

G6414421

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

— INSTRUCTION BOOK 3518

DD FORM 200348

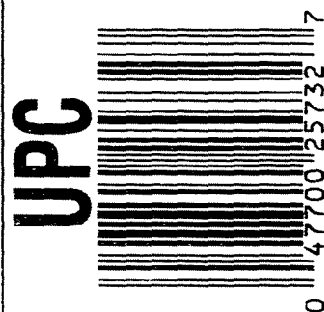


ORDER NO. 25732

BARREL LENGTH 24"

CAPACITY 5

G6414421



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

Original

27

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

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6414421

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>B.S.</u>		
615	ROLLMARK CALIBER		11/11/04	AB
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		11-18-04	AC
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		11-18-04	AC
	C) INSPECT EJECTOR HOLE FOR CHAMFER		11-18-04	AC
	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>6.0</u> <u>6.0</u> <u>6.0</u>	12/3/04	DA
CONT.	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.5</u> <u>2.0</u> <u>2.5</u>	12/3/04	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.023</u> <u>.025</u> <u>.024</u>	12/3/04	DA
	J) ASSEMBLE STOCK		12-1-04	RT
	K) ASSEMBLE SWIVEL STUDS		12-3-04	AC
	L) ATTACH FRONT AND REAR SIGHT ASSY'S			
	M) IRON SIGHT ALIGNMENT			
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER			
640	GALLERY TEST AND TARGET	<u>PASS</u> FAIL	12-2-04	TRW
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
645	INSPECT FOR LIVE AMMO		12-2-04	TRW
655	FINAL INSPECTION A) HEADSPACE		12-3-04	AC
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.48</u> <u>2.35</u> <u>2.37</u> <u>2.39</u> <u>2.49</u>	12/3/04	DA
	C) FUNCTION		12-3-04	AC
660	PACK		12/4/04	DA

AVERAGE PULL FORCE BETWEEN

SERIAL NO. _____

INITIAL & CYCLE TESTS

2.50 LBS (plus or minus 0.50 LBS)

DATE 12-1-04

3.00 LBS (plus or minus 0.75 LBS)

TESTER TRW

4.00 LBS (plus or minus 1.00 LBS)

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.06	2.55		2.39	
PULL #2	2.33	2.70		2.41	
PULL #3	2.27	2.64		2.46	
PULL #4	2.63	2.62		2.37	
PULL #5	2.51	2.60		2.41	
TOTAL	11.80	13.11		12.04	
AVERAGE	2.36	2.62		2.40	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.06	3.07		
PULL #2	3.03	3.08		
PULL #3	3.04	3.05		
PULL #4	3.05	3.08		
PULL #5	3.10	3.06		
TOTAL	15.28	15.34		
AVERAGE	3.05	3.06		

	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	4.25	4.27		4.19
PULL #2	4.34	4.32		4.22
PULL #3	4.20	4.26		4.28
PULL #4	4.40	4.26		4.21
PULL #5	4.47	4.22		4.23
TOTAL	21.66	21.33		21.13
AVERAGE	4.33	4.26		4.22

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6414421.___0
FILE DATE AND TIME: 12/02/2004 08:53

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.044
The Average Y Centroid of the Five Target Set:	-0.058
The Average Point of Impact of the Five Target Set:	0.073
The Average Mean Radius of the Five Target Set:	0.835
The Distance from POA to Centroid Target #1:	0.224
The Distance from Centroid Target #2 to Centroid Target #1:	0.478
The Distance from Centroid Target #3 to Centroid Target #1:	0.096
The Distance from Centroid Target #4 to Centroid Target #1:	0.499
The Distance from Centroid Target #5 to Centroid Target #1:	0.309

SERIAL NUMBER: G6414421. 0

TARGET NUMBER: 1

FILE DATE: 12/02/2004

FILE TIME: 08:53

X CENTROID: 0.083

Y CENTROID: 0.208

POA TO CENTROID: 0.224

HORZ SPREAD: 1.912

VERT SPREAD: 3.478

GROUP SPREAD: 3.637

MIN RADIUS: 0.130

MAX RADIUS: 2.183

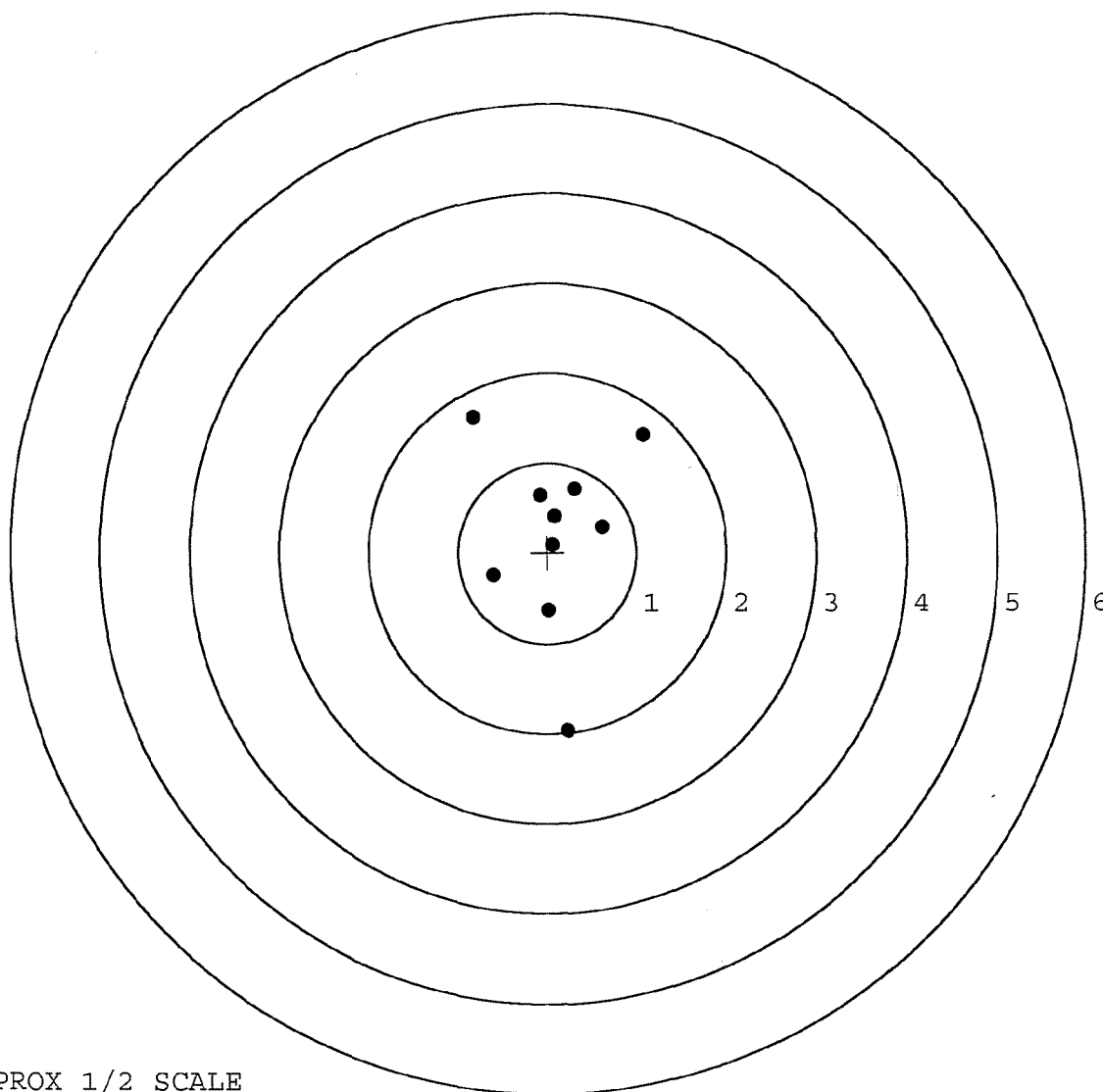
MEAN RADIUS: 0.880

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.078	1.309
2:	0.609	0.291
3:	0.306	0.709
4:	-0.834	1.508
5:	-0.610	-0.247
6:	0.008	-0.634
7:	0.229	-1.970
8:	0.057	0.081
9:	0.078	0.402
10:	-0.090	0.636



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414421. __0

TARGET NUMBER: 2

FILE DATE: 12/02/2004

FILE TIME: 08:53

X CENTROID: -0.020

Y CENTROID: -0.258

POA TO CENTROID: 0.259

HORZ SPREAD: 1.664

VERT SPREAD: 2.460

GROUP SPREAD: 2.456

MIN RADIUS: 0.112

MAX RADIUS: 1.511

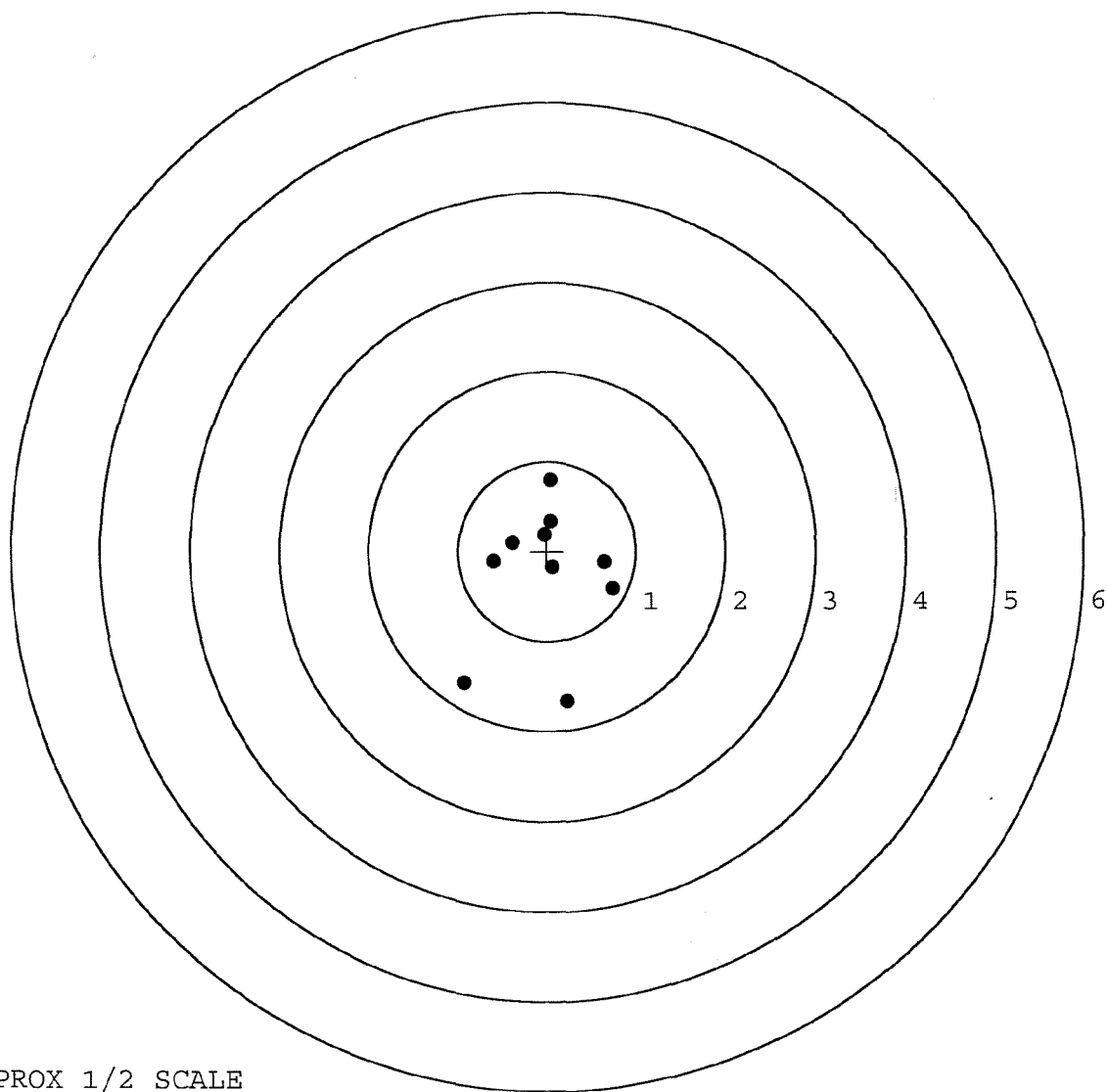
MEAN RADIUS: 0.771

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.736	-0.420
2:	0.646	-0.124
3:	0.065	-0.186
4:	-0.606	-0.118
5:	-0.392	0.094
6:	0.046	0.333
7:	-0.033	0.182
8:	0.037	0.792
9:	0.227	-1.668
10:	-0.928	-1.466



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414421. 0

TARGET NUMBER: 3

FILE DATE: 12/02/2004

FILE TIME: 08:53

X CENTROID: 0.140

Y CENTROID: 0.132

POA TO CENTROID: 0.192

HORZ SPREAD: 2.171

VERT SPREAD: 1.343

GROUP SPREAD: 2.192

MIN RADIUS: 0.277

MAX RADIUS: 1.188

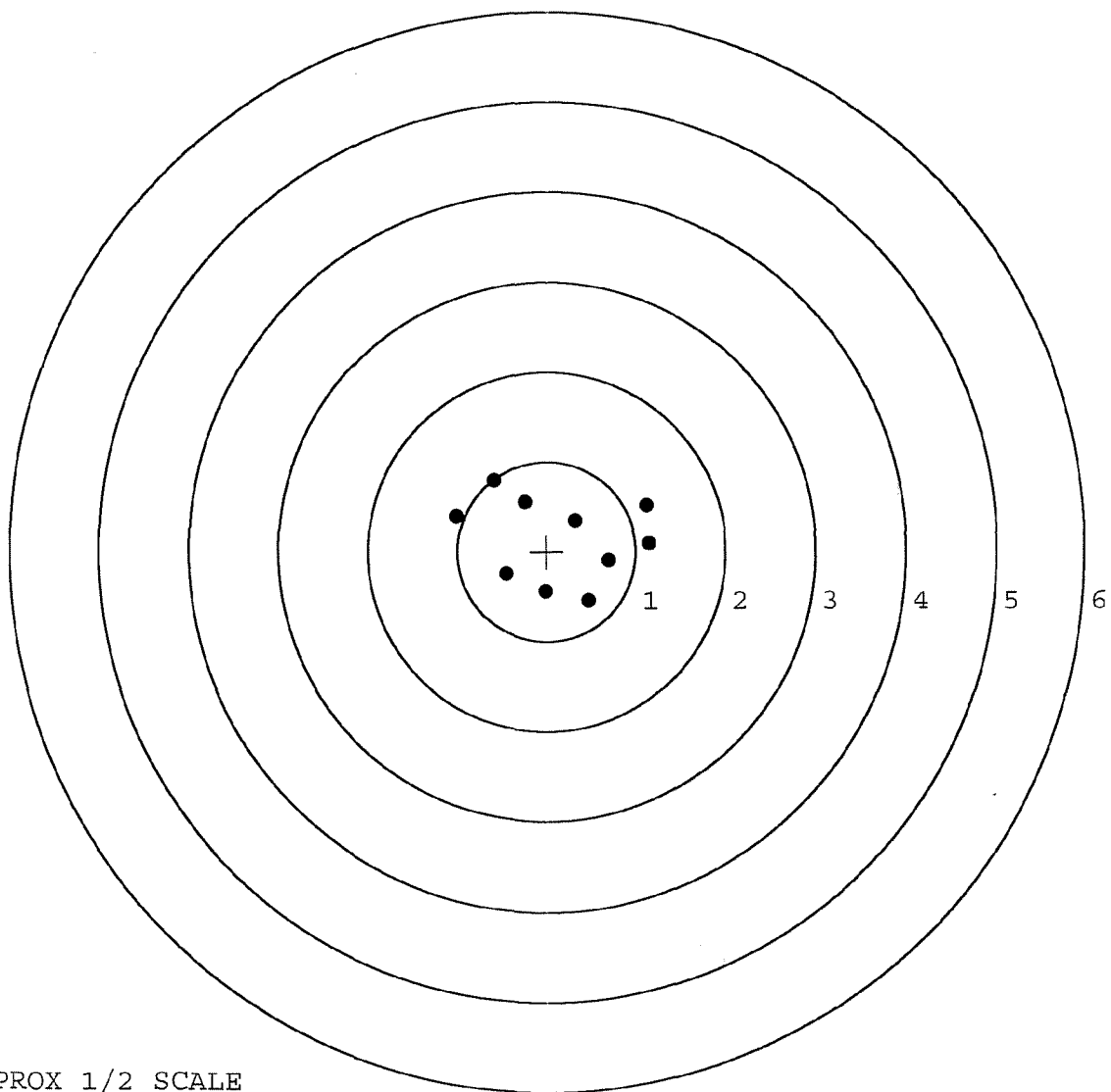
MEAN RADIUS: 0.777

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.152	0.087
2:	1.116	0.512
3:	0.697	-0.106
4:	0.468	-0.553
5:	-0.019	-0.449
6:	0.315	0.346
7:	-0.457	-0.254
8:	-0.251	0.551
9:	-0.600	0.790
10:	-1.019	0.393



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414421. 0

TARGET NUMBER: 4

FILE DATE: 12/02/2004

FILE TIME: 08:53

X CENTROID: -0.047

Y CENTROID: -0.273

POA TO CENTROID: 0.277

HORZ SPREAD: 2.323

VERT SPREAD: 2.681

GROUP SPREAD: 3.053

MIN RADIUS: 0.233

MAX RADIUS: 1.744

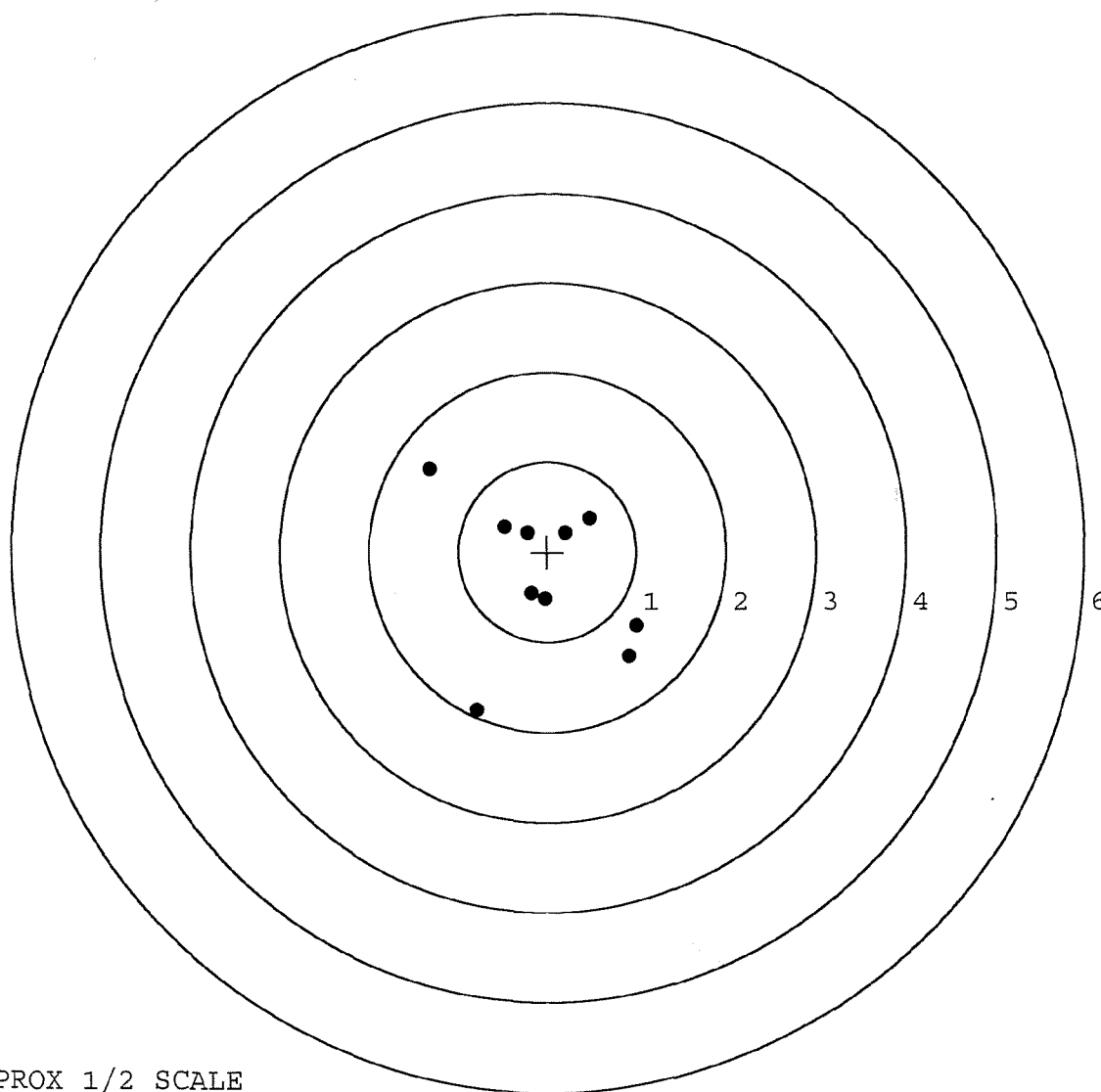
MEAN RADIUS: 0.899

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8

POINT#	X	Y
1:	0.914	-1.162
2:	1.001	-0.823
3:	-0.030	-0.523
4:	-0.183	-0.462
5:	0.469	0.379
6:	0.200	0.216
7:	-0.232	0.215
8:	-0.491	0.276
9:	-1.322	0.917
10:	-0.792	-1.764



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6414421. 0

TARGET NUMBER: 5

FILE DATE: 12/02/2004

FILE TIME: 08:53

X CENTROID: 0.066

Y CENTROID: -0.100

POA TO CENTROID: 0.120

HORZ SPREAD: 2.153

VERT SPREAD: 1.923

GROUP SPREAD: 2.183

MIN RADIUS: 0.235

MAX RADIUS: 1.120

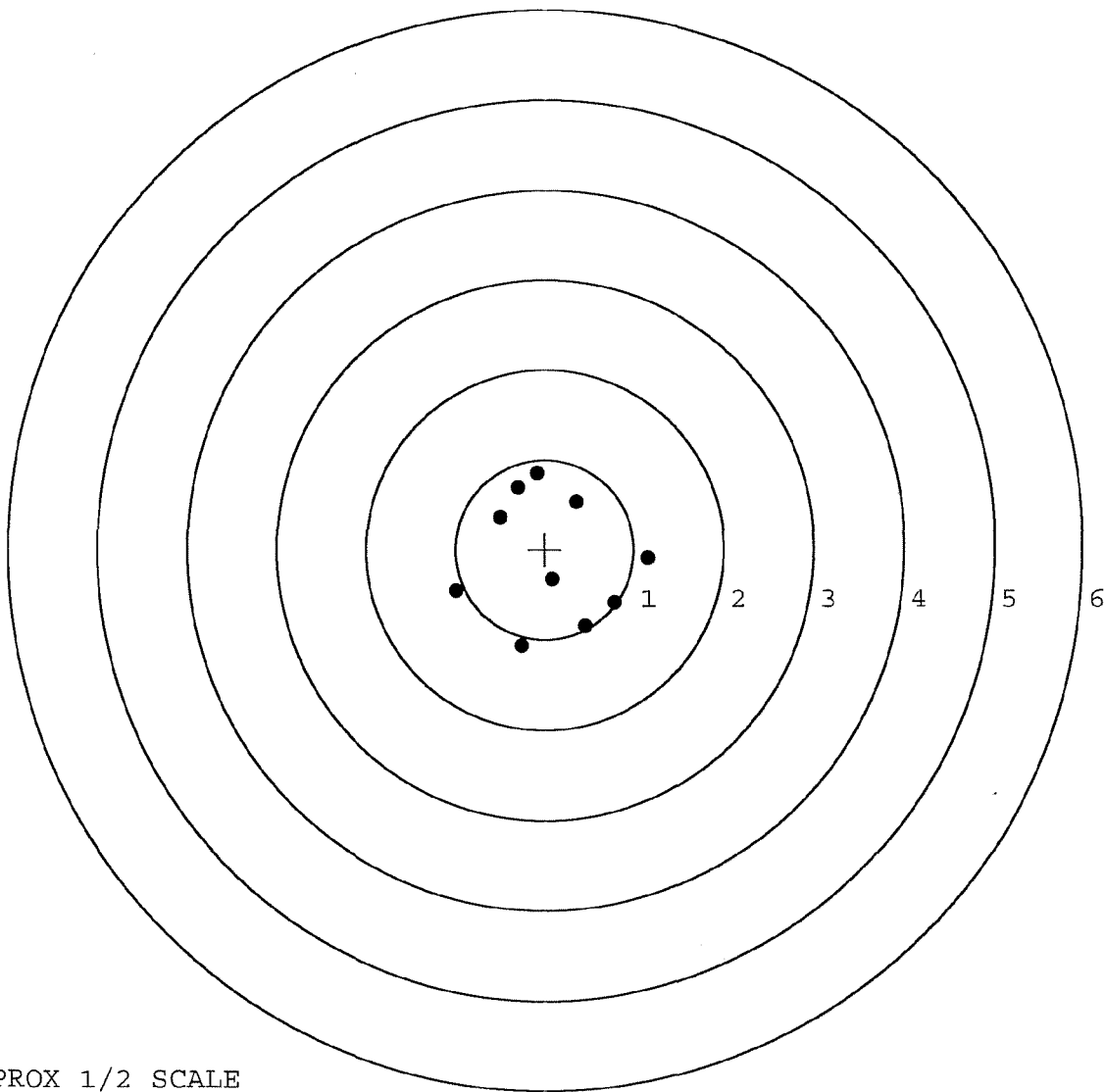
MEAN RADIUS: 0.846

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.459	-0.857
2:	0.781	-0.594
3:	1.159	-0.103
4:	0.086	-0.334
5:	-0.265	-1.074
6:	-0.994	-0.462
7:	-0.507	0.358
8:	0.349	0.527
9:	-0.098	0.849
10:	-0.312	0.690



TARGET APPROX 1/2 SCALE