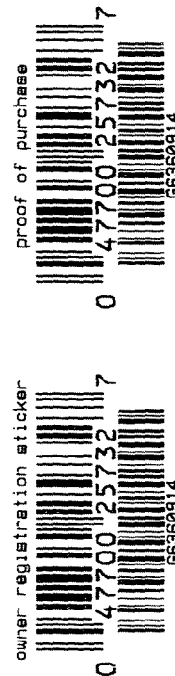


G6360914

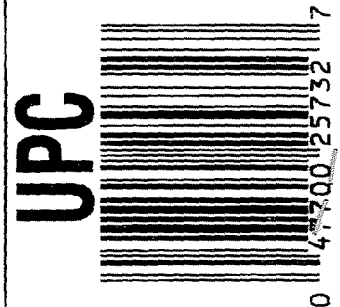
M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

DD FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5
G6360914	



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



SERIAL NO.



10/29/2004 1:34:17 PM

CRIB

9

Reprint

25732

M/24 7.62 NATO (RIFLE ONLY)



.MA25732

Shop Order: SWS5732 - NOV



.ABSWS5732 - NOV

Start Date: 10/4/2004

Finish Date: 11/18/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003516940

0560

Reassemble Action.

89SWS1



0003516941

0690

Pack Rifle

89SWS1



0003516952

0700

Stencil SWS Container

89SWS1



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6360914

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		1-24-05	RTL
600	PROOF	MAGNA-FLUX	1-25-05	AC
607	CHECK HEADSPACE	INSPECTED	1-25-05	AC
610	DIS-ASSEMBLE GUN	JAN 26 2005	1-26-05	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR 		
615	ROLLMARK CALIBER		1-27-05	CW
617	DRILL AND TAP SIGHT HOLES		1-26-05	TRW
620	APPLY COATINGS (BARREL ACTION)		1/31/05	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-16-05	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-16-05	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-16-05	RTL
	D) OIL FIRING PIN ASSEMBLY		3-16-05	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3-29-05	TRW

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>6-0</u> <u>6.75</u> <u>6-0</u>	3-30-05	RTZ
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2-0</u> <u>2-0</u> <u>2-0</u>	3-30-05	RTZ
	H) TRIGGER PULL TEST AND RETAINABILITY		X	X
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.024</u>	3-30-05	RTZ
	J) ASSEMBLE STOCK		3-28-05	RTZ
	K) ASSEMBLE SWIVEL STUDS		3-30-05	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		X	X
	M) IRON SIGHT ALIGNMENT		X	X
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		X	X
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	3-29-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		3-29-05	AC
655	FINAL INSPECTION A) HEADSPACE		3-30-05	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.85</u> <u>2.73</u> <u>2.88</u> <u>2.89</u> <u>2.88</u>	3-29-05	TRW
	C) FUNCTION		3-30-05	AC
660	PACK		3-30-05	OTA

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.

G6360914

DATE

3-9-05

TESTER

TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.60	2.57		2.20	
PULL #2	2.57	2.68		2.23	
PULL #3	2.63	2.28		2.21	
PULL #4	2.60	2.50		2.21	
PULL #5	2.58	2.43		2.23	
TOTAL	12.98	12.46		11.08	
AVERAGE	2.59	2.49		2.21	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.29		
PULL #2	3.18	3.22		
PULL #3	3.21	3.34		
PULL #4	3.25	3.12		
PULL #5	3.49	3.19		
TOTAL	16.21	16.16		
AVERAGE	3.24	3.23		

	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	4.34	4.12		4.10
PULL #2	4.01	4.09		4.14
PULL #3	4.08	4.08		4.11
PULL #4	4.11	4.06		4.13
PULL #5	4.09	4.05		4.05
TOTAL	20.63	20.40		20.53
AVERAGE	4.12	4.08		4.10

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360914.___0
FILE DATE AND TIME: 03/29/2005 07:49

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

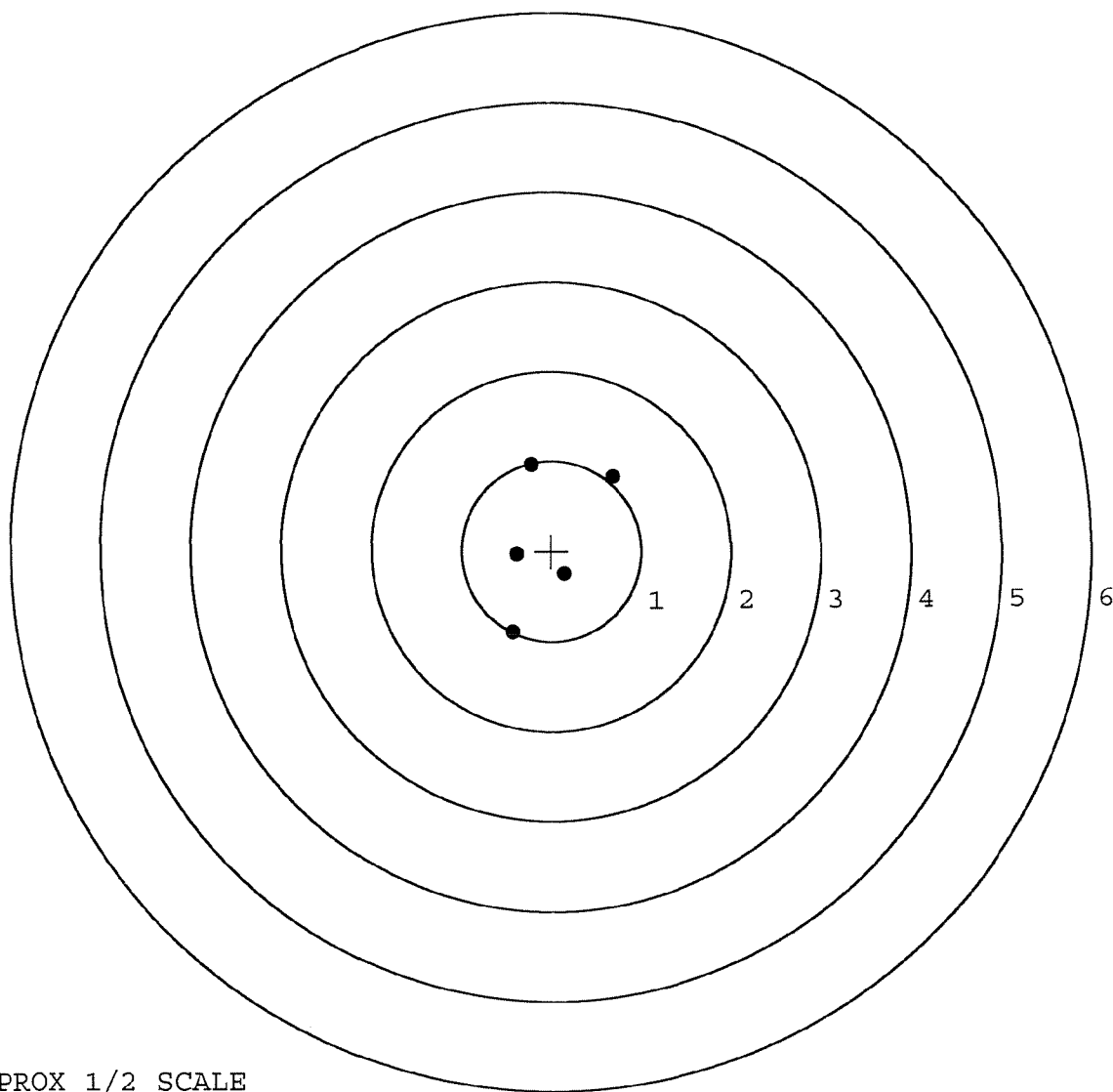
ERROR - NOT POSSIBLE TO REPORT SWS STATS ON DATA
WHERE TOTAL TARGETS ARE NOT EQUAL TO FIVE

AVE. MEAN .5935

SERIAL NUMBER: G6360914. __0
TARGET NUMBER: 1
FILE DATE: 03/29/2005
FILE TIME: 07:49

POINT#	X	Y
1:	-0.440	-0.901
2:	0.142	-0.258
3:	-0.393	-0.034
4:	-0.223	0.957
5:	0.688	0.825

X CENTROID: -0.045
Y CENTROID: 0.118
POA TO CENTROID: 0.126
HORZ SPREAD: 1.128
VERT SPREAD: 1.858
GROUP SPREAD: 2.062
MIN RADIUS: 0.379
MAX RADIUS: 1.093
MEAN RADIUS: 0.754
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 5

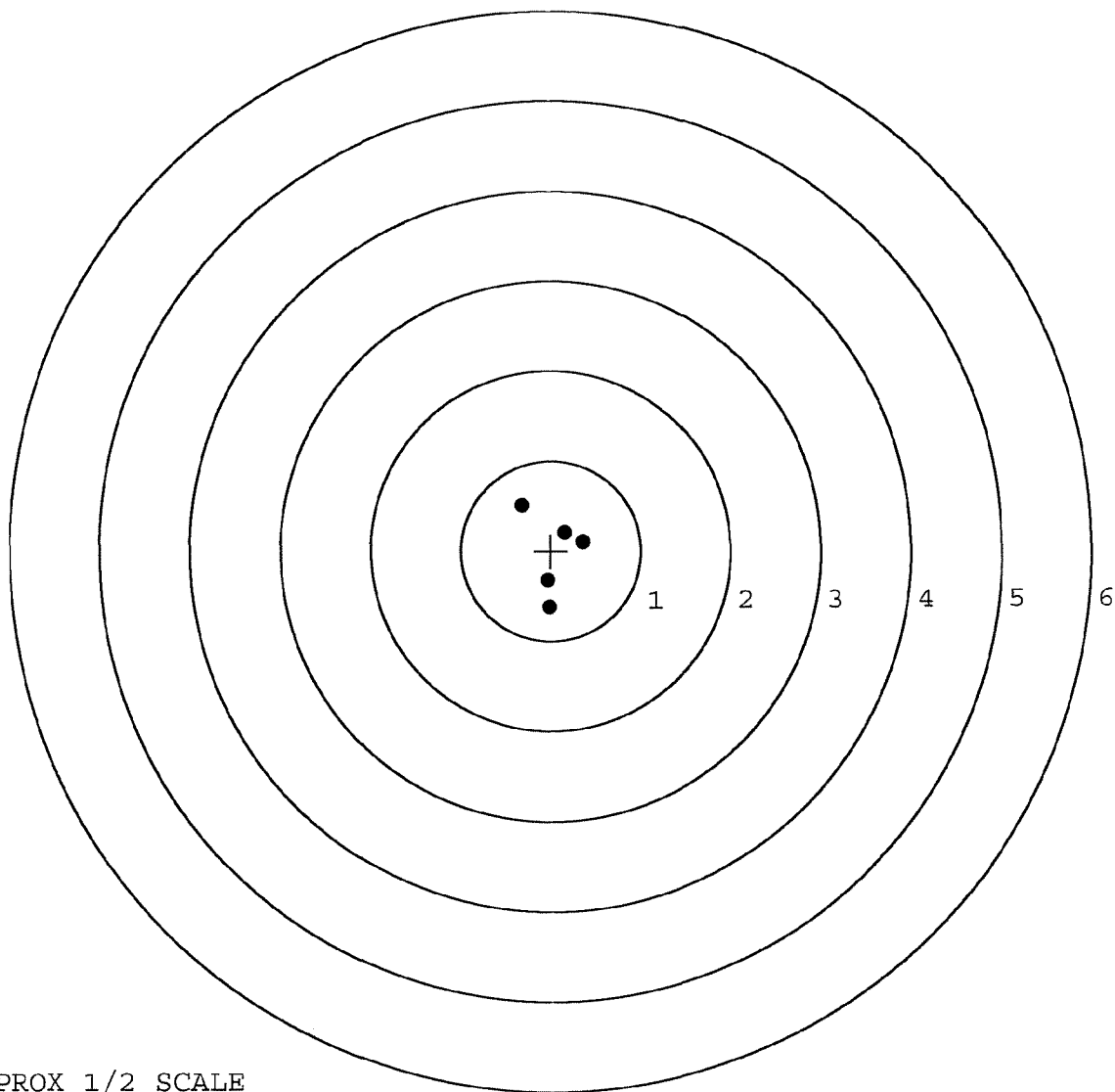


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360914. __0
TARGET NUMBER: 2
FILE DATE: 03/29/2005
FILE TIME: 07:49

FCINT#	X	Y
1:	-0.018	-0.631
2:	-0.035	-0.327
3:	0.364	0.101
4:	0.162	0.204
5:	-0.315	0.500

X CENTROID: 0.032
Y CENTROID: -0.031
POA TO CENTROID: 0.044
HORZ SPREAD: 0.679
VERT SPREAD: 1.131
GROUP SPREAD: 1.169
MIN RADIUS: 0.268
MAX RADIUS: 0.634
MEAN RADIUS: 0.433
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE