98010659

9/27/2004 10:33:18 AM

Original **45** 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.

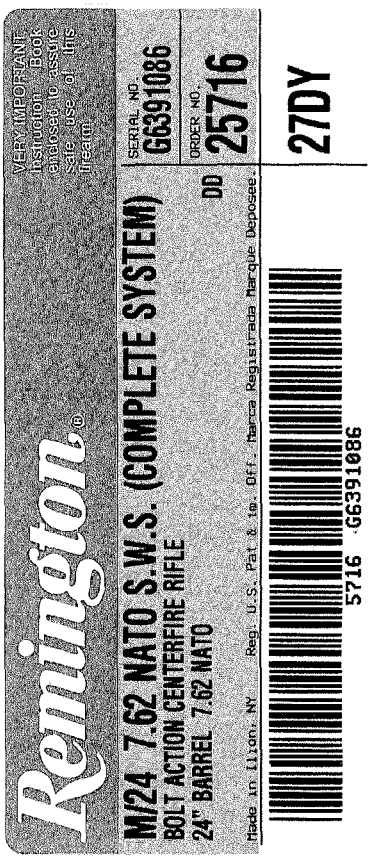
0003451404

0690 89SWS1
Pack Rifle

0003451397

0700 89SWS1
Stencil SWS Container

.OP0700



ORDER 25716

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

UPC

0 47700 25716 7

ORDER 25716

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

UPC

0 47700 25716 7

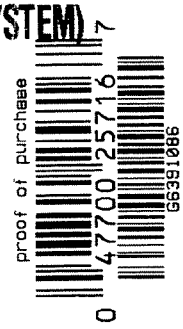
SERIAL NO.

G6391086

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

– INSTUCTION BOOK 3518

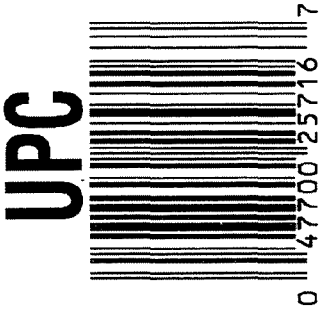
DD FORM



ORDER NO. 25716

BARREL LENGTH	24"
CAPACITY	6

G6391086



7/22/2004 3:21:04 PM

Original 62 Chib

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 # G6a39/086

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		6-15-04	RTL
600	PROOF		6-15-04	RTL
607	CHECK HEADSPACE		6-15-04	RTL
610	DIS-ASSEMBLE GUN		6-15-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	INSPECTED OPERATOR BS		
615	ROLLMARK CALIBER		6-16-04	SR
617	DRILL AND TAP SIGHT HOLES		6-15-04	RTL
620	APPLY COATINGS (BARREL ACTION)		6/28	HP
	(BOLT)		6/28	HP
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		8-30-04	RW
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-30-04	RW
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-30-04	RW
	D) OIL FIRING PIN ASSEMBLY		8-30-04	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 6.0 6.5	9/13/04	DA
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	3.0 2.5 3.0	9/13/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.025 .025 .025	9/13/04	DA
	J) ASSEMBLE STOCK		8-30-04	RW
	K) ASSEMBLE SWIVEL STUDS		9-17-04	RR
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-30-04	RW
	M) IRON SIGHT ALIGNMENT		8-30-04	RW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-30-04	RW
640	GALLERY TEST AND TARGET	PASS FAIL	8-31-04	TRW
	MALFUNCTION	CORRECTION	8-31-04	TRW
	MALFUNCTION	CORRECTION	8-31-04	TRW
	MALFUNCTION	CORRECTION	8-31-04	TRW
	MALFUNCTION	CORRECTION	8-31-04	TRW
645	INSPECT FOR LIVE AMMO		8-31-04	TRW
655	FINAL INSPECTION A) HEADSPACE		9-17-04	RR
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.48 2.43 2.46 2.39 2.64	9/13/04	DA
	C) FUNCTION		9-17-04	RR
660	PACK		9-20-04	AC

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. TRW

DATE 8-30-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.65	2.26		2.27	
PULL #2	2.55	2.69		2.42	
PULL #3	2.52	2.70		2.27	
PULL #4	2.45	2.67		2.31	
PULL #5	2.53	2.52		2.28	
TOTAL	12.70	12.84		11.55	
AVERAGE	2.54	2.56		2.31	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.46		
PULL #2	3.38	3.41		
PULL #3	3.39	3.40		
PULL #4	3.38	3.46		
PULL #5	3.04	3.43		
TOTAL	16.58	17.16		
AVERAGE	3.31	3.43		

	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	4.35	4.10		4.06
PULL #2	4.20	4.25		4.20
PULL #3	4.19	4.09		4.13
PULL #4	4.21	4.17		4.06
PULL #5	4.17	4.16		4.27
TOTAL	21.12	20.77		20.72
AVERAGE	4.22	4.15		4.14

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6391086.__0
FILE DATE AND TIME: 08/31/2004 05:59

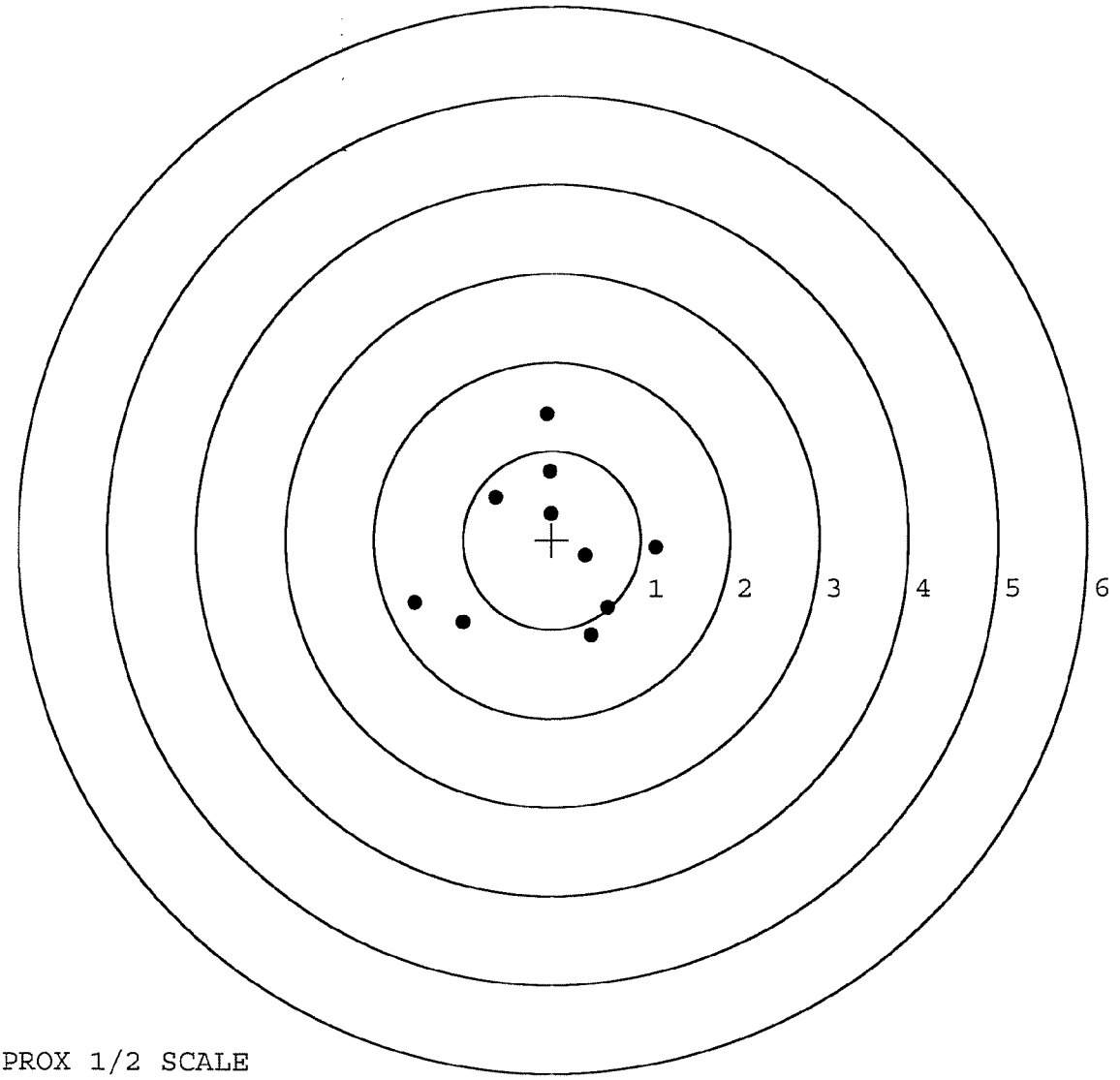
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.093
The Average Y Centroid of the Five Target Set:	0.024
The Average Point of Impact of the Five Target Set:	0.096
The Average Mean Radius of the Five Target Set:	0.957
The Distance from POA to Centroid Target #1:	0.102
The Distance from Centroid Target #2 to Centroid Target #1:	0.369
The Distance from Centroid Target #3 to Centroid Target #1:	0.408
The Distance from Centroid Target #4 to Centroid Target #1:	0.434
The Distance from Centroid Target #5 to Centroid Target #1:	0.260

SERIAL NUMBER: G6391086.__0
TARGET NUMBER: 1
FILE DATE: 08/31/2004
FILE TIME: 05:59

X CENTROID:	-0.066
Y CENTROID:	-0.078
POA TO CENTROID:	0.102
HORZ SPREAD:	2.705
VERT SPREAD:	2.486
GROUP SPREAD:	2.773
MIN RADIUS:	0.374
MAX RADIUS:	1.603
MEAN RADIUS:	1.015
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.442	-1.071
2:	0.629	-0.763
3:	1.164	-0.096
4:	0.375	-0.182
5:	-0.013	0.292
6:	-0.635	0.477
7:	-0.023	0.772
8:	-0.056	1.415
9:	-1.002	-0.923
10:	-1.541	-0.705

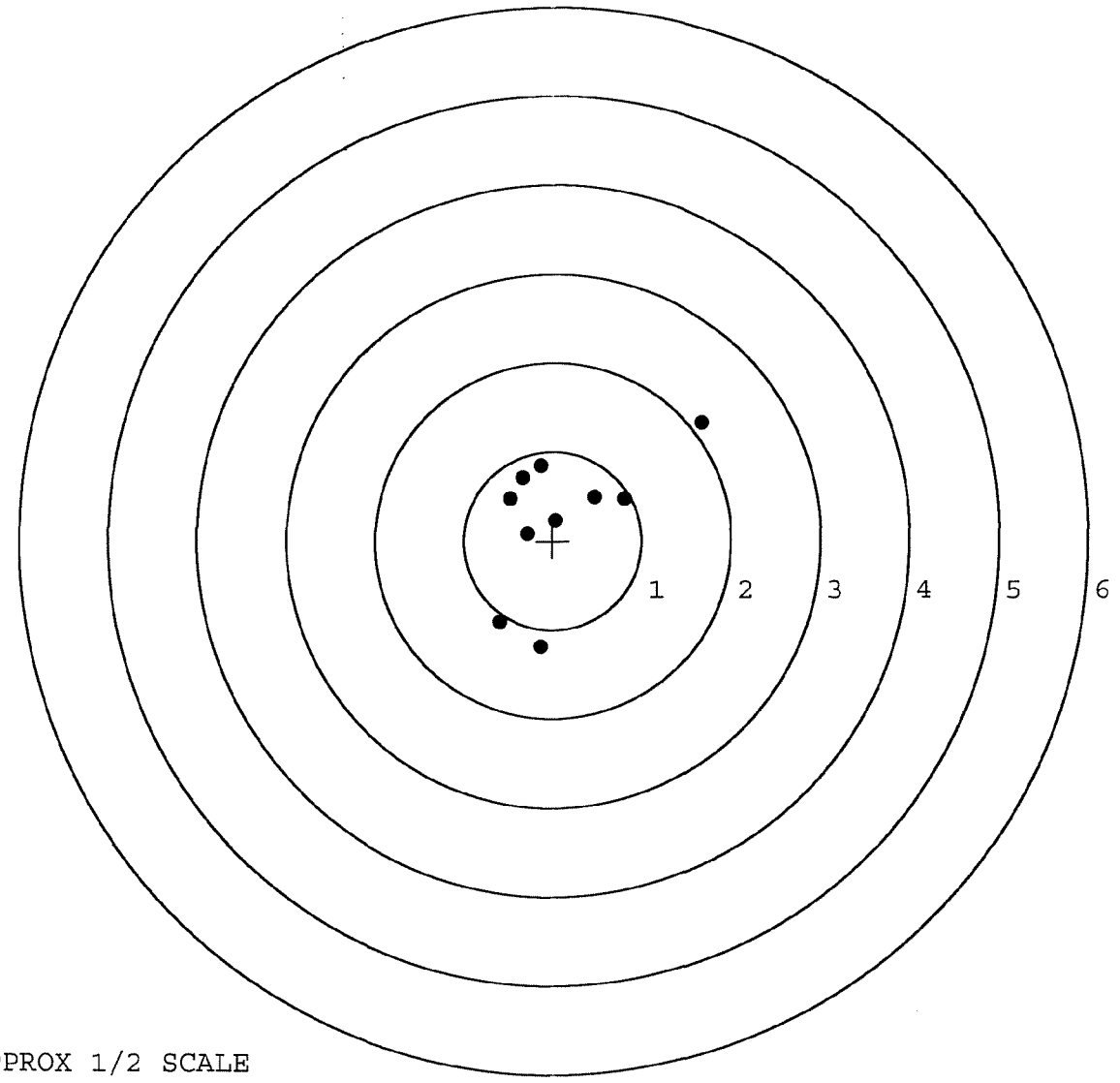


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391086.__0
TARGET NUMBER: 2
FILE DATE: 08/31/2004
FILE TIME: 05:59

X CENTROID:	0.100
Y CENTROID:	0.252
POA TO CENTROID:	0.271
HORZ SPREAD:	2.268
VERT SPREAD:	2.515
GROUP SPREAD:	3.186
MIN RADIUS:	0.069
MAX RADIUS:	1.900
MEAN RADIUS:	0.830
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.671	1.321
2:	0.807	0.473
3:	0.468	0.489
4:	-0.135	0.844
5:	-0.346	0.710
6:	0.034	0.231
7:	-0.280	0.080
8:	-0.597	-0.917
9:	-0.136	-1.194
10:	-0.486	0.478

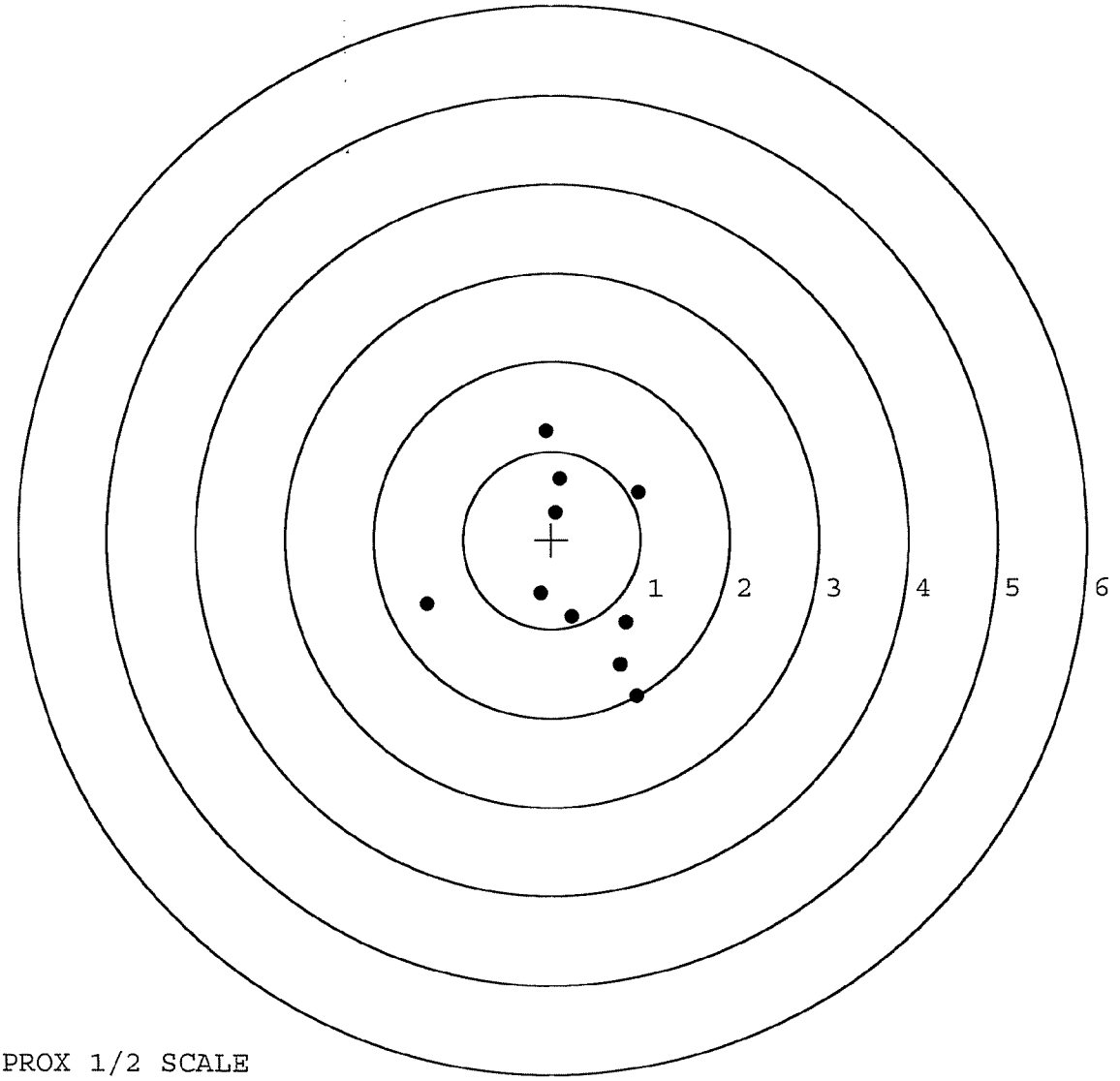


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391086.__0
TARGET NUMBER: 3
FILE DATE: 08/31/2004
FILE TIME: 05:59

X CENTROID:	0.234
Y CENTROID:	-0.356
POA TO CENTROID:	0.426
HORZ SPREAD:	2.374
VERT SPREAD:	2.993
GROUP SPREAD:	2.685
MIN RADIUS:	0.433
MAX RADIUS:	1.675
MEAN RADIUS:	1.074
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	4
# in 3 IN DIAMETER:	7

POINT#	X	Y
1:	0.960	-1.765
2:	0.775	-1.411
3:	0.837	-0.938
4:	0.228	-0.868
5:	-0.121	-0.604
6:	-1.400	-0.726
7:	0.052	0.310
8:	0.098	0.689
9:	0.974	0.529
10:	-0.065	1.228

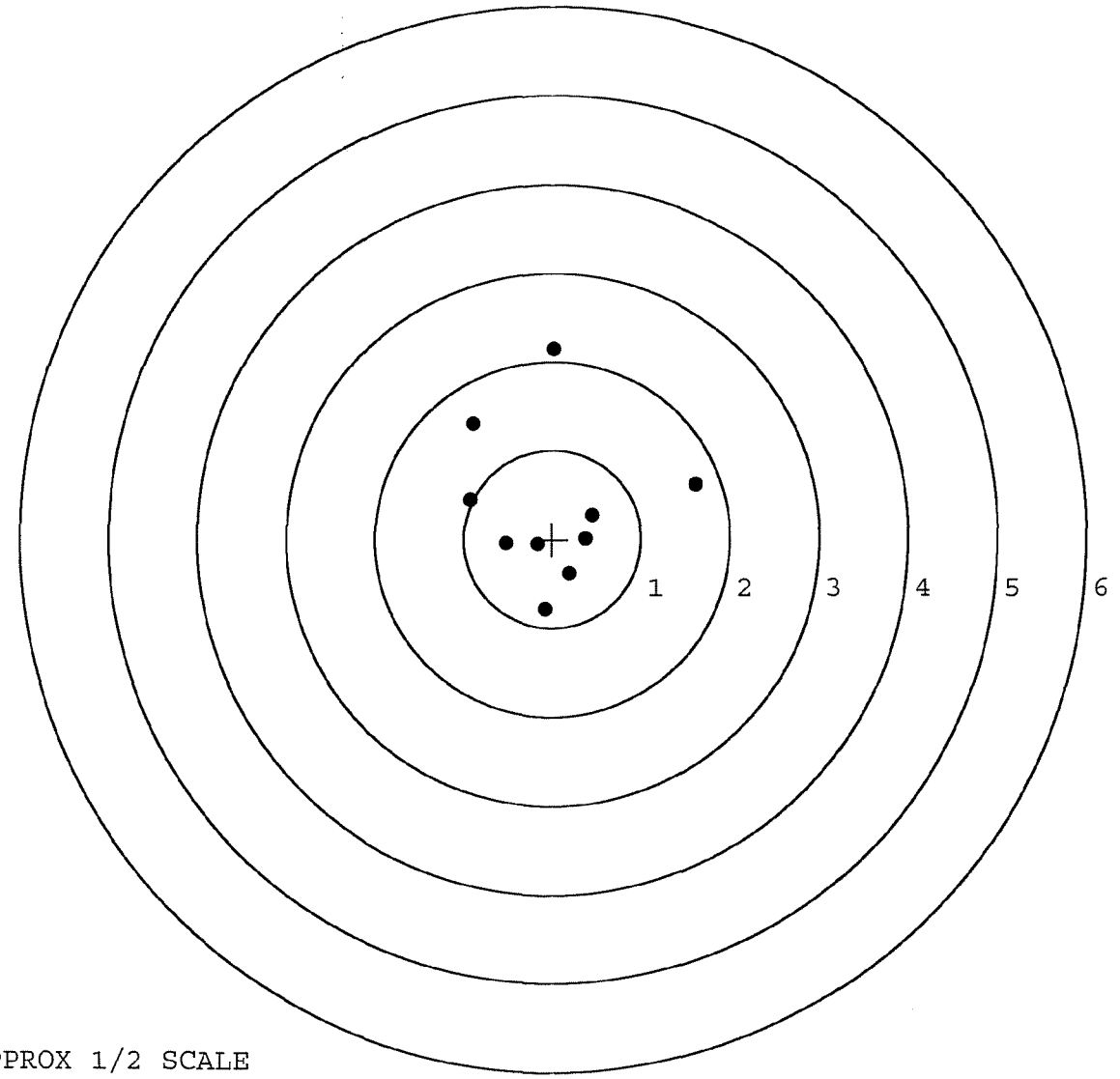


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391086.__0
TARGET NUMBER: 4
FILE DATE: 08/31/2004
FILE TIME: 05:59

X CENTROID:	0.006
Y CENTROID:	0.350
POA TO CENTROID:	0.350
HORZ SPREAD:	2.536
VERT SPREAD:	2.943
GROUP SPREAD:	2.945
MIN RADIUS:	0.437
MAX RADIUS:	1.796
MEAN RADIUS:	0.963
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	1.609	0.617
2:	0.019	2.146
3:	-0.898	1.297
4:	-0.927	0.445
5:	-0.522	-0.049
6:	-0.160	-0.054
7:	0.448	0.273
8:	0.378	0.010
9:	0.199	-0.391
10:	-0.082	-0.797

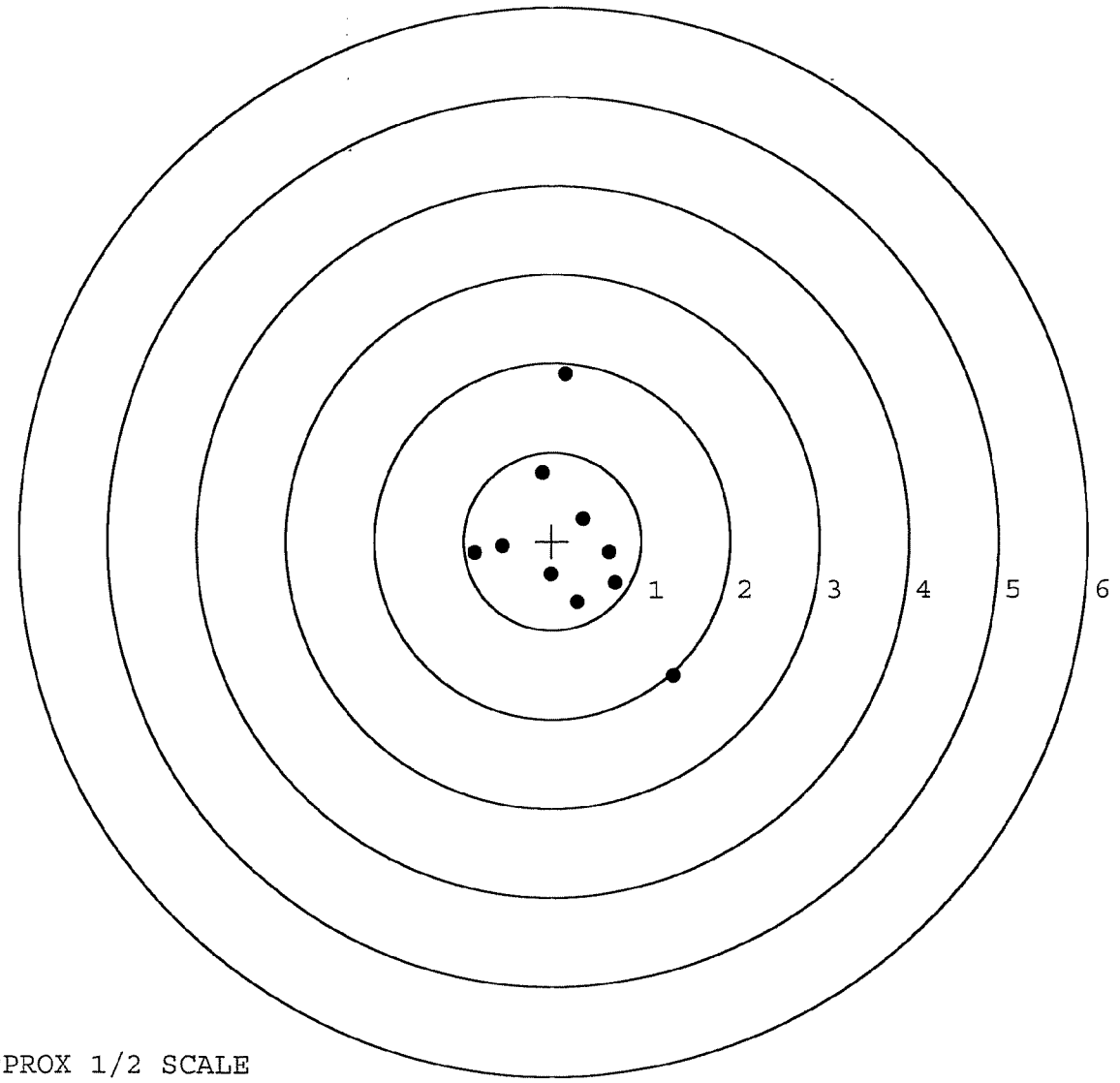


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391086.__0
TARGET NUMBER: 5
FILE DATE: 08/31/2004
FILE TIME: 05:59

X CENTROID:	0.193
Y CENTROID:	-0.049
POA TO CENTROID:	0.199
HORZ SPREAD:	2.230
VERT SPREAD:	3.399
GROUP SPREAD:	3.606
MIN RADIUS:	0.337
MAX RADIUS:	1.926
MEAN RADIUS:	0.900
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	1.355	-1.523
2:	0.282	-0.693
3:	0.708	-0.477
4:	0.643	-0.132
5:	-0.017	-0.375
6:	0.353	0.247
7:	-0.561	-0.058
8:	-0.875	-0.129
9:	-0.112	0.772
10:	0.151	1.876



TARGET APPROX 1/2 SCALE