

G6414361

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

- INSTRUCTION BOOK 3518

DD FORM 200348

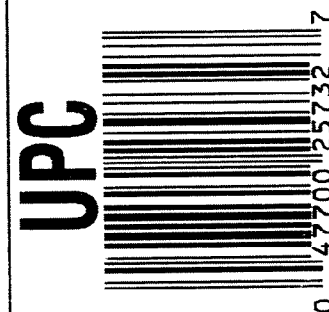


ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6414361



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC

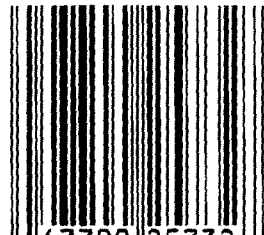


0 47700 25732 7

ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



0 47700 25732 7

SERIAL NO.



66414361

10/27/2004 11:07:03 AM

Original

91

Original

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

Flat Black Powder Coat, Barrel and

01PC001



0003516940

0560

Reassemble Action.

89SWS1



0003516941

0690

Pack Rifle

89SWS1



0003516952

0700

Stencil SWS Container

89SWS1



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414361

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-27-04	RTZ
600	PROOF		12-28-04	A
607	CHECK HEADSPACE		12-28-04	A
610	DIS-ASSEMBLE GUN		12-28-04	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		DEC 27 2004 OPERATOR	JO
615	ROLLMARK CALIBER		12-29-04	AS
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		1-10-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-10-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-21-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-11-05	RTZ
	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>6.5</u> <u>5.5</u>	1-21-05	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.0</u> <u>3.5</u> <u>3.5</u>	1-21-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1.024</u> <u>1.023</u> <u>1.0245</u>	1-21-05	DA
	J) ASSEMBLE STOCK		1-11-05	RT
	K) ASSEMBLE SWIVEL STUDS		1-21-05	RT
	L) ATTACH FRONT AND REAR SIGHT ASSY'S	N.A.		
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
	GALLERY TEST AND			
640	TARGET	<u>PASS</u> FAIL	1-20-05	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-20-05	TRW
655	FINAL INSPECTION A) HEADSPACE		1-21-05	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.92</u> <u>2.92</u> <u>2.83</u> <u>2.89</u> <u>2.92</u>	1-21-05	DA
	C) FUNCTION		1-21-05	RT
660	PACK		1-22-05	DA

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 11-15-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.50	2.71		2.72	
PULL #2	2.71	2.70		2.72	
PULL #3	2.61	2.69		2.70	
PULL #4	2.62	2.73		2.70	
PULL #5	2.65	2.69		2.72	
TOTAL	13.09	13.52		13.56	
AVERAGE	2.61	2.70		2.71	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.46		
PULL #2	3.45	3.41		
PULL #3	3.38	3.35		
PULL #4	3.43	3.34		
PULL #5	3.49	3.28		
TOTAL	17.23	16.84		
AVERAGE	3.44	3.36		

	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	4.37	4.30		4.21
PULL #2	4.32	4.25		4.17
PULL #3	4.18	4.22		4.42
PULL #4	4.45	4.17		4.23
PULL #5	4.11	4.19		4.27
TOTAL	21.43	21.13		21.30
AVERAGE	4.28	4.22		4.26

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414361. __0
FILE DATE AND TIME: 01/20/2005 09:11

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

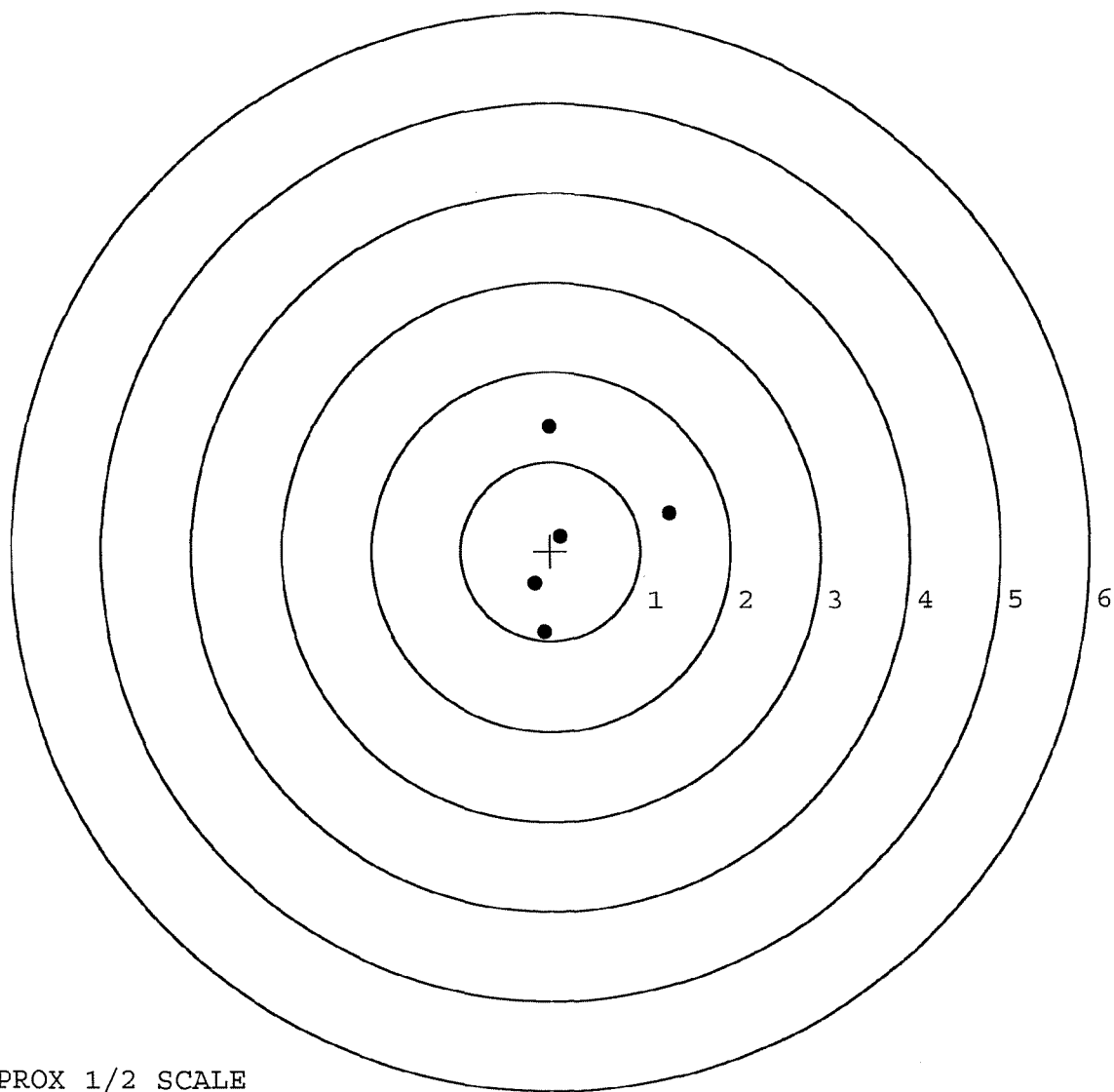
ERROR - NOT POSSIBLE TO REPORT SWS STATS ON DATA
WHERE TOTAL TARGETS ARE NOT EQUAL TO FIVE

AVE MEAN .748

SERIAL NUMBER: G6414361. __ 0
TARGET NUMBER: 1
FILE DATE: 01/20/2005
FILE TIME: 09:11

POINT#	X	Y
1:	1.315	0.424
2:	-0.078	-0.912
3:	-0.178	-0.364
4:	0.118	0.165
5:	-0.010	1.391

X CENTROID: 0.233
Y CENTROID: 0.141
POA TO CENTROID: 0.273
HORZ SPREAD: 1.493
VERT SPREAD: 2.303
GROUP SPREAD: 2.304
MIN RADIUS: 0.118
MAX RADIUS: 1.274
MEAN RADIUS: 0.852
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 2
in 3 IN DIAMETER: 5

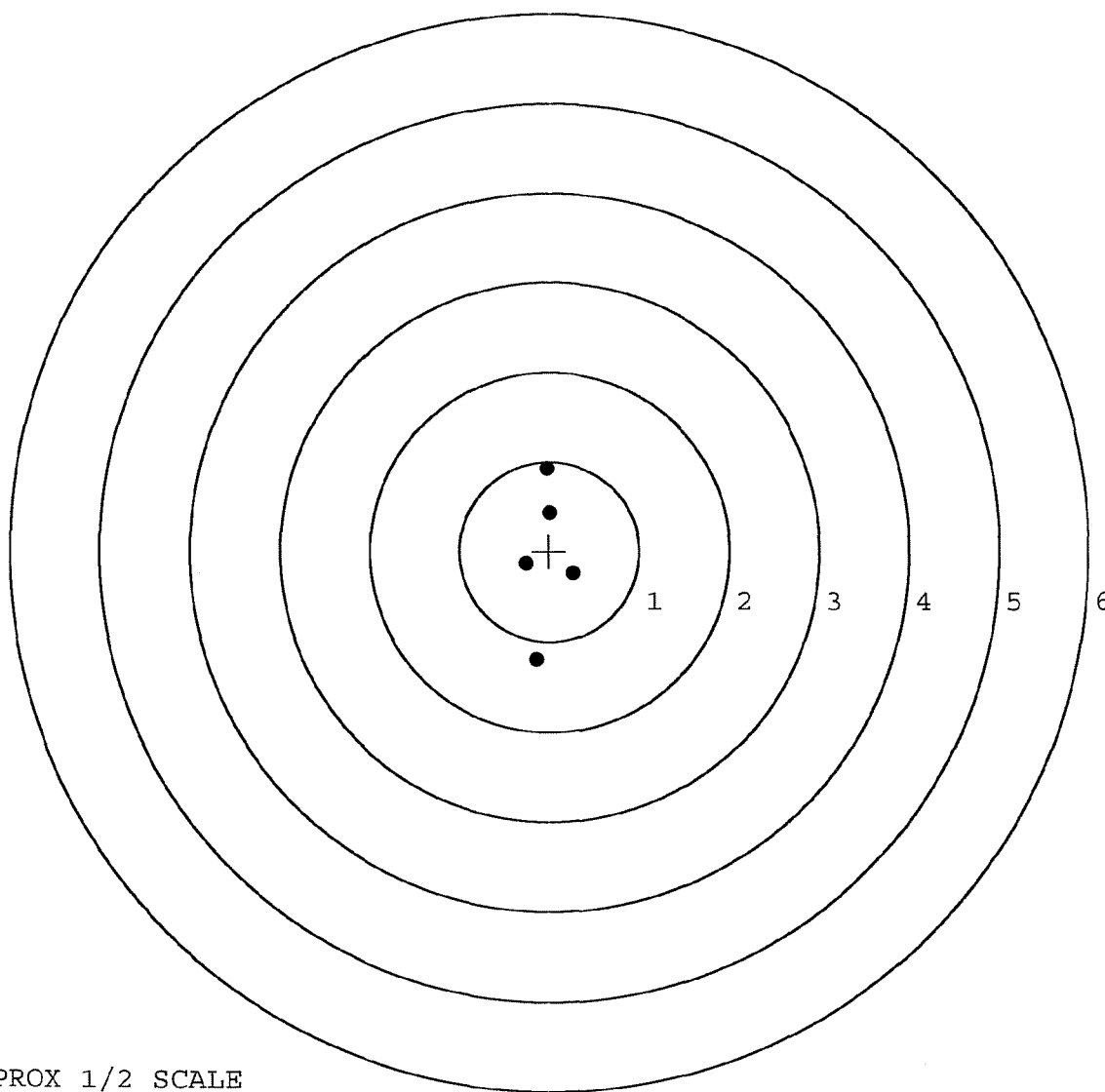


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414361. __0
TARGET NUMBER: 2
FILE DATE: 01/20/2005
FILE TIME: 09:11

POINT#	X	Y
1:	-0.142	-1.201
2:	0.273	-0.253
3:	-0.255	-0.146
4:	0.001	0.433
5:	-0.028	0.921

X CENTROID: -0.030
Y CENTROID: -0.049
POA TO CENTROID: 0.058
HORZ SPREAD: 0.528
VERT SPREAD: 2.122
GROUP SPREAD: 2.125
MIN RADIUS: 0.245
MAX RADIUS: 1.157
MEAN RADIUS: 0.644
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE