

G6414386

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

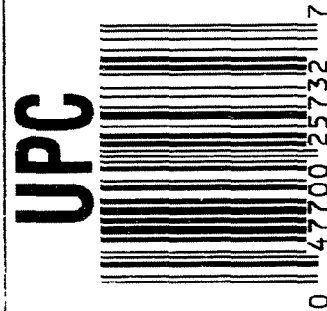
- INSTRUCTION BOOK 3518

DD FORM 200348



|               |              |
|---------------|--------------|
| ORDER NO.     | <b>25732</b> |
| BARREL LENGTH | <b>24"</b>   |
| CAPACITY      | <b>5</b>     |

**G6414386**



**ORDER — 25732**

M/24 7.62 NATO (RIFLE ONLY)

**UPC**



**ORDER 25732**

M/24 7.62 NATO (RIFLE ONLY)

**UPC**



SERIAL NO.



10/26/2004 7:48:11 AM

Crib

32

Original

25732

M/24 7.62 NATO (RIFLE ONLY)



.MA25732

Shop Order: SWS5732 - B



.ABSWS5732 - B

Start Date: 9/8/2004

Finish Date: 10/27/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003512656

0560

Reassemble Action.

89SWS1



0003512657

0690

Pack Rifle

89SWS1



0003512668

0700

Stencil SWS Container

89SWS1



.OP0700

M-24  
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G644386

| OP #      | OPERATION NAME                                                                                                                         | READINGS | DATE     | INITIAL |
|-----------|----------------------------------------------------------------------------------------------------------------------------------------|----------|----------|---------|
| 575 & 580 | ASSEMBLE ACTION AND STOCK                                                                                                              |          | 12-29-04 | RTZ     |
| 600       | PROOF                                                                                                                                  |          | 12-29-04 | RTZ     |
| 607       | CHECK HEADSPACE                                                                                                                        |          | 12-29-04 | RTZ     |
| 610       | DIS-ASSEMBLE GUN                                                                                                                       |          | 12-30-04 | RTZ     |
| 612       | MAGNAFLUX BBL ACTION<br>MAGNAFLUX BOLT                                                                                                 |          |          | RTZ     |
| 615       | ROLLMARK CALIBER                                                                                                                       |          | 1-3-05   | CW      |
| 617       | DRILL AND TAP<br>SIGHT HOLES                                                                                                           |          | 12-30-04 | TRW     |
| 620       | APPLY COATINGS<br>(BARREL ACTION)                                                                                                      |          | 1/1/05   | HP      |
|           | (BOLT)                                                                                                                                 |          |          |         |
| 625       | FINAL ASSEMBLY                                                                                                                         |          |          |         |
|           | A) CLEAN INSIDE OF<br>BOLT ASSEMBLY                                                                                                    |          | 1-12-05  | OA      |
|           | B) INSPECT REAR FIRING<br>PIN HOLE FOR CHAMFER<br>IN BOLT HEAD                                                                         |          | 1-12-05  | OA      |
|           | C) INSPECT EJECTOR<br>HOLE FOR CHAMFER                                                                                                 |          | 1-13-05  | RTZ     |
|           | D) OIL FIRING PIN ASSEMBLY                                                                                                             |          | 1-13-05  | RTZ     |
|           | E) ADJUST TRIGGER PULL<br>TO MIN. SETTING AND<br>STAKE <span style="border: 1px solid black; padding: 2px;">2.50 LBS +/- .5 LBS</span> |          |          |         |

| OP #  | OPERATION NAME                                                           | READINGS                                                    | DATE    | INITIAL |
|-------|--------------------------------------------------------------------------|-------------------------------------------------------------|---------|---------|
| 625   | F) SAFETY ON FORCE <span>2 LBS MIN<br/>10 LBS MAX</span>                 | <u>8.0</u> <u>8.0</u> <u>7.5</u>                            | 1-22-05 | RA      |
| CONT. |                                                                          |                                                             |         |         |
|       | G) SAFETY OFF FORCE <span>2 LBS MIN</span>                               | <u>2.0</u> <u>2.0</u> <u>2.0</u>                            | 1-22-05 | RA      |
|       | H) TRIGGER PULL TEST<br>AND RETAINABILITY                                |                                                             |         |         |
|       | I) FIRING PIN INDENT <span>.020 MIN</span>                               | <u>.025</u> <u>.0245</u> <u>.0245</u>                       | 1-22-05 | RA      |
|       | J) ASSEMBLE STOCK                                                        |                                                             | 1-13-05 | RTZ     |
|       | K) ASSEMBLE SWIVEL<br>STUDS                                              |                                                             | 1-22-05 | RR      |
|       | L) ATTACH FRONT AND<br>REAR SIGHT ASSY'S                                 | N/A.                                                        |         |         |
|       | M) IRON SIGHT<br>ALIGNMENT                                               |                                                             |         |         |
|       | N) DETACH FRONT AND<br>REAR SIGHTS AND PLACE<br>IN NUMBERED CONTAINER    |                                                             |         |         |
| 640   | GALLERY TEST AND<br>TARGET                                               | <span>PASS</span> FAIL                                      | 1-13-05 | TRW     |
|       | MALFUNCTION <i>OH over live rds</i>                                      | CORRECTION OK                                               | 1-21-05 | TRW     |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
|       | MALFUNCTION                                                              | CORRECTION                                                  |         |         |
| 645   | INSPECT FOR LIVE AMMO                                                    |                                                             | 1-13-05 | TRW     |
| 655   | FINAL INSPECTION<br>A) HEADSPACE                                         |                                                             | 1-22-05 | RR      |
|       | B) TRIGGER PULL <span>+/- .5 LBS<br/>MIN 2.50 LBS<br/>MAX 4.0 LBS</span> | <u>2.42</u> <u>2.33</u> <u>2.50</u> <u>2.57</u> <u>2.46</u> | 1-22-05 | RA      |
|       | C) FUNCTION                                                              |                                                             | 1-22-05 | RTZ     |
| 660   | PACK                                                                     |                                                             | 1-24-05 | RA      |

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 11-8-04

TESTER TRL

|         | 2.50 LBS<br>INITIAL | 2.50 LBS AFTER<br>50 CYCLES | FINAL TEST & TO RESET<br>2.50 LBS |       | COMMENTS |
|---------|---------------------|-----------------------------|-----------------------------------|-------|----------|
| PULL #1 | 2.43                | 2.11                        |                                   | 2.29  |          |
| PULL #2 | 2.54                | 2.74                        |                                   | 2.55  |          |
| PULL #3 | 2.59                | 2.71                        |                                   | 2.39  |          |
| PULL #4 | 2.59                | 2.81                        |                                   | 2.35  |          |
| PULL #5 | 2.34                | 2.65                        |                                   | 2.38  |          |
| TOTAL   | 12.49               | 13.02                       |                                   | 11.96 |          |
| AVERAGE | 2.49                | 2.60                        |                                   | 2.39  |          |

|         | 3.00 LBS<br>INITIAL | 3.00 LBS AFTER<br>20 CYCLES |  | COMMENTS |
|---------|---------------------|-----------------------------|--|----------|
| PULL #1 | 3.16                | 3.06                        |  |          |
| PULL #2 | 3.32                | 3.19                        |  |          |
| PULL #3 | 3.47                | 3.35                        |  |          |
| PULL #4 | 3.39                | 3.25                        |  |          |
| PULL #5 | 3.53                | 3.16                        |  |          |
| TOTAL   | 16.87               | 16.01                       |  |          |
| AVERAGE | 3.37                | 3.20                        |  |          |

|         | 4.00 LBS<br>INITIAL | 4.00 LBS AFTER<br>20 CYCLES | MAX SETTING GREATER<br>THAN 4 LBS | RESET TO 4 LBS FOR<br>TARGET & ACCURACY |
|---------|---------------------|-----------------------------|-----------------------------------|-----------------------------------------|
| PULL #1 | 4.16                | 4.05                        |                                   | 4.11                                    |
| PULL #2 | 4.33                | 4.06                        |                                   | 4.29                                    |
| PULL #3 | 4.35                | 4.19                        |                                   | 3.91                                    |
| PULL #4 | 4.24                | 4.14                        |                                   | 4.22                                    |
| PULL #5 | 4.40                | 4.27                        |                                   | 4.04                                    |
| TOTAL   | 21.48               | 20.71                       |                                   | 20.57                                   |
| AVERAGE | 4.29                | 4.14                        |                                   | 4.11                                    |

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414386. \_\_0  
FILE DATE AND TIME: 01/13/2005 10:57

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

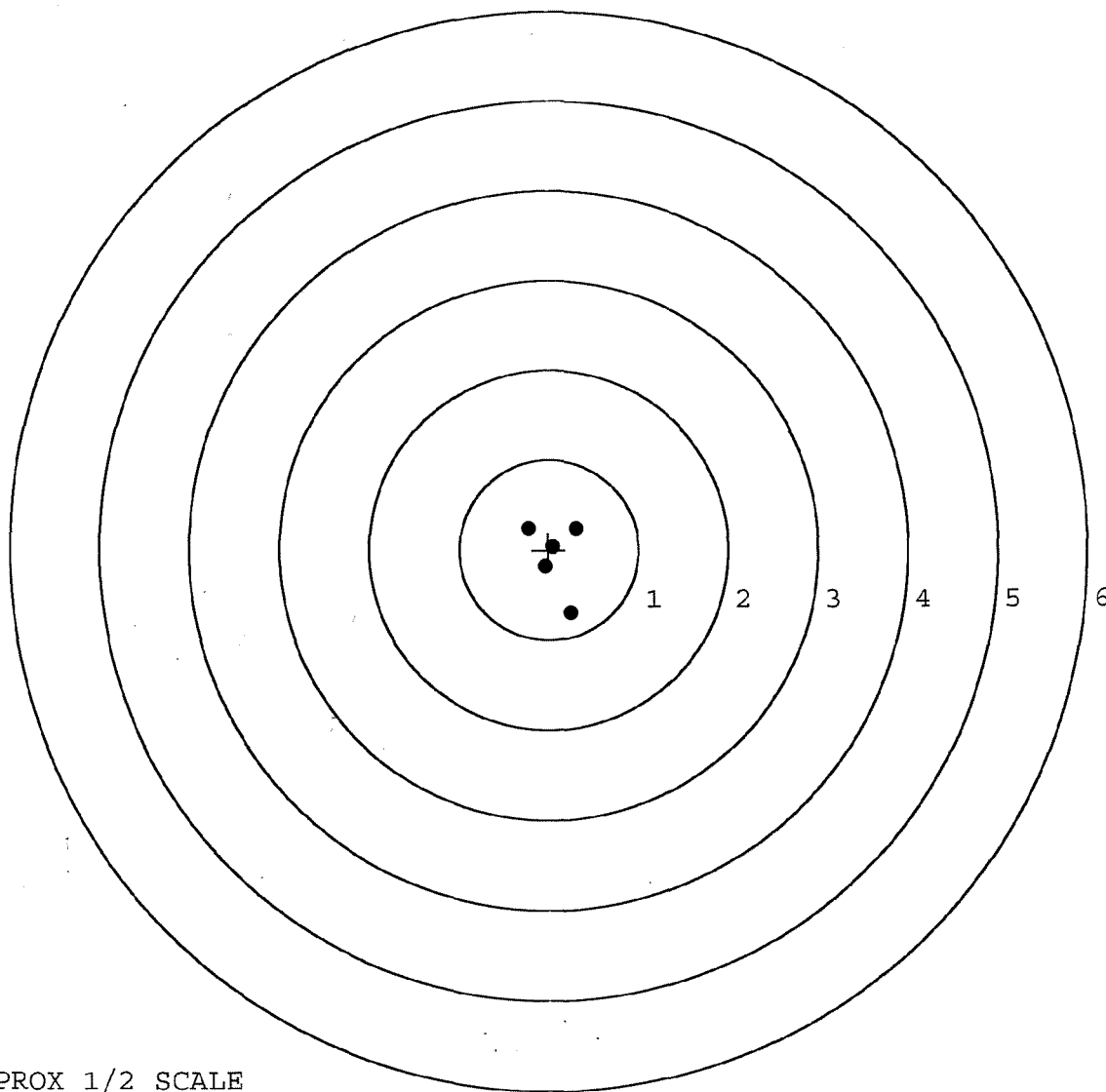
ERROR - NOT POSSIBLE TO REPORT SWS STATS ON DATA  
WHERE TOTAL TARGETS ARE NOT EQUAL TO FIVE

AVE. MEAN .7695

SERIAL NUMBER: G6414386. \_\_0  
TARGET NUMBER: 1  
FILE DATE: 01/13/2005  
FILE TIME: 10:57

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.245  | -0.706 |
| 2:     | 0.305  | 0.240  |
| 3:     | 0.047  | 0.036  |
| 4:     | -0.043 | -0.190 |
| 5:     | -0.227 | 0.239  |

X CENTROID: 0.065  
Y CENTROID: -0.076  
POA TO CENTROID: 0.100  
HORZ SPREAD: 0.532  
VERT SPREAD: 0.946  
GROUP SPREAD: 1.056  
MIN RADIUS: 0.114  
MAX RADIUS: 0.655  
MEAN RADIUS: 0.350  
# IN 1 IN DIAMETER: 4  
# IN 2 IN DIAMETER: 5  
# in 3 IN DIAMETER: 5

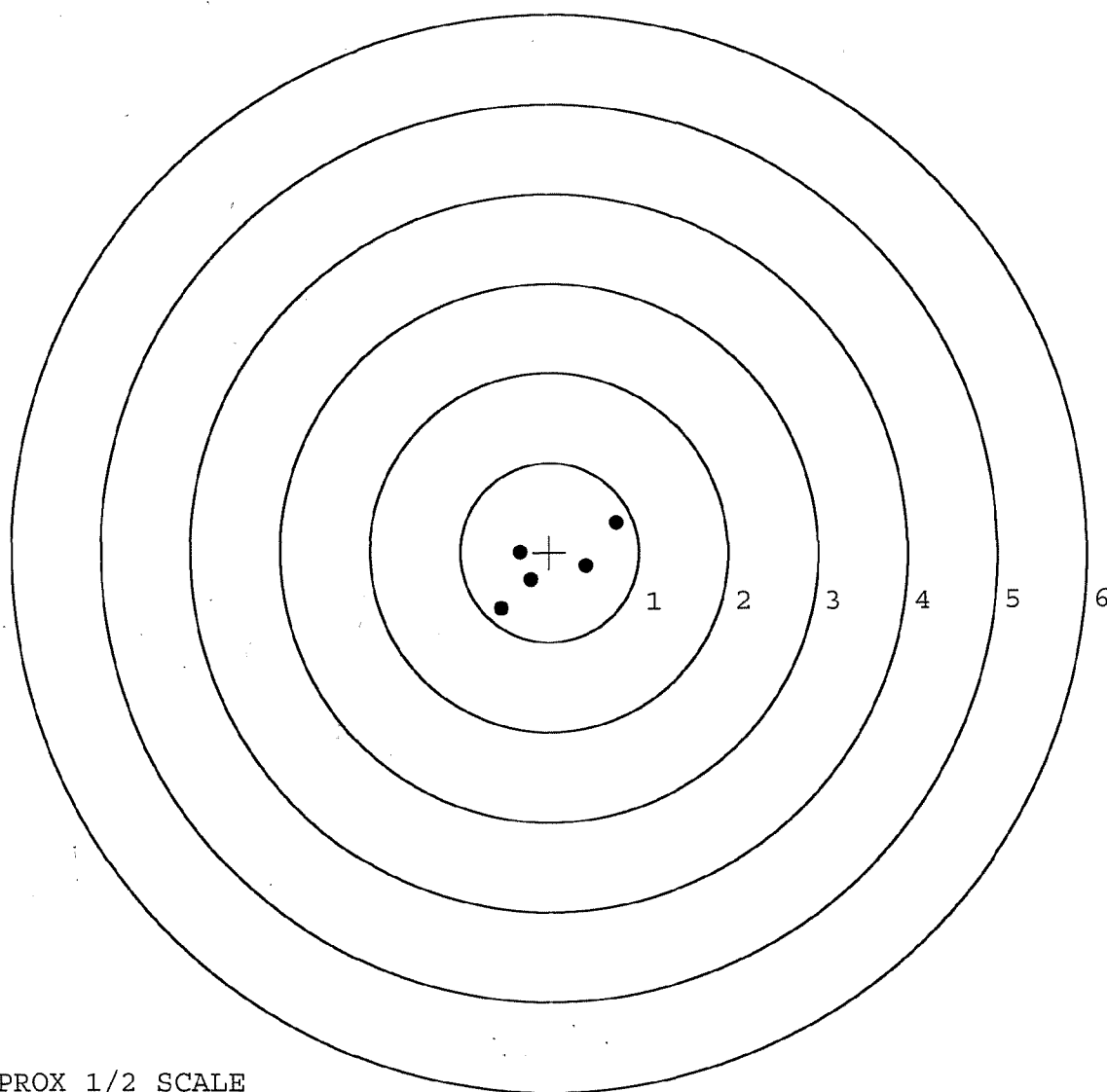


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414386: \_\_0  
TARGET NUMBER: 2  
FILE DATE: 01/13/2005  
FILE TIME: 10:57

| POINT# | X      | Y      |
|--------|--------|--------|
| 1:     | 0.409  | -0.156 |
| 2:     | 0.758  | 0.328  |
| 3:     | -0.333 | 0.002  |
| 4:     | -0.208 | -0.309 |
| 5:     | -0.543 | -0.631 |

X CENTROID: 0.017  
Y CENTROID: -0.153  
POA TO CENTROID: 0.154  
HORZ SPREAD: 1.301  
VERT SPREAD: 0.959  
GROUP SPREAD: 1.616  
MIN RADIUS: 0.273  
MAX RADIUS: 0.884  
MEAN RADIUS: 0.534  
# IN 1 IN DIAMETER: 3  
# IN 2 IN DIAMETER: 5  
# in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE