

G6410217

ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



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M/24 7.62 NATO (RIFLE ONLY)

UPC



SERIAL NO.



M/24 7.62 NATO (RIFLE ONLY)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

— INSTRUCTION BOOK 3518

DD FORM 200348



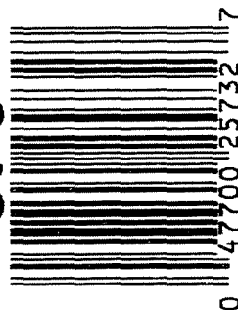
ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6410217

UPC



10/27/2004 11:07:03 AM

Original
2
Crib

25732

M/24 7.62 NATO (RIFLE ONLY)



.MA25732

Shop Order: SWS5732 - NOV



.ABSWS5732 - NOV

Start Date: 10/4/2004
Finish Date: 11/18/2004

0540 01PC001
Flat Black Powder Coat, Barrel and



0003516940

0560 89SWS1
Reassemble Action.



0003516941

0690 89SWS1
Pack Rifle



0003516952

0700 89SWS1
Stencil SWS Container



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # GL6410217

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-27-04	RTL
600	PROOF		12-28-04	RT
607	CHECK HEADSPACE		12-28-04	RT
610	DIS-ASSEMBLE GUN		12-28-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		DEC 29 2004 OPERATOR	RT
615	ROLLMARK CALIBER		12/29/04	RT
617	DRILL AND TAP SIGHT HOLES		12-28-04	TRW
620	APPLY COATINGS (BARREL ACTION)		1/5/05	HP
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		1-12-05	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-12-05	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-12-05	RTL
	D) OIL FIRING PIN ASSEMBLY		1-12-05	RTL
	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>5.5</u> <u>5.5</u> <u>5.5</u>	1-18-05	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.2</u> <u>2.2</u> <u>2.5</u>	1-18-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023</u> <u>.023</u>	1-18-05	DA
	J) ASSEMBLE STOCK		1-12-05	RTL
	K) ASSEMBLE SWIVEL STUDS		1-21-05	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT	N.A.		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	<u>PASS</u> <u>FAIL</u>	1-19-05	A
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-17-05	A
655	FINAL INSPECTION A) HEADSPACE		1-21-05	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.77</u> <u>2.56</u> <u>2.64</u> <u>2.44</u> <u>2.45</u>	1-18-05	DA
	C) FUNCTION		1-21-05	RTL
660	PACK		1-22-05	DA

AVERAGE PULL FORCE BETWEEN

SERIAL NO.

INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

DATE 11-10-04

3.00 LBS (plus or minus 0.75 LBS)

TESTER TRW

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.19	2.41		2.23	
PULL #2	2.63	2.29		2.28	
PULL #3	2.75	2.26		2.18	
PULL #4	2.73	2.21		2.22	
PULL #5	2.68	2.20		2.19	
TOTAL	12.98	11.37		11.10	
AVERAGE	2.59	2.27		2.22	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.13	3.10		
PULL #2	3.15	3.28		
PULL #3	3.14	3.23		
PULL #4	3.13	3.19		
PULL #5	3.16	3.18		
TOTAL	15.71	15.98		
AVERAGE	3.14	3.19		

	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	4.30	3.96		4.19
PULL #2	4.26	4.32		4.08
PULL #3	4.10	4.07		4.09
PULL #4	4.24	4.16		4.07
PULL #5	4.14	4.13		4.05
TOTAL	21.04	20.64		20.48
AVERAGE	4.20	4.12		4.09

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6410217.__0
FILE DATE AND TIME: 01/17/2005 08:51

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

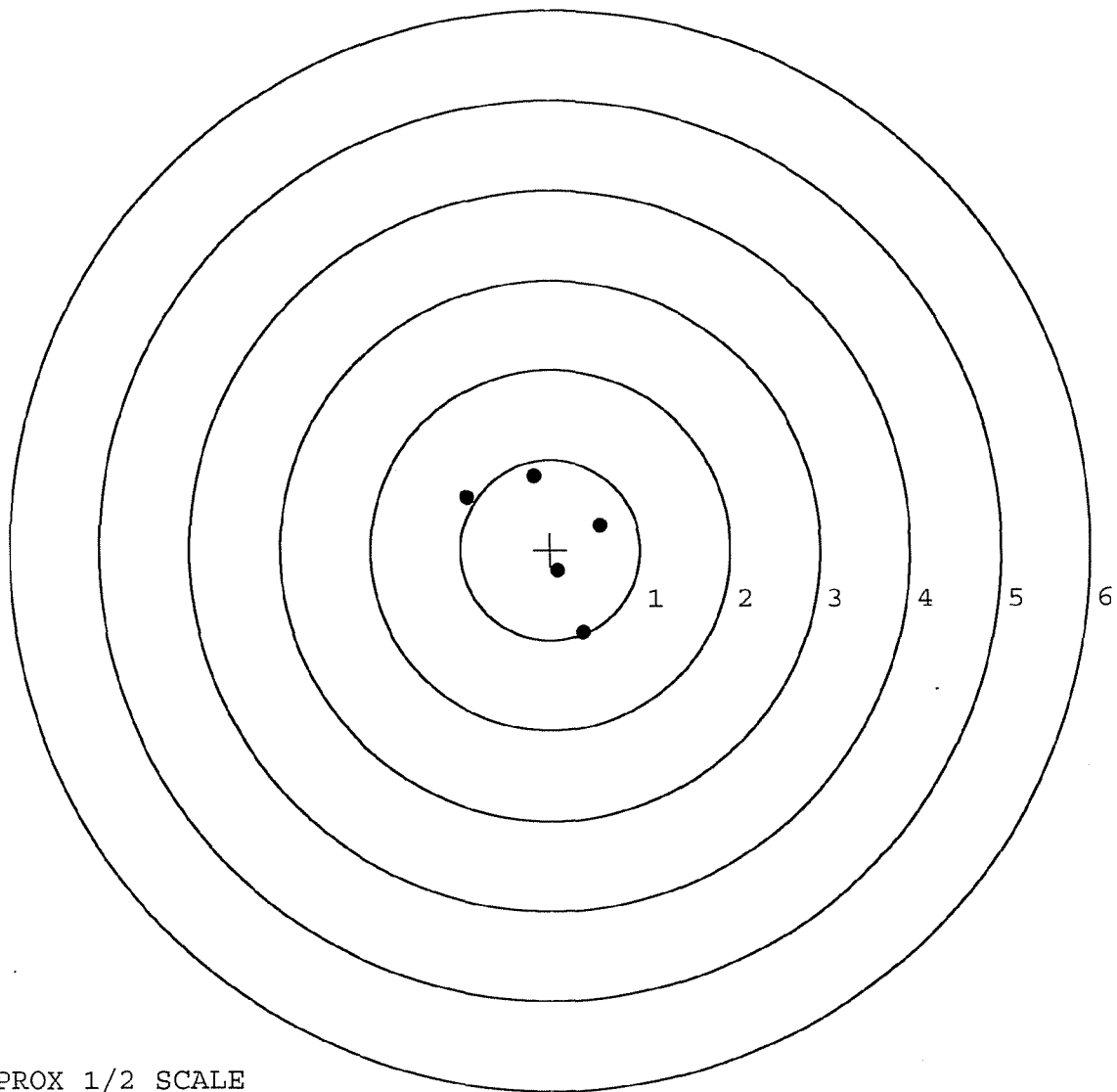
ERROR - NOT POSSIBLE TO REPORT SWS STATS ON DATA
WHERE TOTAL TARGETS ARE NOT EQUAL TO FIVE

AVE. MEAN 88705

SERIAL NUMBER: G6410217. __0
TARGET NUMBER: 1
FILE DATE: 01/17/2005
FILE TIME: 08:51

POINT#	X	Y
1:	0.364	-0.919
2:	0.084	-0.236
3:	0.553	0.279
4:	-0.181	0.816
5:	-0.929	0.587

X CENTROID: -0.022
Y CENTROID: 0.105
POA TO CENTROID: 0.108
HORZ SPREAD: 1.482
VERT SPREAD: 1.735
GROUP SPREAD: 1.985
MIN RADIUS: 0.357
MAX RADIUS: 1.095
MEAN RADIUS: 0.762
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 5

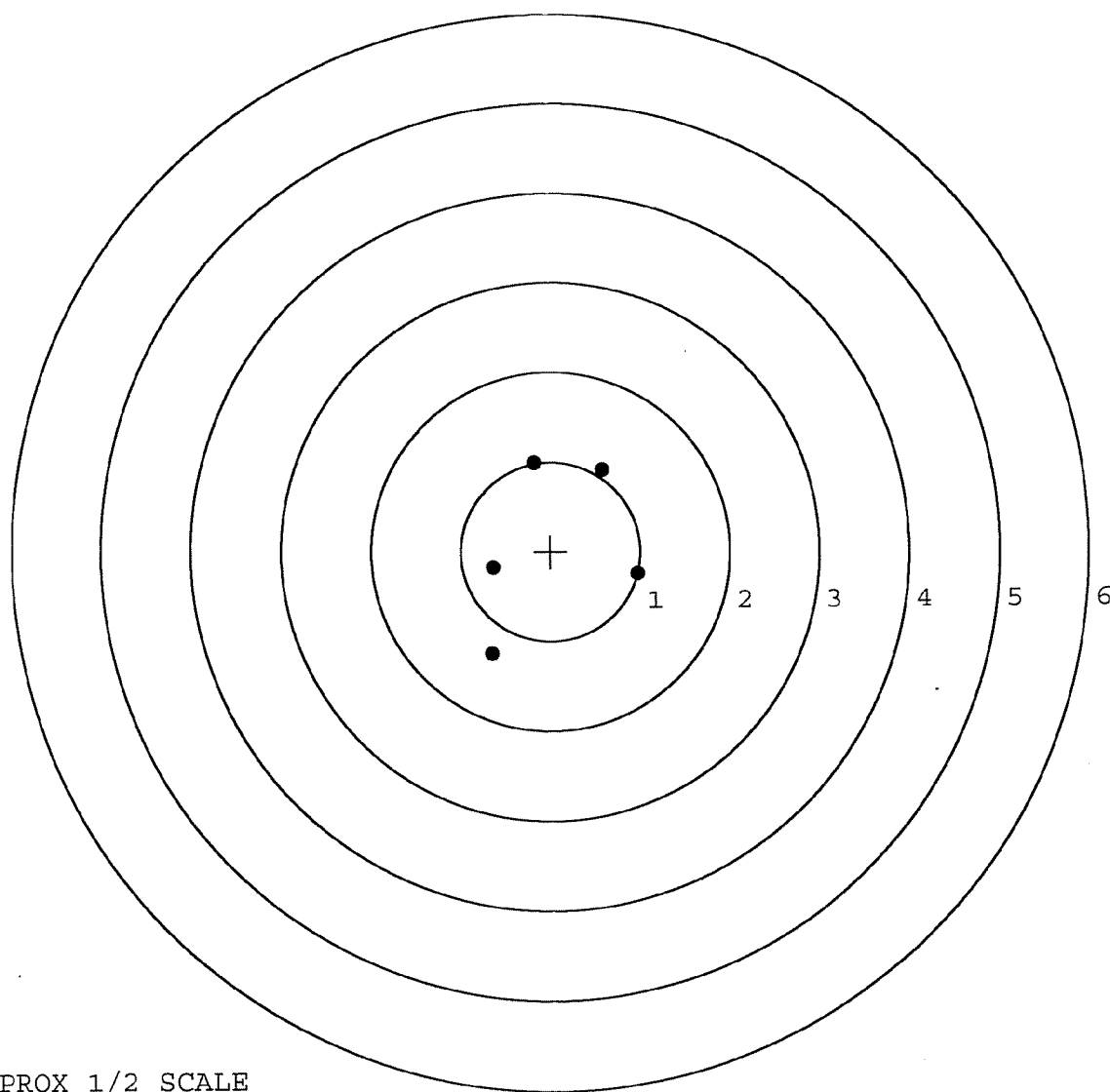


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6410217.___0
TARGET NUMBER: 2
FILE DATE: 01/17/2005
FILE TIME: 08:51

POINT#	X	Y
1:	-0.666	-1.144
2:	0.972	-0.256
3:	-0.641	-0.177
4:	0.583	0.912
5:	-0.186	0.993

X CENTROID: 0.012
Y CENTROID: 0.066
POA TO CENTROID: 0.067
HORZ SPREAD: 1.638
VERT SPREAD: 2.137
GROUP SPREAD: 2.406
MIN RADIUS: 0.697
MAX RADIUS: 1.387
MEAN RADIUS: 1.013
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 2
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE