

G-641 4482

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

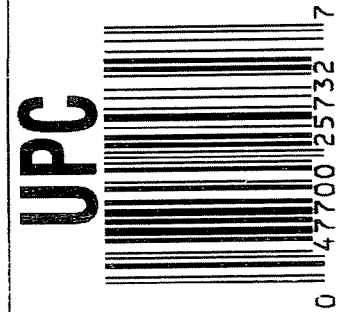


ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6414402



10/27/2004 11:07:03 AM

Chib

3

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 # 66414402

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		12-27-04	RTZ
600	PROOF		12-28-04	RTZ
607	CHECK HEADSPACE		12-28-04	RTZ
610	DIS-ASSEMBLE GUN		12-28-04	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT		12-28-04	RTZ
615	ROLLMARK CALIBER		12/29/04	RTZ
617	DRILL AND TAP SIGHT HOLES		12-28-04	TRC
620	APPLY COATINGS (BARREL ACTION)		1/5/05	RTZ
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-10-05	RTZ
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-10-05	RTZ
	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>55</u> <u>5.5</u> <u>5.9</u>	1-21-05	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>20</u> <u>20</u> <u>2.9</u>	1-21-05	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>1022</u> <u>1022</u> <u>1023</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			
	M) IRON SIGHT ALIGNMENT	N.A.		
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	PASS FAIL	1-19-05	
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		1-19-05	RT
655	FINAL INSPECTION A) HEADSPACE		1-21-05	RT
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>3.77</u> <u>2.89</u> <u>2.89</u> <u>2.56</u> <u>2.76</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 10-22-04

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.46	2.17		2.65	
PULL #2	2.48	2.18		2.72	
PULL #3	2.38	2.24		2.71	
PULL #4	2.08	2.20		2.75	
PULL #5	2.35	2.21		2.77	
TOTAL	11.75	11.00		13.60	
AVERAGE	2.35	2.20		2.72	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.36	3.06		
PULL #2	3.34	3.06		
PULL #3	3.30	3.01		
PULL #4	3.15	2.92		
PULL #5	3.24	3.01		
TOTAL	16.39	15.06		
AVERAGE	3.27	3.01		

	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	4.36	4.17		4.51
PULL #2	4.26	4.19		4.49
PULL #3	4.44	4.15		4.39
PULL #4	4.28	4.11		4.40
PULL #5	4.18	4.12		4.45
TOTAL	21.52	20.74		22.24
AVERAGE	4.30	4.14		4.44

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414402.__0
FILE DATE AND TIME: 01/19/2005 11:42

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

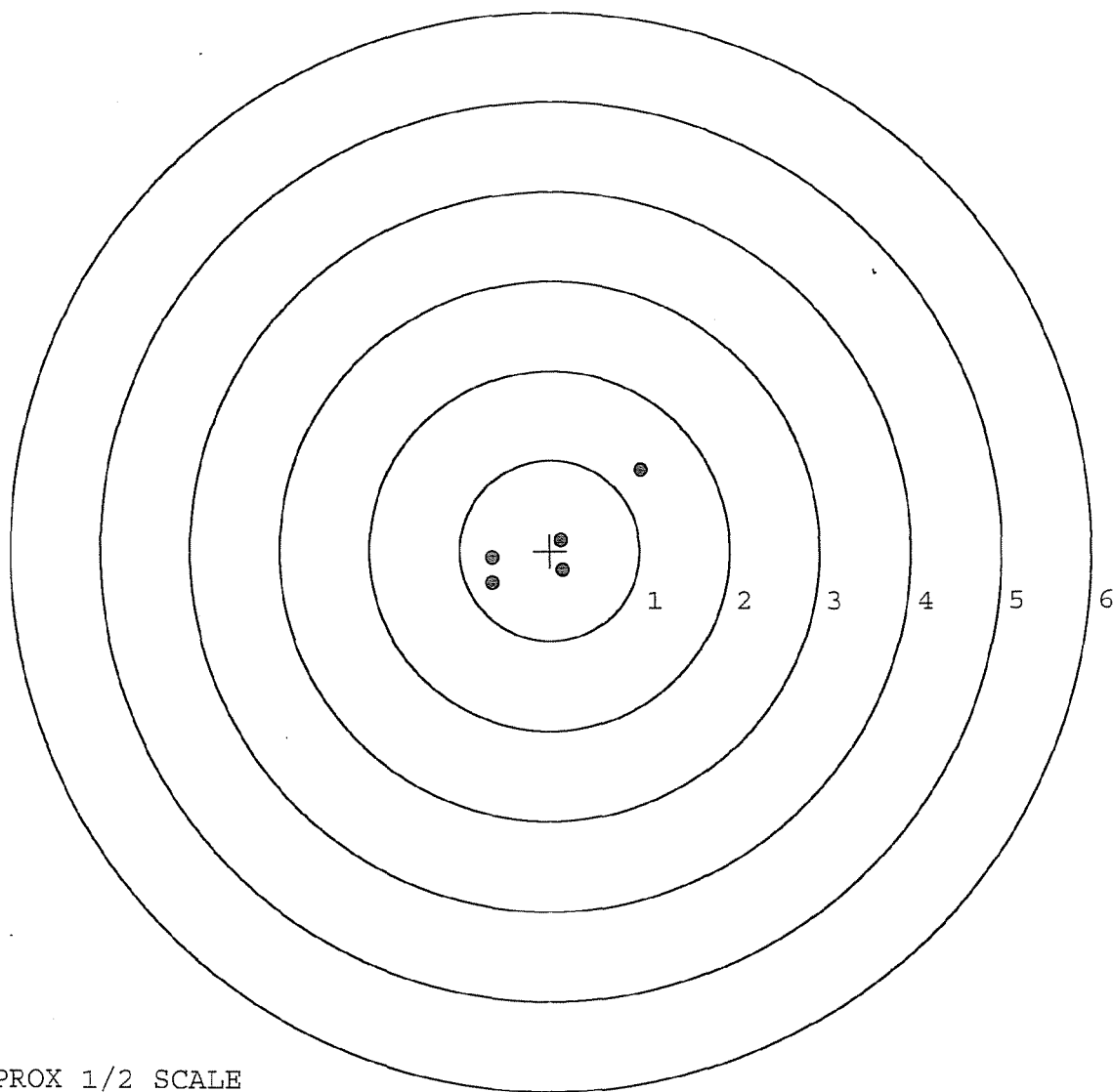
ERROR - NOT POSSIBLE TO REPORT SWS STATS ON DATA
WHERE TOTAL TARGETS ARE NOT EQUAL TO FIVE

AVE. MEAN 6995

SERIAL NUMBER: G6414402. __0
TARGET NUMBER: 1
FILE DATE: 01/19/2005
FILE TIME: 11:42

POINT#	X	Y
1:	1.010	0.888
2:	0.141	-0.217
3:	0.121	0.115
4:	-0.642	-0.082
5:	-0.644	-0.364

X CENTROID: -0.003
Y CENTROID: 0.068
POA TO CENTROID: 0.068
HORZ SPREAD: 1.654
VERT SPREAD: 1.252
GROUP SPREAD: 2.074
MIN RADIUS: 0.132
MAX RADIUS: 1.303
MEAN RADIUS: 0.637
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 5

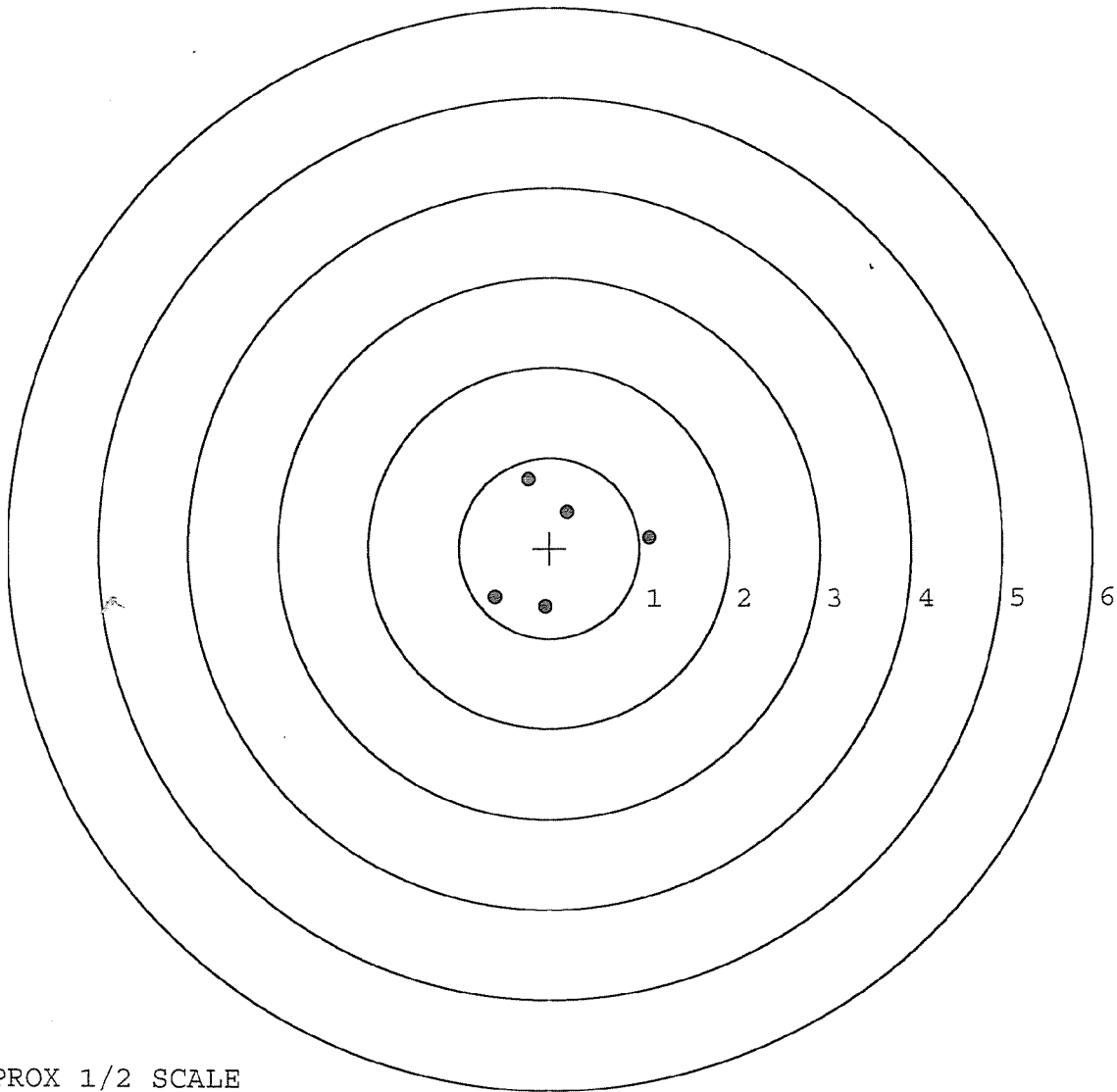


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414402. __0
TARGET NUMBER: 2
FILE DATE: 01/19/2005
FILE TIME: 11:42

POINT#	X	Y
1:	1.108	0.119
2:	0.195	0.402
3:	-0.235	0.764
4:	-0.051	-0.651
5:	-0.604	-0.541

X CENTROID: 0.083
Y CENTROID: 0.019
POA TO CENTROID: 0.085
HORZ SPREAD: 1.712
VERT SPREAD: 1.415
GROUP SPREAD: 1.835
MIN RADIUS: 0.400
MAX RADIUS: 1.030
MEAN RADIUS: 0.762
IN 1 IN DIAMETER: 1
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 5



TARGET APPROX 1/2 SCALE