G 1310877

9/27/2004 10:33:18 AM

Original 18 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.

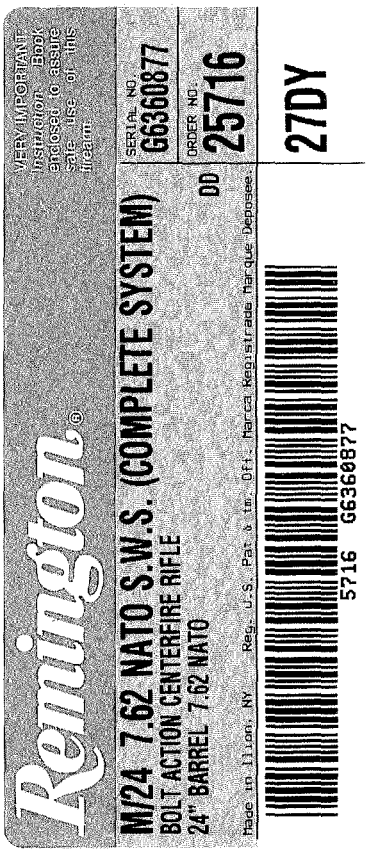
0003451404

0690 89SWS1
Pack Rifle

0003451397

0700 89SWS1
Stencil SWS Container

.OP0700



ORDER 25716

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

UPC

0 47700 25716 7

ORDER 25716

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

UPC

0 47700 25716 7

SERIAL NO.

G6360877

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

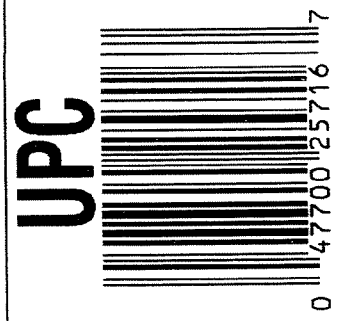
– INSTUCTION BOOK 3518

DD FORM

ORDER NO. **25716**

BARREL LENGTH	24"
CAPACITY	6

G6360877



7/22/2004 3:21:04 PM

Original **37** 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

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 # GA360877

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		4-6-04	RTL
610	DIS-ASSEMBLE GUN		4-6-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	RL		
615	ROLLMARK CALIBER		4/8/04	ds
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		6-15-04	RW
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-15-04	RW
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6-15-04	RW
	D) OIL FIRING PIN ASSEMBLY		6-15-04	RW
	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 6.2 6.5	6-21-04	RTL
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	3.0 2.75 2.50	6-21-04	RTL
	H) TRIGGER PULL TEST AND RETAINABILITY		6-21-04	RTL
	I) FIRING PIN INDENT [.020 MIN]	.022 .022 .021	6-21-04	RTL
	J) ASSEMBLE STOCK		6-15-04	RTL
	K) ASSEMBLE SWIVEL STUDS		9-7-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-26-04	RTL
	M) IRON SIGHT ALIGNMENT		8-26-04	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-26-04	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	6-18-04	AC
	MALFUNCTION	CORRECTION	6-18-04	AC
	MALFUNCTION	CORRECTION	6-18-04	AC
	MALFUNCTION	CORRECTION	6-18-04	AC
	MALFUNCTION	CORRECTION	6-18-04	AC
645	INSPECT FOR LIVE AMMO		6-18-04	AC
655	FINAL INSPECTION A) HEADSPACE		9-7-04	RTL
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	267 248 250 241 245	6-21-04	RTL
	C) FUNCTION		9-7-04	RTL
660	PACK		9/8/04	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 6-15-04

TESTER GW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.33	2.40		2.18	
PULL #2	2.57	2.37		2.04	
PULL #3	2.61	2.35		2.17	
PULL #4	2.61	2.48		2.29	
PULL #5	2.63	2.35		2.32	
TOTAL	12.75	11.95		11.00	
AVERAGE	2.55	2.39		2.20	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.04		
PULL #2	3.38	3.18		
PULL #3	3.16	3.41		
PULL #4	3.37	3.30		
PULL #5	3.43	3.37		
TOTAL	16.71	16.30		
AVERAGE	3.34	3.26		

	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	4.16	4.07		4.21
PULL #2	4.06	4.01		4.23
PULL #3	4.17	4.02		4.26
PULL #4	4.16	4.12		4.31
PULL #5	4.21	4.00		4.35
TOTAL	20.76	20.22		21.36
AVERAGE	4.15	4.04		4.27

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6360877.__0
FILE DATE AND TIME: 06/18/2004 06:38

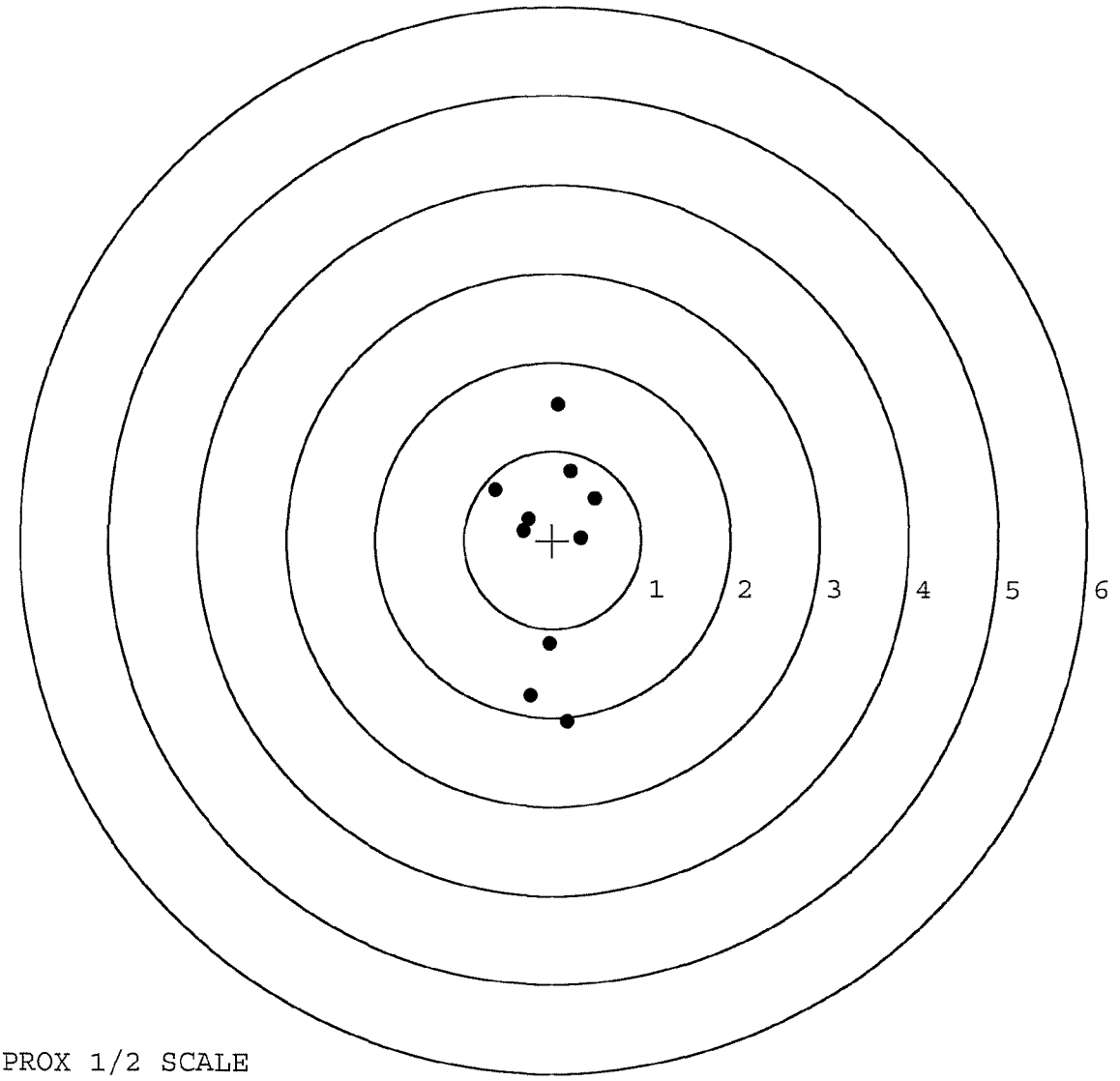
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.008
The Average Y Centroid of the Five Target Set:	-0.071
The Average Point of Impact of the Five Target Set:	0.071
The Average Mean Radius of the Five Target Set:	0.976
The Distance from POA to Centroid Target #1:	0.131
The Distance from Centroid Target #2 to Centroid Target #1:	0.247
The Distance from Centroid Target #3 to Centroid Target #1:	0.093
The Distance from Centroid Target #4 to Centroid Target #1:	0.387
The Distance from Centroid Target #5 to Centroid Target #1:	0.342

