

6628 5920

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6285920

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-18-02	RL
600	PROOF		11-18-02	A
607	CHECK HEADSPACE		11-18-02	A
610	DIS-ASSEMBLE GUN		12-2-02	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	RL		
615	ROLLMARK CALIBER		12-6-02	B
617	DRILL AND TAP SIGHT HOLES		12-3-02	TRW
620	APPLY COATINGS (BARREL ACTION)		12-17	TH
	(BOLT)		12-17	TH
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-10-03	WTA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-10-03	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-10-03	DA
	D) OIL FIRING PIN ASSEMBLY		1-10-03	DA
	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>9.5</u> <u>9</u> <u>9</u>	3-28-03	RW
CONT.					
	G) SAFETY OFF FORCE	2 LBS MIN	<u>3</u> <u>3</u> <u>3</u>	3-28-03	RW
	H) TRIGGER PULL TEST AND RETAINABILITY				
	I) FIRING PIN INDENT	.020 MIN	<u>.0215</u> <u>.021</u> <u>.0215</u>	3-28-03	RW
	J) ASSEMBLE STOCK			3-27-03	RW
	K) ASSEMBLE SWIVEL STUDS			3-28-03	RW
	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		PASS FAIL	3-28-03	A
	MALFUNCTION		CORRECTION	3-28-03	A
	MALFUNCTION		CORRECTION	3-28-03	A
	MALFUNCTION		CORRECTION	3-28-03	A
	MALFUNCTION		CORRECTION	3-28-03	A
645	INSPECT FOR LIVE AMMO			3-28-03	A
655	FINAL INSPECTION A) HEADSPACE			3-28-03	RW
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.83</u> <u>2.83</u> <u>2.71</u> <u>2.76</u> <u>2.73</u>	3-29-03	RW
	C) FUNCTION			3-28-03	RW
660	PACK			4/2/03	DA

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS
2.50# ± .50#
3.00# ± .75#
4.00# ± 1.00#

SERIAL NO.
DATE 12-17-02
TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.56		2.29	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT ABLE LESS THAN
PULL #2	2.27	2.52		2.21	
PULL #3	2.19	2.24		2.17	
PULL #4	2.18	2.10		2.22	
PULL #5	2.17	2.32		2.23	
TOTAL	11.09	11.74		11.12	
AVG.	2.21	2.34		2.22	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.33	3.25		
PULL #2	3.29	3.41		
PULL #3	3.17	3.34		
PULL #4	3.26	3.28		
PULL #5	3.04	3.33		
TOTAL	16.09	16.61		
AVG.	3.21	3.32		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# TARGET & ACCU
PULL #1	4.11	4.27		4.28
PULL #2	4.04	4.24		4.17
PULL #3	4.02	4.22		4.14
PULL #4	4.19	4.08		4.13
PULL #5	4.04	4.12		4.20
TOTAL	20.40	20.93		20.92
AVG.	4.08	4.18		4.18

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6285920.___0
FILE DATE AND TIME: 03/29/2003 05:05

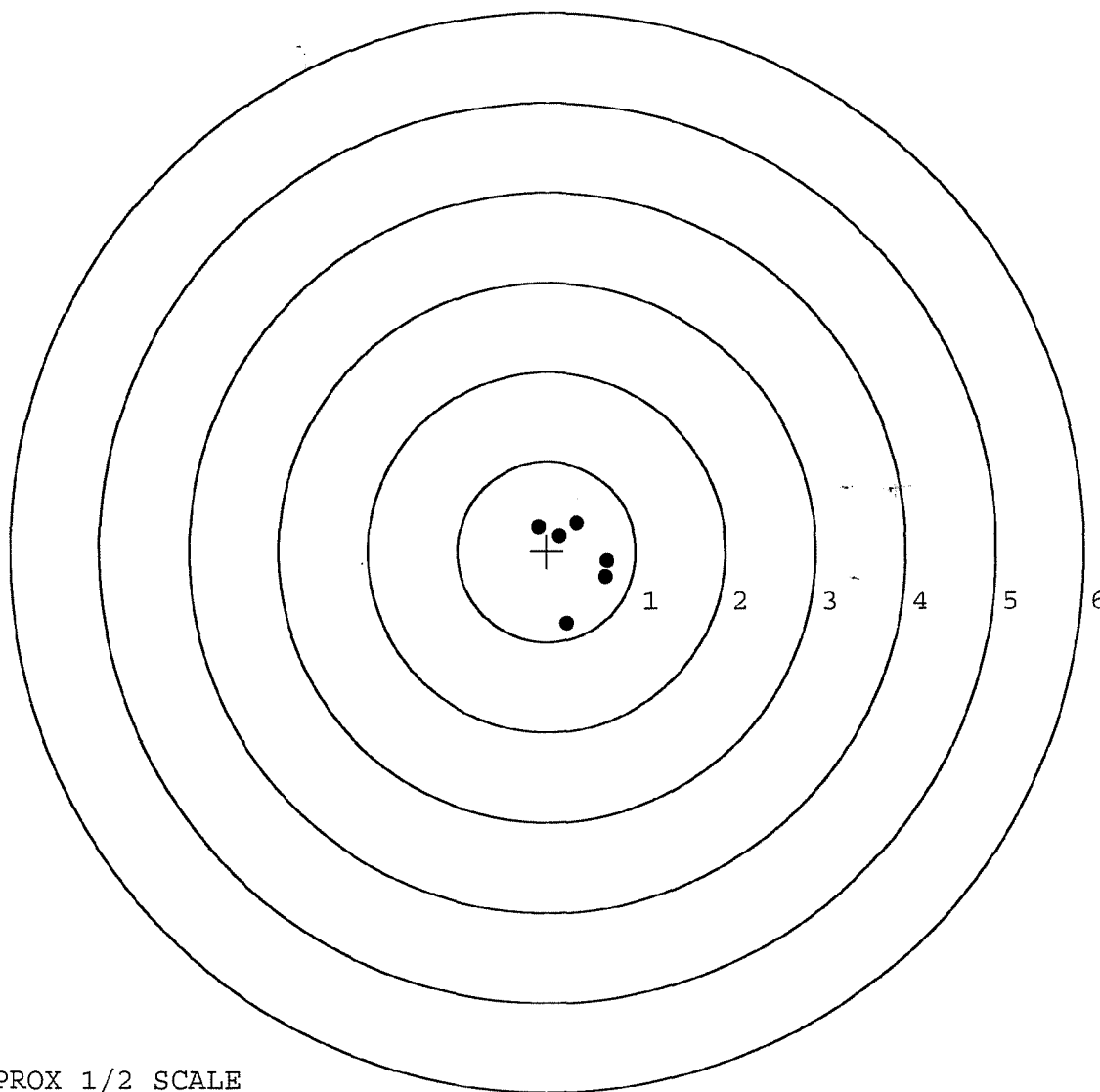
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.011
The Average Y Centroid of the Five Target Set:	-0.104
The Average Point of Impact of the Five Target Set:	0.105
The Average Mean Radius of the Five Target Set:	0.676
The Distance from POA to Centroid Target #1:	0.329
The Distance from Centroid Target #2 to Centroid Target #1:	0.356
The Distance from Centroid Target #3 to Centroid Target #1:	0.491
The Distance from Centroid Target #4 to Centroid Target #1:	0.475
The Distance from Centroid Target #5 to Centroid Target #1:	0.300

SERIAL NUMBER: G6285920. 0
TARGET NUMBER: 1
FILE DATE: 03/29/2003
FILE TIME: 05:05

POINT#	X	Y
1:	0.221	-0.796
2:	0.659	-0.284
3:	0.678	-0.110
4:	0.331	0.318
5:	0.142	0.173
6:	-0.103	0.272

X CENTROID: 0.321
Y CENTROID: -0.071
POA TO CENTROID: 0.329
HORZ SPREAD: 0.781
VERT SPREAD: 1.114
GROUP SPREAD: 1.119
MIN RADIUS: 0.303
MAX RADIUS: 0.732
MEAN RADIUS: 0.455
IN 1 IN DIAMETER: 4
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 6



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285920. 0

TARGET NUMBER: 2

FILE DATE: 03/29/2003

FILE TIME: 05:05

X CENTROID: -0.028

Y CENTROID: -0.138

POA TO CENTROID: 0.141

HORZ SPREAD: 3.022

VERT SPREAD: 1.356

GROUP SPREAD: 3.040

MIN RADIUS: 0.144

MAX RADIUS: 1.821

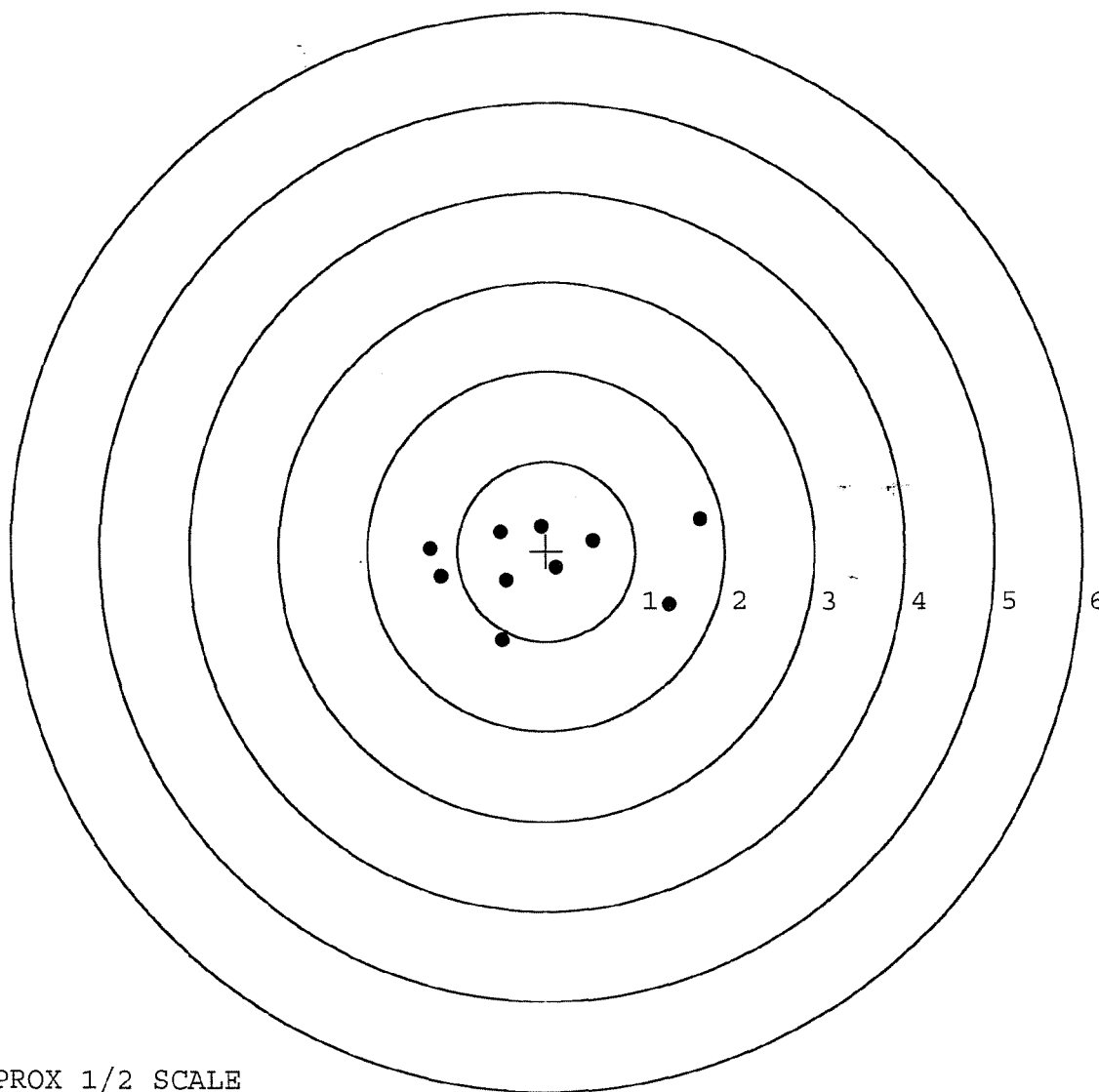
MEAN RADIUS: 0.897

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	1.375	-0.593
2:	1.724	0.359
3:	0.531	0.125
4:	0.109	-0.184
5:	-0.498	-0.997
6:	-0.458	-0.330
7:	-1.181	-0.282
8:	-1.298	0.030
9:	-0.518	0.212
10:	-0.064	0.275



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285920. 0

TARGET NUMBER: 3

FILE DATE: 03/29/2003

FILE TIME: 05:05

POINT#	X	Y
1:	0.756	-0.325
2:	0.132	-0.075
3:	0.859	0.654
4:	-0.067	-0.387
5:	-0.278	-0.062
6:	-0.514	0.015
7:	-0.742	0.402
8:	-0.731	0.067
9:	-0.903	-0.081
10:	-0.161	-0.243

X CENTROID: -0.165

Y CENTROID: -0.003

POA TO CENTROID: 0.165

HORZ SPREAD: 1.762

VERT SPREAD: 1.041

GROUP SPREAD: 1.909

MIN RADIUS: 0.127

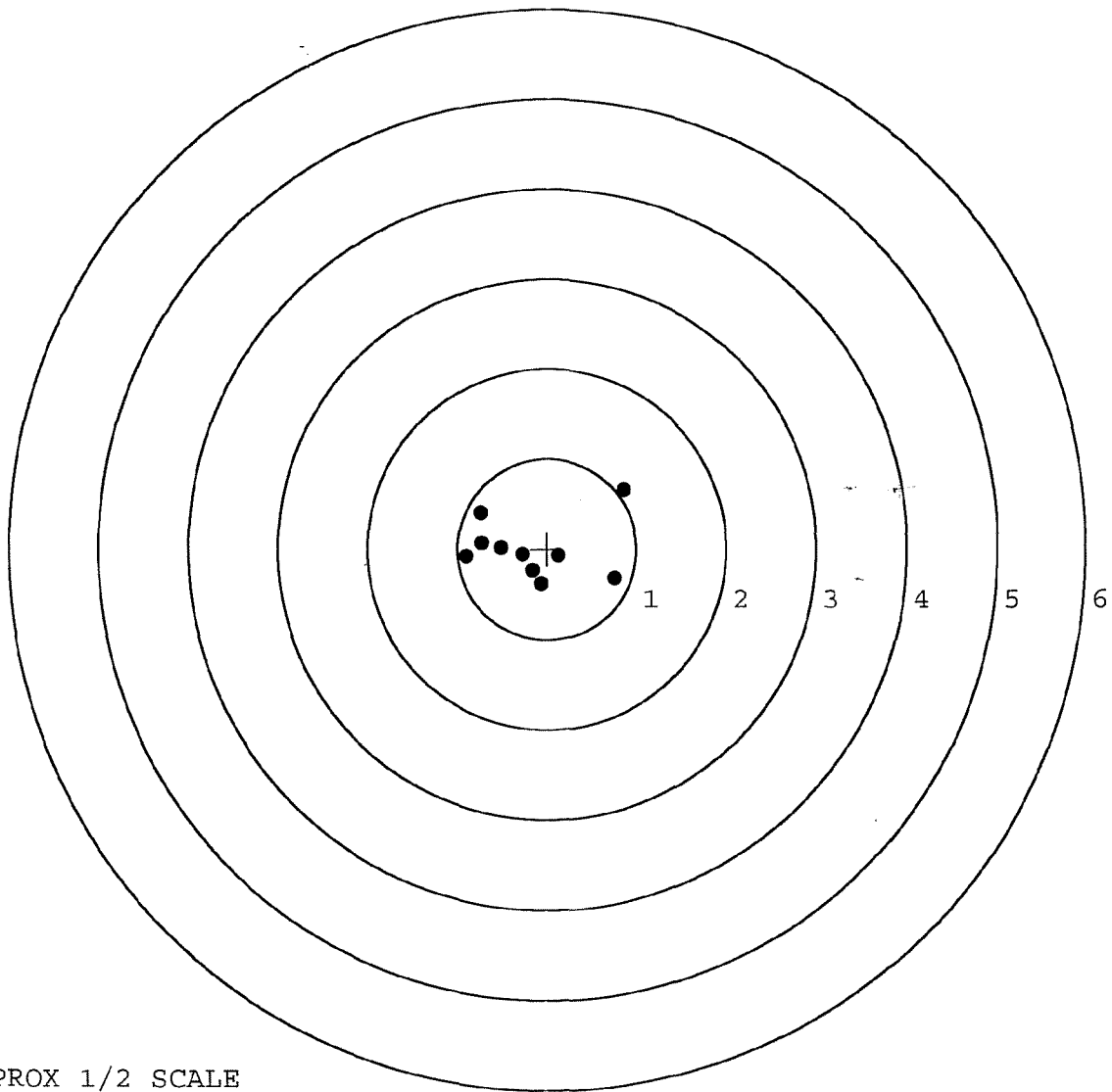
MAX RADIUS: 1.217

MEAN RADIUS: 0.563

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

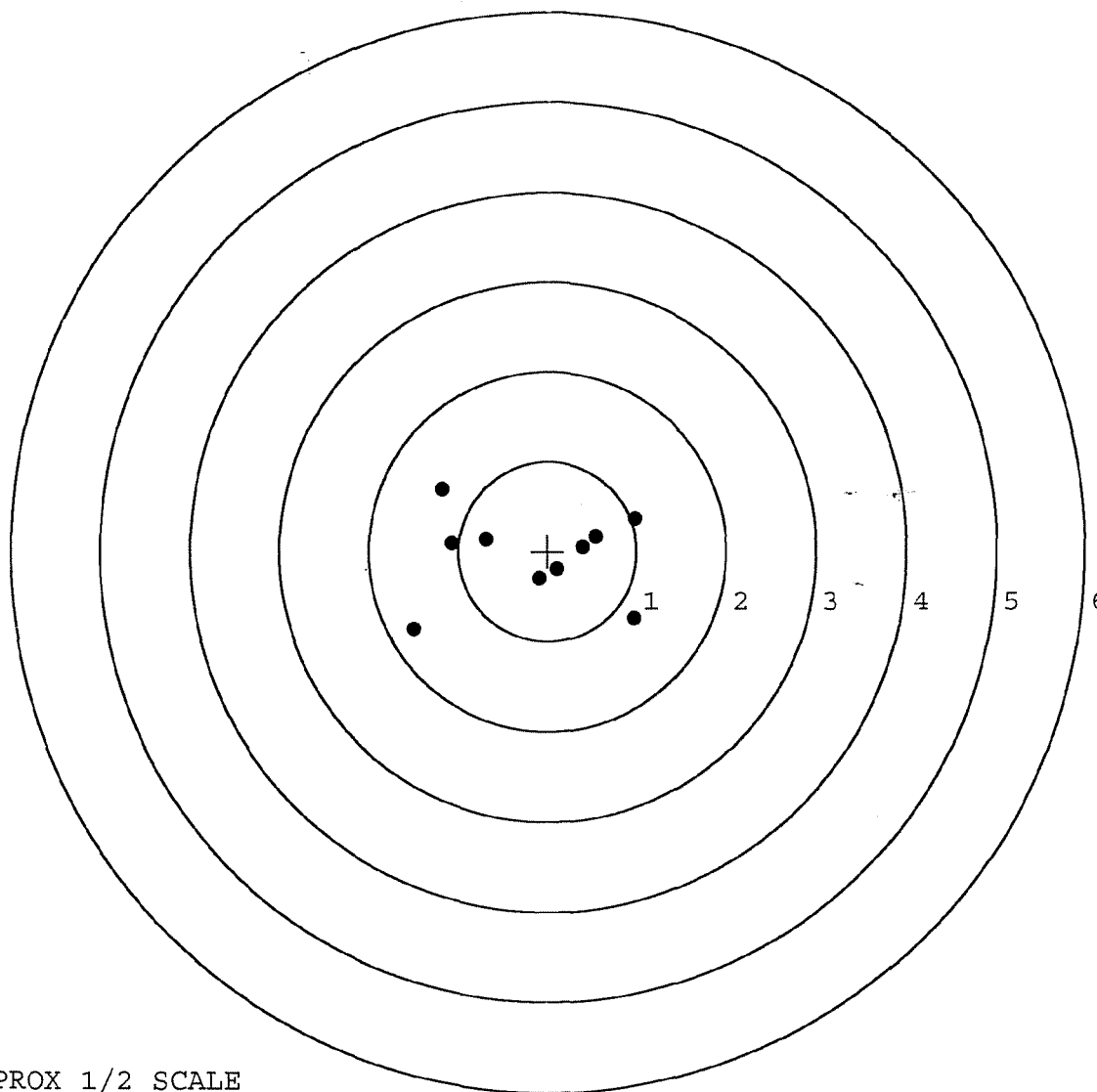


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285920. __0
TARGET NUMBER: 4
FILE DATE: 03/29/2003
FILE TIME: 05:05

POINT#	X	Y
1:	0.973	-0.749
2:	-1.494	-0.876
3:	-1.073	0.093
4:	-1.185	0.687
5:	-0.689	0.140
6:	-0.095	-0.310
7:	0.111	-0.200
8:	0.395	0.056
9:	0.544	0.171
10:	0.974	0.370

X CENTROID: -0.154
Y CENTROID: -0.062
POA TO CENTROID: 0.166
HORZ SPREAD: 2.468
VERT SPREAD: 1.563
GROUP SPREAD: 2.765
MIN RADIUS: 0.255
MAX RADIUS: 1.568
MEAN RADIUS: 0.872
IN 1 IN DIAMETER: 2
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285920. 0

TARGET NUMBER: 5

FILE DATE: 03/29/2003

FILE TIME: 05:05

POINT#	X	Y
1:	1.025	-1.460
2:	0.034	-0.550
3:	-0.713	-0.505
4:	0.582	-0.181
5:	0.432	0.008
6:	0.178	-0.193
7:	0.295	0.385
8:	-0.140	-0.007
9:	-0.348	0.014
10:	-0.555	0.014

X CENTROID: 0.079

Y CENTROID: -0.247

POA TO CENTROID: 0.260

HORZ SPREAD: 1.738

VERT SPREAD: 1.845

GROUP SPREAD: 2.161

MIN RADIUS: 0.113

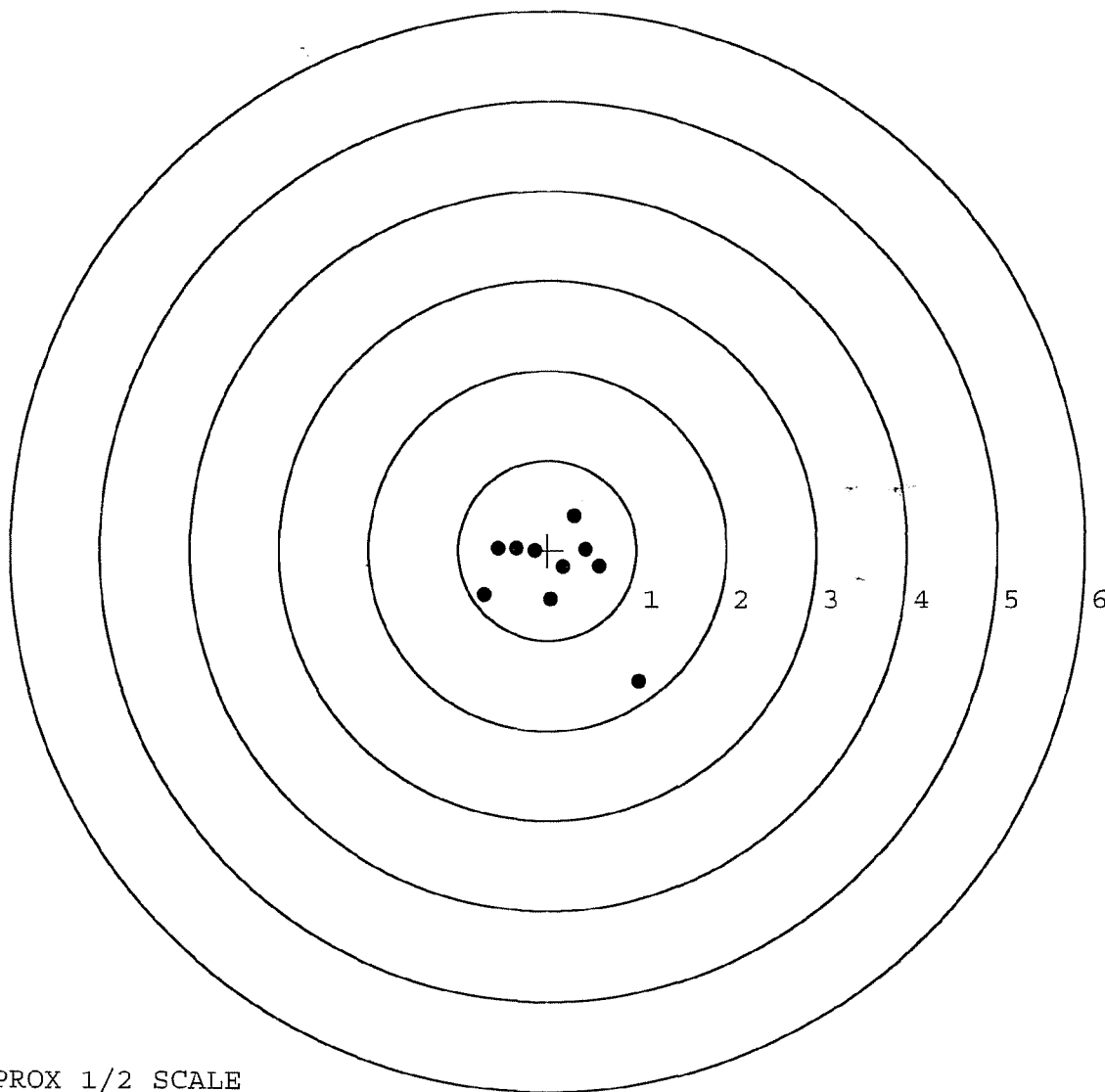
MAX RADIUS: 1.538

MEAN RADIUS: 0.591

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE