

G6414399

ORDER 25727
M/24 7.62 NATO S.W.S (SCOPE & SIGHTS)
UPC



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UPC



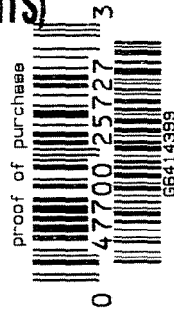
SERIAL NO.



M/24 7.62 NATO S.W.S (SCOPE & SIGHTS)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

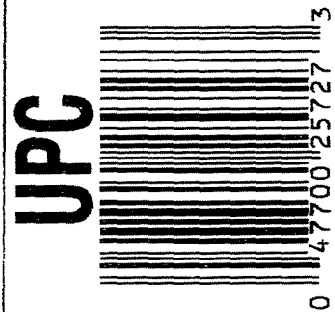
— INSTRUCTION BOOK 3518

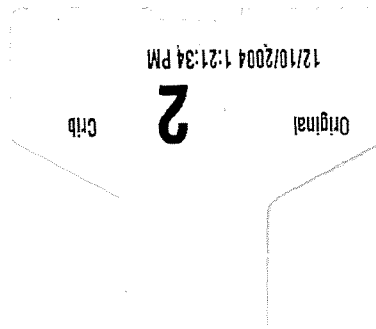
DD FORM 1651



ORDER NO.	25727
BARREL LENGTH	24"
CAPACITY	5

G6414399





25727

M/24 7.62 NATO (RIFLE W/SCOPE&SIGHTS)



.MA25727

Shop Order: SWS667663A



.ABSWS667663A

Start Date: 12/17/2004

Finish Date: 1/12/2005

0540

Flat Black Powder Coat, Barrel and

01PC001



0003592015

0560

Reassemble Action.

89SWS1



0003592016

0690

Pack Rifle

89SWS1



0003592027

0700

Stencil SWS Container

89SWS1



.OP0700

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414399

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	B
617	DRILL AND TAP SIGHT HOLES		10-22-04	TRL
620	APPLY COATINGS (BARREL ACTION)		10/30	H
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-9-04	RTL
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-9-04	RTL
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-9-04	RTL
	D) OIL FIRING PIN ASSEMBLY		11-9-04	RL
	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>6 lbs</u> <u>6 lbs</u> <u>6 lbs</u>	12-15-04	AC
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3 lbs</u> <u>3 lbs</u> <u>3 lbs</u>	12-15-04	AC
	H) TRIGGER PULL TEST AND RETAINABILITY		12-17-04	RTL
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.024</u> <u>.024</u>	12-15-04	AC
	J) ASSEMBLE STOCK		11-9-04	RTL
	K) ASSEMBLE SWIVEL STUDS		12-14-04	RTL
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		12-14-04	RTL
	M) IRON SIGHT ALIGNMENT		12-14-04	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		12-14-04	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	12-14-04	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		12-14-04	TRW
655	FINAL INSPECTION A) HEADSPACE		12-17-04	RTL
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.68</u> <u>2.79</u> <u>2.75</u> <u>2.75</u> <u>2.83</u>	12-17-04	RTL
	C) FUNCTION		12-17-04	RTL
660	PACK		12/17/04	BA

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414399.___0
FILE DATE AND TIME: 12/14/2004 11:32

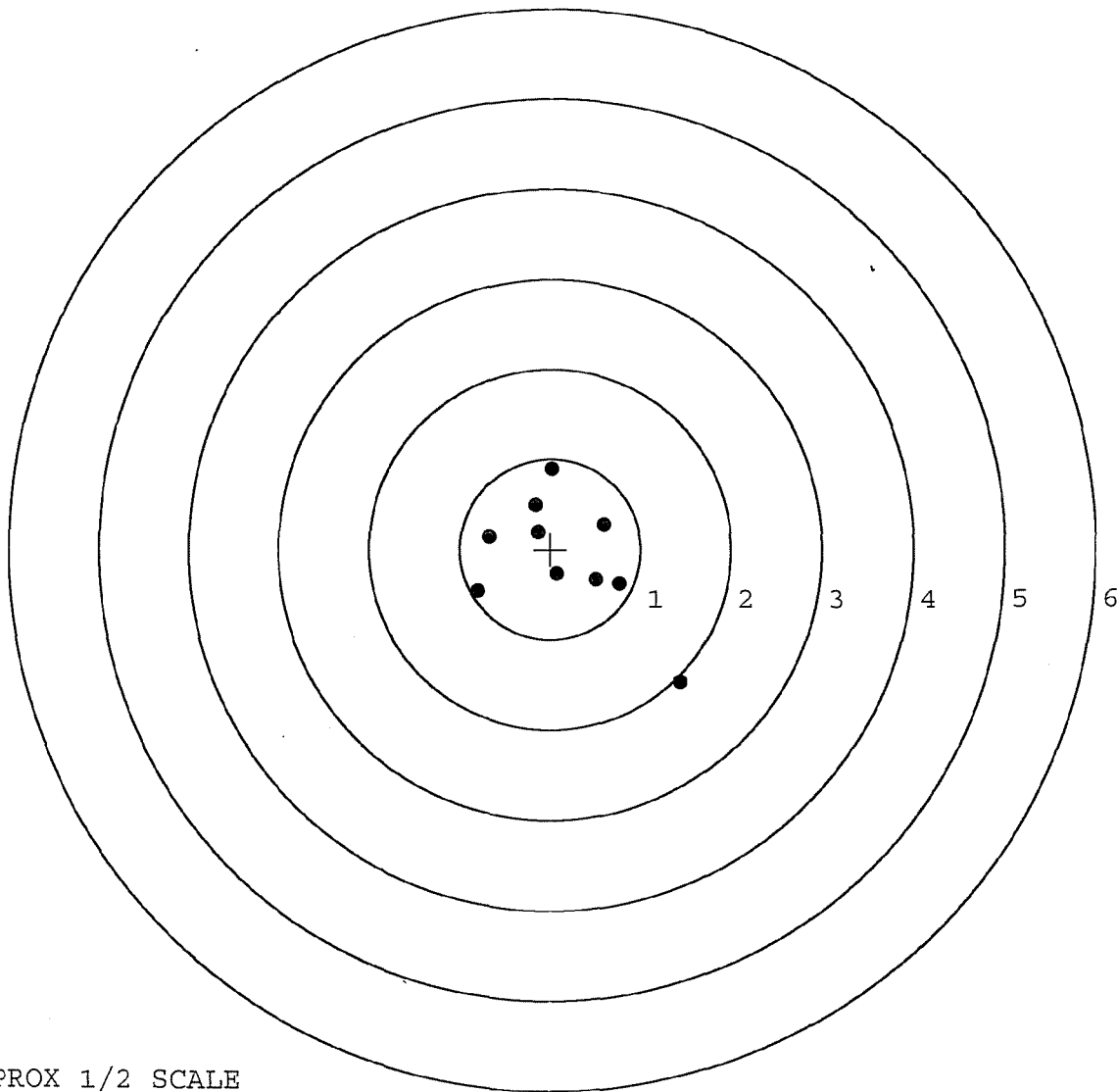
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.148
The Average Y Centroid of the Five Target Set:	-0.023
The Average Point of Impact of the Five Target Set:	0.149
The Average Mean Radius of the Five Target Set:	0.935
The Distance from POA to Centroid Target #1:	0.186
The Distance from Centroid Target #2 to Centroid Target #1:	0.093
The Distance from Centroid Target #3 to Centroid Target #1:	0.299
The Distance from Centroid Target #4 to Centroid Target #1:	0.081
The Distance from Centroid Target #5 to Centroid Target #1:	0.320

SERIAL NUMBER: G6414399. __0
TARGET NUMBER: 1
FILE DATE: 12/14/2004
FILE TIME: 11:32

POINT#	X	Y
1:	1.442	-1.477
2:	0.766	-0.385
3:	0.505	-0.346
4:	0.592	0.278
5:	0.073	-0.276
6:	-0.146	0.193
7:	-0.169	0.492
8:	0.017	0.892
9:	-0.679	0.134
10:	-0.806	-0.470

X CENTROID: 0.160
Y CENTROID: -0.097
POA TO CENTROID: 0.186
HORZ SPREAD: 2.248
VERT SPREAD: 2.369
GROUP SPREAD: 2.765
MIN RADIUS: 0.199
MAX RADIUS: 1.884
MEAN RADIUS: 0.775
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 9

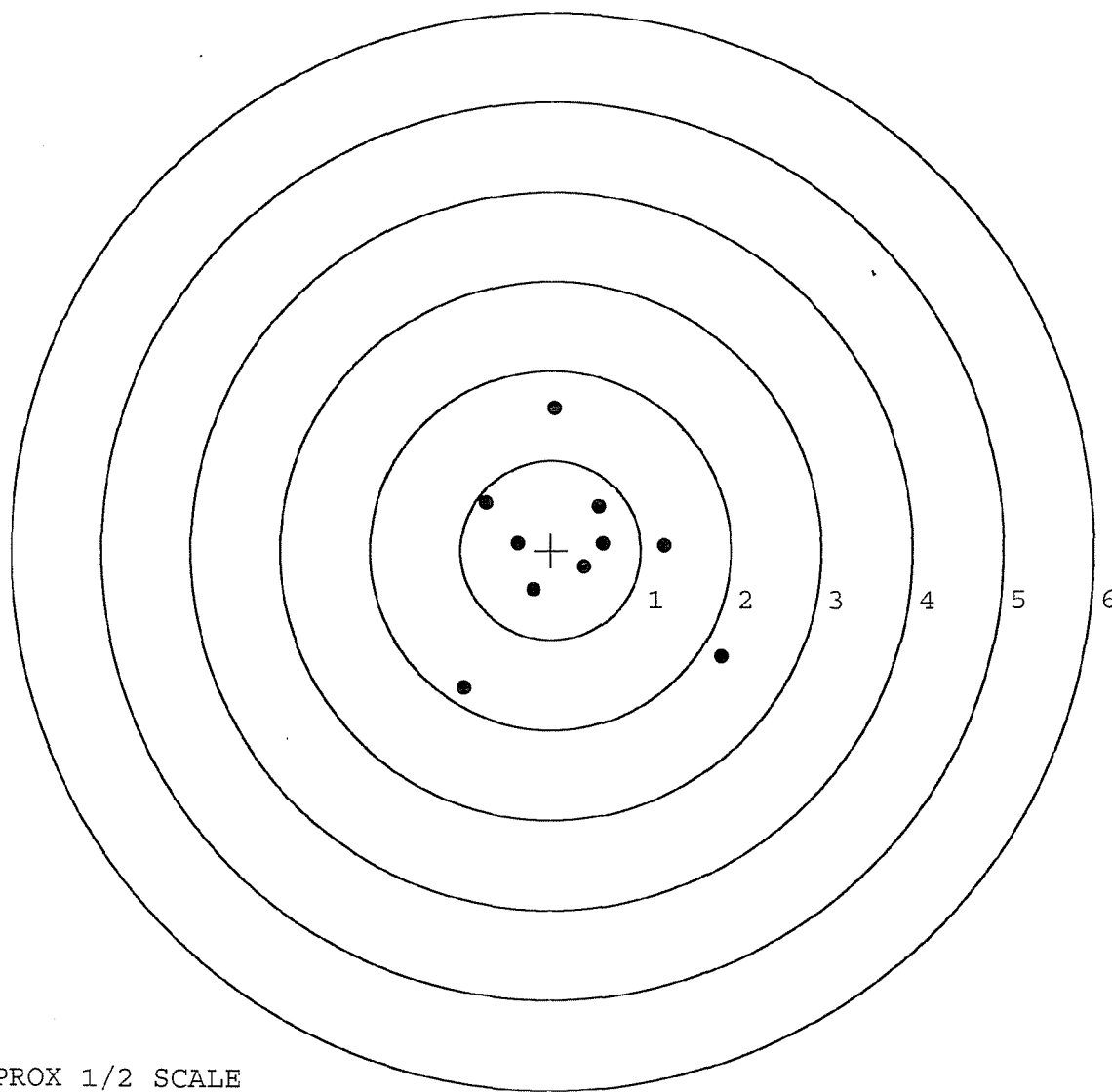


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414399. __0
TARGET NUMBER: 2
FILE DATE: 12/14/2004
FILE TIME: 11:32

POINT#	X	Y
1:	1.897	-1.181
2:	-0.966	-1.546
3:	1.266	0.057
4:	0.368	-0.192
5:	0.533	0.490
6:	-0.373	0.085
7:	-0.198	-0.444
8:	-0.726	0.531
9:	0.585	0.082
10:	0.039	1.582

X CENTROID: 0.242
Y CENTROID: -0.054
POA TO CENTROID: 0.248
HORZ SPREAD: 2.863
VERT SPREAD: 3.128
GROUP SPREAD: 3.330
MIN RADIUS: 0.187
MAX RADIUS: 2.002
MEAN RADIUS: 1.012
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 7

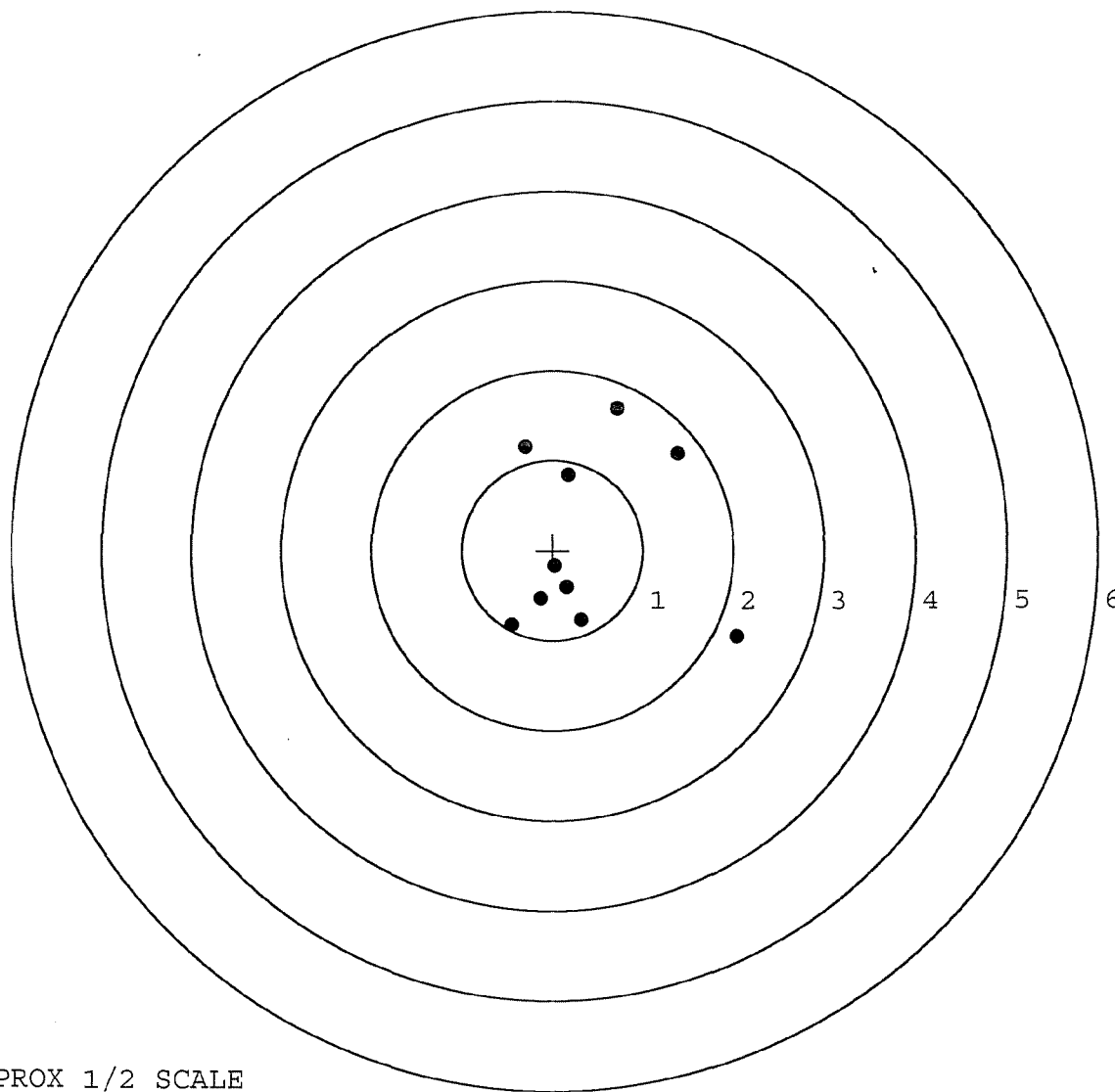


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414399. __0
TARGET NUMBER: 3
FILE DATE: 12/14/2004
FILE TIME: 11:32

POINT#	X	Y
1:	2.037	-0.955
2:	1.382	1.073
3:	0.713	1.579
4:	0.168	0.839
5:	-0.309	1.151
6:	0.023	-0.176
7:	0.155	-0.412
8:	-0.139	-0.539
9:	0.314	-0.779
10:	-0.454	-0.829

X CENTROID: 0.389
Y CENTROID: 0.095
POA TO CENTROID: 0.400
HORZ SPREAD: 2.491
VERT SPREAD: 2.534
GROUP SPREAD: 3.153
MIN RADIUS: 0.456
MAX RADIUS: 1.954
MEAN RADIUS: 1.088
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 5
in 3 IN DIAMETER: 8

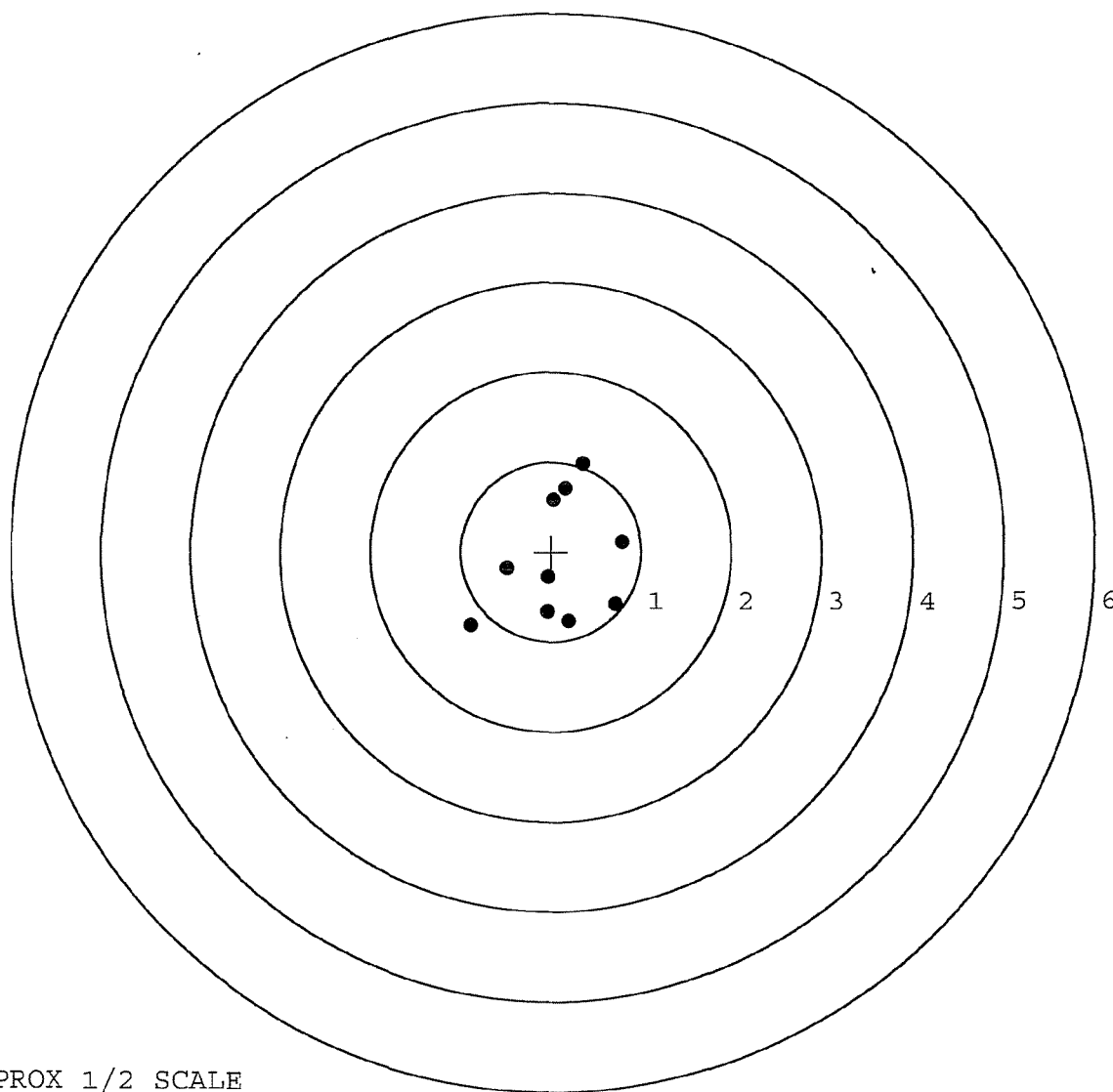


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414399. 0
TARGET NUMBER: 4
FILE DATE: 12/14/2004
FILE TIME: 11:32

POINT#	X	Y
1:	0.717	-0.590
2:	0.789	0.108
3:	0.351	0.982
4:	0.155	0.712
5:	0.026	0.582
6:	-0.487	-0.193
7:	-0.889	-0.826
8:	-0.034	-0.282
9:	-0.040	-0.675
10:	0.200	-0.780

X CENTROID: 0.079
Y CENTROID: -0.096
POA TO CENTROID: 0.124
HORZ SPREAD: 1.678
VERT SPREAD: 1.808
GROUP SPREAD: 2.192
MIN RADIUS: 0.217
MAX RADIUS: 1.212
MEAN RADIUS: 0.744
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 8
in 3 IN DIAMETER: 10

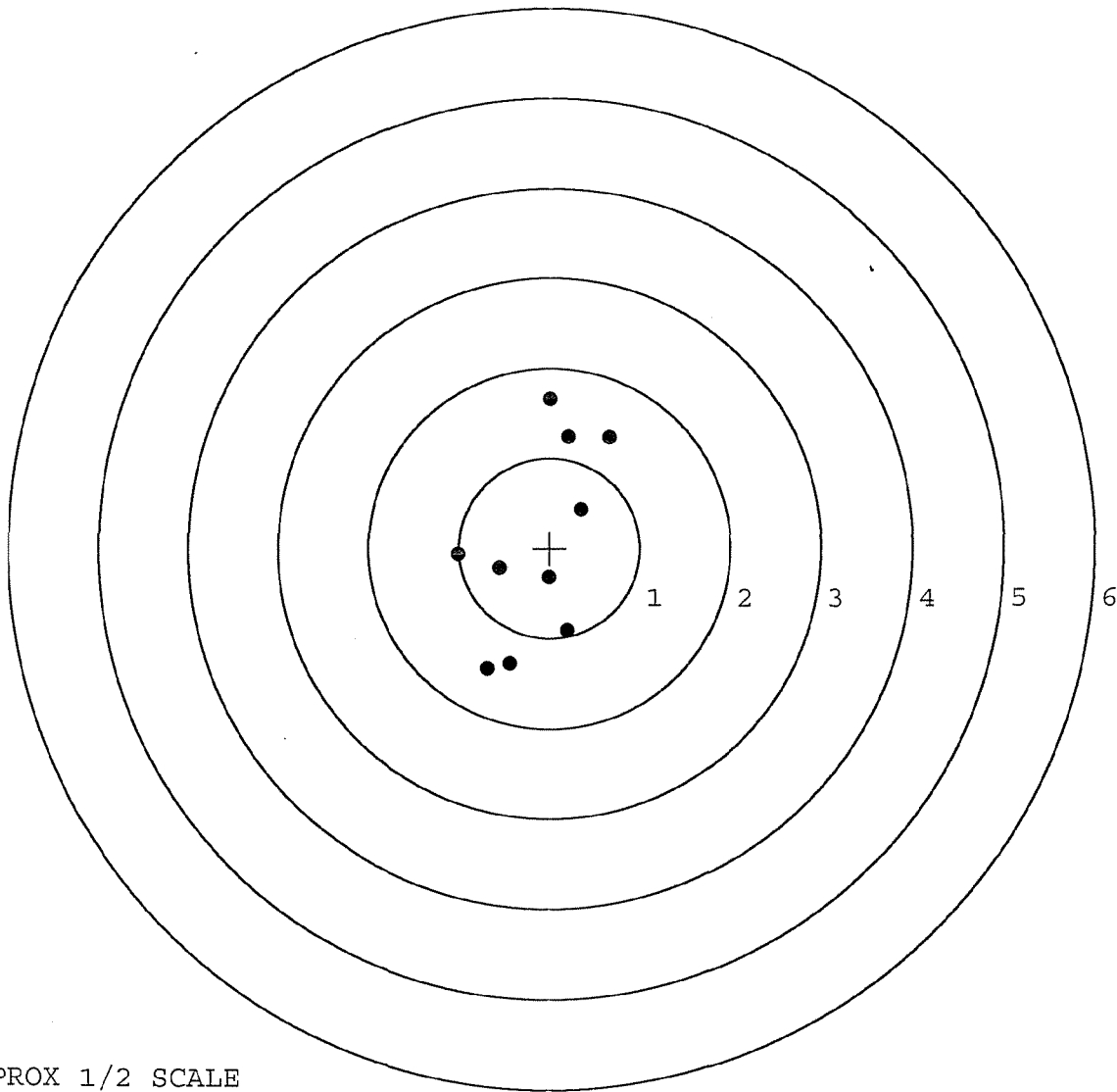


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414399. __0
TARGET NUMBER: 5
FILE DATE: 12/14/2004
FILE TIME: 11:32

POINT#	X	Y
1:	0.195	-0.923
2:	-0.445	-1.285
3:	-0.692	-1.338
4:	-0.008	-0.332
5:	-0.556	-0.226
6:	-1.008	-0.068
7:	0.341	0.427
8:	0.658	1.227
9:	0.202	1.235
10:	0.003	1.658

X CENTROID: -0.131
Y CENTROID: 0.038
POA TO CENTROID: 0.136
HORZ SPREAD: 1.666
VERT SPREAD: 2.996
GROUP SPREAD: 3.076
MIN RADIUS: 0.389
MAX RADIUS: 1.626
MEAN RADIUS: 1.054
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

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 6-22-04

TESTER RW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.73	2.76		2.22	
PULL #2	2.65	2.52		2.32	
PULL #3	2.65	2.67		2.26	
PULL #4	2.67	2.76		2.68	
PULL #5	2.68	2.62		2.38	
TOTAL	13.38	13.33		11.86	
AVERAGE	2.68	2.67		2.37	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.10	3.20		
PULL #2	3.05	3.10		
PULL #3	2.94	3.13		
PULL #4	2.92	3.04		
PULL #5	2.97	3.09		
TOTAL	14.98	15.56		
AVERAGE	3.00	3.11		

	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	4.18	4.08		4.19
PULL #2	4.19	4.19		4.17
PULL #3	4.17	4.16		4.31
PULL #4	4.38	4.07		4.26
PULL #5	4.20	4.17		4.21
TOTAL	21.12	20.67		21.14
AVERAGE	4.22	4.13		4.23