK		6-10-04	DA

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 4-22-04
 TESTER PW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.39	2.19		2.10	
PULL #2	2.34	2.11		2.06	
PULL #3	2.30	2.19		2.06	
PULL #4	2.27	2.16		2.07	
PULL #5	2.38	2.10		2.04	
TOTAL	11.68	10.75		10.33	
AVERAGE	2.34	2.15		2.07	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.01	3.11		
PULL #2	3.17	3.11		
PULL #3	3.22	3.14		
PULL #4	3.21	3.14		
PULL #5	3.20	3.10		
TOTAL	15.81	15.60		
AVERAGE	3.16	3.12		

	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	4.24	4.13		4.37
PULL #2	4.22	4.17		4.28
PULL #3	4.14	4.15		4.20
PULL #4	4.15	4.21		4.23
PULL #5	4.17	4.15		4.18
TOTAL	20.92	20.81		21.26
AVERAGE	4.18	4.16		4.25

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360900.___0

FILE DATE AND TIME: 05/03/2004 06:45

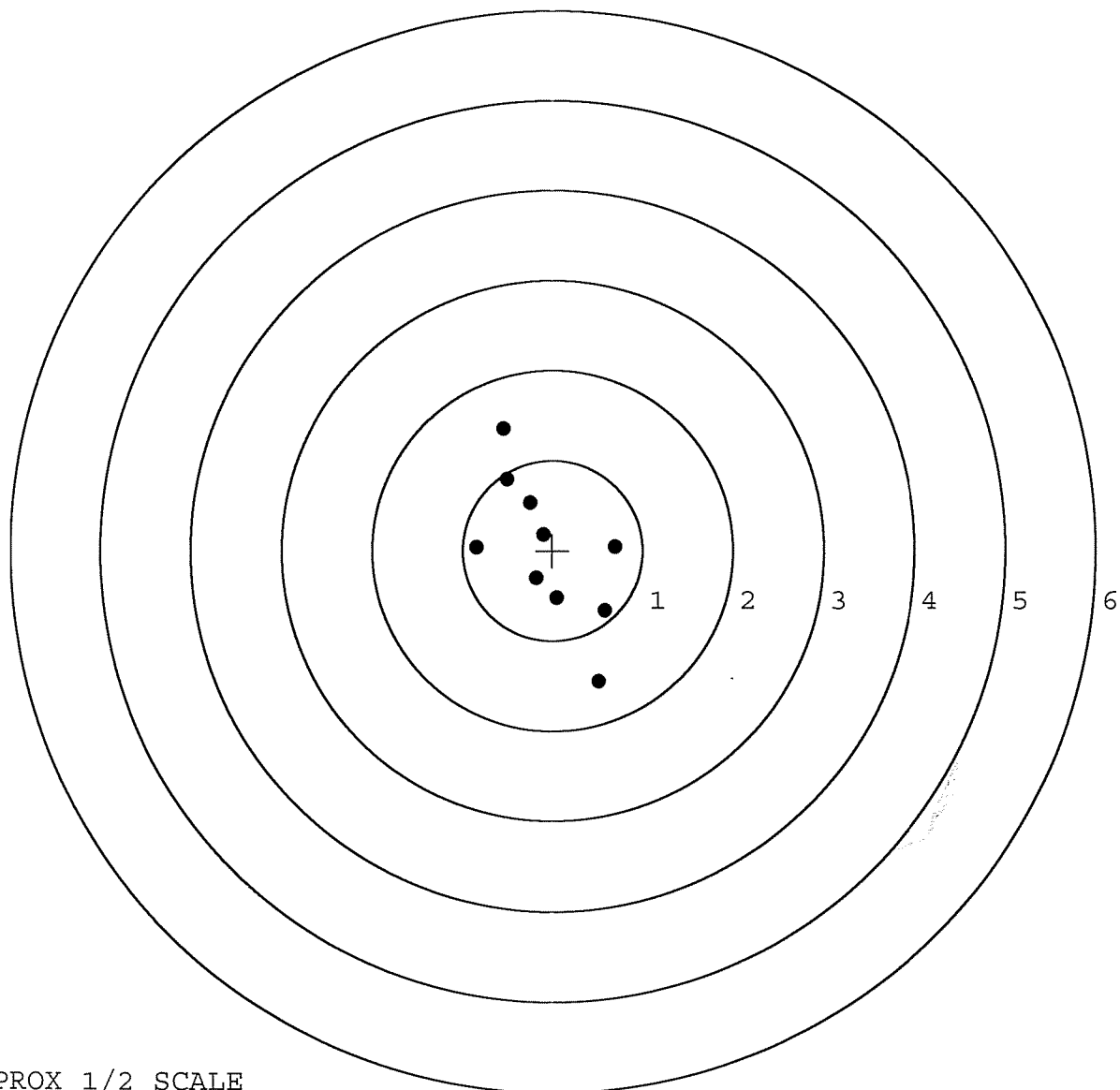
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.005
The Average Y Centroid of the Five Target Set:	-0.004
The Average Point of Impact of the Five Target Set:	0.006
The Average Mean Radius of the Five Target Set:	0.771
The Distance from POA to Centroid Target #1:	0.060
The Distance from Centroid Target #2 to Centroid Target #1:	0.253
The Distance from Centroid Target #3 to Centroid Target #1:	0.122
The Distance from Centroid Target #4 to Centroid Target #1:	0.289
The Distance from Centroid Target #5 to Centroid Target #1:	0.171

SERIAL NUMBER: G6360900. __0
TARGET NUMBER: 1
FILE DATE: 05/03/2004
FILE TIME: 06:45

X CENTROID: -0.060
Y CENTROID: -0.004
POA TO CENTROID: 0.060
HORZ SPREAD: 1.545
VERT SPREAD: 2.808
GROUP SPREAD: 3.002
MIN RADIUS: 0.188
MAX RADIUS: 1.565
MEAN RADIUS: 0.802
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.515	-1.459
2:	0.586	-0.672
3:	0.698	0.046
4:	0.047	-0.529
5:	-0.185	-0.312
6:	-0.102	0.180
7:	-0.248	0.533
8:	-0.513	0.792
9:	-0.548	1.349
10:	-0.847	0.036

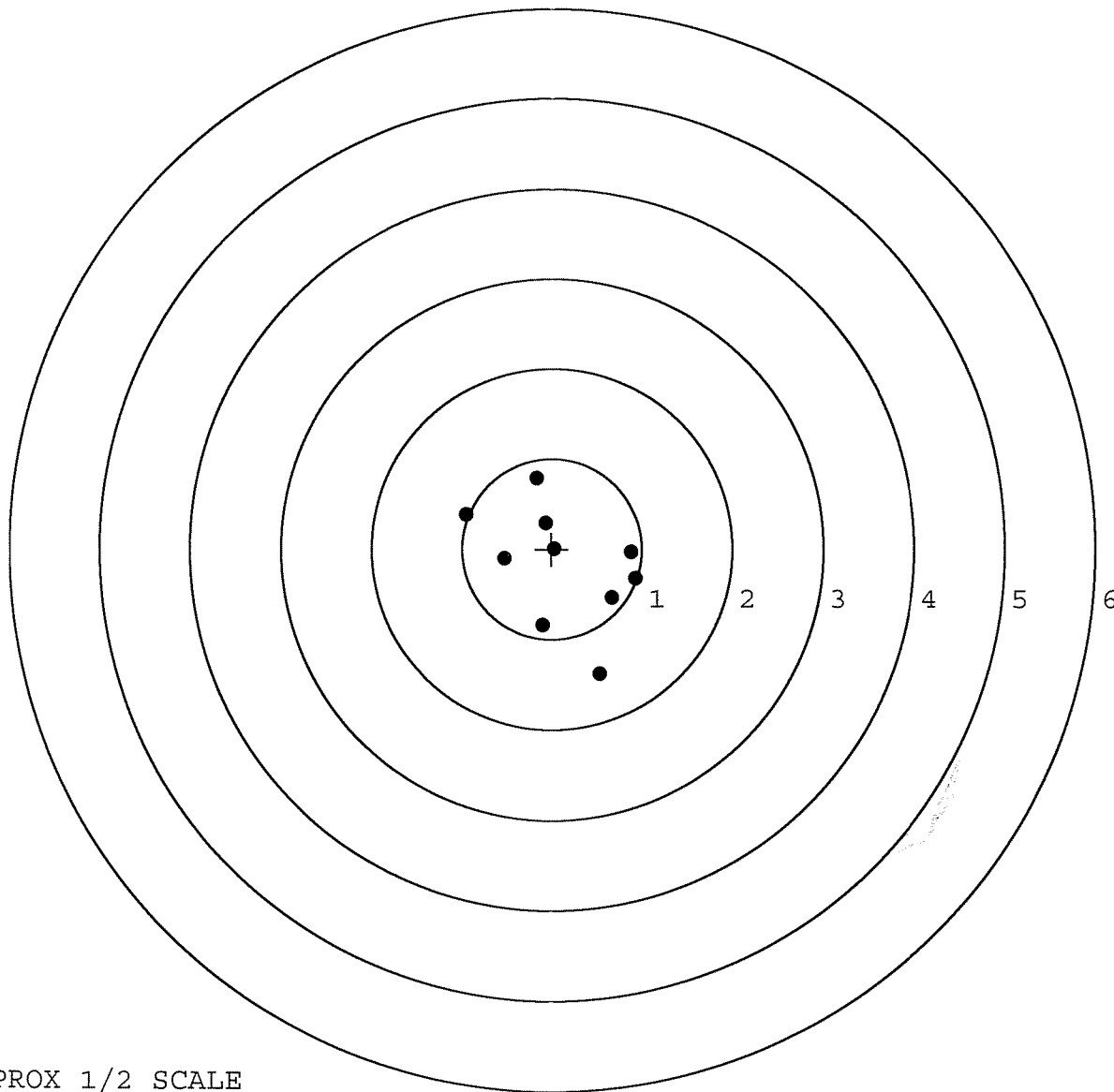


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360900. __0
TARGET NUMBER: 2
FILE DATE: 05/03/2004
FILE TIME: 06:45

X CENTROID: 0.122
Y CENTROID: -0.180
POA TO CENTROID: 0.218
HORZ SPREAD: 1.884
VERT SPREAD: 2.178
GROUP SPREAD: 2.322
MIN RADIUS: 0.203
MAX RADIUS: 1.282
MEAN RADIUS: 0.783
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.540	-1.392
2:	-0.103	-0.849
3:	0.671	-0.543
4:	0.930	-0.327
5:	0.882	-0.038
6:	0.031	0.001
7:	-0.069	0.288
8:	-0.533	-0.111
9:	-0.954	0.385
10:	-0.173	0.786



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360900.____0

TARGET NUMBER: 3

FILE DATE: 05/03/2004

FILE TIME: 06:45

X CENTROID: 0.058

Y CENTROID: 0.029

POA TO CENTROID: 0.065

HORZ SPREAD: 1.524

VERT SPREAD: 2.315

GROUP SPREAD: 2.502

MIN RADIUS: 0.296

MAX RADIUS: 1.311

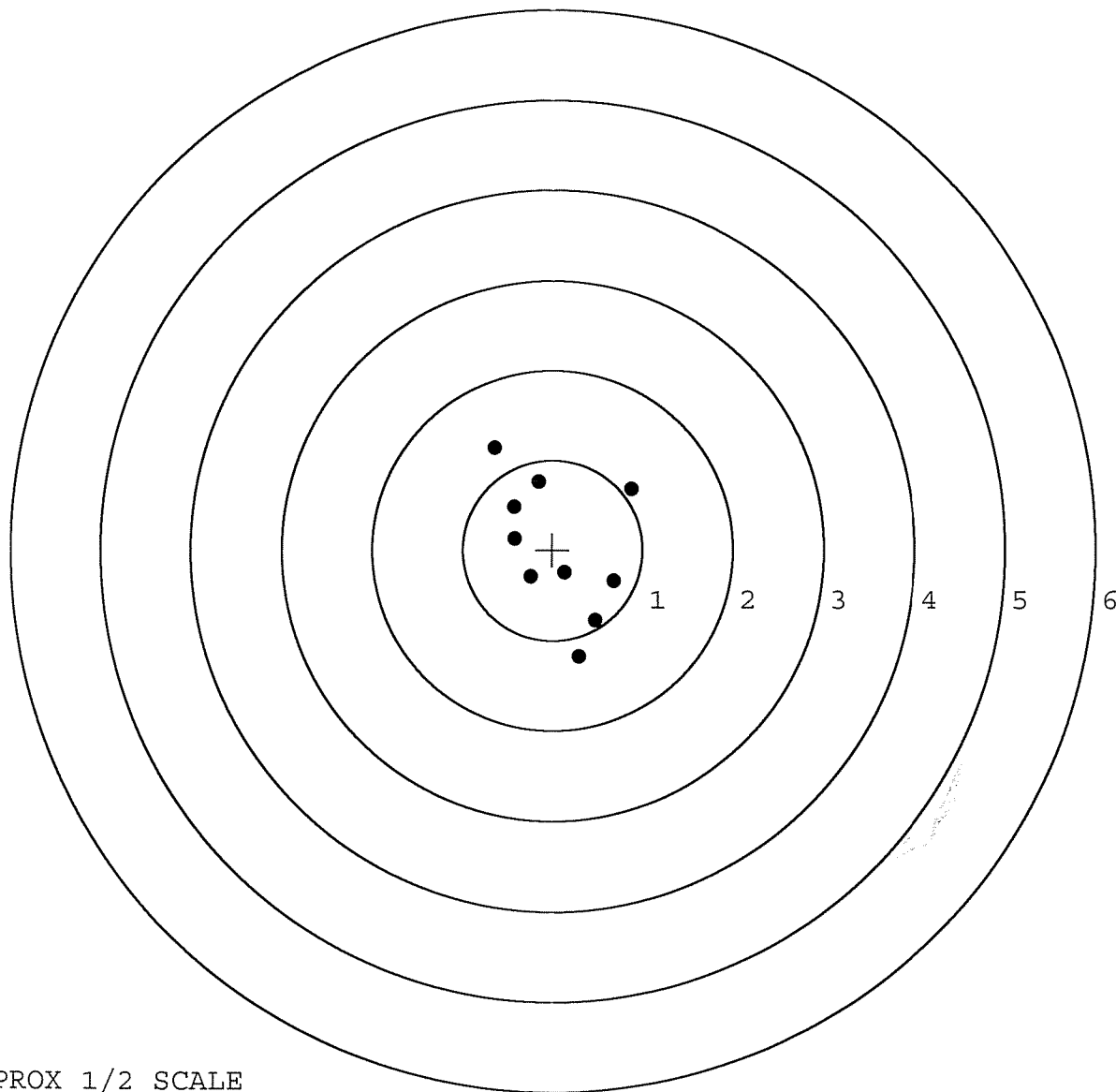
MEAN RADIUS: 0.789

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.300	-1.181
2:	0.479	-0.783
3:	0.685	-0.349
4:	0.137	-0.256
5:	-0.244	-0.306
6:	-0.421	0.125
7:	-0.433	0.480
8:	-0.154	0.755
9:	-0.648	1.134
10:	0.876	0.676

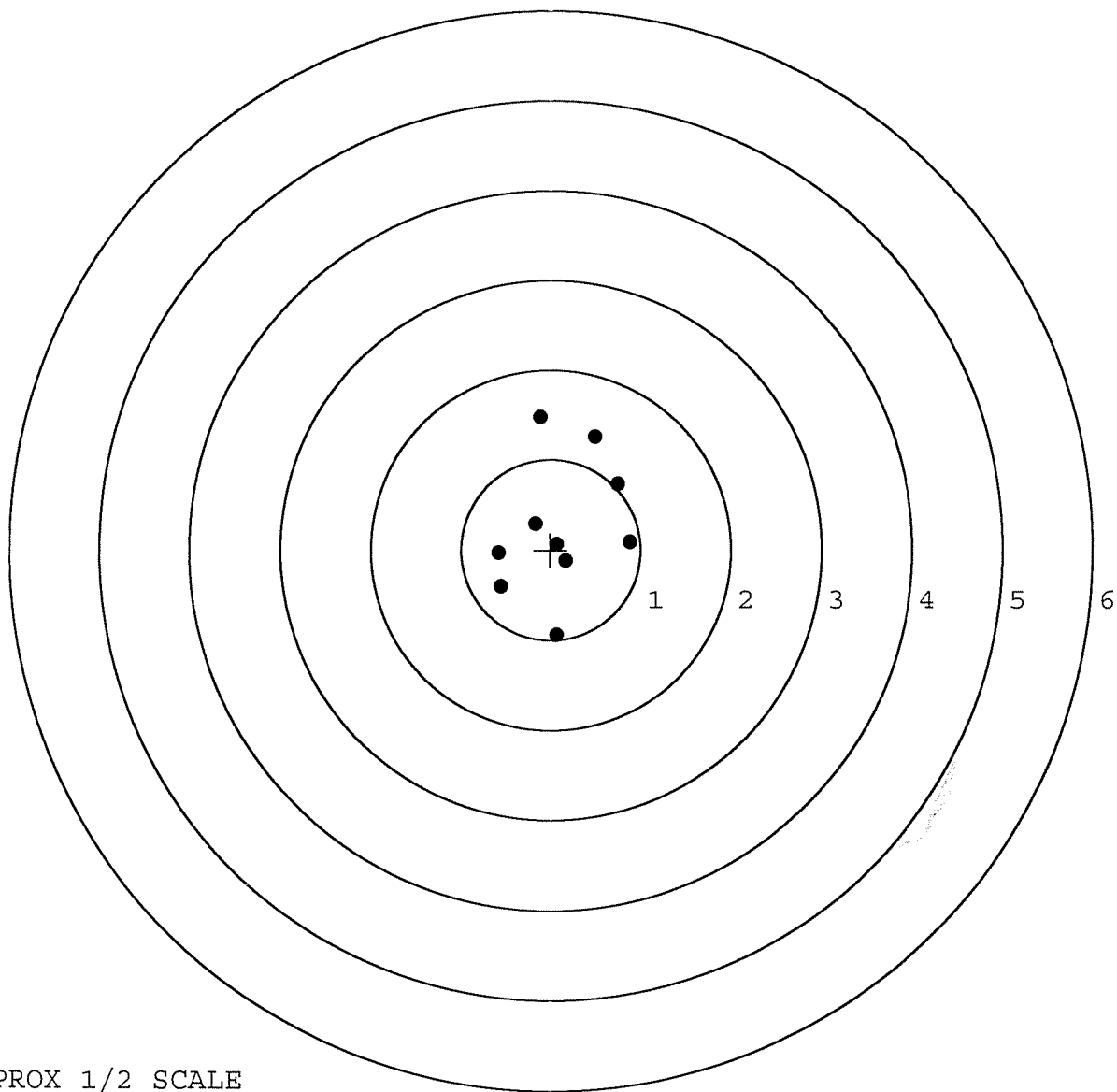


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360900. __0
 TARGET NUMBER: 4
 FILE DATE: 05/03/2004
 FILE TIME: 06:45

X CENTROID: 0.101
 Y CENTROID: 0.237
 POA TO CENTROID: 0.257
 HORZ SPREAD: 1.468
 VERT SPREAD: 2.422
 GROUP SPREAD: 2.430
 MIN RADIUS: 0.175
 MAX RADIUS: 1.252
 MEAN RADIUS: 0.762
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 7
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.072	-0.953
2:	0.885	0.092
3:	0.750	0.729
4:	0.496	1.251
5:	-0.119	1.469
6:	0.167	-0.123
7:	0.067	0.065
8:	-0.169	0.289
9:	-0.583	-0.039
10:	-0.557	-0.411

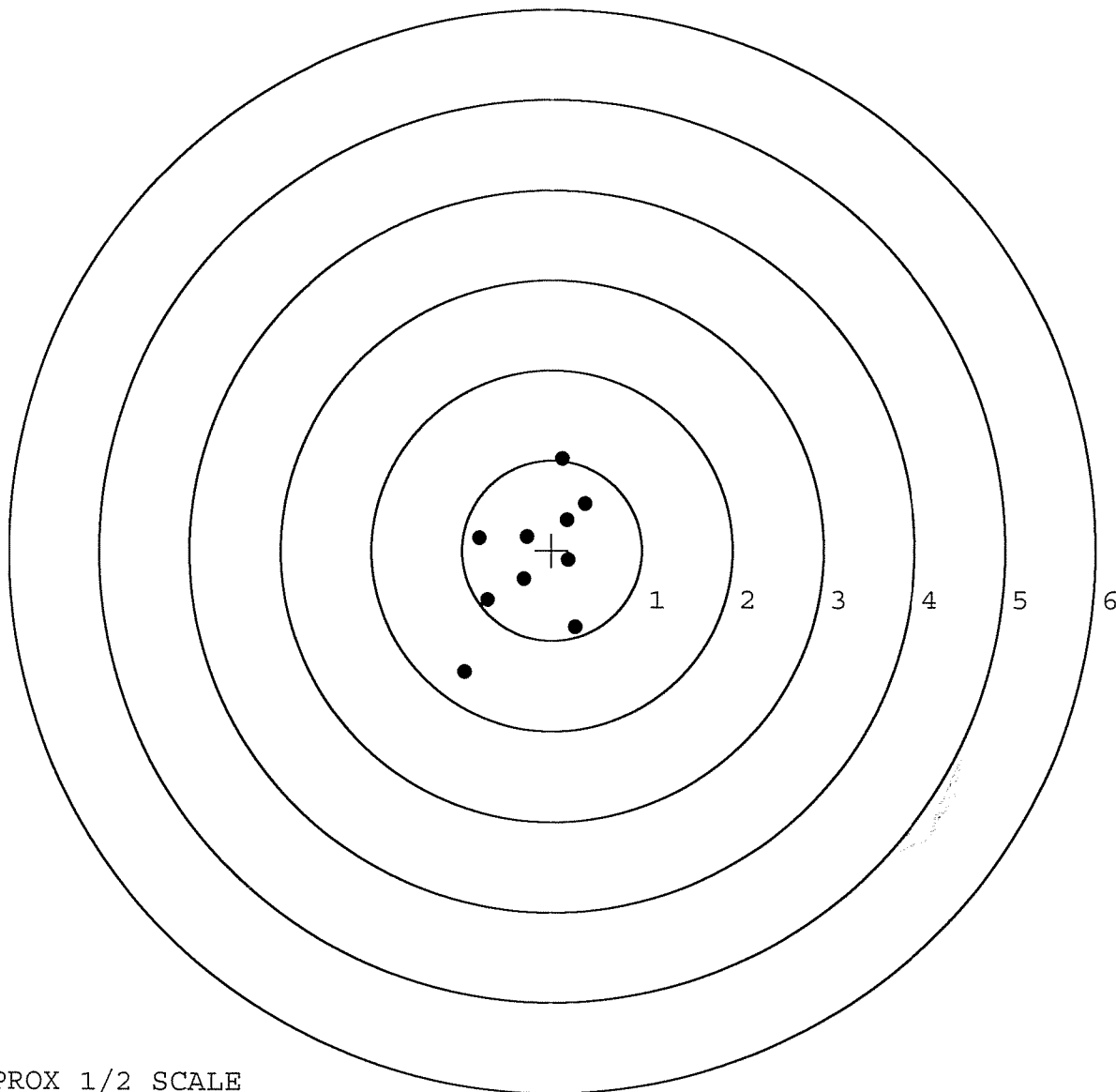


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360900.____0
TARGET NUMBER: 5
FILE DATE: 05/03/2004
FILE TIME: 06:45

POINT#	X	Y
1:	0.265	-0.854
2:	-0.969	-1.358
3:	-0.720	-0.558
4:	-0.311	-0.324
5:	-0.809	0.134
6:	0.185	-0.108
7:	-0.278	0.152
8:	0.172	0.336
9:	0.370	0.517
10:	0.115	1.020

X CENTROID: -0.198
Y CENTROID: -0.104
POA TO CENTROID: 0.224
HORZ SPREAD: 1.339
VERT SPREAD: 2.378
GROUP SPREAD: 2.613
MIN RADIUS: 0.247
MAX RADIUS: 1.472
MEAN RADIUS: 0.718
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

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

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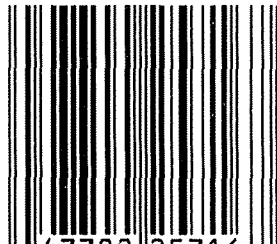


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- INSTRUCTION BOOK 3518

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CAPACITY 6

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