

G6414398

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

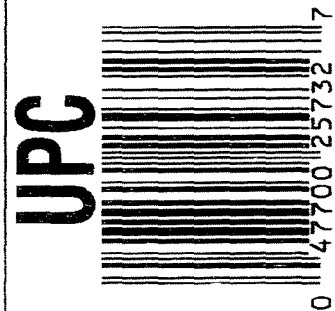


ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6414398



12/10/2004 1:19:29 PM
Original
45
Crib

25732

M/24 7.62 NATO (RIFLE ONLY)



.MA25732

Shop Order: SWS5732 - DEC



.ABSWS5732 - DEC

Start Date: 10/12/2004

Finish Date: 12/17/2004

0540

Flat Black Powder Coat, Barrel and

01PC001



0003544860

0560

Reassemble Action.

89SWS1



0003544861

0690

Pack Rifle

89SWS1



0003544872

0700

Stencil SWS Container

89SWS1



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 66414398

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-29-04	RTZ
600	PROOF		12-29-04	A
607	CHECK HEADSPACE		12-29-04	RTZ
610	DIS-ASSEMBLE GUN		12-30-04	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		12-30-04	RTZ
615	ROLLMARK CALIBER		1-3-05	CW
617	DRILL AND TAP SIGHT HOLES		12-30-04	TRW
620	APPLY COATINGS (BARREL ACTION)		1-14-05	HP
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		1-13-05	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-13-05	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-14-05	RTZ
	D) OIL FIRING PIN ASSEMBLY		1-14-05	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>7.5</u> <u>7.0</u> <u>7.0</u>	1-22-05	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.5</u> <u>2.5</u>	1-22-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1024</u> <u>10225</u> <u>1024</u>	1-22-05	DA
	J) ASSEMBLE STOCK		1-14-05	RT
	K) ASSEMBLE SWIVEL STUDS		1-22-05	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			
640	GALLERY TEST AND TARGET	PASS FAIL	1-18-05	K
	MALFUNCTION <i>Feeds hard</i>	CORRECTION <i>OK</i>	1-18-05	K
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-18-05	K
655	FINAL INSPECTION A) HEADSPACE		1-22-05	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.49</u> <u>2.52</u> <u>2.50</u> <u>2.50</u> <u>2.48</u>	1-22-05	DA
	C) FUNCTION		1-22-05	RT
660	PACK		1-24-05	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 10-27-04

TESTER TRL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.26	2.49		2.70	
PULL #2	2.31	2.62		2.66	
PULL #3	2.37	2.48		2.67	
PULL #4	2.43	2.57		2.63	
PULL #5	2.39	2.52		2.71	
TOTAL	11.76	12.68		13.37	
AVERAGE	2.35	2.53		2.67	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.15	3.34		
PULL #2	3.37	3.54		
PULL #3	3.33	3.57		
PULL #4	3.32	3.31		
PULL #5	3.34	3.44		
TOTAL	16.51	17.20		
AVERAGE	3.30	3.44		

	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	4.21	4.26		4.34
PULL #2	4.41	4.06		4.19
PULL #3	4.48	4.06		4.51
PULL #4	4.37	4.18		4.39
PULL #5	4.53	4.16		4.23
TOTAL	22.00	20.72		21.66
AVERAGE	4.40	4.14		4.33

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414398.___0
FILE DATE AND TIME: 01/18/2005 07:39

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

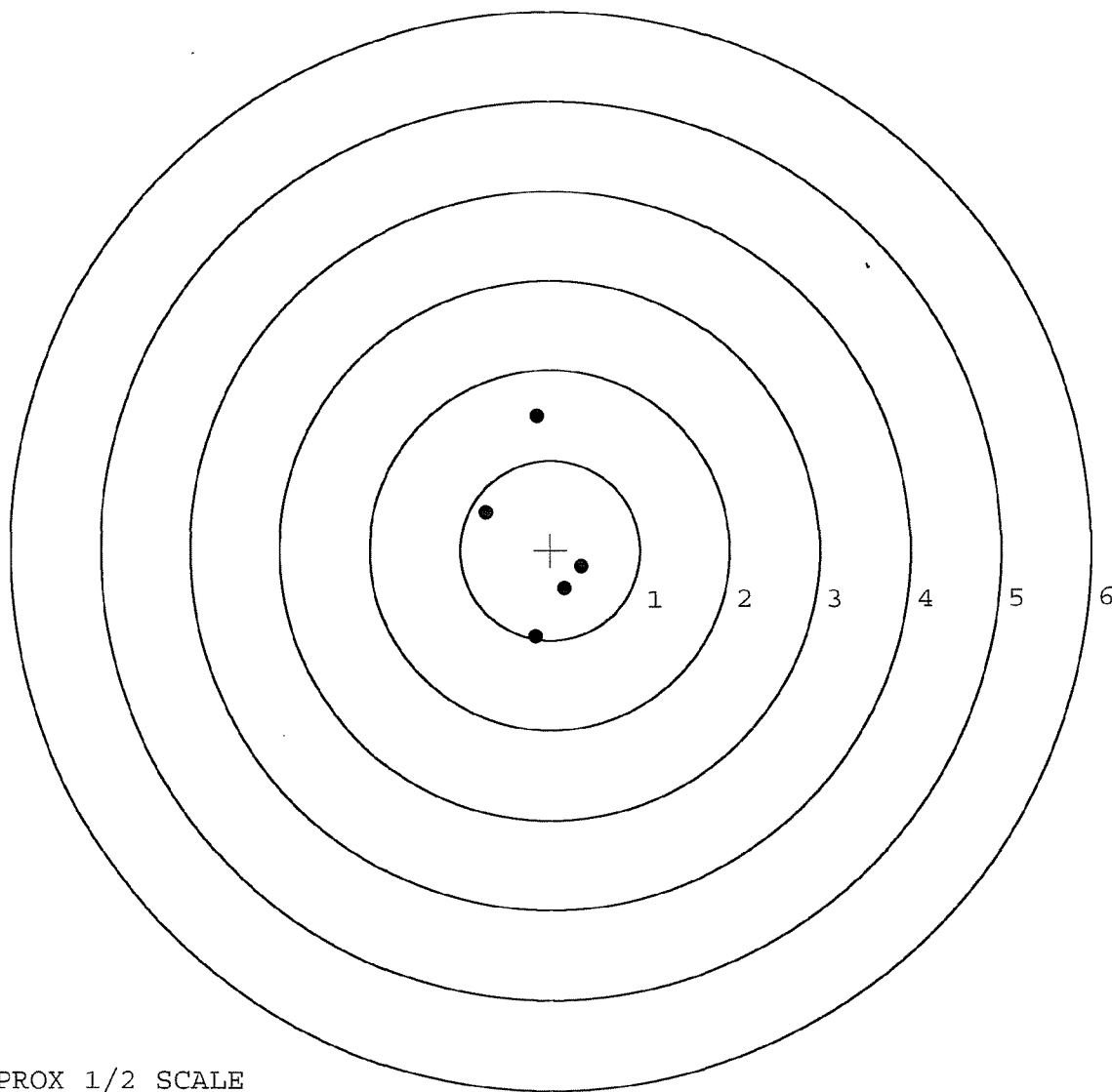
ERROR - NOT POSSIBLE TO REPORT SWS STATS ON DATA
WHERE TOTAL TARGETS ARE NOT EQUAL TO FIVE

AVE. MEAN 920

SERIAL NUMBER: G6414398.___0
TARGET NUMBER: 1
FILE DATE: 01/18/2005
FILE TIME: 07:39

X CENTROID: -0.105
Y CENTROID: 0.068
POA TO CENTROID: 0.125
HORZ SPREAD: 1.058
VERT SPREAD: 2.455
GROUP SPREAD: 2.455
MIN RADIUS: 0.514
MAX RADIUS: 1.424
MEAN RADIUS: 0.847
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 3
in 3 IN DIAMETER: 5

POINT#	X	Y
1:	-0.167	-0.964
2:	0.154	-0.427
3:	0.345	-0.181
4:	-0.713	0.421
5:	-0.145	1.491

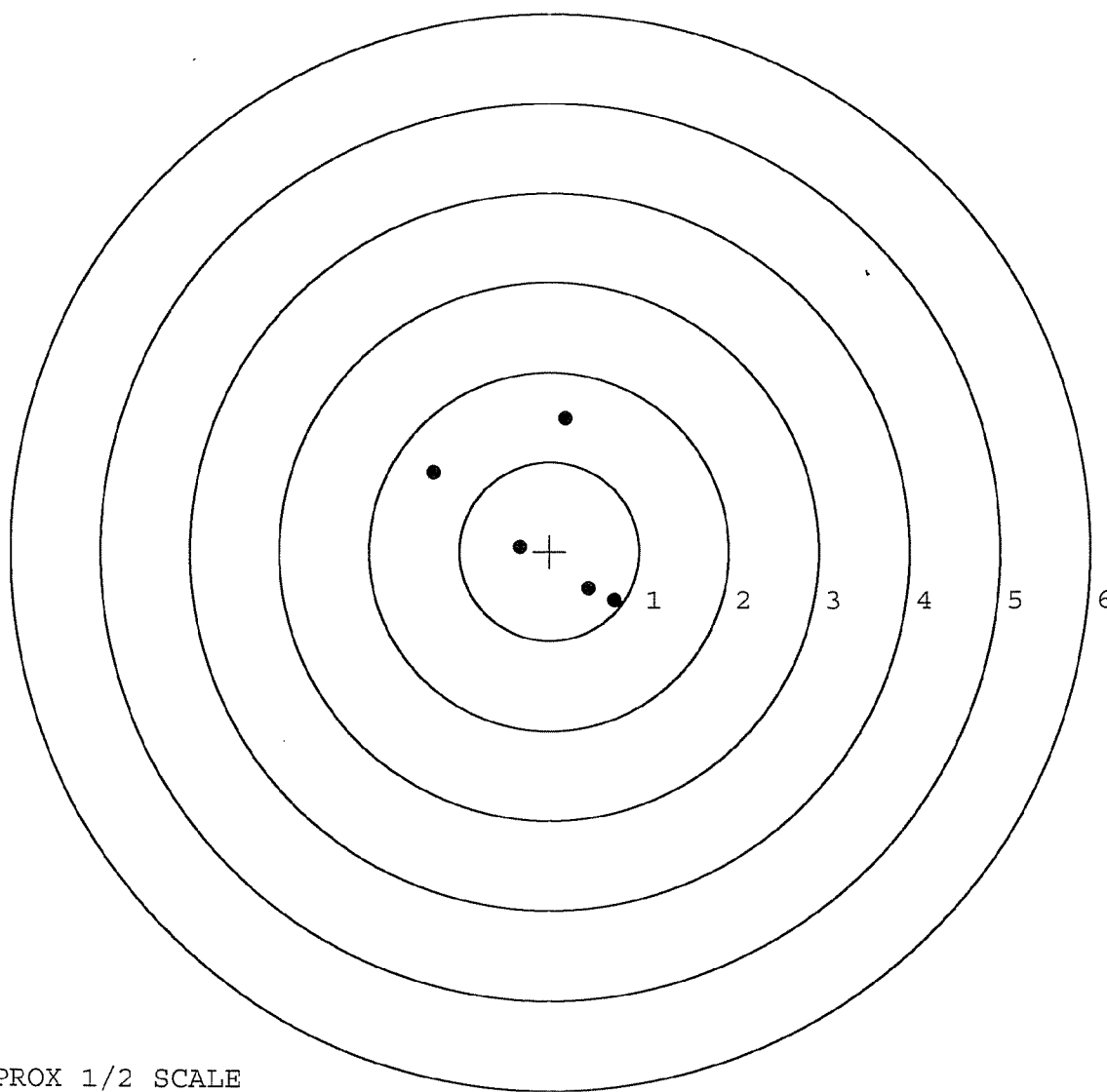


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414398. __0
TARGET NUMBER: 2
FILE DATE: 01/18/2005
FILE TIME: 07:39

POINT#	X	Y
1:	0.178	1.483
2:	-1.293	0.883
3:	-0.329	0.051
4:	0.436	-0.420
5:	0.722	-0.558

X CENTROID: -0.057
Y CENTROID: 0.288
POA TO CENTROID: 0.293
HORZ SPREAD: 2.015
VERT SPREAD: 2.041
GROUP SPREAD: 2.477
MIN RADIUS: 0.360
MAX RADIUS: 1.372
MEAN RADIUS: 0.993
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 2
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE