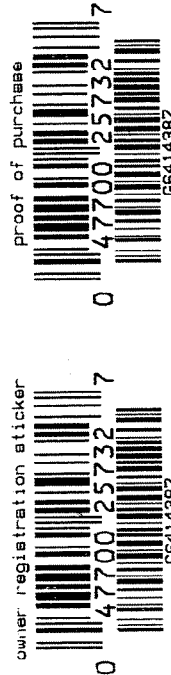


G6414387

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

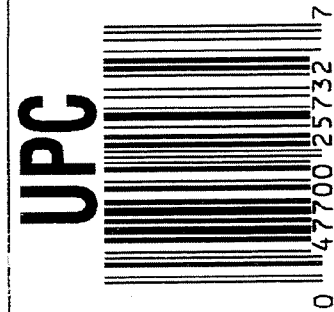
- INSTRUCTION BOOK 3518

DD FORM 200348



ORDER NO.	25732
BARREL LENGTH	24"
CAPACITY	5

G6414387



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

CHB

91

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

1PC0



0003512656

0560

Reassemble Action.

20SW



0003512657

0690

Pack Rifle

20SW



0003512668

0700

Stencil SWS Container

895



.OP070J

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66414387

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		10-19-04	RTL
600	PROOF			
607	CHECK HEADSPACE			
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		10/27/04	AB
617	DRILL AND TAP SIGHT HOLES		10-22-04	TRW
620	APPLY COATINGS (BARREL ACTION)		10/30	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-5-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-5-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-5-04	RTL
	D) OIL FIRING PIN ASSEMBLY		11-5-04	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>8.2</u> <u>8.2</u> <u>8.2</u>	12/7/04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.2</u> <u>2.2</u> <u>2.2</u>	12/7/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1022</u> <u>1023</u> <u>1023</u>	12/7/04	DA
	J) ASSEMBLE STOCK		11-5-04	RTL
	K) ASSEMBLE SWIVEL STUDS		12-7-04	AC
	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 TARGET			
640		PASS FAIL	12-6-04	TRC
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		12-6-04	TRC
655	FINAL INSPECTION A) HEADSPACE		12-7-04	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.88</u> <u>2.88</u> <u>2.70</u> <u>2.69</u> <u>2.67</u>	12/7/04	DA
	C) FUNCTION		12-7-04	AC
660	PACK		12-10-04	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. 87

DATE 6-14-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.46	2.55		2.84	
PULL #2	2.31	2.64		2.90	
PULL #3	2.45	2.66		2.88	
PULL #4	2.23	2.70		2.84	
PULL #5	2.29	2.51		2.83	
TOTAL	11.74	13.06		14.29	
AVERAGE	2.34	2.61		2.85	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.34	3.48		
PULL #2	3.32	3.25		
PULL #3	3.16	3.23		
PULL #4	3.23	3.11		
PULL #5	3.21	3.54		
TOTAL	16.26	16.61		
AVERAGE	3.25	3.32		

	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	4.40	4.30		4.30
PULL #2	4.06	4.26		4.03
PULL #3	4.13	4.30		4.03
PULL #4	4.32	4.22		4.20
PULL #5	4.41	4.26		4.28
TOTAL	21.32	21.34		20.84
AVERAGE	4.26	4.26		4.16

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414387.___0
FILE DATE AND TIME: 12/06/2004 08:38

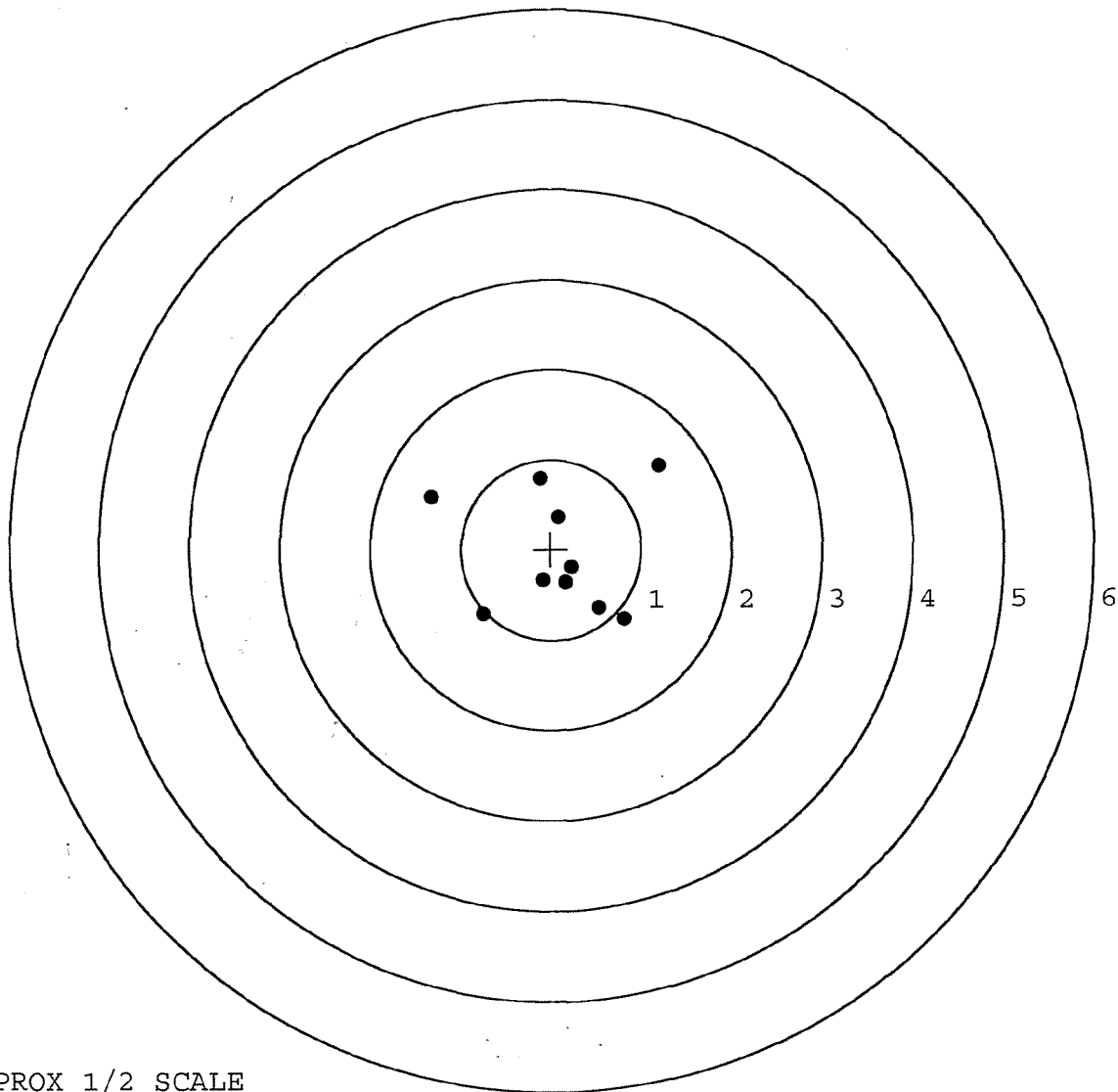
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.006
The Average Y Centroid of the Five Target Set:	-0.179
The Average Point of Impact of the Five Target Set:	0.179
The Average Mean Radius of the Five Target Set:	0.654
The Distance from POA to Centroid Target #1:	0.081
The Distance from Centroid Target #2 to Centroid Target #1:	0.350
The Distance from Centroid Target #3 to Centroid Target #1:	0.147
The Distance from Centroid Target #4 to Centroid Target #1:	0.169
The Distance from Centroid Target #5 to Centroid Target #1:	0.337

SERIAL NUMBER: G6414387: 0
TARGET NUMBER: 1
FILE DATE: 12/06/2004
FILE TIME: 08:38

POINT#	X	Y
1:	0.812	-0.771
2:	0.527	-0.646
3:	1.198	0.928
4:	-0.119	0.791
5:	0.084	0.357
6:	0.233	-0.194
7:	0.162	-0.365
8:	-0.088	-0.340
9:	-0.758	-0.710
10:	-1.326	0.582

X CENTROID: 0.072
Y CENTROID: -0.037
POA TO CENTROID: 0.081
HORZ SPREAD: 2.524
VERT SPREAD: 1.699
GROUP SPREAD: 2.548
MIN RADIUS: 0.225
MAX RADIUS: 1.529
MEAN RADIUS: 0.803
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

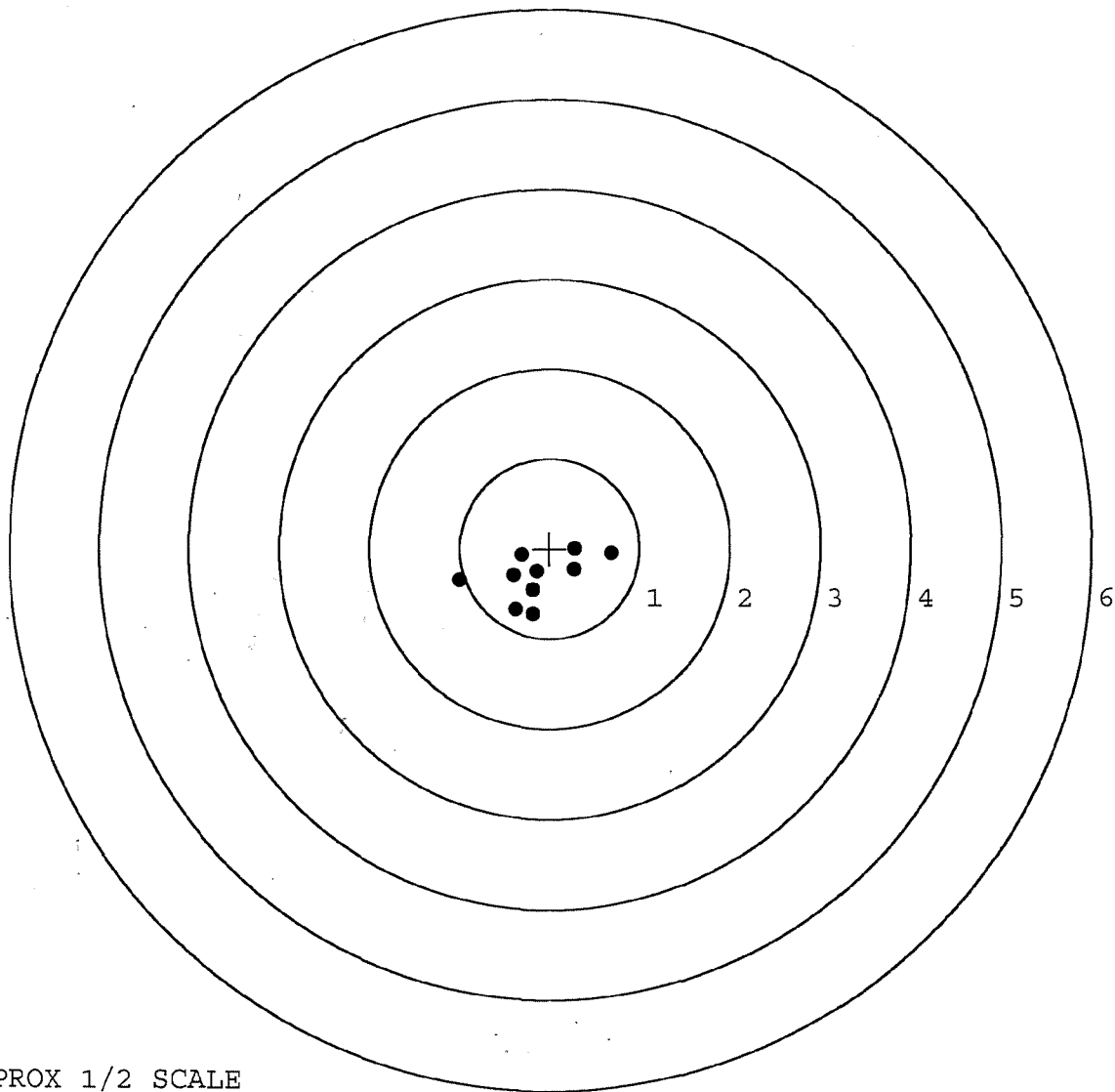


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414387: 0
TARGET NUMBER: 2
FILE DATE: 12/06/2004
FILE TIME: 08:38

X CENTROID: -0.138
Y CENTROID: -0.317
POA TO CENTROID: 0.345
HORZ SPREAD: 1.689
VERT SPREAD: 0.732
GROUP SPREAD: 1.715
MIN RADIUS: 0.061
MAX RADIUS: 0.865
MEAN RADIUS: 0.432
IN 1 IN DIAMETER: 7
IN 2 IN DIAMETER: 10
in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.688	-0.060
2:	0.283	0.002
3:	0.275	-0.238
4:	-1.001	-0.358
5:	-0.309	-0.072
6:	-0.145	-0.256
7:	-0.401	-0.304
8:	-0.193	-0.466
9:	-0.385	-0.685
10:	-0.190	-0.730



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414387: 0

TARGET NUMBER: 3

FILE DATE: 12/06/2004

FILE TIME: 08:38

POINT#	X	Y
--------	---	---

1:	1.208	-0.331
----	-------	--------

2:	0.557	-0.520
----	-------	--------

3:	0.450	0.002
----	-------	-------

4:	0.430	0.488
----	-------	-------

5:	0.732	0.961
----	-------	-------

6:	-0.223	0.084
----	--------	-------

7:	-0.011	0.025
----	--------	-------

8:	-0.615	-0.643
----	--------	--------

9:	-0.124	-0.580
----	--------	--------

10:	-0.279	-0.316
-----	--------	--------

X CENTROID: 0.212

Y CENTROID: -0.083

POA TO CENTROID: 0.228

HORZ SPREAD: 1.823

VERT SPREAD: 1.604

GROUP SPREAD: 2.095

MIN RADIUS: 0.248

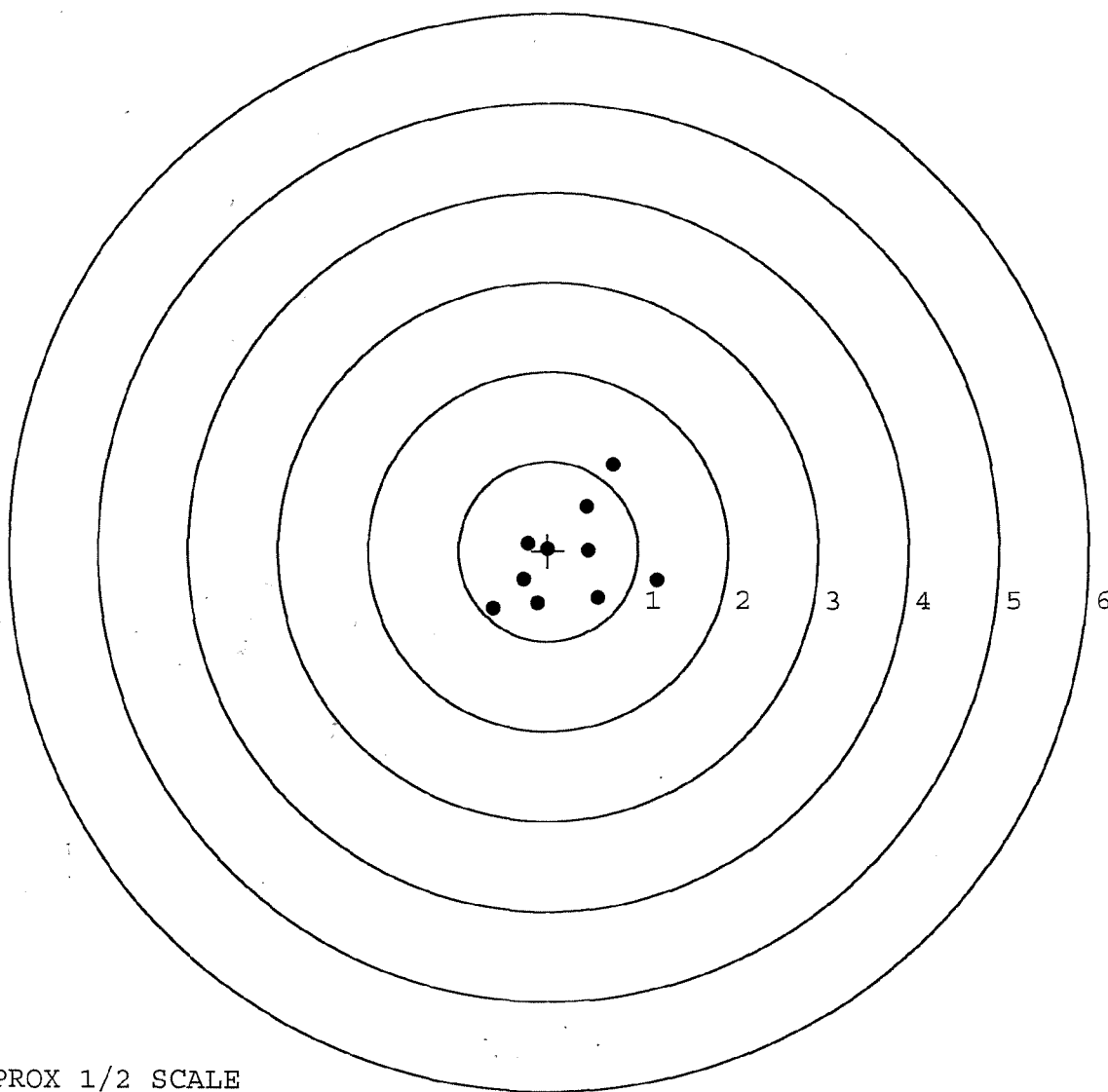
MAX RADIUS: 1.166

MEAN RADIUS: 0.647

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414387: __0

TARGET NUMBER: 4

FILE DATE: 12/06/2004

FILE TIME: 08:38

POINT#	X	Y
--------	---	---

1:	0.794	0.372
----	-------	-------

2:	0.321	0.468
----	-------	-------

3:	0.187	-0.467
----	-------	--------

4:	0.280	0.061
----	-------	-------

5:	-0.475	-0.578
----	--------	--------

6:	-0.687	-0.098
----	--------	--------

7:	-0.664	-1.029
----	--------	--------

8:	-0.107	0.158
----	--------	-------

9:	-0.198	-0.311
----	--------	--------

10:	-0.016	-0.037
-----	--------	--------

X CENTROID: -0.056

Y CENTROID: -0.146

POA TO CENTROID: 0.157

HORZ SPREAD: 1.481

VERT SPREAD: 1.497

GROUP SPREAD: 2.022

MIN RADIUS: 0.116

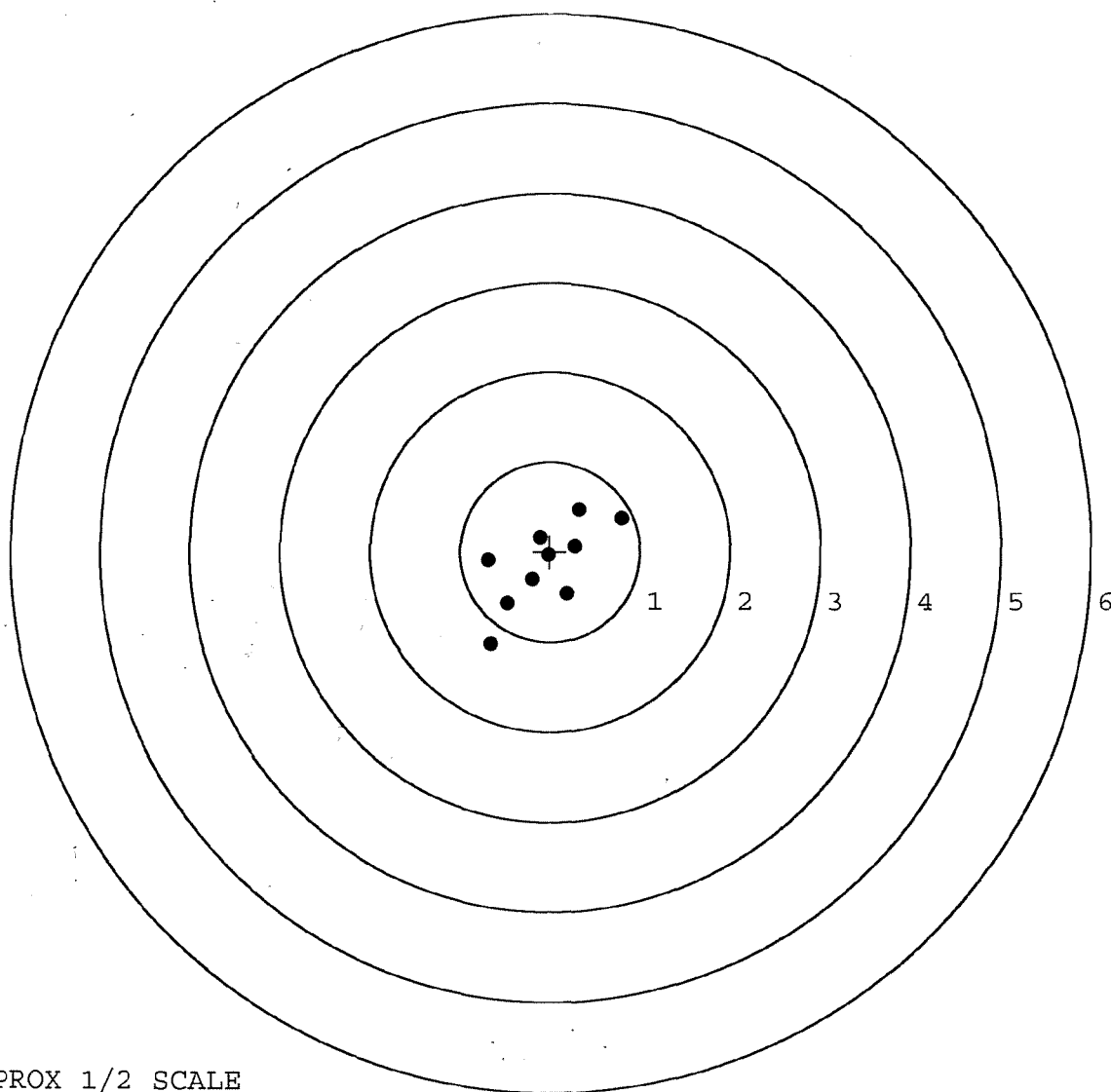
MAX RADIUS: 1.072

MEAN RADIUS: 0.546

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

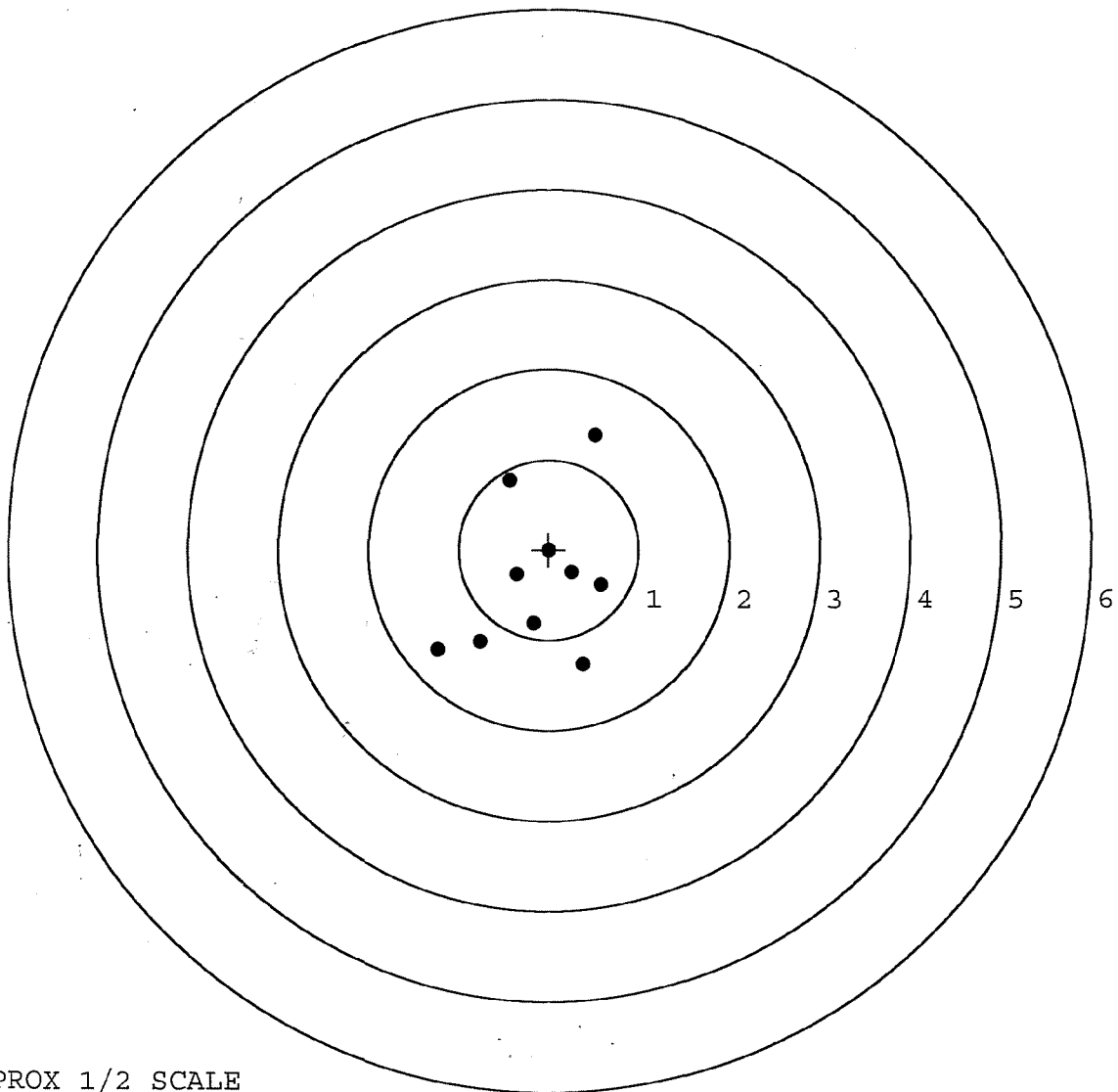


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414387: __0
TARGET NUMBER: 5
FILE DATE: 12/06/2004
FILE TIME: 08:38

X CENTROID: -0.120
Y CENTROID: -0.313
POA TO CENTROID: 0.335
HORZ SPREAD: 1.812
VERT SPREAD: 2.549
GROUP SPREAD: 2.956
MIN RADIUS: 0.236
MAX RADIUS: 1.707
MEAN RADIUS: 0.842
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.386	-1.279
2:	-0.168	-0.823
3:	-0.765	-1.022
4:	-1.232	-1.112
5:	0.580	-0.397
6:	0.258	-0.255
7:	0.519	1.270
8:	-0.428	0.774
9:	0.001	-0.007
10:	-0.354	-0.277



TARGET APPROX 1/2 SCALE