

G-623 6228

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6236228

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>JPB</u>		
615	ROLLMARK CALIBER		10/9/02	RL
617	DRILL AND TAP SIGHT HOLES		10/1 9/02	TRW
620	APPLY COATINGS (BARREL ACTION)		10-17	TH
	(BOLT)		10-17	TH
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			
	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>8.5</u> <u>7</u> <u>7</u>	3-28-03	RW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>3</u> <u>2.5</u>	3-28-03	RW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.023</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	TRW
	MALFUNCTION	CORRECTION	3-27-03	TRW
	MALFUNCTION	CORRECTION	3-27-03	TRW
	MALFUNCTION	CORRECTION	3-27-03	TRW
	MALFUNCTION	CORRECTION	3-27-03	TRW
645	INSPECT FOR LIVE AMMO		3-27-03	TRW
655	FINAL INSPECTION A) HEADSPACE		3-28-03	RW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.64</u> <u>2.77</u> <u>2.82</u> <u>2.81</u> <u>2.74</u>	3-28-03	RW
	C) FUNCTION		3-28-03	RW
660	PACK		4/2/03	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO.

DATE 12-17-02

TESTER

TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.52	2.29		2.41	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT ABLE LESS THAN
PULL #2	2.46	2.52		2.32	
PULL #3	2.33	2.32		2.28	
PULL #4	2.48	2.31		2.30	
PULL #5	2.40	2.41		2.31	
TOTAL	12.19	11.85		11.62	
AVG.	2.43	2.37		2.32	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.17		
PULL #2	3.05	3.14		
PULL #3	3.06	3.19		
PULL #4	3.07	3.16		
PULL #5	3.05	3.15		
TOTAL	15.33	15.81		
AVG.	3.06	3.16		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# TARGET & ACCU
PULL #1	4.11	4.06		4.07
PULL #2	4.33	4.08		4.01
PULL #3	4.14	4.13		4.05
PULL #4	4.21	4.10		4.02
PULL #5	4.29	4.13		3.97
TOTAL	21.08	20.50		20.12
AVG.	4.21	4.10		4.02

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6232628.___0
FILE DATE AND TIME: 03/28/2003 11:01

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.091
The Average Y Centroid of the Five Target Set:	0.076
The Average Point of Impact of the Five Target Set:	0.119
The Average Mean Radius of the Five Target Set:	0.732
The Distance from POA to Centroid Target #1:	0.064
The Distance from Centroid Target #2 to Centroid Target #1:	0.155
The Distance from Centroid Target #3 to Centroid Target #1:	0.214
The Distance from Centroid Target #4 to Centroid Target #1:	0.329
The Distance from Centroid Target #5 to Centroid Target #1:	0.280

SERIAL NUMBER: G6232628. __0

TARGET NUMBER: 1

FILE DATE: 03/28/2003

FILE TIME: 11:01

X CENTROID: -0.001

Y CENTROID: -0.064

POA TO CENTROID: 0.064

HORZ SPREAD: 1.557

VERT SPREAD: 1.660

GROUP SPREAD: 1.665

MIN RADIUS: 0.124

MAX RADIUS: 1.131

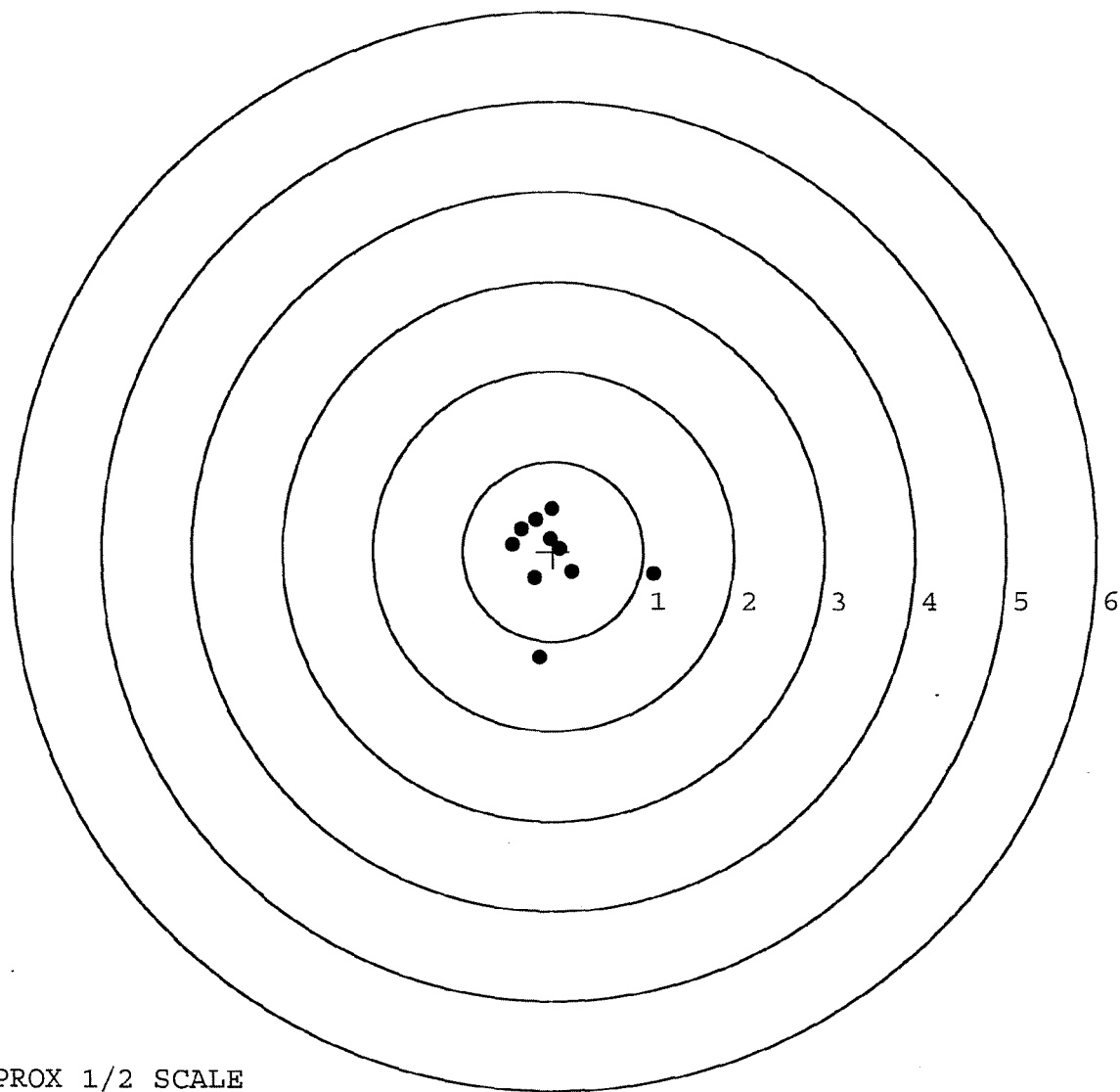
MEAN RADIUS: 0.511

IN 1 IN DIAMETER: 7

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.108	-0.249
2:	-0.147	-1.185
3:	-0.449	0.077
4:	-0.210	-0.302
5:	0.212	-0.227
6:	0.078	0.031
7:	-0.354	0.250
8:	-0.199	0.349
9:	-0.018	0.475
10:	-0.033	0.142



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6232628. __0

TARGET NUMBER: 2

FILE DATE: 03/28/2003

FILE TIME: 11:01

X CENTROID: -0.068

Y CENTROID: 0.076

POA TO CENTROID: 0.102

HORZ SPREAD: 2.147

VERT SPREAD: 2.374

GROUP SPREAD: 2.577

MIN RADIUS: 0.204

MAX RADIUS: 1.415

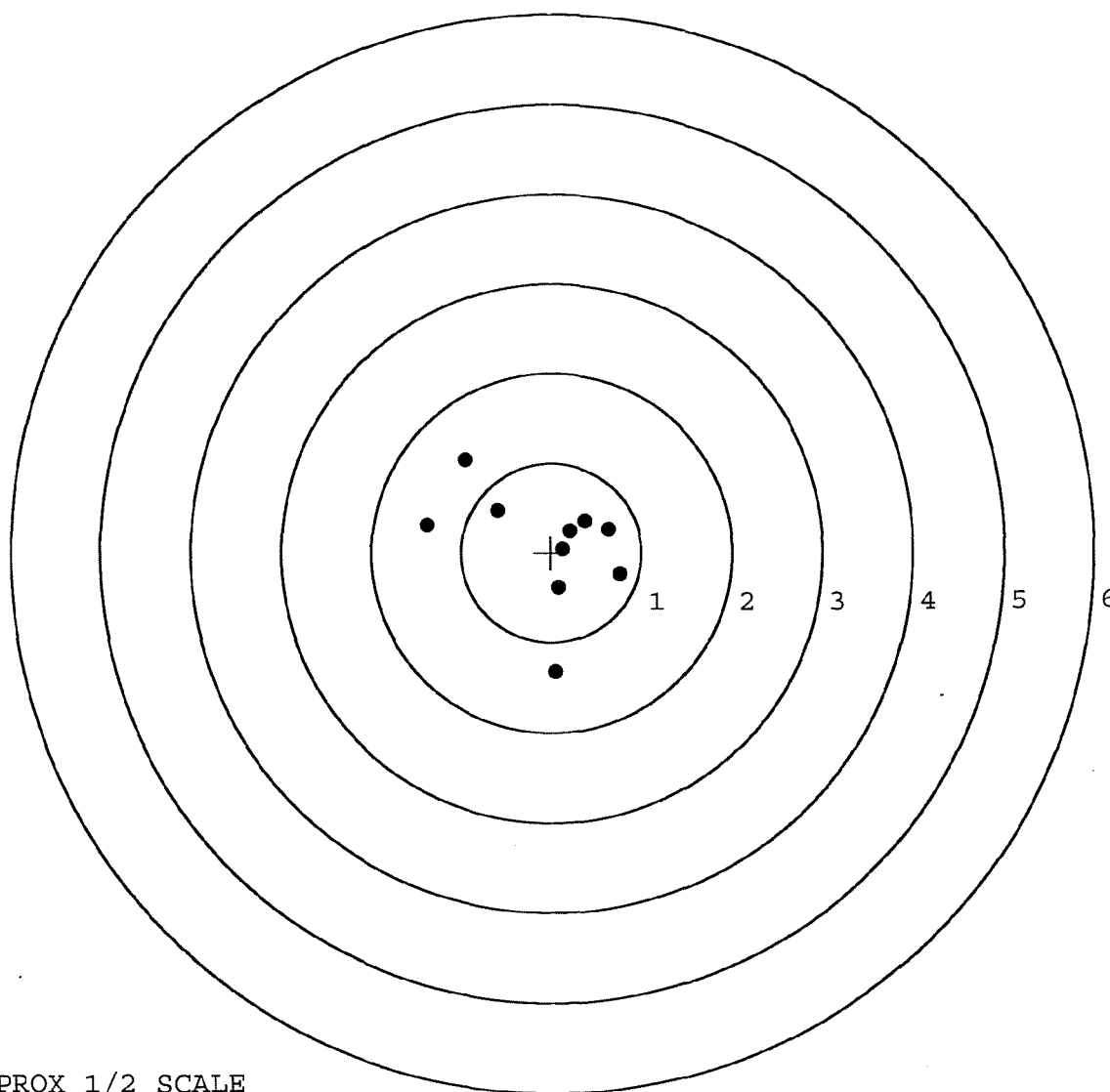
MEAN RADIUS: 0.789

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.638	0.261
2:	0.377	0.354
3:	0.209	0.243
4:	0.133	0.040
5:	0.765	-0.242
6:	0.083	-0.394
7:	-0.598	0.480
8:	-0.952	1.040
9:	-1.382	0.316
10:	0.051	-1.334



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6232628. __0

TARGET NUMBER: 3

FILE DATE: 03/28/2003

FILE TIME: 11:01

POINT#	X	Y
1:	1.180	0.718
2:	0.978	0.752
3:	0.201	1.027
4:	-0.125	0.373
5:	0.044	0.161
6:	0.219	-0.104
7:	-0.125	-0.624
8:	-0.557	-0.547
9:	-0.610	-0.198
10:	-0.814	-0.098

X CENTROID: 0.039

Y CENTROID: 0.146

POA TO CENTROID: 0.151

HORZ SPREAD: 1.994

VERT SPREAD: 1.651

GROUP SPREAD: 2.155

MIN RADIUS: 0.016

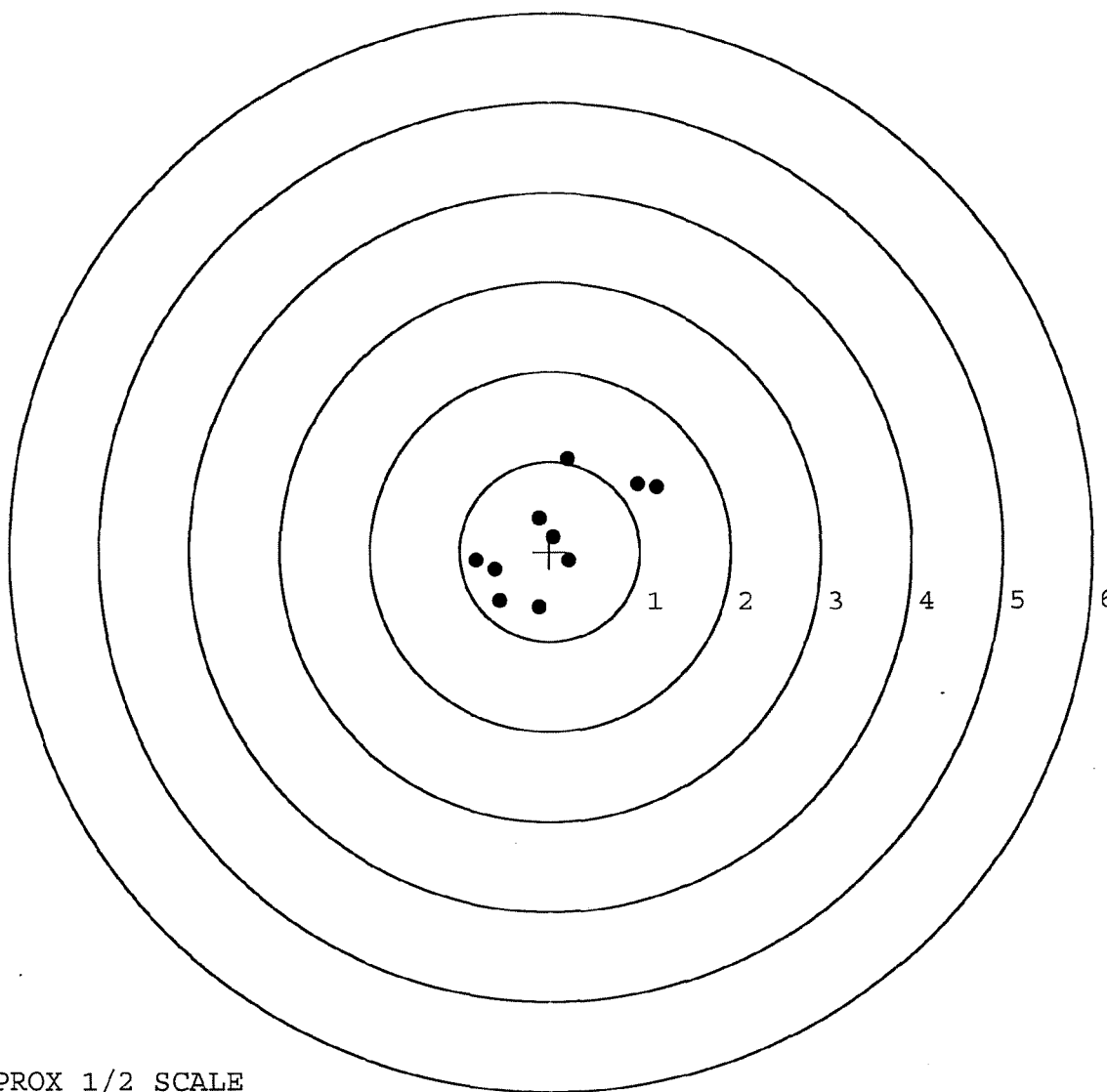
MAX RADIUS: 1.276

MEAN RADIUS: 0.722

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6232628.___0

TARGET NUMBER: 4

FILE DATE: 03/28/2003

FILE TIME: 11:01

POINT#	X	Y
1:	0.000	-0.983
2:	0.216	-0.644
3:	0.107	-0.629
4:	0.035	0.573
5:	-0.404	0.218
6:	-0.444	-0.031
7:	1.215	0.373
8:	0.874	0.672
9:	0.663	1.916
10:	0.092	0.188

X CENTROID: 0.235

Y CENTROID: 0.165

POA TO CENTROID: 0.288

HORZ SPREAD: 1.659

VERT SPREAD: 2.899

GROUP SPREAD: 2.974

MIN RADIUS: 0.145

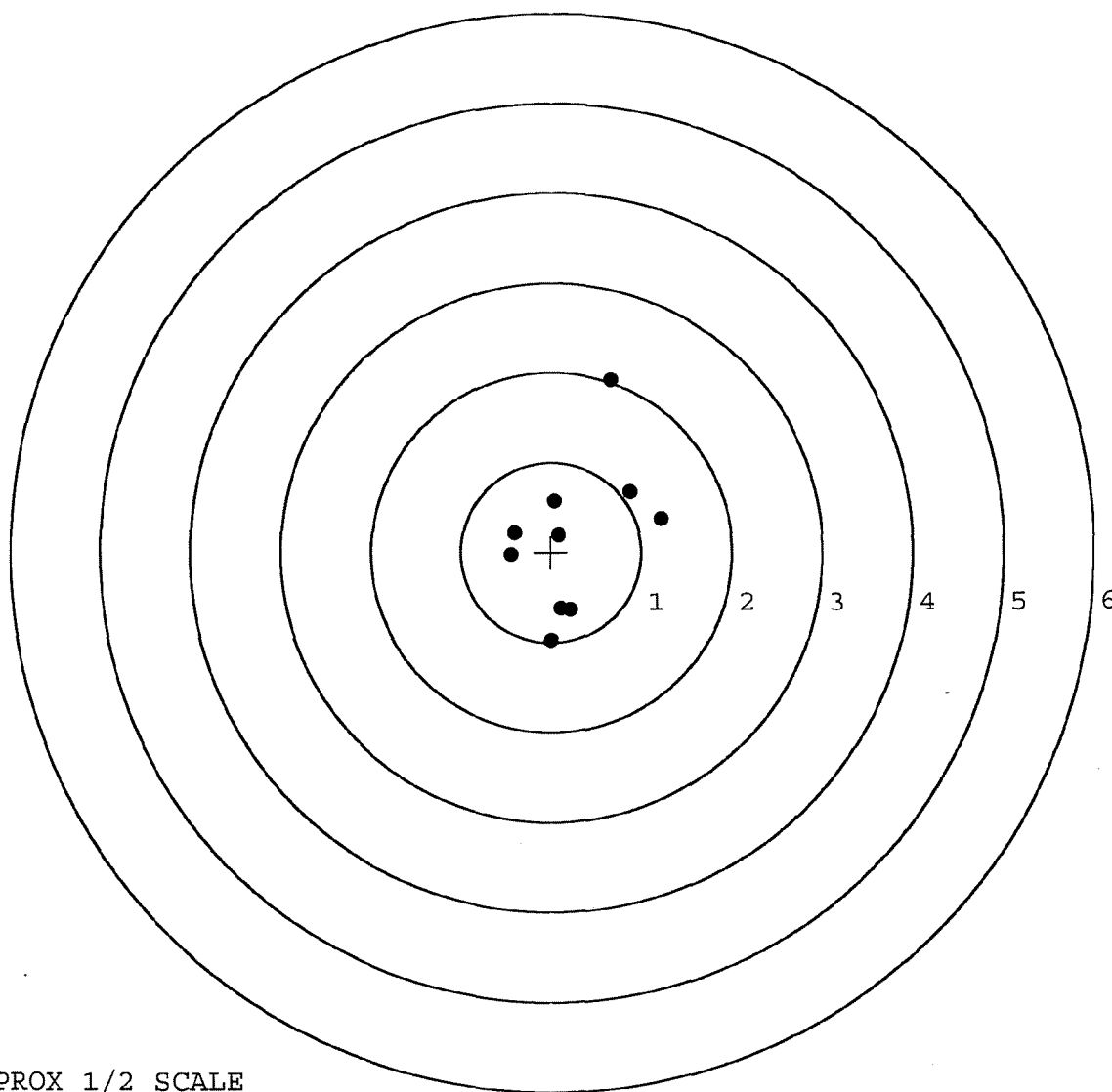
MAX RADIUS: 1.802

MEAN RADIUS: 0.835

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6232628. __0

TARGET NUMBER: 5

FILE DATE: 03/28/2003

FILE TIME: 11:01

POINT#	X	Y
1:	0.152	0.224
2:	-0.010	0.319
3:	-0.341	0.062
4:	-0.394	-0.115
5:	1.203	0.250
6:	0.953	0.497
7:	0.545	1.779
8:	0.143	-0.652
9:	0.245	-0.697
10:	0.015	-1.086

X CENTROID: 0.251

Y CENTROID: 0.058

POA TO CENTROID: 0.258

HORZ SPREAD: 1.597

VERT SPREAD: 2.865

GROUP SPREAD: 2.914

MIN RADIUS: 0.193

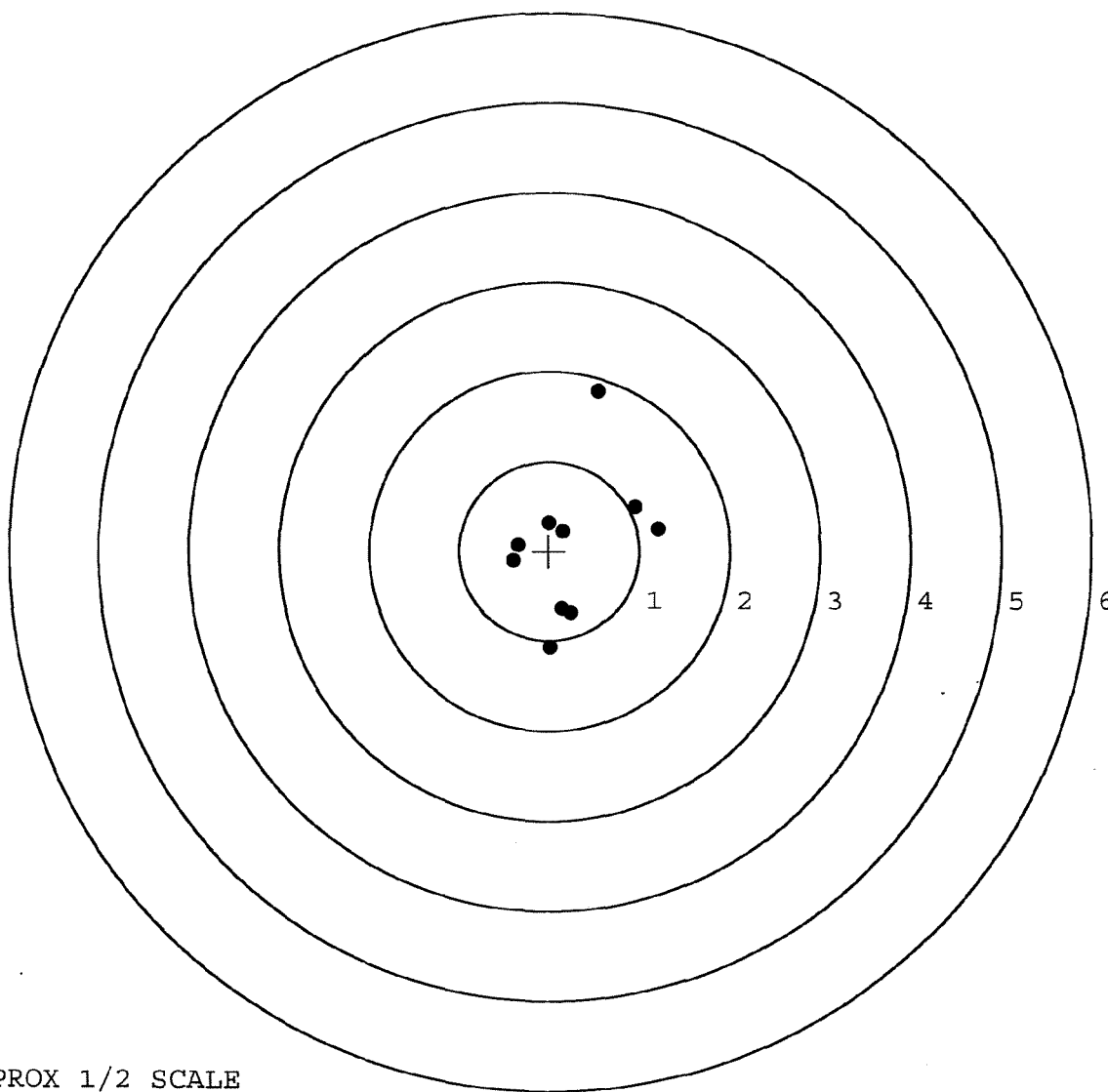
MAX RADIUS: 1.746

MEAN RADIUS: 0.801

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE