

G 6236118

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66236118

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		10/7/02	RL
600	PROOF		10/7/02	RL
607	CHECK HEADSPACE	MAGNA - FLUX INSPECTED	10/7/02	RL
610	DIS-ASSEMBLE GUN		10/7/02	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OCT 8 2002 OPERATOR <u>RL</u>		
615	ROLLMARK CALIBER		10/9/02	RL
617	DRILL AND TAP SIGHT HOLES		10/9/02	TRW
620	APPLY COATINGS (BARREL ACTION)		10-17	TA
	(BOLT)		10-17	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		3-27-03	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-03	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-03	RTL
	D) OIL FIRING PIN ASSEMBLY		3-27-03	RTL
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3-27-03	RTL

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>9</u> <u>9</u> <u>9</u>	3-28-03	RW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3</u> <u>3.5</u>	3-28-03	RW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	3-28-03	RW
	J) ASSEMBLE STOCK		3-26-03	RW
	K) ASSEMBLE SWIVEL STUDS		3-28-03	RW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	PASS FAIL	3-27-03	A
	MALFUNCTION	CORRECTION	3-27-03	A
	MALFUNCTION	CORRECTION	3-27-03	A
	MALFUNCTION	CORRECTION	3-27-03	A
	MALFUNCTION	CORRECTION	3-27-03	A
645	INSPECT FOR LIVE AMMO		3-27-03	A
655	FINAL INSPECTION A) HEADSPACE		3-28-03	RW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.70</u> <u>2.81</u> <u>2.81</u> <u>2.66</u> <u>2.57</u>	3-28-03	RW
	C) FUNCTION		3-28-03	RW
660	PACK		4/6/03	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO. _____
DATE 3-26-03

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.61	2.49	2.07	MIN. SETTING,
PULL #2	2.51	2.34	2.36	NO AVG. OF 5
PULL #3	2.60	2.09	2.21	READINGS ACCEPT-
PULL #4	2.53	2.20	2.04	ABLE LESS THAN 2
PULL #5	2.59	2.21	2.41	
TOTAL	12.84	11.33	11.09	
AVG.	2.56	2.26	2.21	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.25	3.47	
PULL #2	3.39	3.22	
PULL #3	3.29	3.16	
PULL #4	3.07	3.02	
PULL #5	3.04	3.32	
TOTAL	16.04	16.19	
AVG.	3.20	3.23	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCUR.
PULL #1	4.21	4.34		4.28
PULL #2	4.06	4.18		4.36
PULL #3	4.24	4.31		4.22
PULL #4	4.14	4.49		3.99
PULL #5	4.25	4.45		4.14
TOTAL	20.90	21.77		20.99
AVG.	4.18	4.35		4.19

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6236118.__0

FILE DATE AND TIME: 03/28/2003 11:09

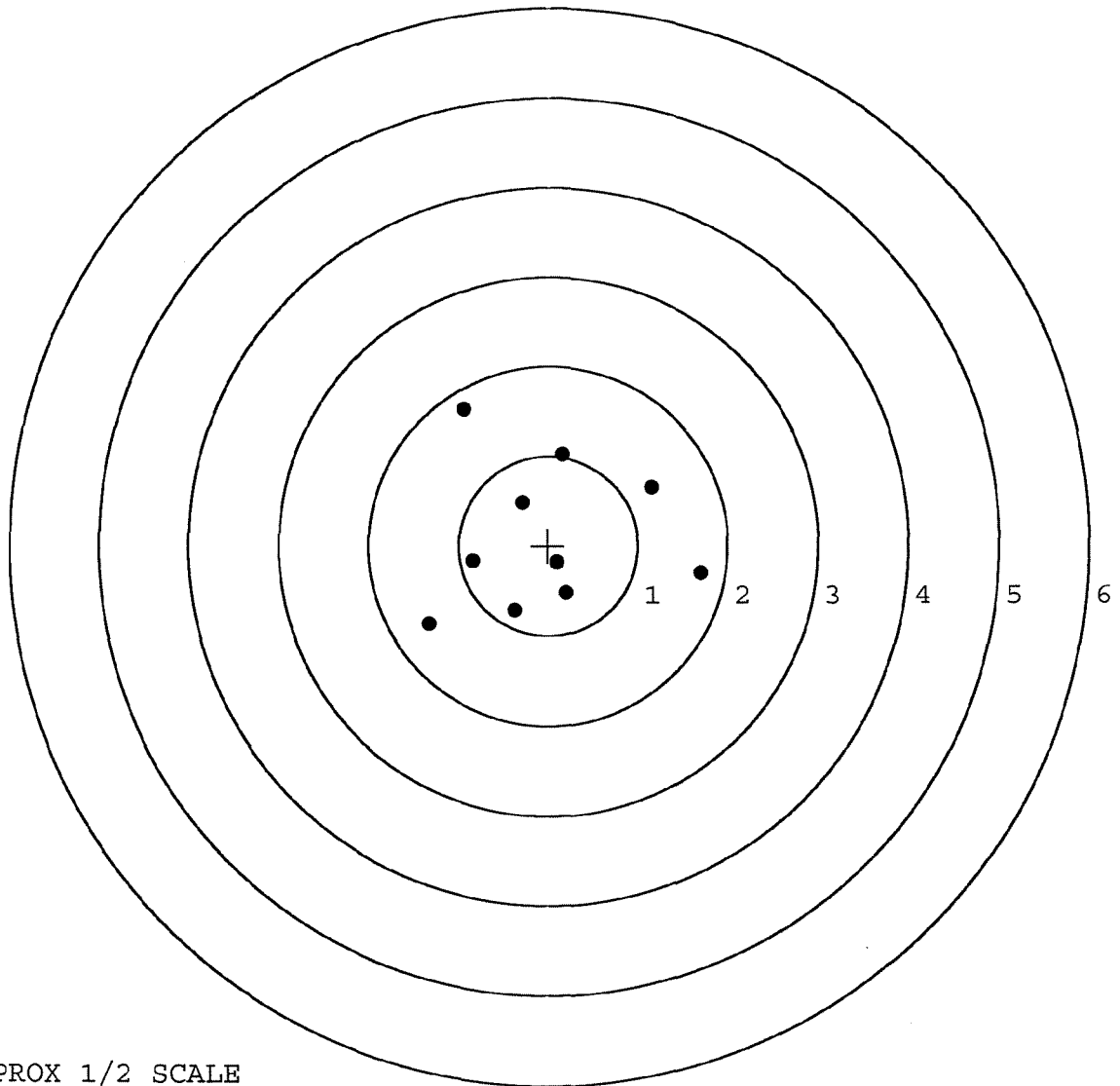
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.037
The Average Y Centroid of the Five Target Set:	0.071
The Average Point of Impact of the Five Target Set:	0.080
The Average Mean Radius of the Five Target Set:	0.846
The Distance from POA to Centroid Target #1:	0.100
The Distance from Centroid Target #2 to Centroid Target #1:	0.276
The Distance from Centroid Target #3 to Centroid Target #1:	0.125
The Distance from Centroid Target #4 to Centroid Target #1:	0.075
The Distance from Centroid Target #5 to Centroid Target #1:	0.392

SERIAL NUMBER: G6236118. 0
TARGET NUMBER: 1
FILE DATE: 03/28/2003
FILE TIME: 11:09

X CENTROID: -0.047
Y CENTROID: 0.089
POA TO CENTROID: 0.100
HORZ SPREAD: 3.028
VERT SPREAD: 2.404
GROUP SPREAD: 3.218
MIN RADIUS: 0.316
MAX RADIUS: 1.791
MEAN RADIUS: 1.053
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	1.701	-0.302
2:	1.152	0.651
3:	0.163	1.016
4:	0.106	-0.188
5:	0.202	-0.532
6:	-0.948	1.525
7:	-0.292	0.486
8:	-0.844	-0.167
9:	-0.379	-0.721
10:	-1.327	-0.879

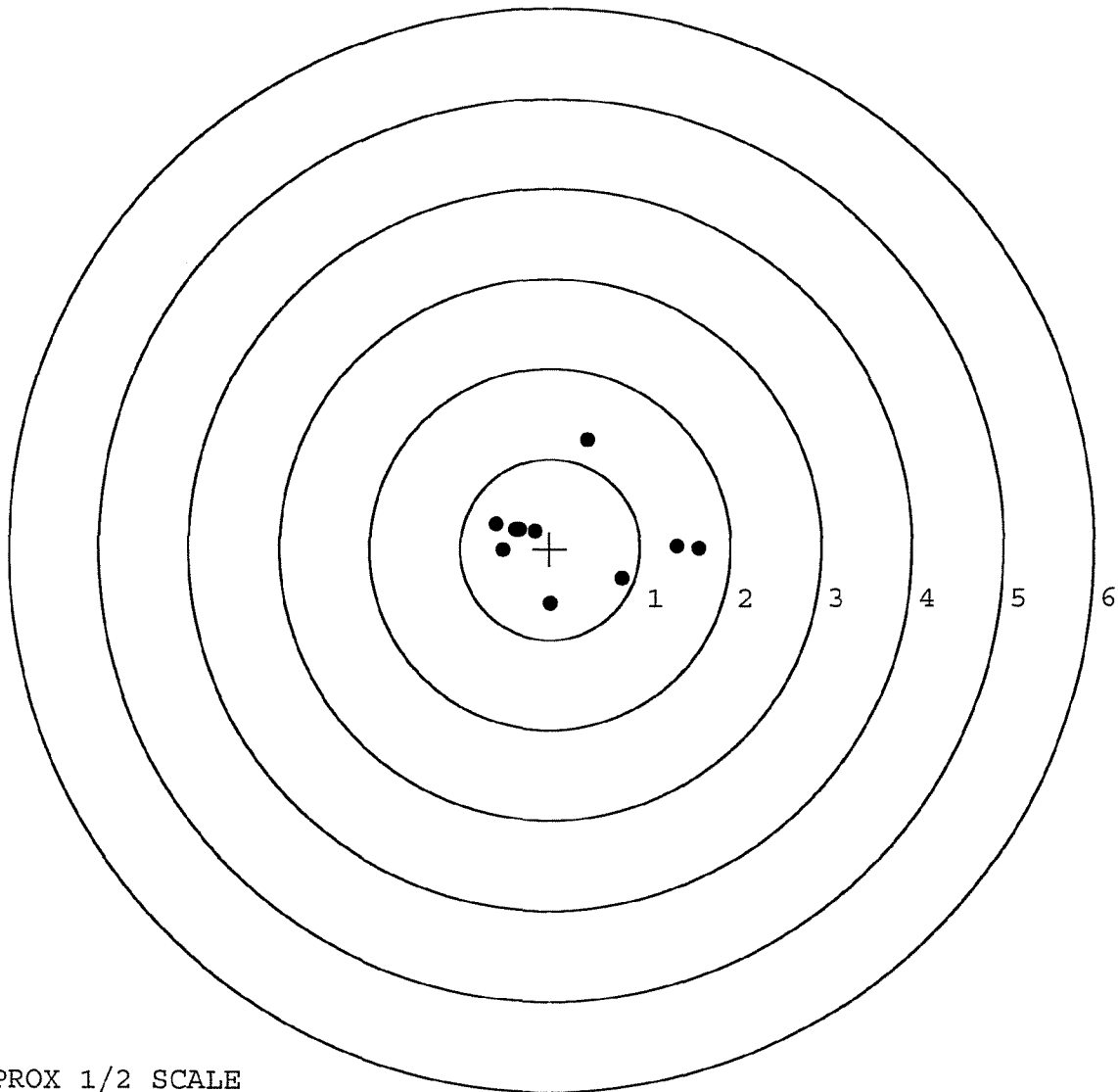


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236118. __0
TARGET NUMBER: 2
FILE DATE: 03/28/2003
FILE TIME: 11:09

POINT#	X	Y
1:	1.654	-0.004
2:	1.412	0.024
3:	0.806	-0.338
4:	0.013	-0.602
5:	0.420	1.210
6:	-0.171	0.199
7:	-0.342	0.213
8:	-0.605	0.273
9:	-0.521	-0.022
10:	-0.388	0.207

X CENTROID: 0.228
Y CENTROID: 0.116
POA TO CENTROID: 0.256
HORZ SPREAD: 2.259
VERT SPREAD: 1.812
GROUP SPREAD: 2.276
MIN RADIUS: 0.407
MAX RADIUS: 1.431
MEAN RADIUS: 0.843
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 10



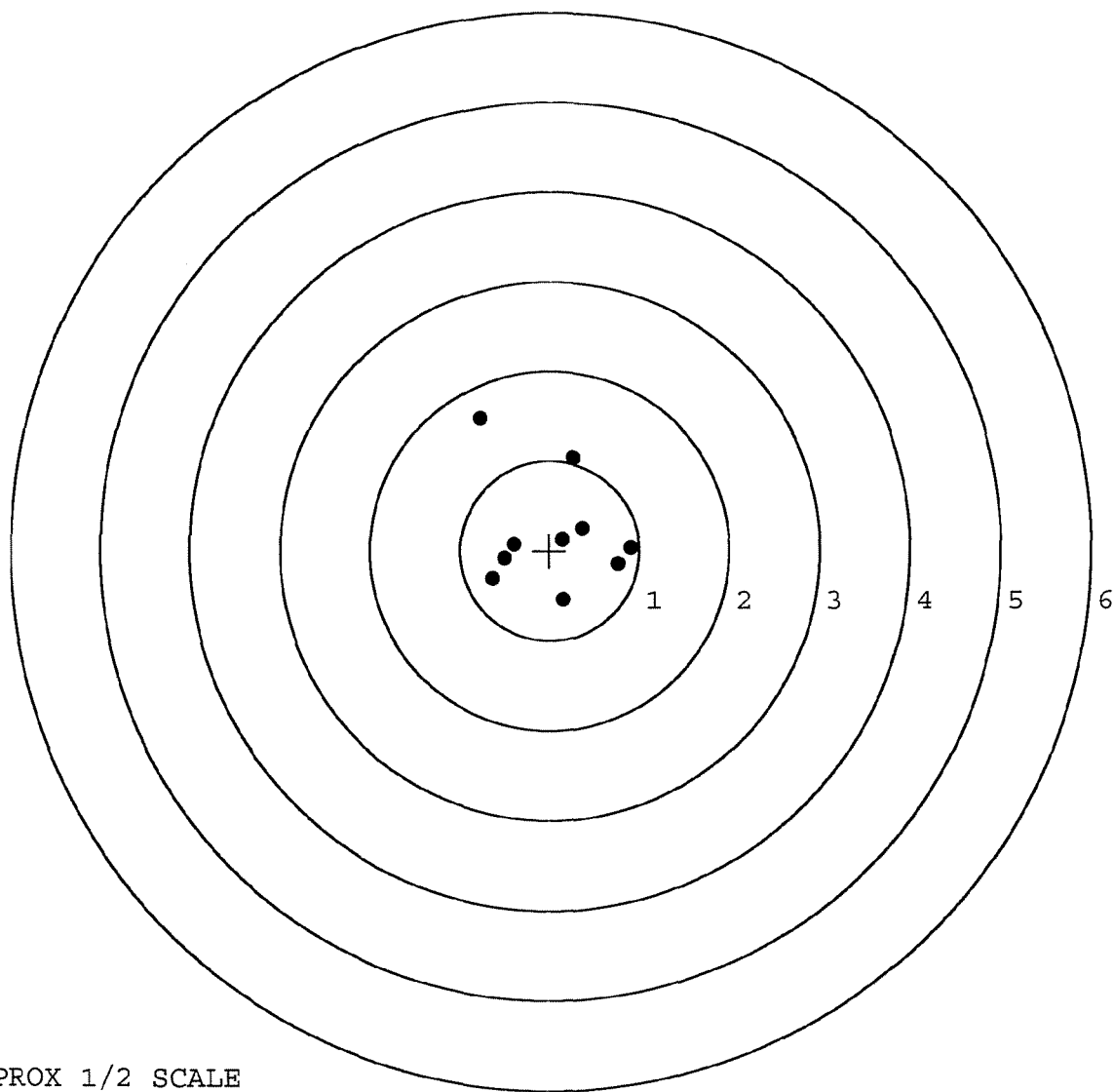
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236118. __0
TARGET NUMBER: 3
FILE DATE: 03/28/2003
FILE TIME: 11:09

POINT#	X	Y
1:	0.768	-0.148
2:	0.907	0.037
3:	0.156	-0.548
4:	0.262	1.033
5:	-0.786	1.470
6:	0.365	0.252
7:	0.147	0.121
8:	-0.395	0.072
9:	-0.504	-0.087
10:	-0.637	-0.318

X CENTROID: 0.028
Y CENTROID: 0.188
POA TO CENTROID: 0.191
HORZ SPREAD: 1.693
VERT SPREAD: 2.018
GROUP SPREAD: 2.243
MIN RADIUS: 0.137
MAX RADIUS: 1.518
MEAN RADIUS: 0.720

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 9



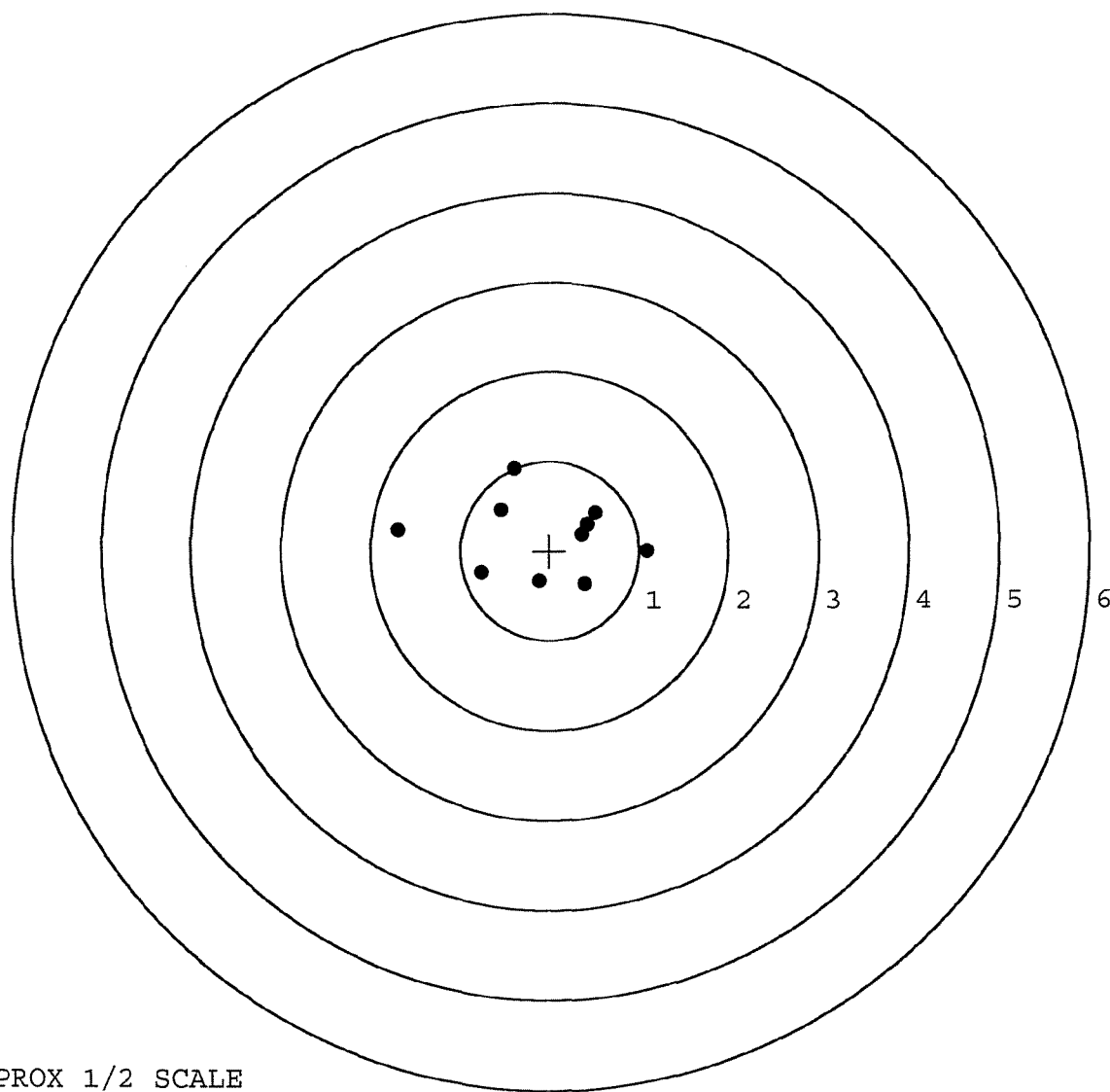
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236118. __0
TARGET NUMBER: 4
FILE DATE: 03/28/2003
FILE TIME: 11:09

X CENTROID: -0.074
Y CENTROID: 0.159
POA TO CENTROID: 0.175
HORZ SPREAD: 2.785
VERT SPREAD: 1.289
GROUP SPREAD: 2.795
MIN RADIUS: 0.433
MAX RADIUS: 1.624
MEAN RADIUS: 0.780

POINT#	X	Y
1:	1.089	-0.001
2:	0.508	0.429
3:	0.358	0.190
4:	0.399	-0.368
5:	-0.114	-0.346
6:	-0.766	-0.241
7:	-0.548	0.465
8:	-0.398	0.921
9:	-1.696	0.237
10:	0.425	0.301

IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

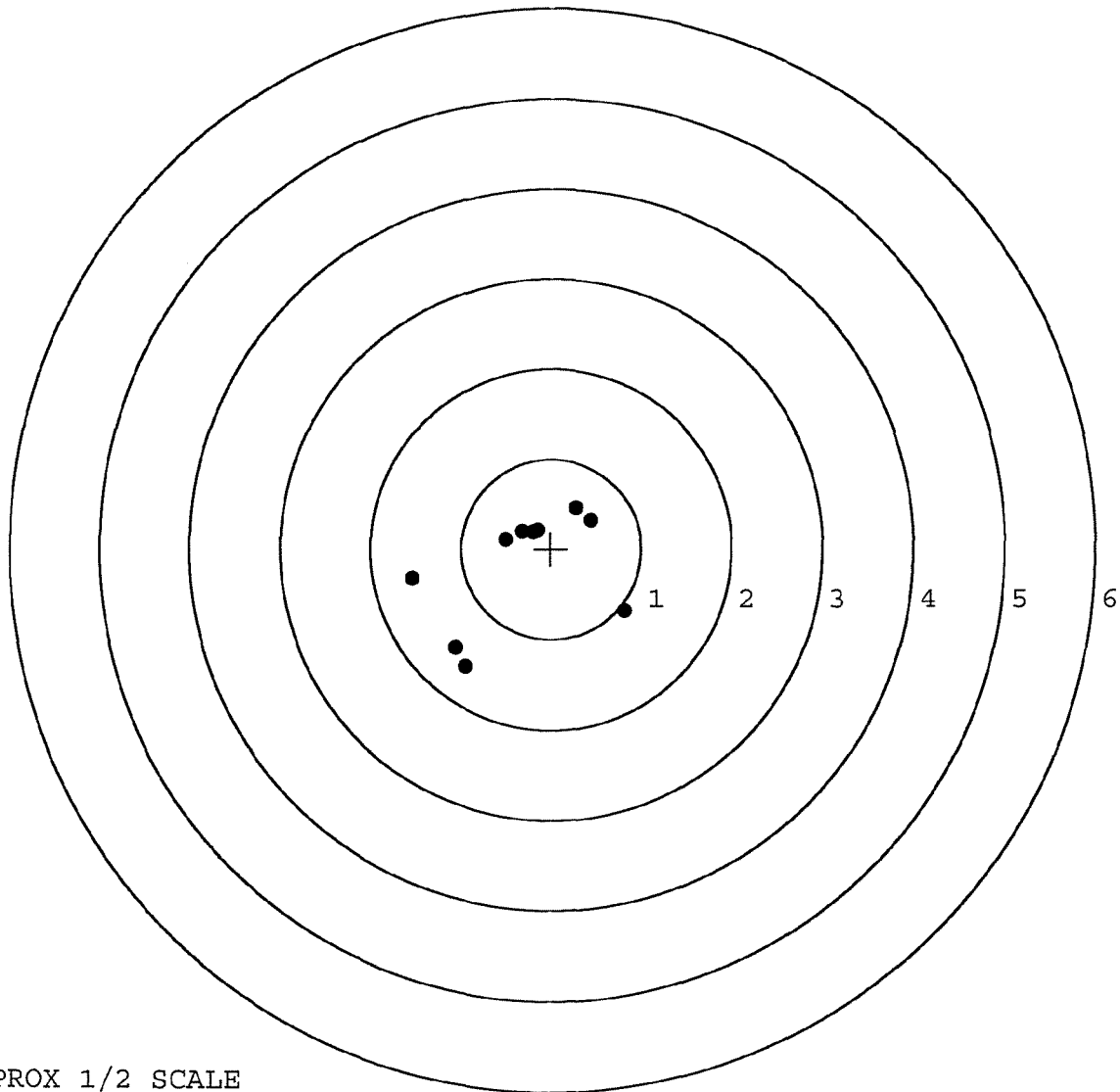


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236118. 0
TARGET NUMBER: 5
FILE DATE: 03/28/2003
FILE TIME: 11:09

X CENTROID: -0.318
Y CENTROID: -0.194
POA TO CENTROID: 0.373
HORZ SPREAD: 2.352
VERT SPREAD: 1.773
GROUP SPREAD: 2.156
MIN RADIUS: 0.354
MAX RADIUS: 1.280
MEAN RADIUS: 0.832
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.818	-0.692
2:	0.442	0.326
3:	0.278	0.465
4:	-0.148	0.212
5:	-0.322	0.199
6:	-0.506	0.106
7:	-1.534	-0.337
8:	-1.058	-1.105
9:	-0.949	-1.308
10:	-0.202	0.189



TARGET APPROX 1/2 SCALE