SERIAL NUMBER: G6360877.__0
TARGET NUMBER: 1
FILE DATE: 06/18/2004
FILE TIME: 06:38

X CENTROID:	-0.031
Y CENTROID:	-0.127
POA TO CENTROID:	0.131
HORZ SPREAD:	1.133
VERT SPREAD:	3.577
GROUP SPREAD:	3.579
MIN RADIUS:	0.385
MAX RADIUS:	1.937
MEAN RADIUS:	1.013
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	7

POINT#	X	Y
1:	0.175	-2.053
2:	-0.244	-1.755
3:	-0.034	-1.169
4:	-0.655	0.565
5:	-0.338	0.105
6:	0.323	0.031
7:	0.061	1.524
8:	0.201	0.776
9:	0.478	0.469
10:	-0.275	0.238

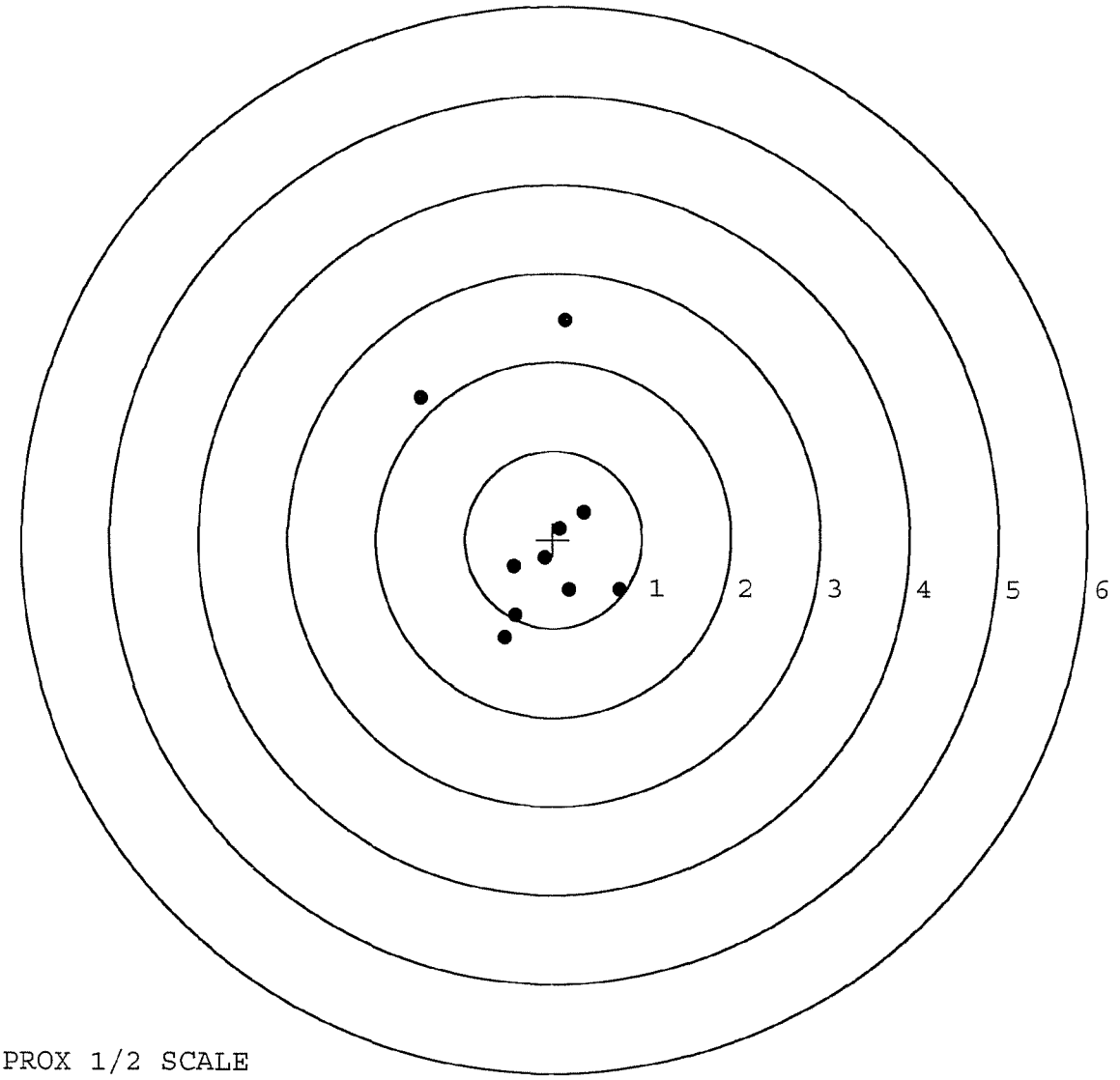


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360877.__0
TARGET NUMBER: 2
FILE DATE: 06/18/2004
FILE TIME: 06:38

X CENTROID:	-0.156
Y CENTROID:	0.086
POA TO CENTROID:	0.178
HORZ SPREAD:	2.252
VERT SPREAD:	3.588
GROUP SPREAD:	3.651
MIN RADIUS:	0.237
MAX RADIUS:	2.403
MEAN RADIUS:	1.011
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.749	-0.570
2:	0.182	-0.570
3:	-0.552	-1.115
4:	-0.428	-0.866
5:	-1.503	1.595
6:	0.124	2.473
7:	0.341	0.310
8:	0.078	0.124
9:	-0.097	-0.210
10:	-0.452	-0.307

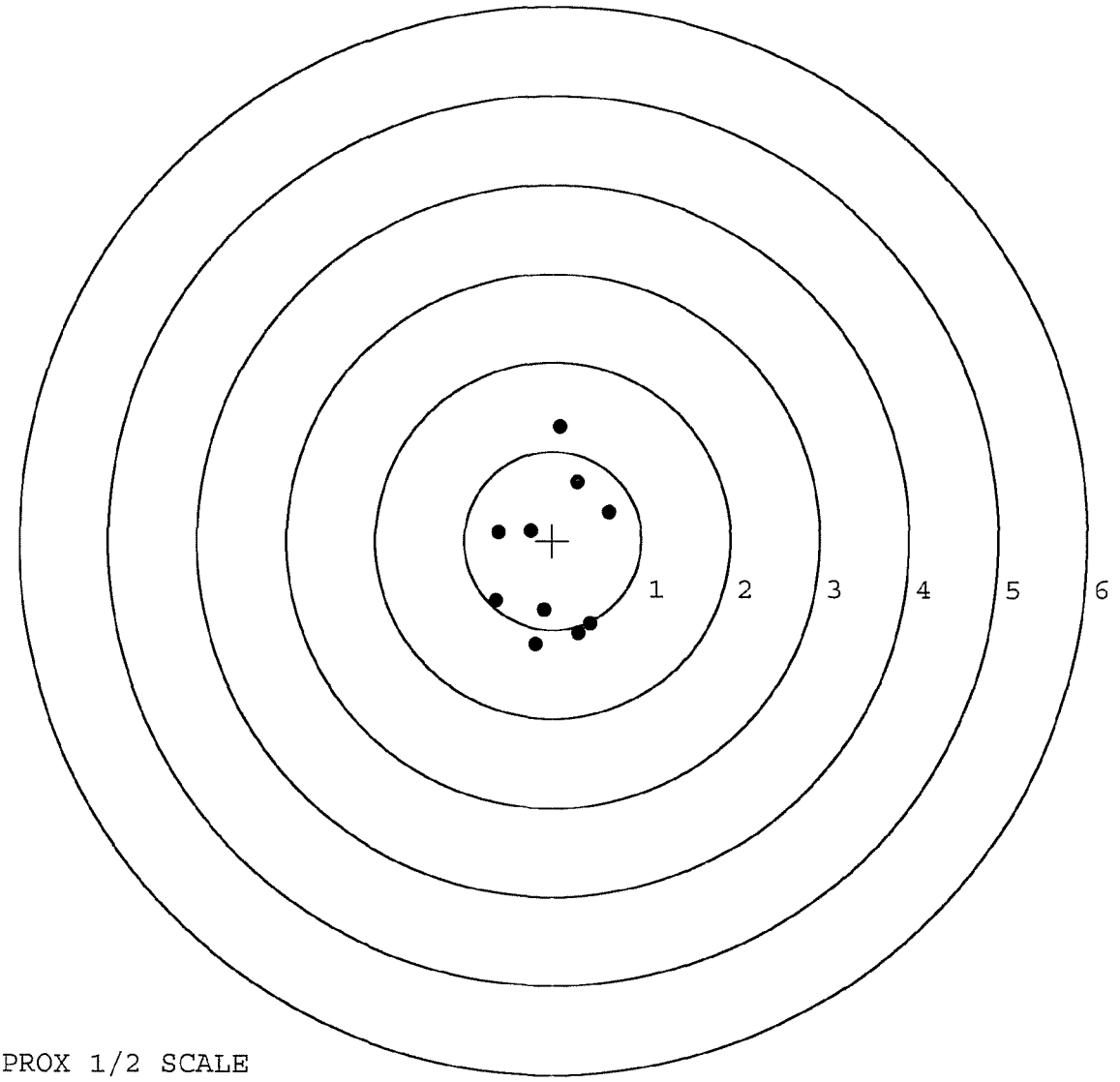


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360877.__0
TARGET NUMBER: 3
FILE DATE: 06/18/2004
FILE TIME: 06:38

X CENTROID:	-0.008
Y CENTROID:	-0.217
POA TO CENTROID:	0.217
HORZ SPREAD:	1.284
VERT SPREAD:	2.446
GROUP SPREAD:	2.462
MIN RADIUS:	0.401
MAX RADIUS:	1.495
MEAN RADIUS:	0.839
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.289	-1.043
2:	-0.097	-0.786
3:	-0.196	-1.170
4:	-0.644	-0.684
5:	-0.610	0.093
6:	-0.244	0.108
7:	0.640	0.317
8:	0.276	0.660
9:	0.083	1.276
10:	0.421	-0.938

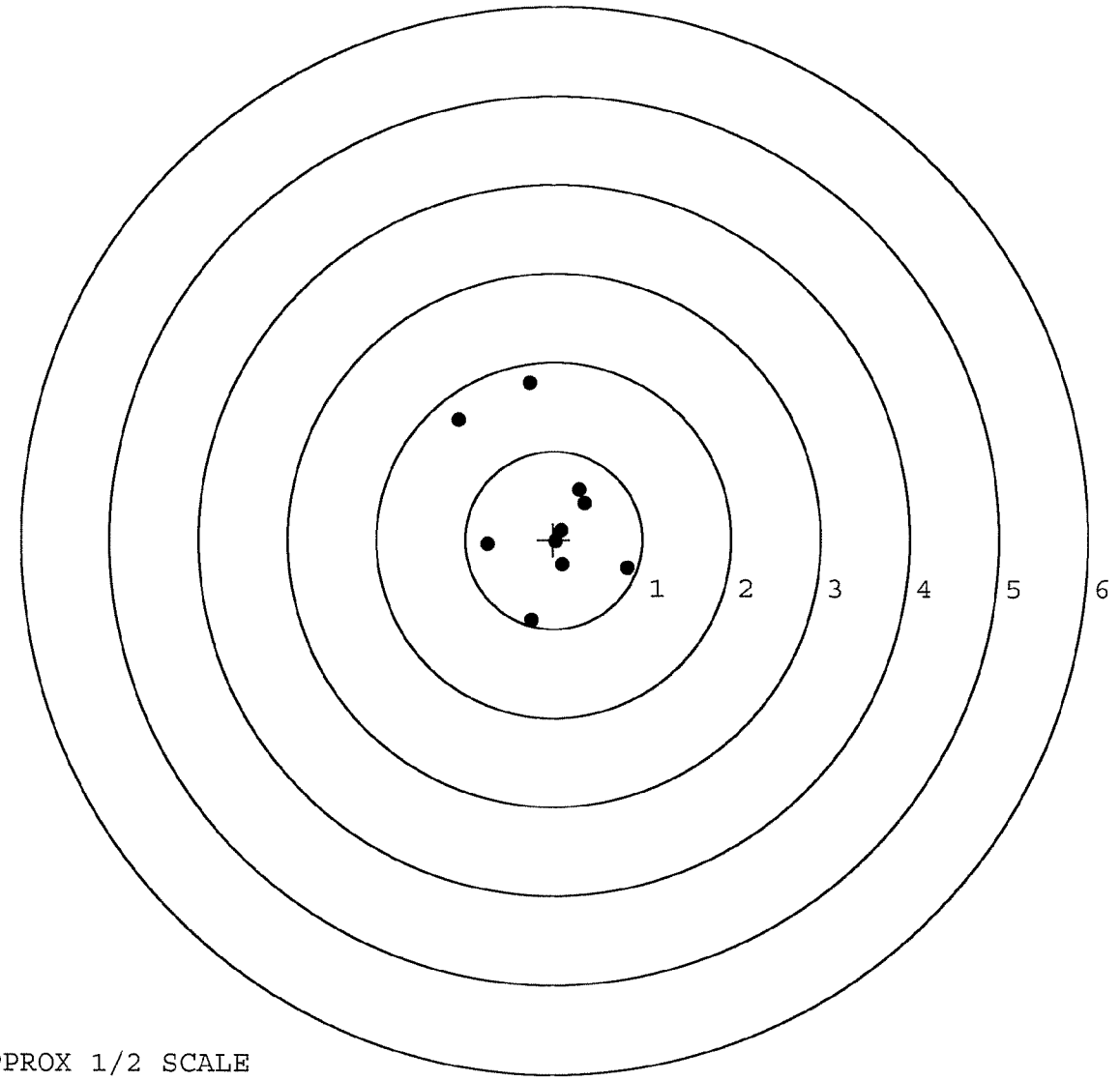


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360877.__0
TARGET NUMBER: 4
FILE DATE: 06/18/2004
FILE TIME: 06:38

X CENTROID:	-0.066
Y CENTROID:	0.259
POA TO CENTROID:	0.267
HORZ SPREAD:	1.910
VERT SPREAD:	2.674
GROUP SPREAD:	2.674
MIN RADIUS:	0.222
MAX RADIUS:	1.519
MEAN RADIUS:	0.801
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.274	1.763
2:	-1.076	1.349
3:	0.293	0.562
4:	0.350	0.411
5:	0.834	-0.326
6:	0.093	0.103
7:	0.021	-0.024
8:	0.102	-0.284
9:	-0.253	-0.911
10:	-0.749	-0.056

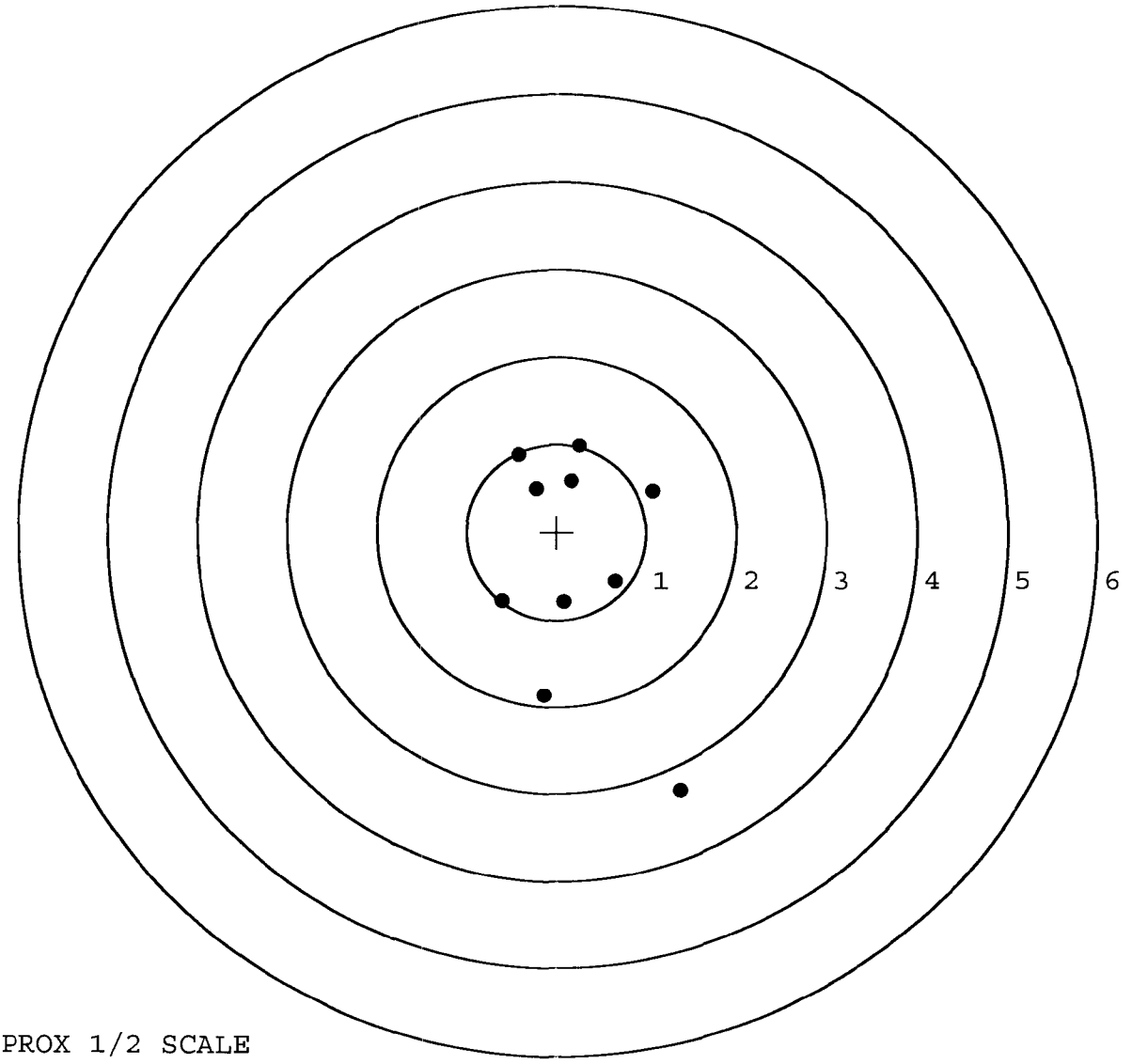


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6360877.__0
TARGET NUMBER: 5
FILE DATE: 06/18/2004
FILE TIME: 06:38

X CENTROID:	0.223
Y CENTROID:	-0.357
POA TO CENTROID:	0.421
HORZ SPREAD:	1.997
VERT SPREAD:	3.953
GROUP SPREAD:	4.257
MIN RADIUS:	0.464
MAX RADIUS:	2.861
MEAN RADIUS:	1.214
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	1.075	0.472
2:	0.658	-0.564
3:	0.084	-0.800
4:	-0.612	-0.784
5:	-0.143	-1.872
6:	-0.421	0.884
7:	-0.223	0.499
8:	0.170	0.586
9:	0.256	0.982
10:	1.385	-2.971



TARGET APPROX 1/2 SCALE