

G-603 602 55

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6236255

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	OCT 8 2002	10/7/02	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>LRD</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	A
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		3-27-03	A
	C) INSPECT EJECTOR HOLE FOR CHAMFER		3-27-03	A
	D) OIL FIRING PIN ASSEMBLY		3-27-03	A
	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>9.5</u> <u>9.5</u> <u>10</u>	3-28-03	RW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>3</u> <u>3</u>	3-28-03	RW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.021</u> <u>.0205</u> <u>.021</u>	3-28-03	RW
	J) ASSEMBLE STOCK		3-27-03	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	3-28-03	TRW
	MALFUNCTION	CORRECTION	3-28-03	TRW
	MALFUNCTION	CORRECTION	3-28-03	TRW
	MALFUNCTION	CORRECTION	3-28-03	TRW
	MALFUNCTION	CORRECTION	3-28-03	TRW
645	INSPECT FOR LIVE AMMO		3-28-03	TRW
655	FINAL INSPECTION A) HEADSPACE		3-28-03	RW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.84</u> <u>2.60</u> <u>2.54</u> <u>2.56</u> <u>2.56</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 12-18-02

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.27	2.59		2.27	MIN. SETTING
PULL #2	2.39	2.47		2.20	NO AVG. OF 5
PULL #3	2.36	2.44		2.26	READINGS ACCEPT
PULL #4	2.43	2.55		2.17	ABLE LESS THAN
PULL #5	2.39	2.38		2.13	
TOTAL	11.84	12.43		11.03	
AVG.	2.36	2.48		2.20	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.15		
PULL #2	3.12	3.16		
PULL #3	3.15	3.03		
PULL #4	3.09	3.09		
PULL #5	3.08	3.13		
TOTAL	15.72	15.56		
AVG.	3.14	3.11		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# & TARGET & ACCU
PULL #1	4.37	4.33		4.16
PULL #2	4.43	4.43		4.19
PULL #3	4.39	4.48		4.18
PULL #4	4.36	4.38		4.20
PULL #5	4.41	4.40		4.21
TOTAL	21.96	22.02		20.94
AVG.	4.39	4.40		4.18

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6236255.__0
FILE DATE AND TIME: 03/29/2003 05:12

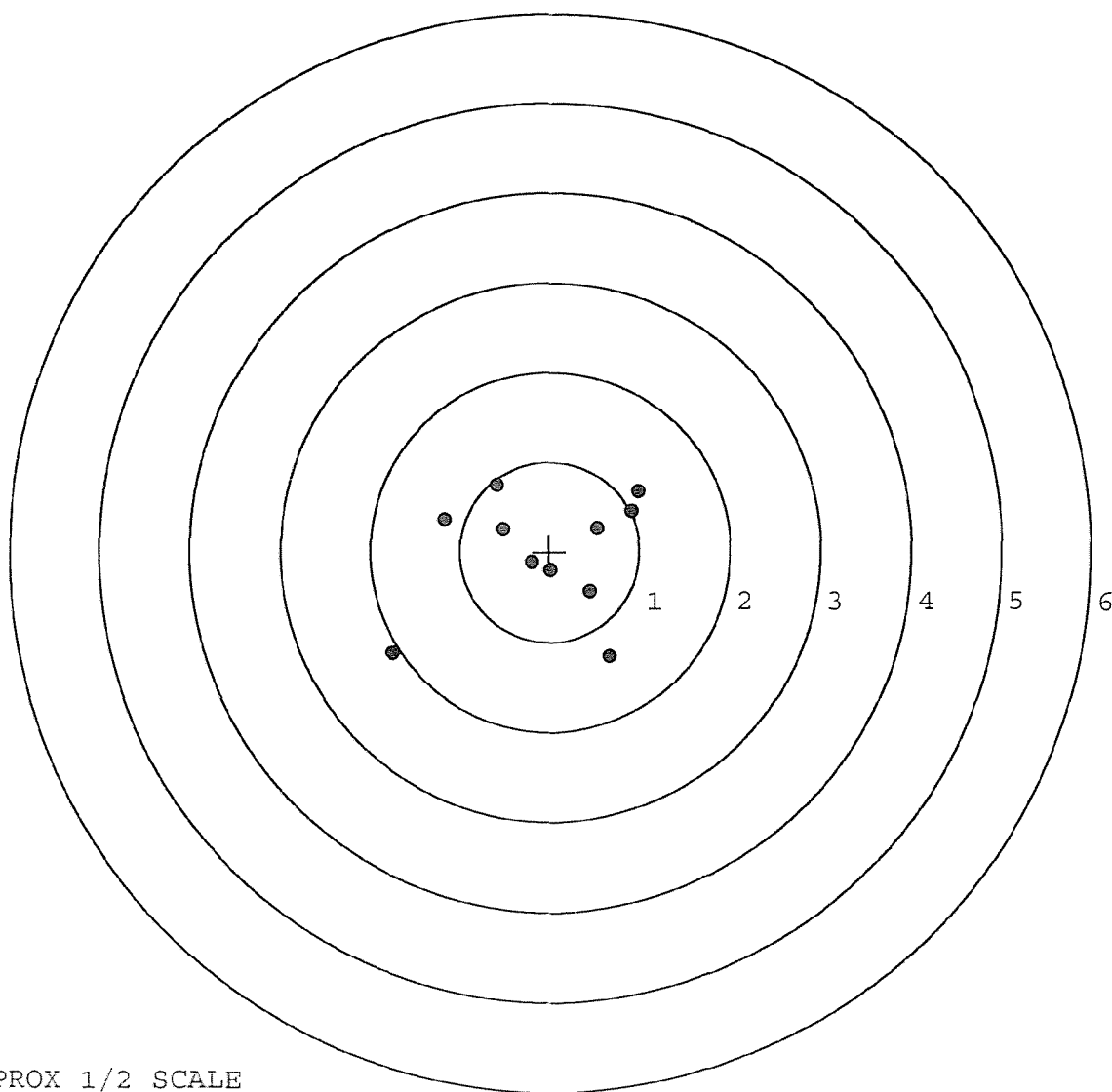
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.018
The Average Y Centroid of the Five Target Set:	0.081
The Average Point of Impact of the Five Target Set:	0.083
The Average Mean Radius of the Five Target Set:	0.957
The Distance from POA to Centroid Target #1:	0.070
The Distance from Centroid Target #2 to Centroid Target #1:	0.400
The Distance from Centroid Target #3 to Centroid Target #1:	0.161
The Distance from Centroid Target #4 to Centroid Target #1:	0.412
The Distance from Centroid Target #5 to Centroid Target #1:	0.202

SERIAL NUMBER: G6236255. __0
TARGET NUMBER: 1
FILE DATE: 03/29/2003
FILE TIME: 05:12

X CENTROID: -0.061
Y CENTROID: -0.033
POA TO CENTROID: 0.070
HORZ SPREAD: 2.745
VERT SPREAD: 1.895
GROUP SPREAD: 3.286
MIN RADIUS: 0.165
MAX RADIUS: 2.025
MEAN RADIUS: 0.913
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.672	-1.160
2:	0.459	-0.441
3:	0.019	-0.210
4:	-0.198	-0.125
5:	-0.525	0.243
6:	-0.593	0.735
7:	-1.175	0.352
8:	-1.760	-1.135
9:	0.529	0.254
10:	0.913	0.451
11:	0.985	0.672



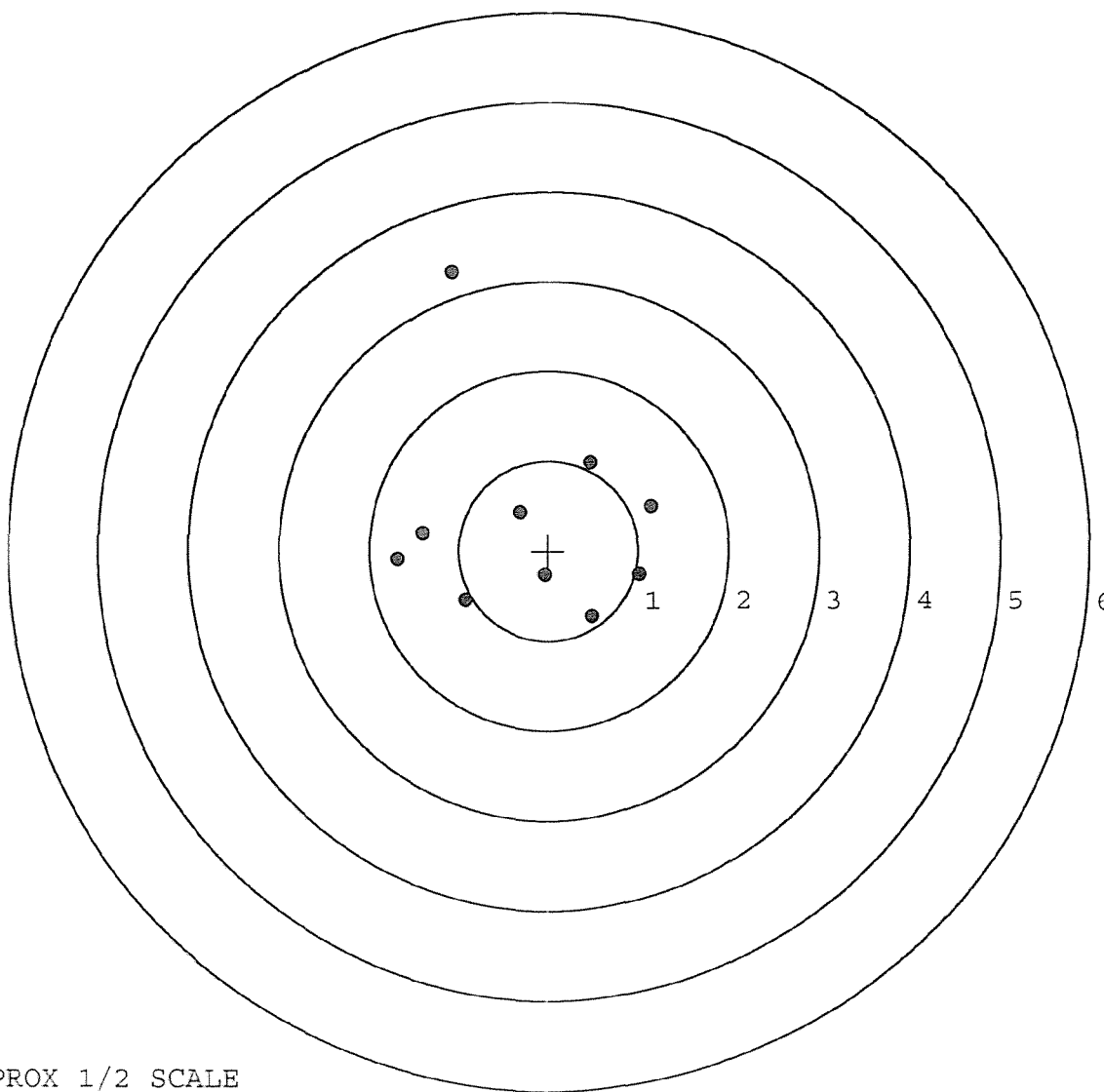
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236255. __0
TARGET NUMBER: 2
FILE DATE: 03/29/2003
FILE TIME: 05:12

X CENTROID: -0.235
Y CENTROID: 0.327
POA TO CENTROID: 0.403
HORZ SPREAD: 2.821
VERT SPREAD: 3.826
GROUP SPREAD: 4.141
MIN RADIUS: 0.135
MAX RADIUS: 2.901
MEAN RADIUS: 1.249

POINT#	X	Y
1:	0.493	-0.728
2:	1.016	-0.266
3:	1.138	0.495
4:	0.469	0.980
5:	-0.318	0.433
6:	-0.036	-0.268
7:	-0.925	-0.558
8:	-1.683	-0.107
9:	-1.409	0.191
10:	-1.092	3.098

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

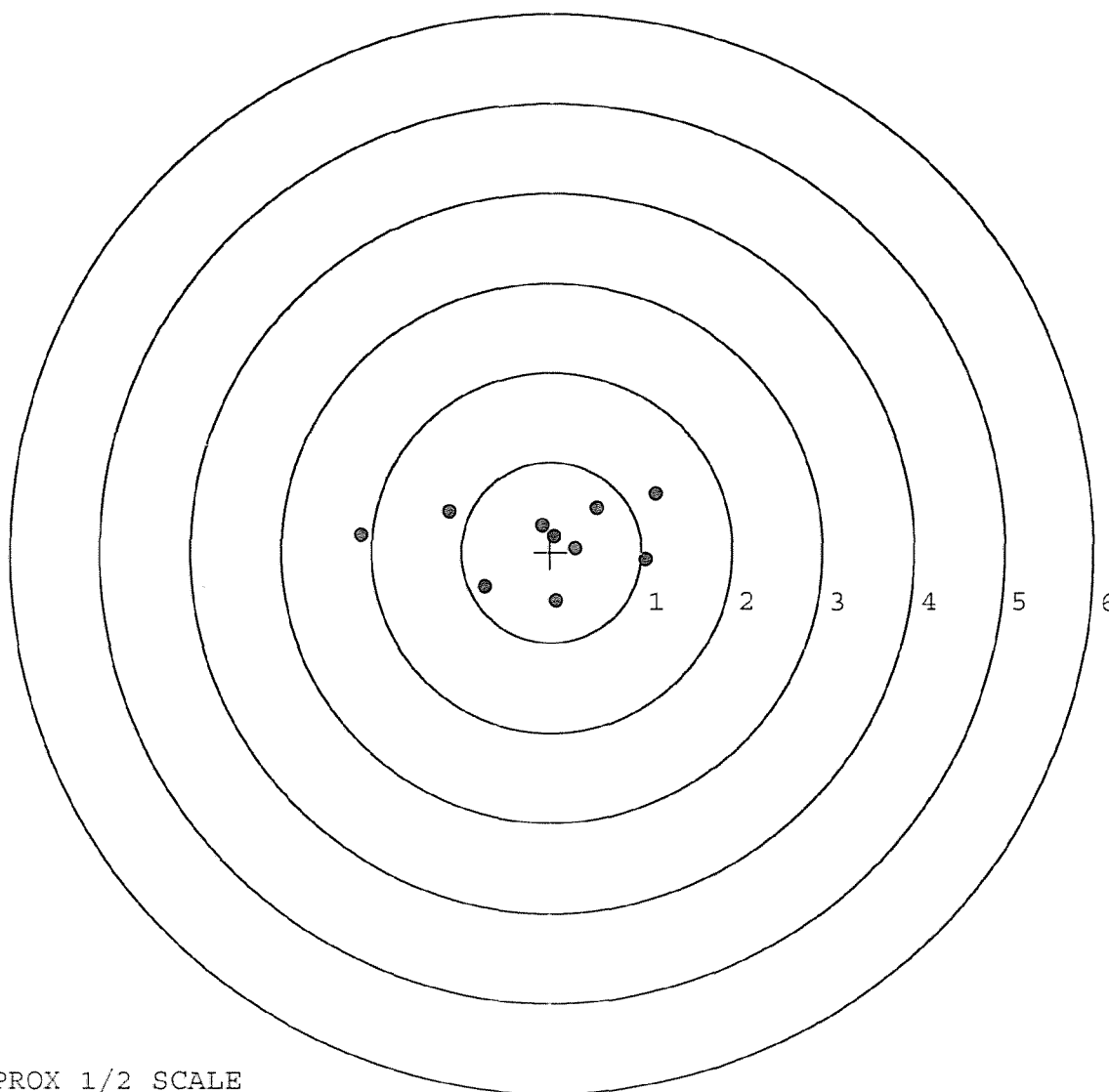


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236255. __0
TARGET NUMBER: 3
FILE DATE: 03/29/2003
FILE TIME: 05:12

X CENTROID: -0.100
Y CENTROID: 0.124
POA TO CENTROID: 0.159
HORZ SPREAD: 3.278
VERT SPREAD: 1.187
GROUP SPREAD: 3.311
MIN RADIUS: 0.155
MAX RADIUS: 2.024
MEAN RADIUS: 0.857
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.048	-0.093
2:	0.511	0.489
3:	1.154	0.641
4:	0.276	0.040
5:	0.045	0.178
6:	-0.100	0.295
7:	0.065	-0.546
8:	-0.740	-0.389
9:	-1.140	0.443
10:	-2.124	0.177



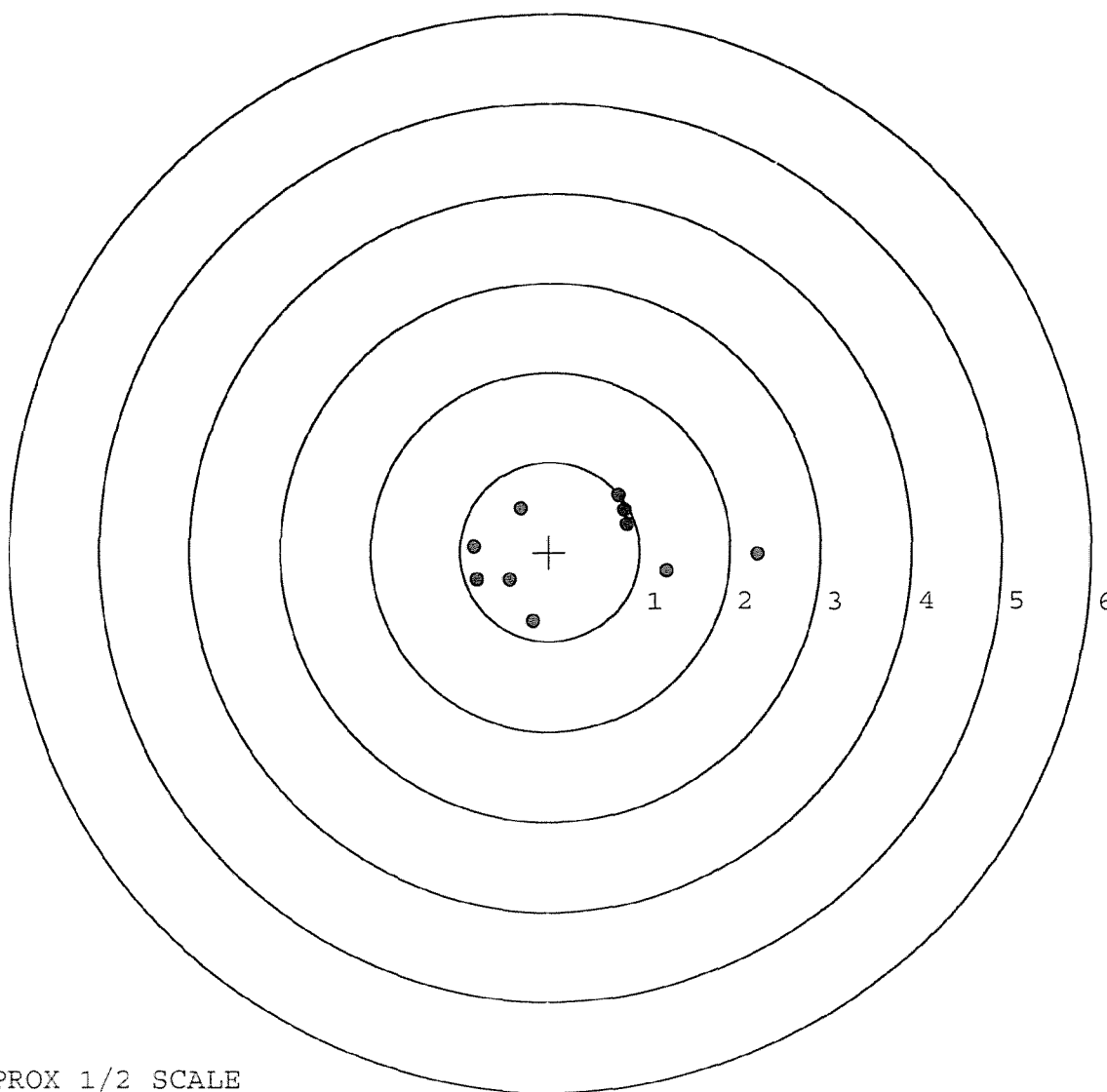
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236255. __0
TARGET NUMBER: 4
FILE DATE: 03/29/2003
FILE TIME: 05:12

POINT#	X	Y
1:	2.306	-0.031
2:	1.300	-0.215
3:	0.860	0.319
4:	0.823	0.479
5:	0.763	0.636
6:	-0.324	0.487
7:	-0.842	0.054
8:	-0.813	-0.317
9:	-0.441	-0.309
10:	-0.181	-0.774

X CENTROID: 0.345
Y CENTROID: 0.033
POA TO CENTROID: 0.347
HORZ SPREAD: 3.148
VERT SPREAD: 1.410
GROUP SPREAD: 3.149
MIN RADIUS: 0.589
MAX RADIUS: 1.962
MEAN RADIUS: 0.995

IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

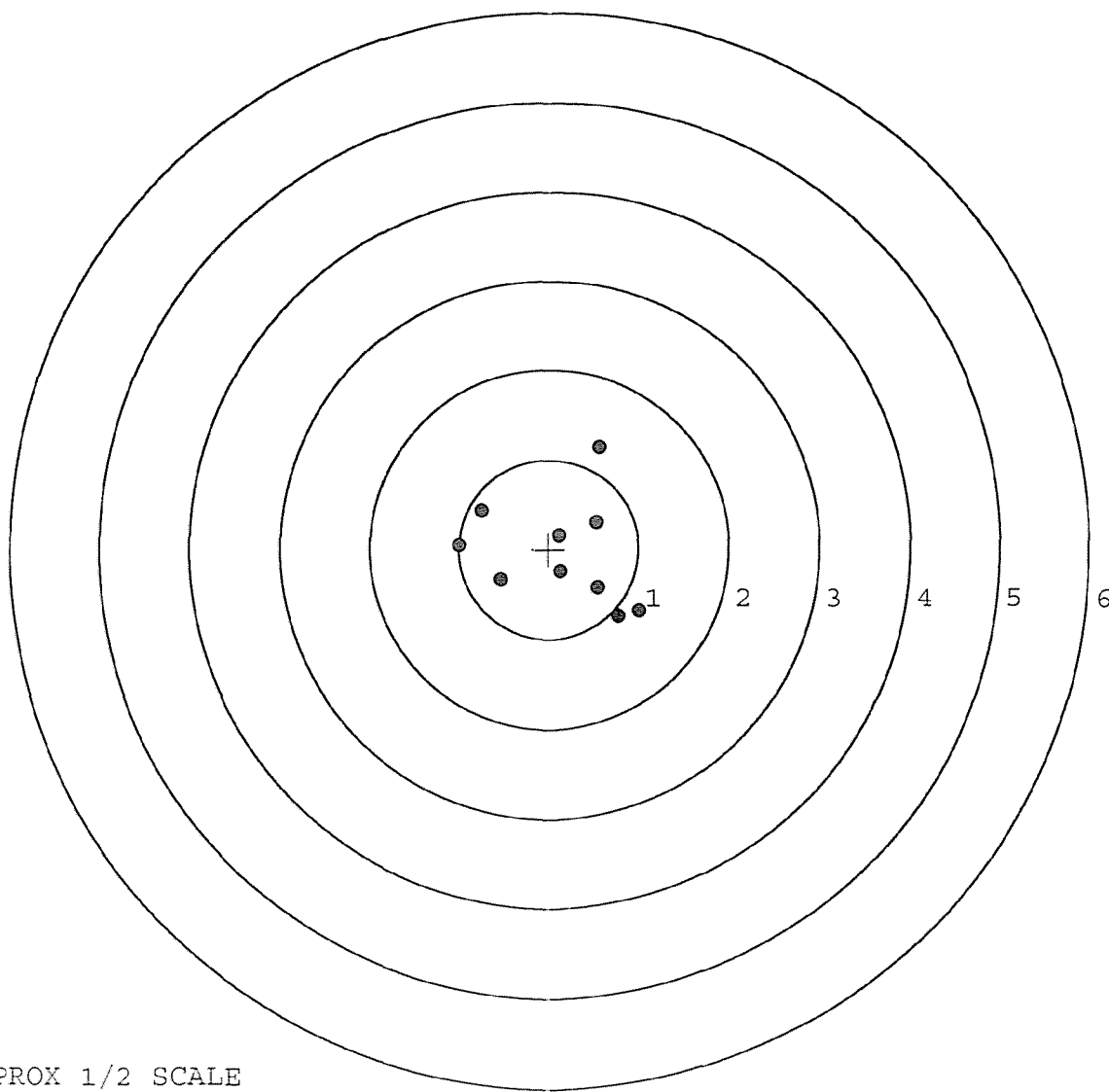


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6236255. __0
TARGET NUMBER: 5
FILE DATE: 03/29/2003
FILE TIME: 05:12

POINT#	X	Y
1:	1.008	-0.697
2:	0.779	-0.756
3:	0.549	-0.440
4:	0.139	-0.253
5:	0.119	0.159
6:	0.529	0.298
7:	0.560	1.138
8:	-0.749	0.423
9:	-1.000	0.036
10:	-0.530	-0.351

X CENTROID: 0.140
Y CENTROID: -0.044
POA TO CENTROID: 0.147
HORZ SPREAD: 2.008
VERT SPREAD: 1.894
GROUP SPREAD: 1.910
MIN RADIUS: 0.204
MAX RADIUS: 1.255
MEAN RADIUS: 0.768
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE