

G 641 4420

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

- INSTRUCTION BOOK 3518

DD FORM 200348

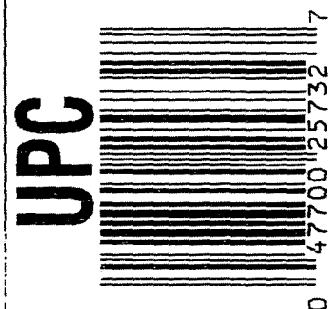


ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6414420



ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



0 47700 25732 7

ORDER 25732

M/24 7.62 NATO (RIFLE ONLY)

UPC



0 47700 25732 7

SERIAL NO.



66414420

10/26/2004 7:48:11 AM

Crib

8

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

INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414420

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-9-04	RTL
600	PROOF		11-9-04	RTL
607	CHECK HEADSPACE	MAGNA - FLUX INSPECTED	11-9-04	RTL
610	DIS-ASSEMBLE GUN	NOV 10 2004	11-10-04	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>BS</u>		
615	ROLLMARK CALIBER		11/11/04	KB
617	DRILL AND TAP SIGHT HOLES		11-10-04	TRW
620	APPLY COATINGS (BARREL ACTION)		11/13	HP
	(BOLT)			
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		11-11-04	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11/19/04	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11/19/04	DA
	D) OIL FIRING PIN ASSEMBLY		12-1-04	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>5.5</u> <u>6.0</u> <u>6.0</u>	12/2/04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	12/2/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.024</u> <u>.024</u>	12/2/04	DA
	J) ASSEMBLE STOCK		12-1-04	RTN
	K) ASSEMBLE SWIVEL STUDS		12-1-04	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	12-1-04	Ac
	MALFUNCTION <i>CH</i>	CORRECTION <i>OK</i>	12-3-04	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		12-1-04	Ac
655	FINAL INSPECTION A) HEADSPACE		12-1-04	Ac
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.42</u> <u>2.42</u> <u>2.40</u> <u>2.45</u> <u>2.47</u>	12/2/04	DA
	C) FUNCTION		12-1-04	Ac
660	PACK		12/8/04	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. _____

DATE 12-1-04

TESTER TRL

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.28	2.64		2.18	
PULL #2	2.27	2.51		2.12	
PULL #3	2.17	2.52		2.17	
PULL #4	2.37	2.48		2.16	
PULL #5	2.38	2.57		2.01	
TOTAL	11.47	12.72		10.64	
AVERAGE	2.29	2.54		2.12	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.41		
PULL #2	3.33	3.31		
PULL #3	3.43	3.33		
PULL #4	3.52	3.27		
PULL #5	3.47	3.28		
TOTAL	16.83	16.60		
AVERAGE	3.36	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	4.19	4.01		4.04
PULL #2	4.04	4.24		4.35
PULL #3	4.21	4.03		4.11
PULL #4	4.16	3.99		4.20
PULL #5	4.07	4.01		4.21
TOTAL	20.67	20.28		20.91
AVERAGE	4.13	4.05		4.18

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414420.__0
FILE DATE AND TIME: 12/01/2004 11:15

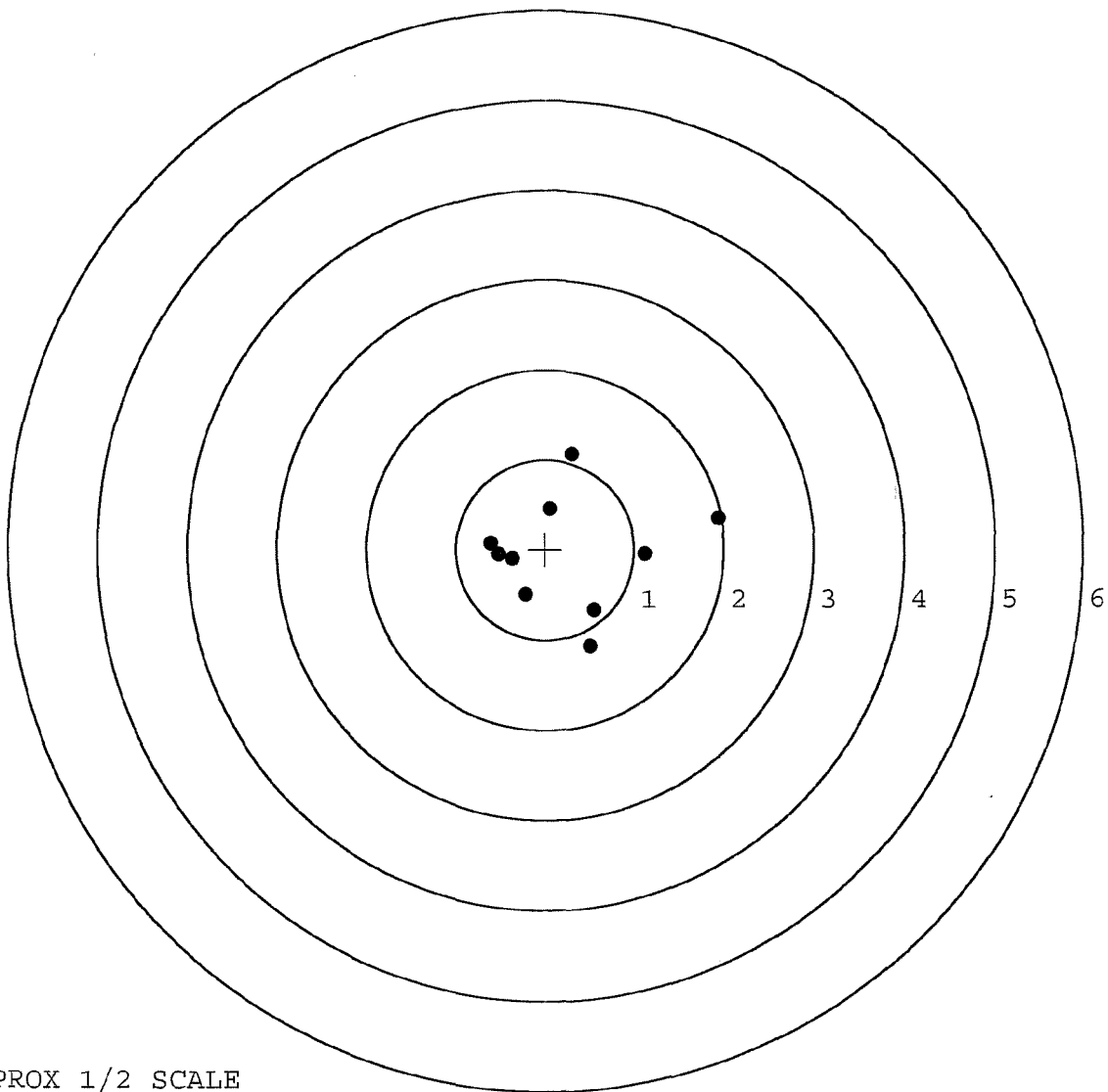
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.145
The Average Y Centroid of the Five Target Set:	-0.017
The Average Point of Impact of the Five Target Set:	0.146
The Average Mean Radius of the Five Target Set:	0.716
The Distance from POA to Centroid Target #1:	0.280
The Distance from Centroid Target #2 to Centroid Target #1:	0.089
The Distance from Centroid Target #3 to Centroid Target #1:	0.292
The Distance from Centroid Target #4 to Centroid Target #1:	0.297
The Distance from Centroid Target #5 to Centroid Target #1:	0.143

SERIAL NUMBER: G6414420. 0
TARGET NUMBER: 1
FILE DATE: 12/01/2004
FILE TIME: 11:15

X CENTROID: 0.275
Y CENTROID: -0.054
POA TO CENTROID: 0.280
HORZ SPREAD: 2.548
VERT SPREAD: 2.133
GROUP SPREAD: 2.562
MIN RADIUS: 0.551
MAX RADIUS: 1.711
MEAN RADIUS: 0.896
IN 1 IN DIAMETER: 0
IN 2 IN DIAMETER: 7
in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.302	1.065
2:	0.052	0.449
3:	1.939	0.343
4:	1.126	-0.059
5:	0.548	-0.672
6:	0.508	-1.068
7:	-0.225	-0.505
8:	-0.371	-0.110
9:	-0.609	0.073
10:	-0.522	-0.060



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414420. __0

TARGET NUMBER: 2

FILE DATE: 12/01/2004

FILE TIME: 11:15

X CENTROID: 0.339

Y CENTROID: 0.008

POA TO CENTROID: 0.339

HORZ SPREAD: 1.838

VERT SPREAD: 2.861

GROUP SPREAD: 2.869

MIN RADIUS: 0.262

MAX RADIUS: 1.618

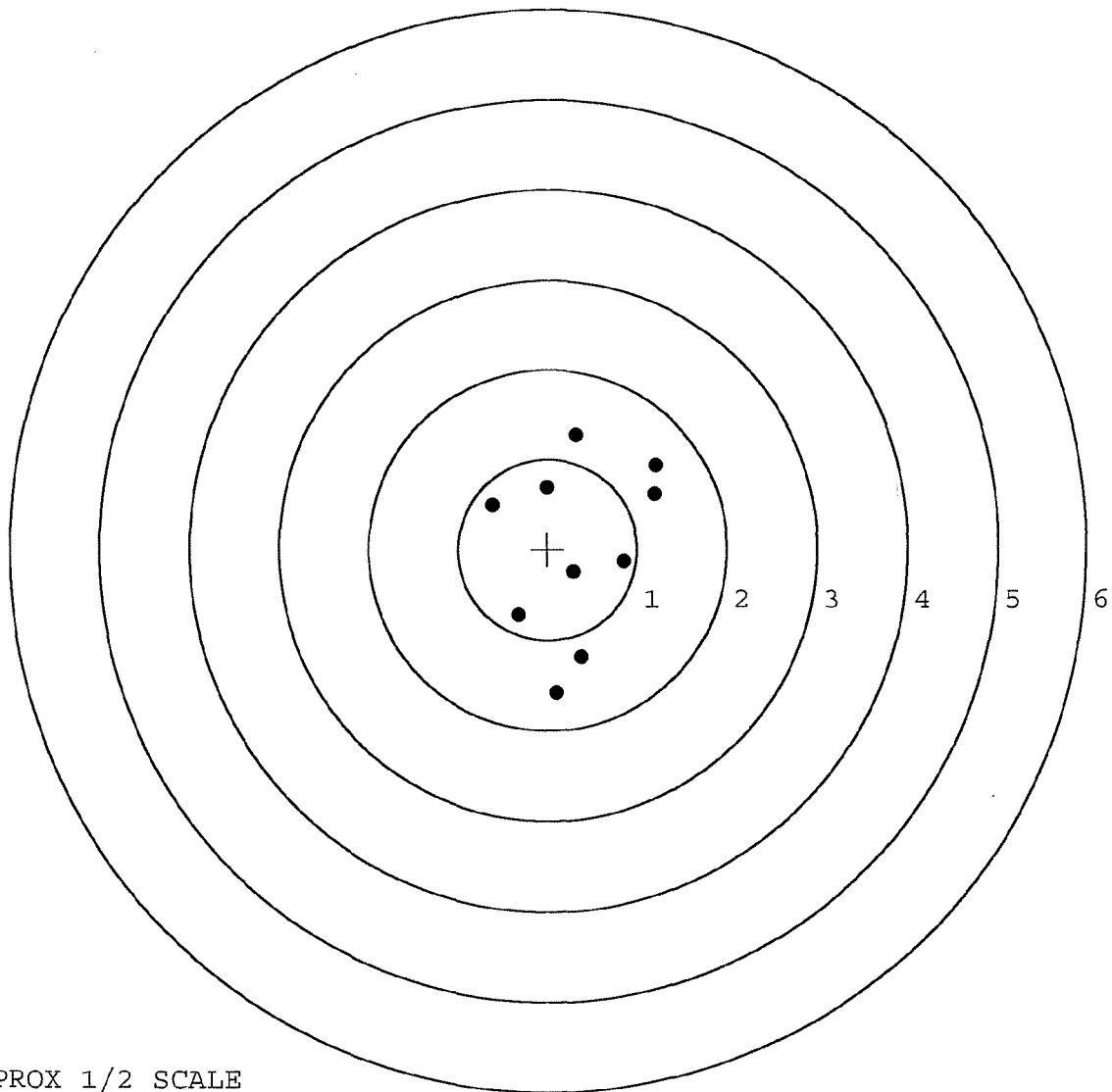
MEAN RADIUS: 1.004

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 4

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.213	0.932
2:	1.197	0.612
3:	0.858	-0.138
4:	0.381	-1.192
5:	0.106	-1.593
6:	-0.332	-0.733
7:	0.291	-0.249
8:	-0.015	0.682
9:	0.314	1.268
10:	-0.625	0.492



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414420. 0

TARGET NUMBER: 3

FILE DATE: 12/01/2004

FILE TIME: 11:15

X CENTROID: -0.014

Y CENTROID: -0.017

POA TO CENTROID: 0.022

HORZ SPREAD: 1.348

VERT SPREAD: 0.923

GROUP SPREAD: 1.364

MIN RADIUS: 0.192

MAX RADIUS: 0.849

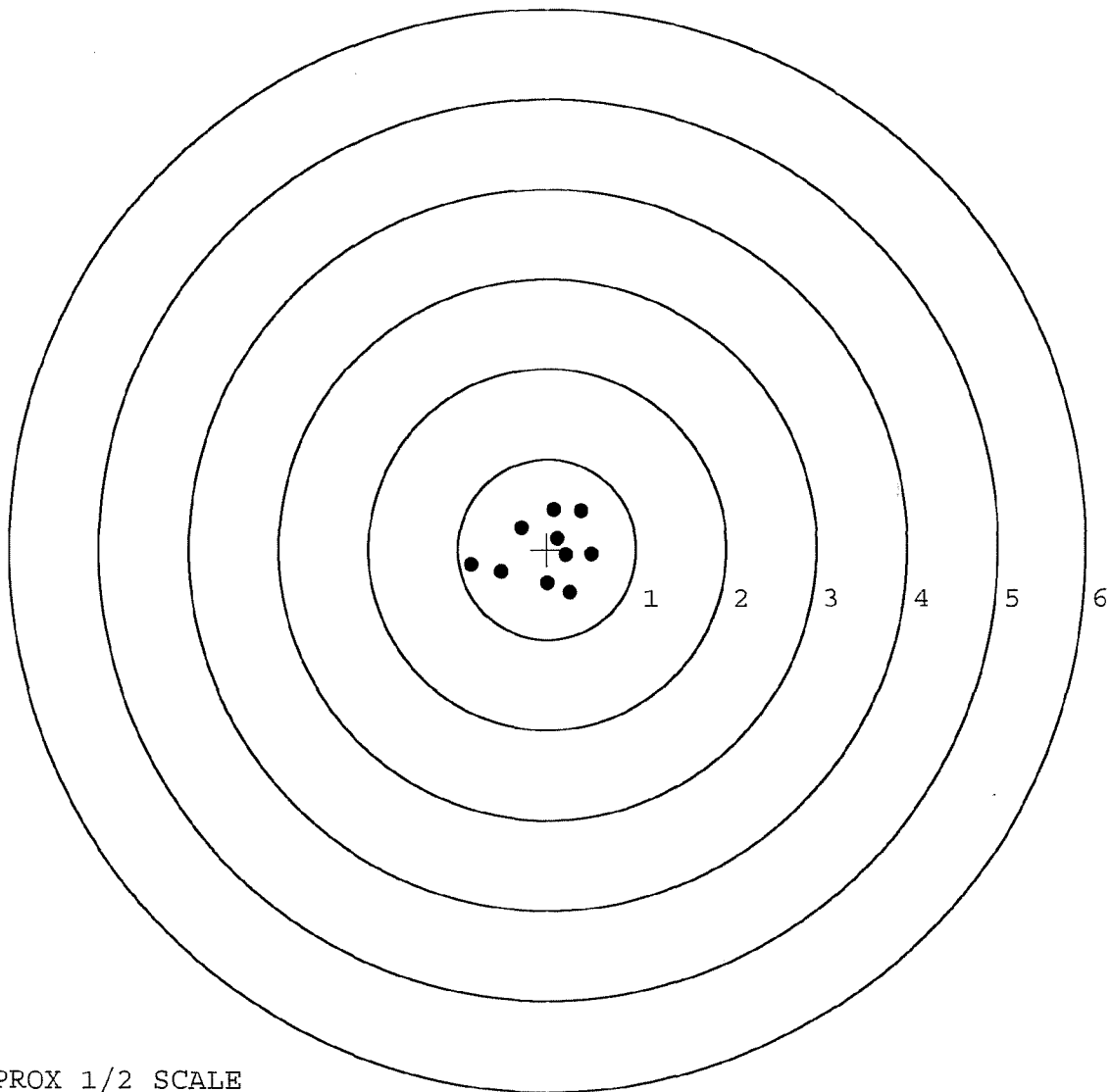
MEAN RADIUS: 0.469

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.849	-0.175
2:	-0.515	-0.255
3:	-0.299	0.244
4:	0.067	0.442
5:	0.374	0.430
6:	0.499	-0.056
7:	0.257	-0.481
8:	-0.005	-0.379
9:	0.115	0.125
10:	0.212	-0.063



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414420. 0

TARGET NUMBER: 4

FILE DATE: 12/01/2004

FILE TIME: 11:15

X CENTROID: -0.008

Y CENTROID: 0.036

POA TO CENTROID: 0.037

HORZ SPREAD: 1.471

VERT SPREAD: 1.552

GROUP SPREAD: 1.868

MIN RADIUS: 0.229

MAX RADIUS: 1.206

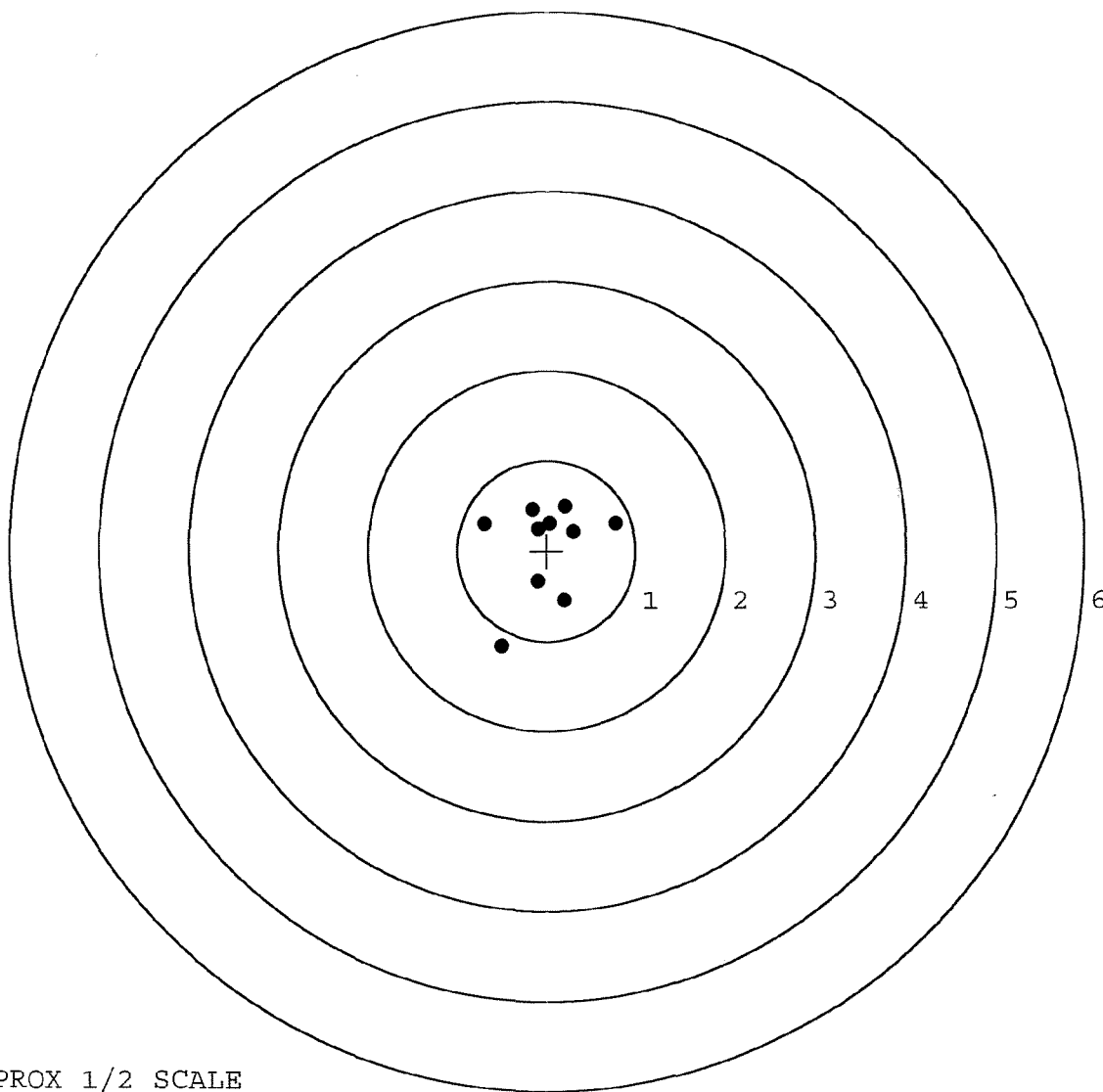
MEAN RADIUS: 0.559

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.767	0.302
2:	-0.105	-0.336
3:	0.196	-0.552
4:	-0.512	-1.060
5:	-0.704	0.295
6:	-0.163	0.457
7:	-0.101	0.245
8:	0.206	0.492
9:	0.304	0.209
10:	0.028	0.305



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414420. 0

TARGET NUMBER: 5

FILE DATE: 12/01/2004

FILE TIME: 11:15

X CENTROID: 0.132

Y CENTROID: -0.059

POA TO CENTROID: 0.144

HORZ SPREAD: 1.688

VERT SPREAD: 1.665

GROUP SPREAD: 1.713

MIN RADIUS: 0.140

MAX RADIUS: 1.091

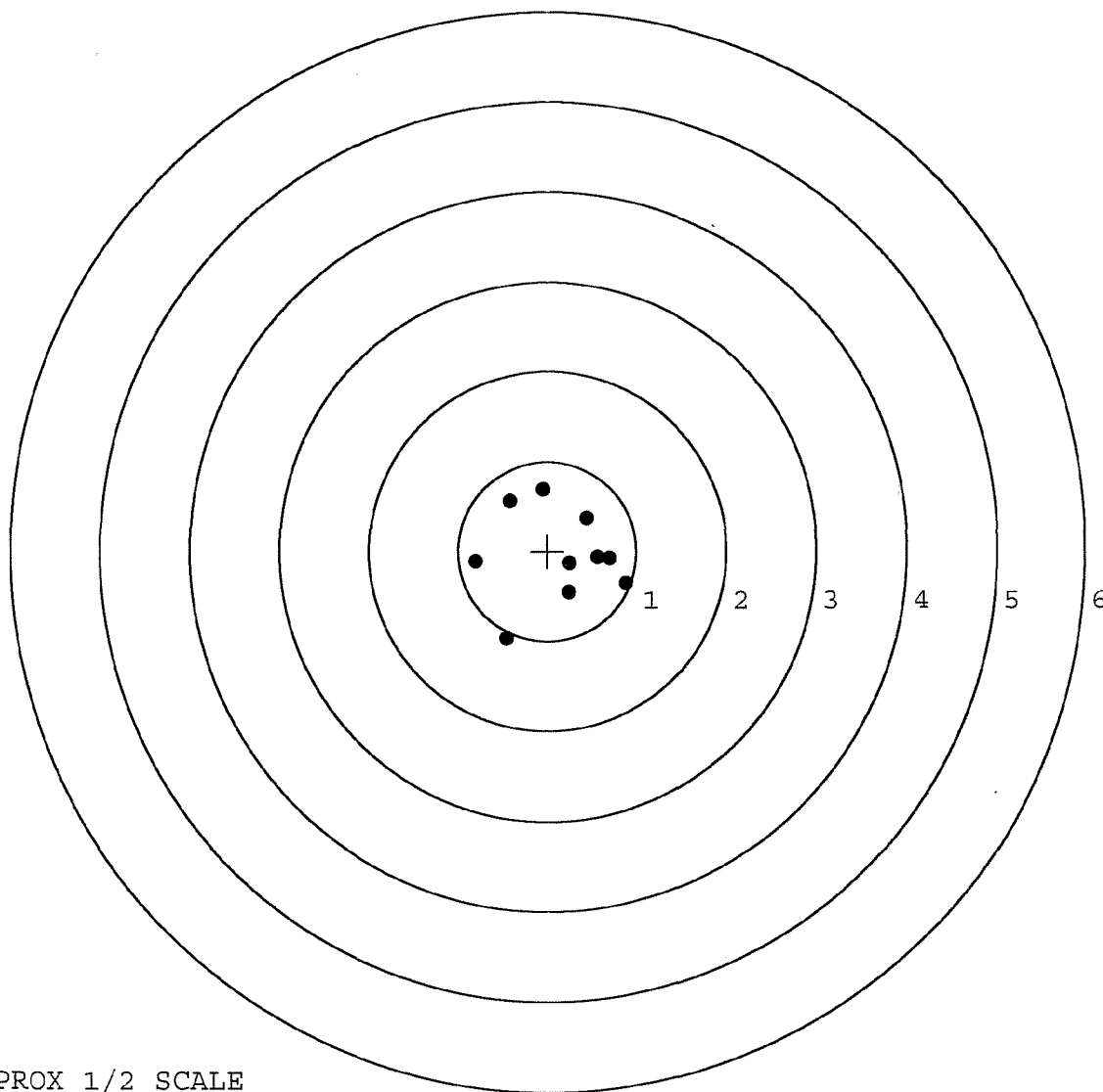
MEAN RADIUS: 0.654

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.433	0.563
2:	-0.059	0.691
3:	0.439	0.367
4:	0.885	-0.366
5:	0.698	-0.084
6:	0.243	-0.464
7:	0.247	-0.138
8:	-0.463	-0.974
9:	-0.803	-0.117
10:	0.563	-0.069



TARGET APPROX 1/2 SCALE