G 639/090

9/27/2004 10:33:18 AM

Original 57 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.

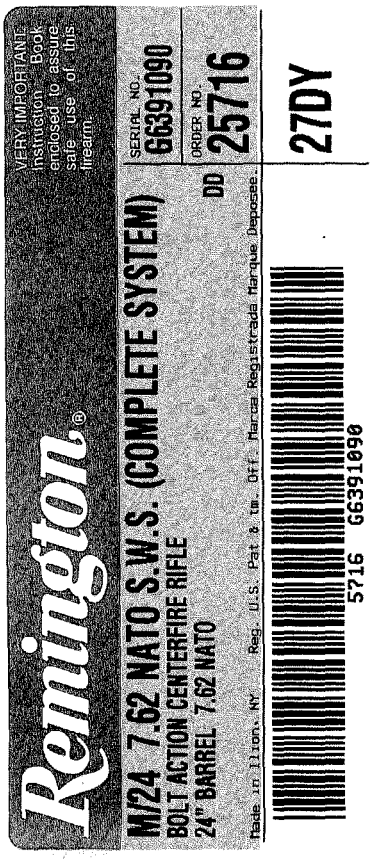
0003451404

0690 89SWS1
Pack Rifle

0003451397

0700 89SWS1
Stencil SWS Container

.OP0700



ORDER 25716

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

UPC

ORDER 25716

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

UPC

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

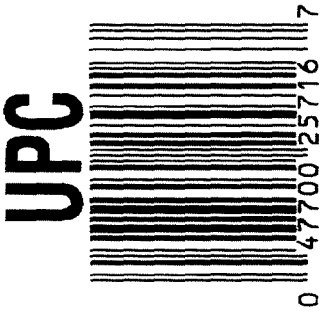
– INSTUCTION BOOK 3518

DD FORM

ORDER NO. 25716

BARREL LENGTH	24"
CAPACITY	6

G6391090



7/22/2004 3:21:04 PM

Original 57 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

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6391090

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	MAGNA-FLUX INSPECTED DEC 15 2004	6-15-04	RTL
610	DIS-ASSEMBLE GUN		6-15-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR		
615	ROLLMARK CALIBER		6-16-04	SB
617	DRILL AND TAP SIGHT HOLES		6-15-04	RTL
620	APPLY COATINGS (BARREL ACTION)		6-15-04	RTL
	(BOLT)		6-25	##
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		8-29-04	
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		8-29-04	
	C) INSPECT EJECTOR HOLE FOR CHAMFER		8-29-04	
	D) OIL FIRING PIN ASSEMBLY		8-29-04	
	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]	6.5 6.0 6.5	9/13/04	DA
CONT.	G) SAFETY OFF FORCE [2 LBS MIN]	3.0 3.0 3.0	9/13/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT [.020 MIN]	.023 .024 .024	9/13/04	DA
	J) ASSEMBLE STOCK		8-29-04	RW
	K) ASSEMBLE SWIVEL STUDS		9-16-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		8-29-04	RW
	M) IRON SIGHT ALIGNMENT		8-29-04	RW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		8-29-04	RW
640	GALLERY TEST AND TARGET	PASS FAIL	8-30-04	TRW
	MALFUNCTION	CORRECTION	8-30-04	TRW
	MALFUNCTION	CORRECTION	8-30-04	TRW
	MALFUNCTION	CORRECTION	8-30-04	TRW
	MALFUNCTION	CORRECTION	8-30-04	TRW
645	INSPECT FOR LIVE AMMO		8-30-04	TRW
655	FINAL INSPECTION A) HEADSPACE		9-16-04	RTL
	B) TRIGGER PULL [+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS]	2.36 2.38 2.19 2.26 2.27	9/13/04	DA
	C) FUNCTION		9-16-04	RTL
660	PACK		9-21-04	[illegible]

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 8-25-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.36	2.67		2.61	
PULL #2	2.51	2.81		2.79	
PULL #3	2.56	2.68		2.69	
PULL #4	2.51	2.65		2.70	
PULL #5	2.57	2.80		2.81	
TOTAL	12.51	13.61		13.60	
AVERAGE	2.50	2.72		2.72	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.28	3.45		
PULL #2	3.10	3.41		
PULL #3	3.22	3.31		
PULL #4	3.17	3.36		
PULL #5	3.23	3.46		
TOTAL	16.00	16.99		
AVERAGE	3.20	3.39		

	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	4.27	4.04		3.95
PULL #2	4.26	4.17		3.94
PULL #3	4.43	4.31		4.03
PULL #4	4.44	4.31		4.01
PULL #5	4.23	3.92		4.16
TOTAL	21.63	20.75		20.09
AVERAGE	4.32	4.15		4.01

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6391090.__0
FILE DATE AND TIME: 08/30/2004 05:56

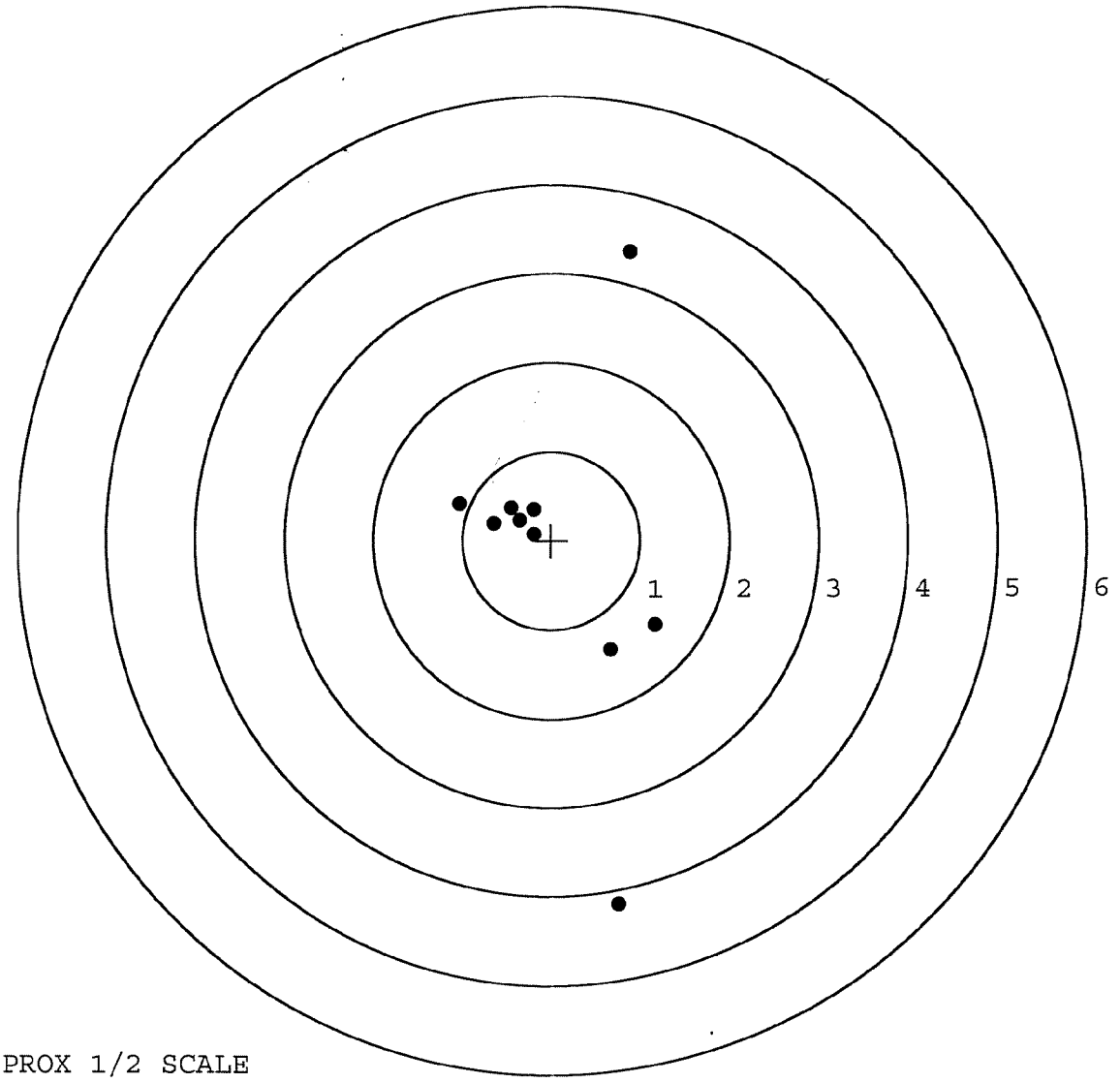
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.019
The Average Y Centroid of the Five Target Set:	-0.090
The Average Point of Impact of the Five Target Set:	0.092
The Average Mean Radius of the Five Target Set:	0.970
The Distance from POA to Centroid Target #1:	0.154
The Distance from Centroid Target #2 to Centroid Target #1:	0.177
The Distance from Centroid Target #3 to Centroid Target #1:	0.192
The Distance from Centroid Target #4 to Centroid Target #1:	0.252
The Distance from Centroid Target #5 to Centroid Target #1:	0.225

SERIAL NUMBER: G6391090.__0
TARGET NUMBER: 1
FILE DATE: 08/30/2004
FILE TIME: 05:56

X CENTROID:	0.062
Y CENTROID:	-0.141
POA TO CENTROID:	0.154
HORZ SPREAD:	2.198
VERT SPREAD:	7.337
GROUP SPREAD:	7.338
MIN RADIUS:	0.336
MAX RADIUS:	4.018
MEAN RADIUS:	1.430
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-0.196	0.347
2:	-0.198	0.073
3:	-0.447	0.372
4:	-0.649	0.196
5:	-0.354	0.233
6:	-1.033	0.415
7:	0.673	-1.228
8:	1.165	-0.956
9:	0.900	3.239
10:	0.756	-4.098

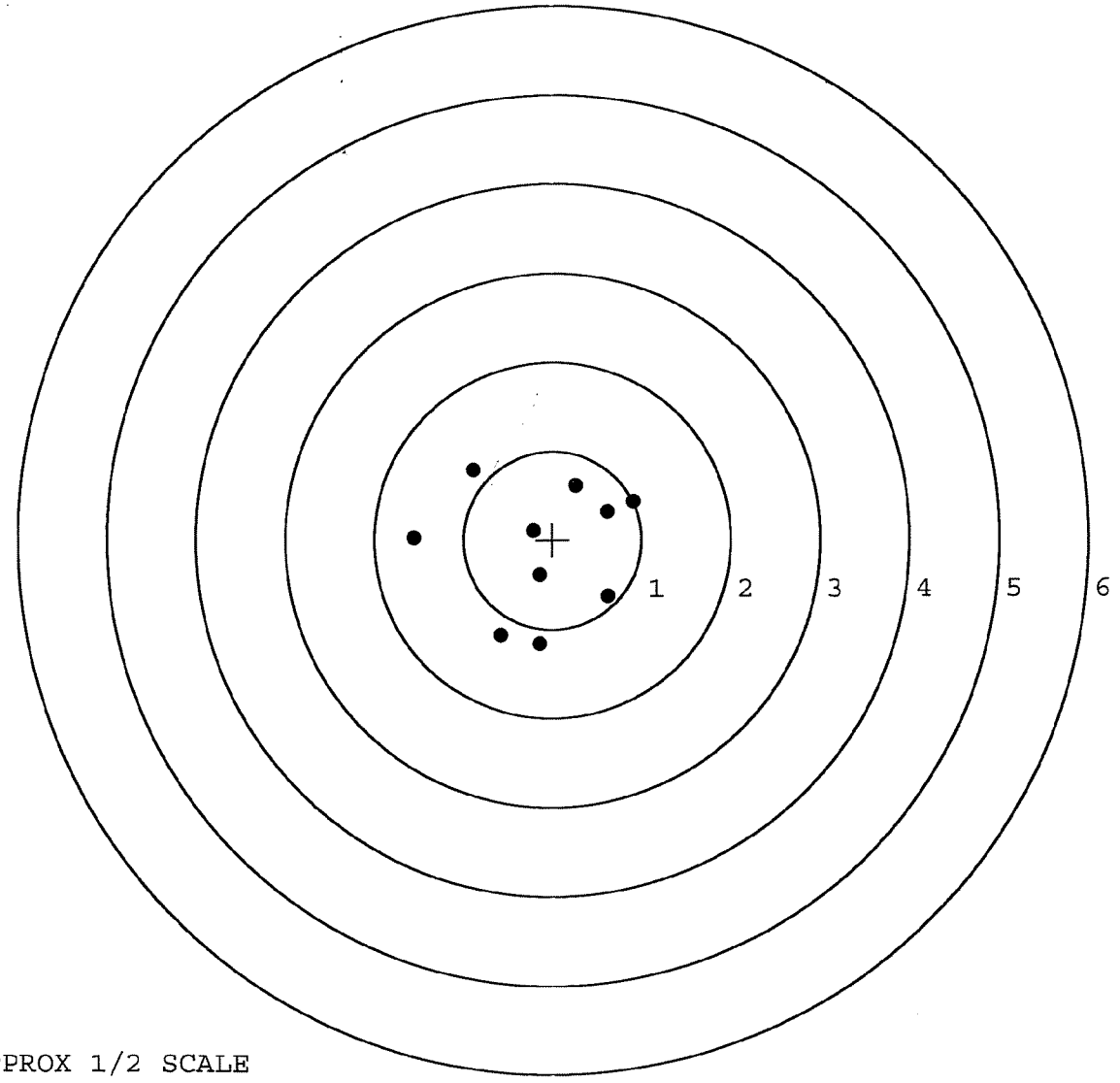


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391090.__0
TARGET NUMBER: 2
FILE DATE: 08/30/2004
FILE TIME: 05:56

X CENTROID:	-0.111
Y CENTROID:	-0.099
POA TO CENTROID:	0.148
HORZ SPREAD:	2.462
VERT SPREAD:	1.964
GROUP SPREAD:	2.494
MIN RADIUS:	0.231
MAX RADIUS:	1.450
MEAN RADIUS:	0.902
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	5
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.144	-1.171
2:	-0.586	-1.068
3:	0.633	-0.635
4:	-0.142	-0.395
5:	-0.218	0.106
6:	0.907	0.428
7:	0.624	0.318
8:	0.262	0.609
9:	-0.888	0.793
10:	-1.555	0.029

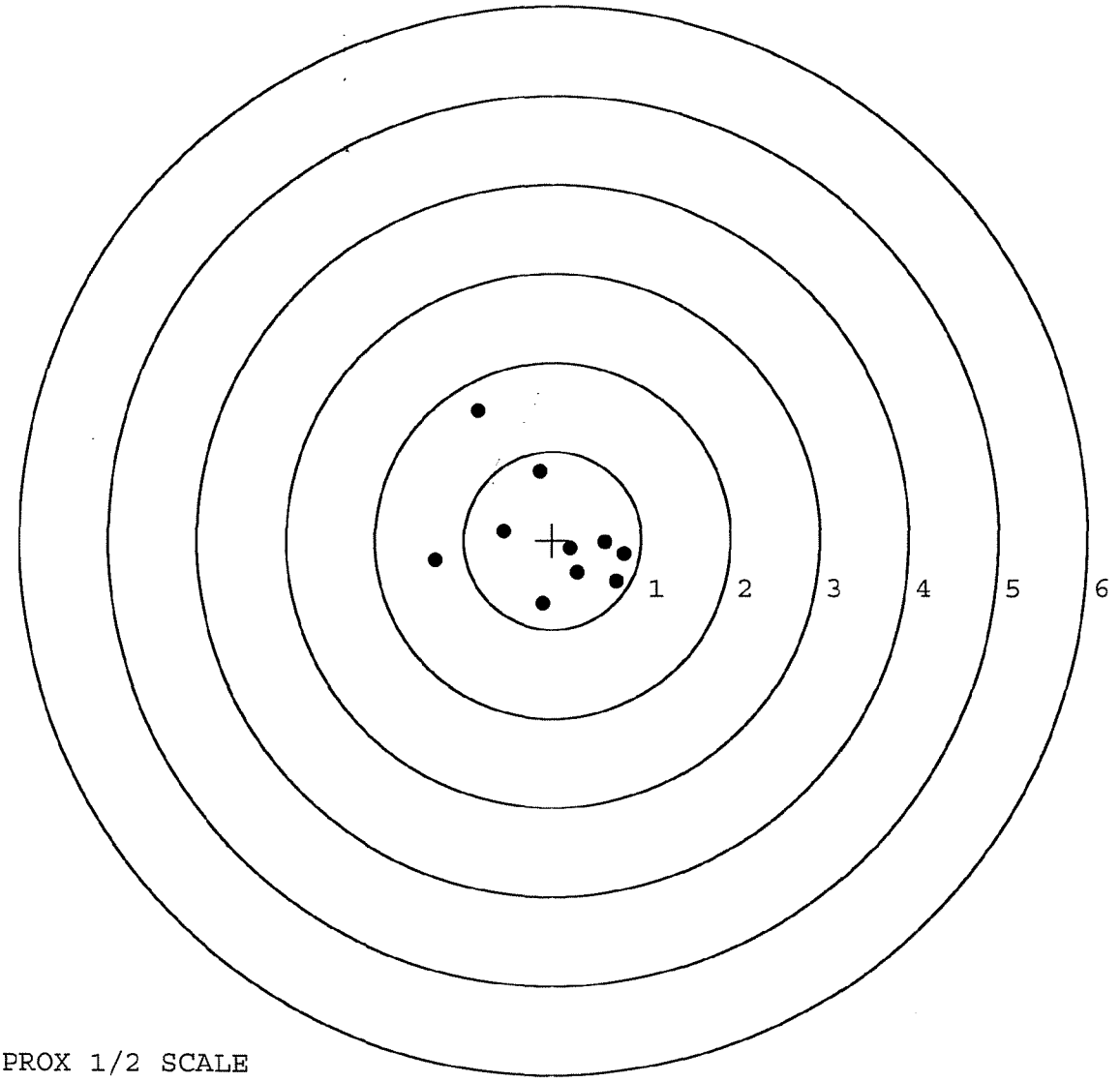


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391090.__0
TARGET NUMBER: 3
FILE DATE: 08/30/2004
FILE TIME: 05:56

X CENTROID:	-0.034
Y CENTROID:	0.025
POA TO CENTROID:	0.043
HORZ SPREAD:	2.127
VERT SPREAD:	2.172
GROUP SPREAD:	2.484
MIN RADIUS:	0.265
MAX RADIUS:	1.645
MEAN RADIUS:	0.816
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	8
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	-0.144	0.778
2:	-0.551	0.094
3:	-1.315	-0.227
4:	-0.844	1.457
5:	-0.111	-0.715
6:	0.200	-0.098
7:	0.285	-0.370
8:	0.725	-0.469
9:	0.812	-0.166
10:	0.598	-0.032

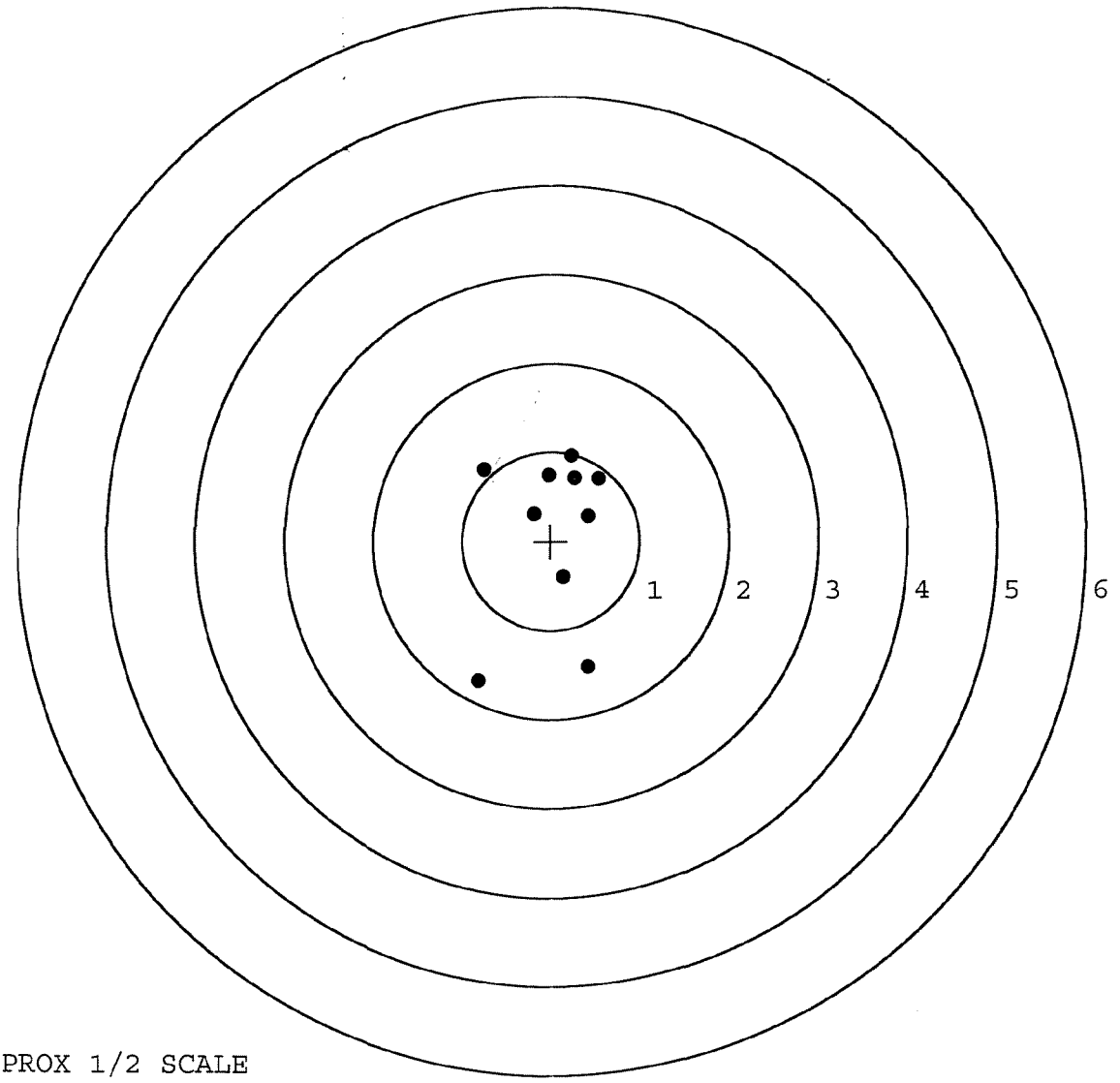


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391090.__0
TARGET NUMBER: 4
FILE DATE: 08/30/2004
FILE TIME: 05:56

X CENTROID:	0.022
Y CENTROID:	0.108
POA TO CENTROID:	0.111
HORZ SPREAD:	1.368
VERT SPREAD:	2.528
GROUP SPREAD:	2.742
MIN RADIUS:	0.290
MAX RADIUS:	1.880
MEAN RADIUS:	0.868
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	0.415	-1.415
2:	-0.825	-1.570
3:	0.145	-0.404
4:	0.420	0.276
5:	-0.195	0.301
6:	-0.755	0.802
7:	0.543	0.699
8:	0.236	0.958
9:	0.265	0.702
10:	-0.027	0.735

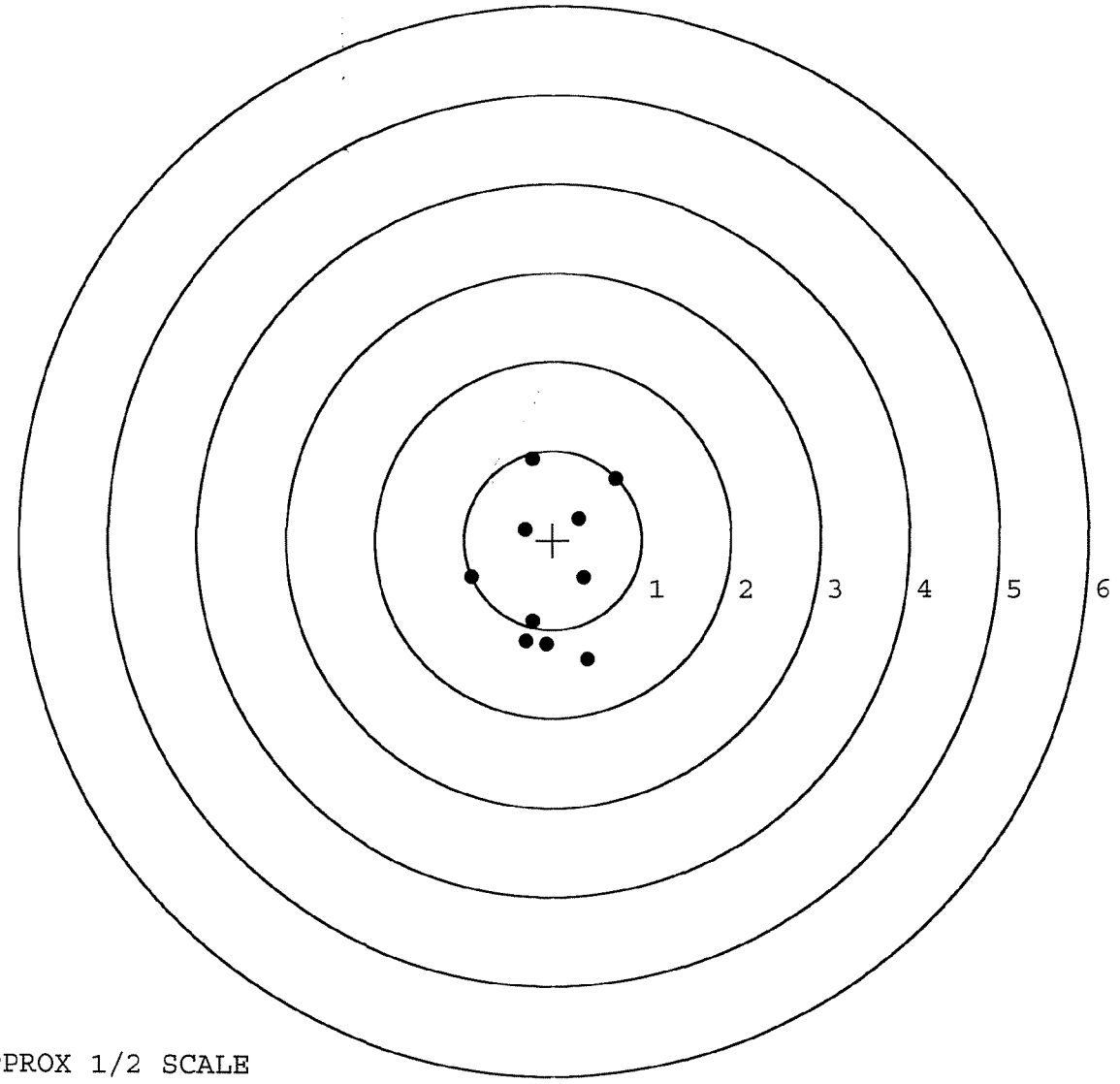


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6391090.__0
TARGET NUMBER: 5
FILE DATE: 08/30/2004
FILE TIME: 05:56

X CENTROID:	-0.033
Y CENTROID:	-0.345
POA TO CENTROID:	0.346
HORZ SPREAD:	1.625
VERT SPREAD:	2.255
GROUP SPREAD:	2.339
MIN RADIUS:	0.390
MAX RADIUS:	1.270
MEAN RADIUS:	0.836
# IN 1 IN DIAMETER:	1
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	0.388	-1.345
2:	0.350	-0.422
3:	0.292	0.237
4:	0.710	0.681
5:	-0.232	0.910
6:	-0.308	0.117
7:	-0.915	-0.410
8:	-0.301	-1.136
9:	-0.078	-1.168
10:	-0.233	-0.909



TARGET APPROX 1/2 SCALE