

G6360901

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66360 901

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	PK		
615	ROLLMARK CALIBER		2/25/04	JB
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		3/12/04	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3/12/04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3/12/04	DA
	D) OIL FIRING PIN ASSEMBLY		3/12/04	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>7.0</u> <u>6.5</u> <u>6.0</u>	3/23/04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	3/23/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY		3-23-04	RTL
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.022</u> <u>.022</u>	3/23/04	DA
	J) ASSEMBLE STOCK		3-19-04	RLW
	K) ASSEMBLE SWIVEL STUDS		3-24-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		3-19-04	RLW
	M) IRON SIGHT ALIGNMENT		3-19-04	RLW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		3-19-04	RLW
640	GALLERY TEST AND TARGET	PASS FAIL	3-22-04	TRW
	MALFUNCTION	CORRECTION	3-22-04	TRW
	MALFUNCTION	CORRECTION	3-22-04	TRW
	MALFUNCTION	CORRECTION	3-22-04	TRW
	MALFUNCTION	CORRECTION	3-22-04	TRW
645	INSPECT FOR LIVE AMMO		3-22-04	TRW
655	FINAL INSPECTION A) HEADSPACE		3-24-04	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.52</u> <u>2.74</u> <u>2.39</u> <u>2.33</u> <u>2.46</u>	3/23/04	DA
	C) FUNCTION		3-24-04	RTL
660	PACK		3/24/04	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 3-18-04

TESTER EW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.40	2.53		2.65	
PULL #2	2.51	2.59		2.69	
PULL #3	2.51	2.53		2.51	
PULL #4	2.52	2.56		2.33	
PULL #5	2.43	2.55		2.62	
TOTAL	12.37	12.76		12.80	
AVERAGE	2.47	2.55		2.56	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.05		
PULL #2	3.13	3.22		
PULL #3	3.25	3.06		
PULL #4	3.19	3.01		
PULL #5	3.02	3.04		
TOTAL	15.87	15.38		
AVERAGE	3.17	3.08		

	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	4.25	4.11		4.17
PULL #2	4.23	4.15		4.06
PULL #3	4.16	4.14		4.29
PULL #4	4.12	4.16		4.06
PULL #5	4.22	4.13		4.18
TOTAL	20.98	20.69		20.76
AVERAGE	4.20	4.14		4.15

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360901.___0
FILE DATE AND TIME: 03/22/2004 07:38

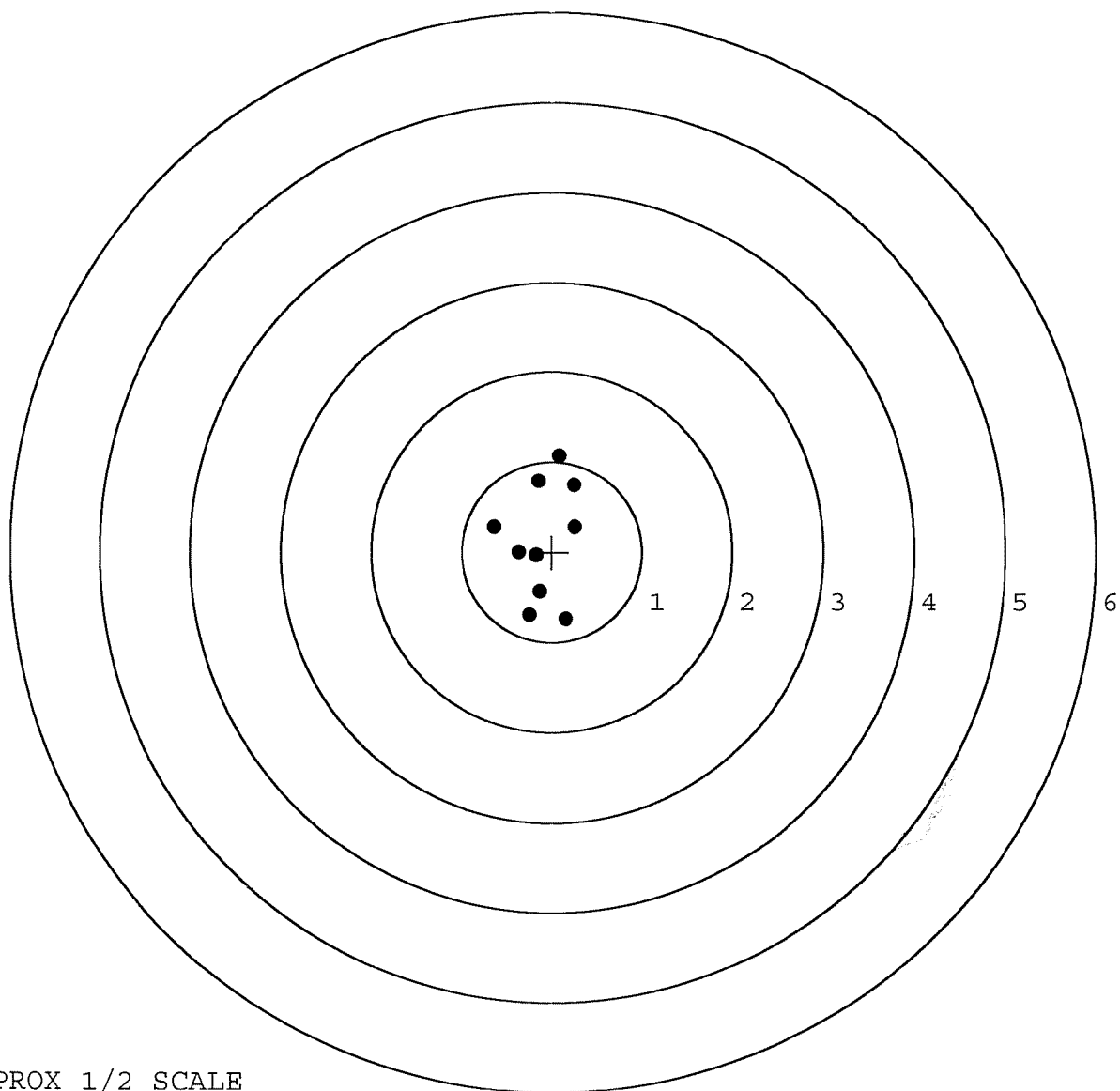
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.044
The Average Y Centroid of the Five Target Set:	-0.005
The Average Point of Impact of the Five Target Set:	0.044
The Average Mean Radius of the Five Target Set:	0.626
The Distance from POA to Centroid Target #1:	0.155
The Distance from Centroid Target #2 to Centroid Target #1:	0.119
The Distance from Centroid Target #3 to Centroid Target #1:	0.174
The Distance from Centroid Target #4 to Centroid Target #1:	0.199
The Distance from Centroid Target #5 to Centroid Target #1:	0.237

SERIAL NUMBER: G6360901.____0
 TARGET NUMBER: 1
 FILE DATE: 03/22/2004
 FILE TIME: 07:38

X CENTROID: -0.099
 Y CENTROID: 0.120
 POA TO CENTROID: 0.155
 HORZ SPREAD: 0.901
 VERT SPREAD: 1.813
 GROUP SPREAD: 1.815
 MIN RADIUS: 0.173
 MAX RADIUS: 0.958
 MEAN RADIUS: 0.607
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.158	-0.752
2:	-0.252	-0.706
3:	-0.139	-0.439
4:	-0.373	-0.003
5:	-0.174	-0.036
6:	0.256	0.274
7:	-0.645	0.279
8:	0.248	0.736
9:	0.083	1.061
10:	-0.149	0.785

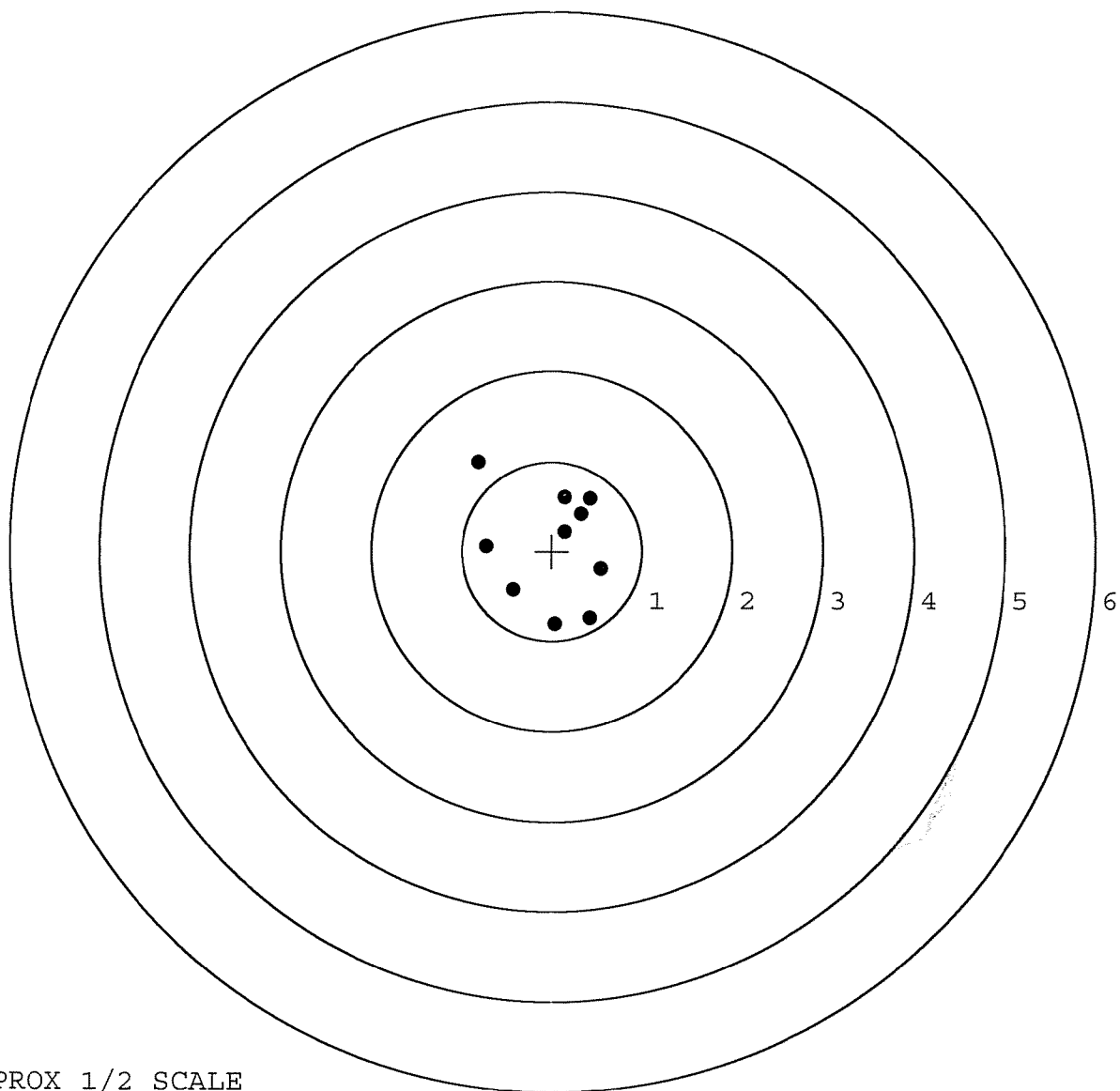


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360901.____0
TARGET NUMBER: 2
FILE DATE: 03/22/2004
FILE TIME: 07:38

X CENTROID: 0.009
Y CENTROID: 0.069
POA TO CENTROID: 0.069
HORZ SPREAD: 1.363
VERT SPREAD: 1.816
GROUP SPREAD: 2.146
MIN RADIUS: 0.199
MAX RADIUS: 1.242
MEAN RADIUS: 0.695
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.432	-0.748
2:	0.036	-0.818
3:	0.547	-0.195
4:	-0.431	-0.428
5:	-0.730	0.056
6:	-0.816	0.998
7:	0.142	0.216
8:	0.432	0.590
9:	0.142	0.600
10:	0.333	0.418

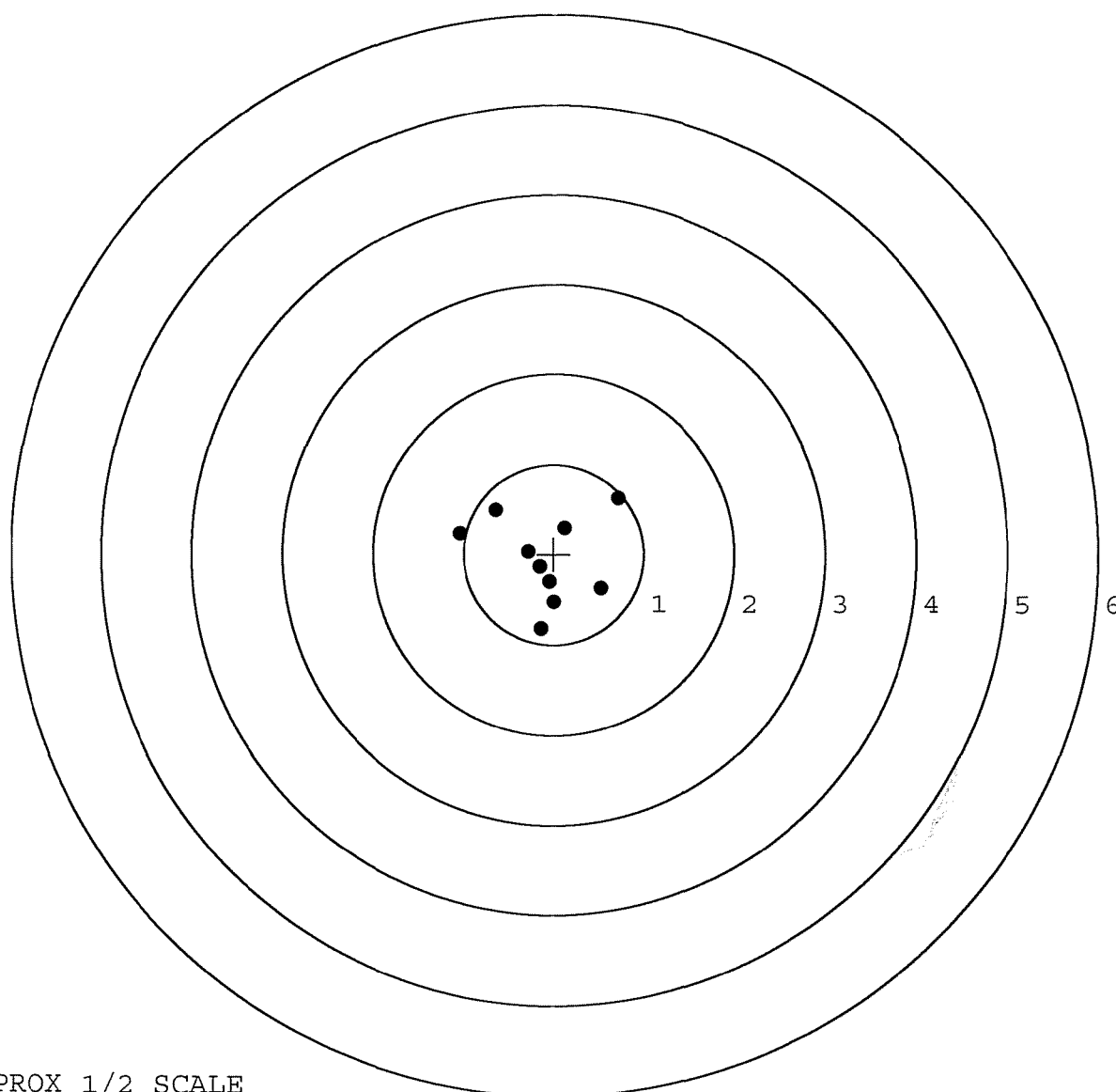


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360901.____0
 TARGET NUMBER: 3
 FILE DATE: 03/22/2004
 FILE TIME: 07:38

X CENTROID: -0.094
 Y CENTROID: -0.054
 POA TO CENTROID: 0.108
 HORZ SPREAD: 1.764
 VERT SPREAD: 1.454
 GROUP SPREAD: 1.808
 MIN RADIUS: 0.112
 MAX RADIUS: 1.062
 MEAN RADIUS: 0.578
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.142	-0.828
2:	0.530	-0.383
3:	0.722	0.626
4:	0.123	0.289
5:	-0.644	0.489
6:	-1.042	0.228
7:	-0.283	0.031
8:	-0.158	-0.146
9:	-0.047	-0.307
10:	-0.001	-0.537

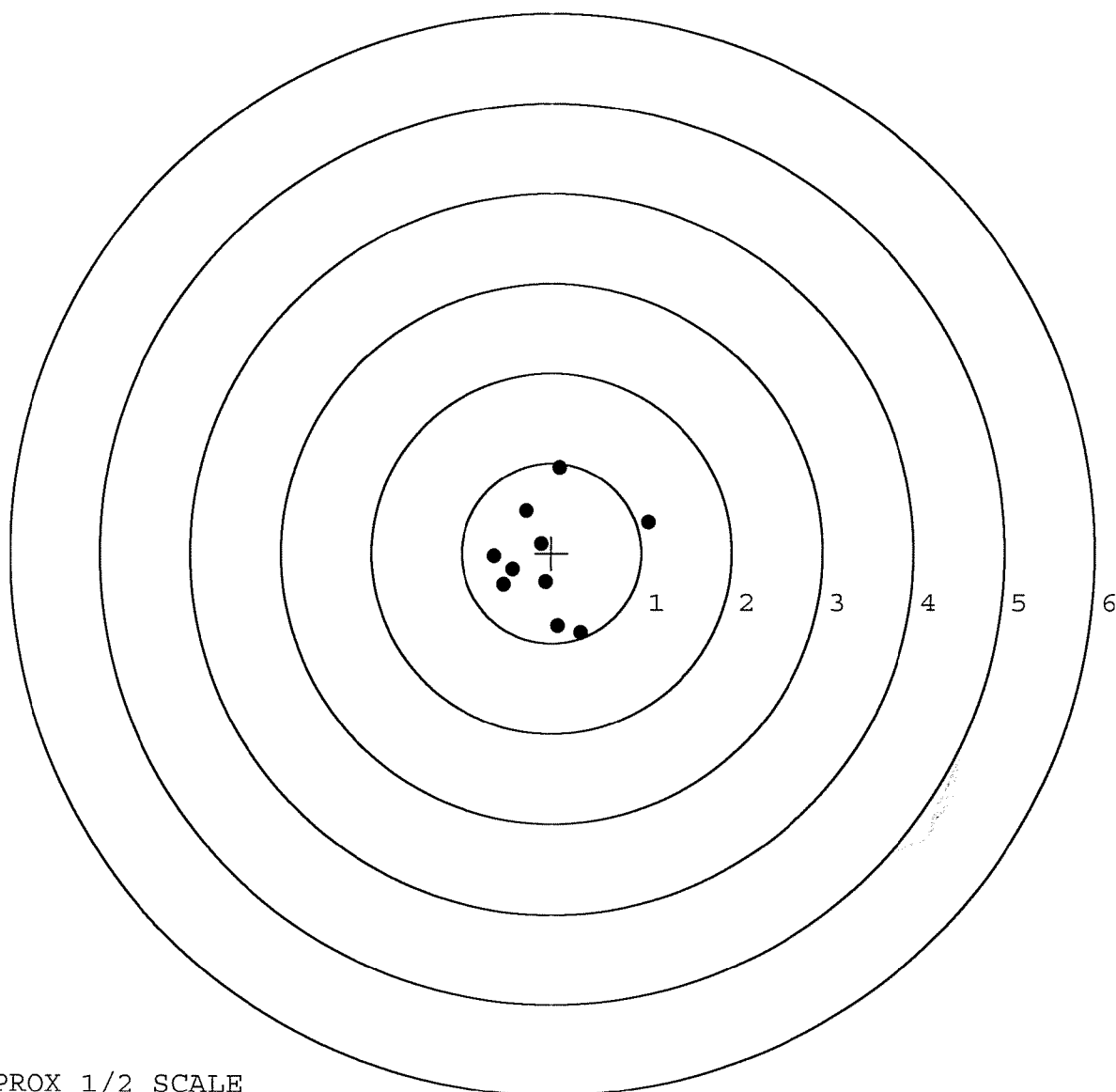


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360901.____0
 TARGET NUMBER: 4
 FILE DATE: 03/22/2004
 FILE TIME: 07:38

X CENTROID: -0.052
 Y CENTROID: -0.073
 POA TO CENTROID: 0.090
 HORZ SPREAD: 1.720
 VERT SPREAD: 1.842
 GROUP SPREAD: 1.762
 MIN RADIUS: 0.189
 MAX RADIUS: 1.203
 MEAN RADIUS: 0.648
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.077	0.342
2:	0.331	-0.891
3:	0.073	-0.815
4:	0.088	0.951
5:	-0.285	0.473
6:	-0.119	0.103
7:	-0.070	-0.325
8:	-0.534	-0.351
9:	-0.643	-0.039
10:	-0.437	-0.181

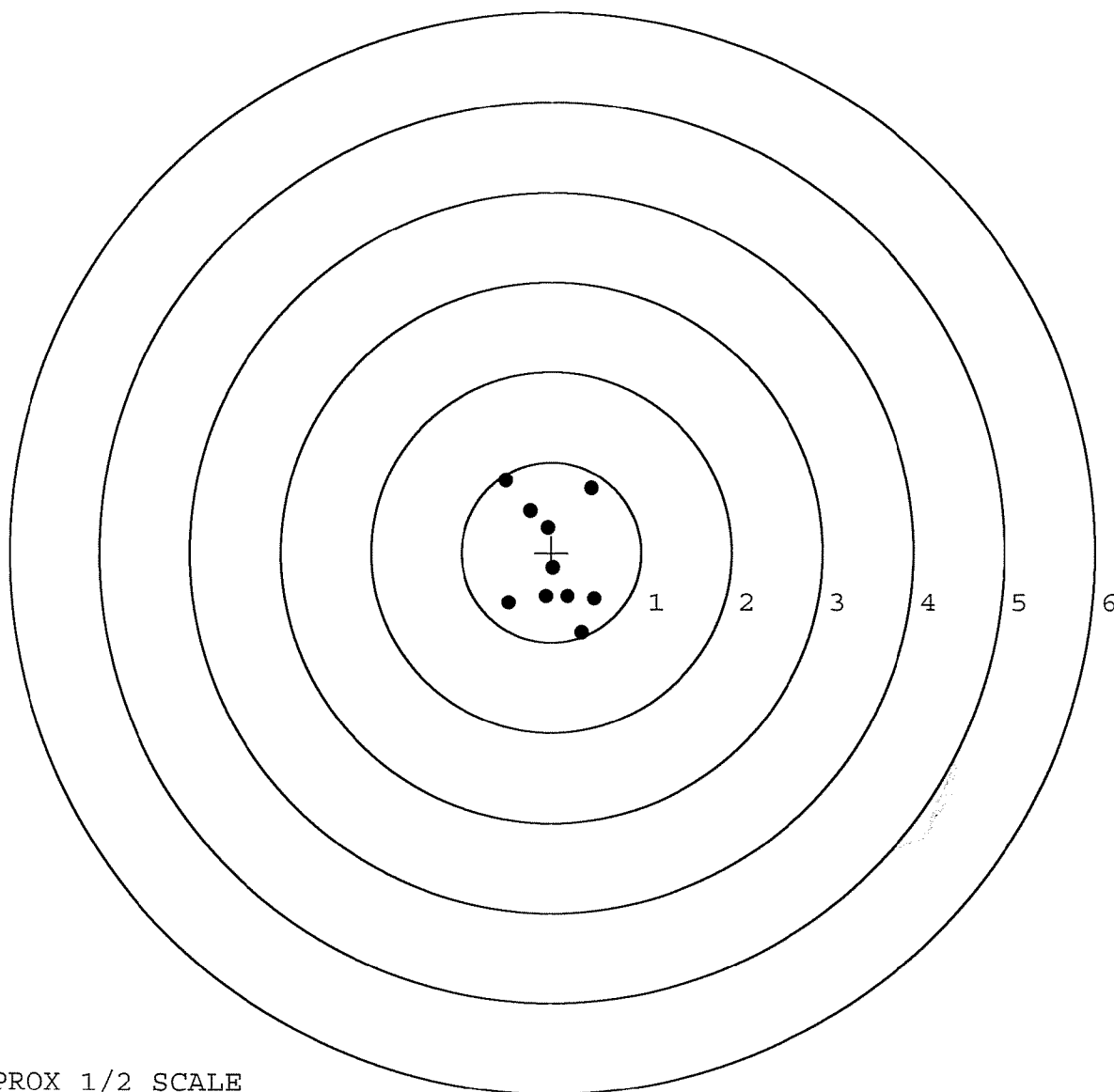


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360901. 0
 TARGET NUMBER: 5
 FILE DATE: 03/22/2004
 FILE TIME: 07:38

X CENTROID: 0.015
 Y CENTROID: -0.088
 POA TO CENTROID: 0.089
 HORZ SPREAD: 0.995
 VERT SPREAD: 1.692
 GROUP SPREAD: 1.896
 MIN RADIUS: 0.084
 MAX RADIUS: 1.029
 MEAN RADIUS: 0.604
 # IN 1 IN DIAMETER: 4
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.346	-0.895
2:	0.485	-0.517
3:	-0.479	-0.563
4:	0.447	0.709
5:	-0.238	0.466
6:	-0.040	0.280
7:	-0.510	0.797
8:	0.016	-0.171
9:	0.185	-0.491
10:	-0.060	-0.490



TARGET APPROX 1/2 SCALE

VERY IMPORTANT
Instruction Book
enclosed to assure
safe use of this
firearm.

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

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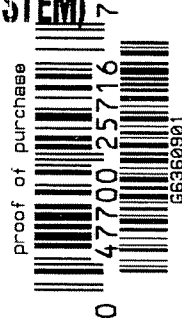
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24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM



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CAPACITY	6

G6360901

