

G6a285929

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # 6628 5929

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-18-02	RL
600	PROOF		11-19-02	AC
607	CHECK HEADSPACE		11-19-02	AC
610	DIS-ASSEMBLE GUN		12-2-02	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	RR		
615	ROLLMARK CALIBER		12-6-02	AB
617	DRILL AND TAP SIGHT HOLES		12-3-02	TRW
620	APPLY COATINGS (BARREL ACTION)		12-17	
	(BOLT)		12-17	
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		1-2-03	BA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-2-03	BA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-2-03	BA
	D) OIL FIRING PIN ASSEMBLY		1-2-03	BA
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS		3-28-03	RTL

OP #	OPERATION NAME	READINGS	DATE	INITIAL
625	F) SAFETY ON FORCE 2 LBS MIN 10 LBS MAX	<u>9</u> <u>10</u> <u>10</u>	3-28-03	RW
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>4</u> <u>4</u> <u>4</u>	3-28-03	RW
	H) TRIGGER PULL TEST AND RETAINABILITY		3-28-03	RTL
	I) FIRING PIN INDENT .020 MIN	<u>.022</u> <u>.023</u> <u>.022</u>	3-28-03	RW
	J) ASSEMBLE STOCK		3-26-03	RW
	K) ASSEMBLE SWIVEL STUDS			
	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	3-27-03	TRW
	MALFUNCTION	CORRECTION	3-27-03	TRW
	MALFUNCTION	CORRECTION	3-27-03	TRW
	MALFUNCTION	CORRECTION	3-27-03	TRW
	MALFUNCTION	CORRECTION	3-27-03	TRW
645	INSPECT FOR LIVE AMMO		3-27-03	TRW
655	FINAL INSPECTION A) HEADSPACE		3-28-03	RW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.94</u> <u>2.87</u> <u>2.95</u> <u>2.87</u> <u>2.89</u>	3-28-03	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 3-26-03

TESTER TRW

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.67	2.58	2.48	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2
PULL #2	2.34	2.53	2.85	
PULL #3	2.46	2.58	2.72	
PULL #4	2.50	2.64	2.82	
PULL #5	2.56	2.63	2.84	
TOTAL	12.53	12.96	13.71	
AVG.	2.50	2.59	2.74	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	3.23	3.40	
PULL #2	3.40	3.45	
PULL #3	3.37	3.10	
PULL #4	3.41	3.31	
PULL #5	3.47	3.32	
TOTAL	16.88	16.58	
AVG.	3.37	3.31	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCUR.
PULL #1	4.24	4.43		4.17
PULL #2	4.07	4.33		4.18
PULL #3	4.26	4.34		4.39
PULL #4	4.42	4.26		4.47
PULL #5	4.34	4.45		4.39
TOTAL	21.33	21.81		21.60
AVG.	4.26	4.36		4.32

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6285929.__0
FILE DATE AND TIME: 03/28/2003 11:17

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.105
The Average Y Centroid of the Five Target Set:	-0.090
The Average Point of Impact of the Five Target Set:	0.138
The Average Mean Radius of the Five Target Set:	0.800
The Distance from POA to Centroid Target #1:	0.052
The Distance from Centroid Target #2 to Centroid Target #1:	0.117
The Distance from Centroid Target #3 to Centroid Target #1:	0.049
The Distance from Centroid Target #4 to Centroid Target #1:	0.256
The Distance from Centroid Target #5 to Centroid Target #1:	0.200

SERIAL NUMBER: G6285929. __0

TARGET NUMBER: 1

FILE DATE: 03/28/2003

FILE TIME: 11:17

POINT#	X	Y
1:	1.144	-1.399
2:	0.162	-1.118
3:	-0.041	-0.554
4:	0.662	0.284
5:	0.481	0.403
6:	0.191	0.350
7:	0.059	0.196
8:	-0.741	0.267
9:	-0.676	0.861
10:	-1.760	0.682

X CENTROID: -0.052

Y CENTROID: -0.003

POA TO CENTROID: 0.052

HORZ SPREAD: 2.904

VERT SPREAD: 2.260

GROUP SPREAD: 3.573

MIN RADIUS: 0.228

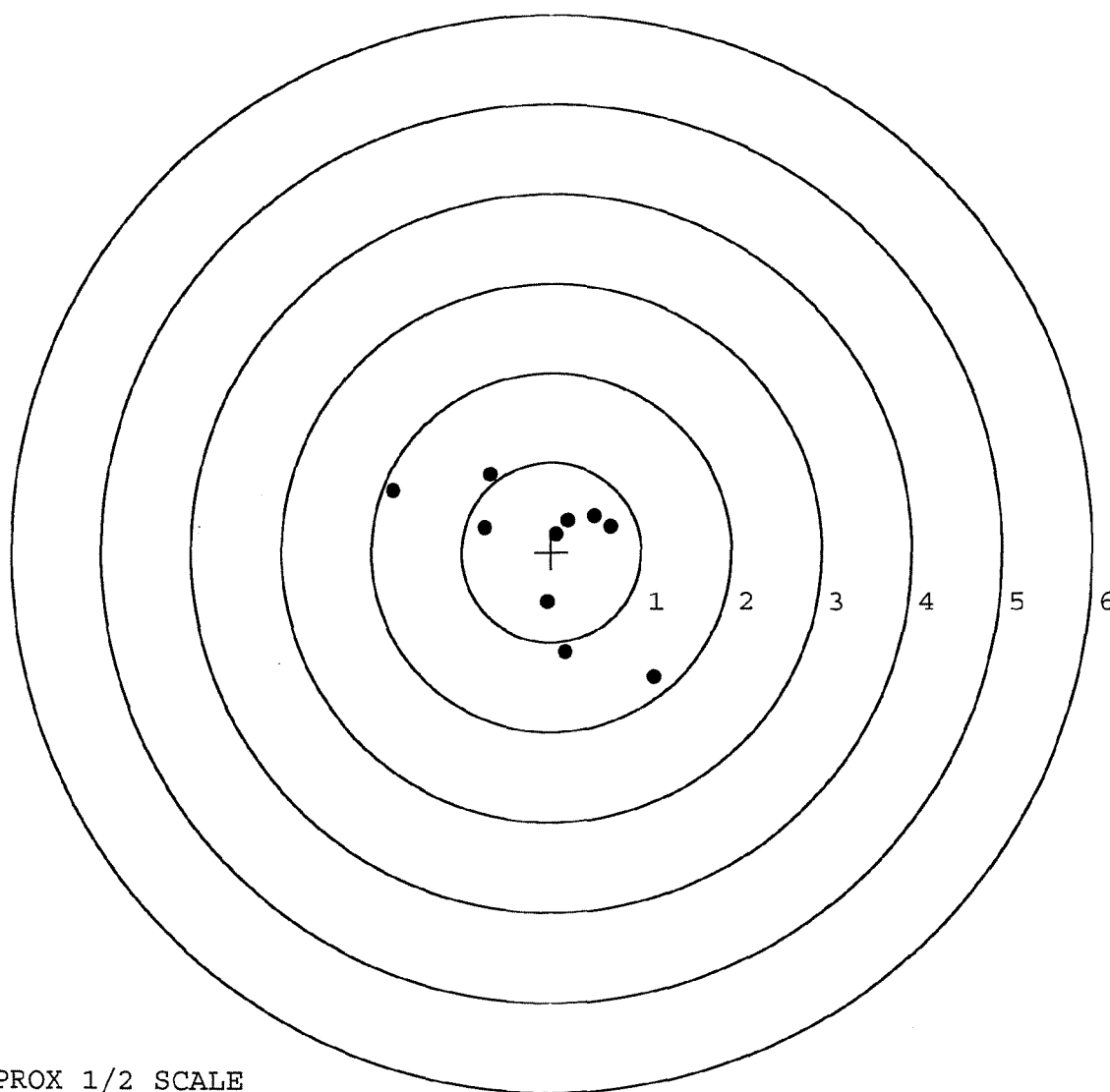
MAX RADIUS: 1.840

MEAN RADIUS: 0.927

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 8



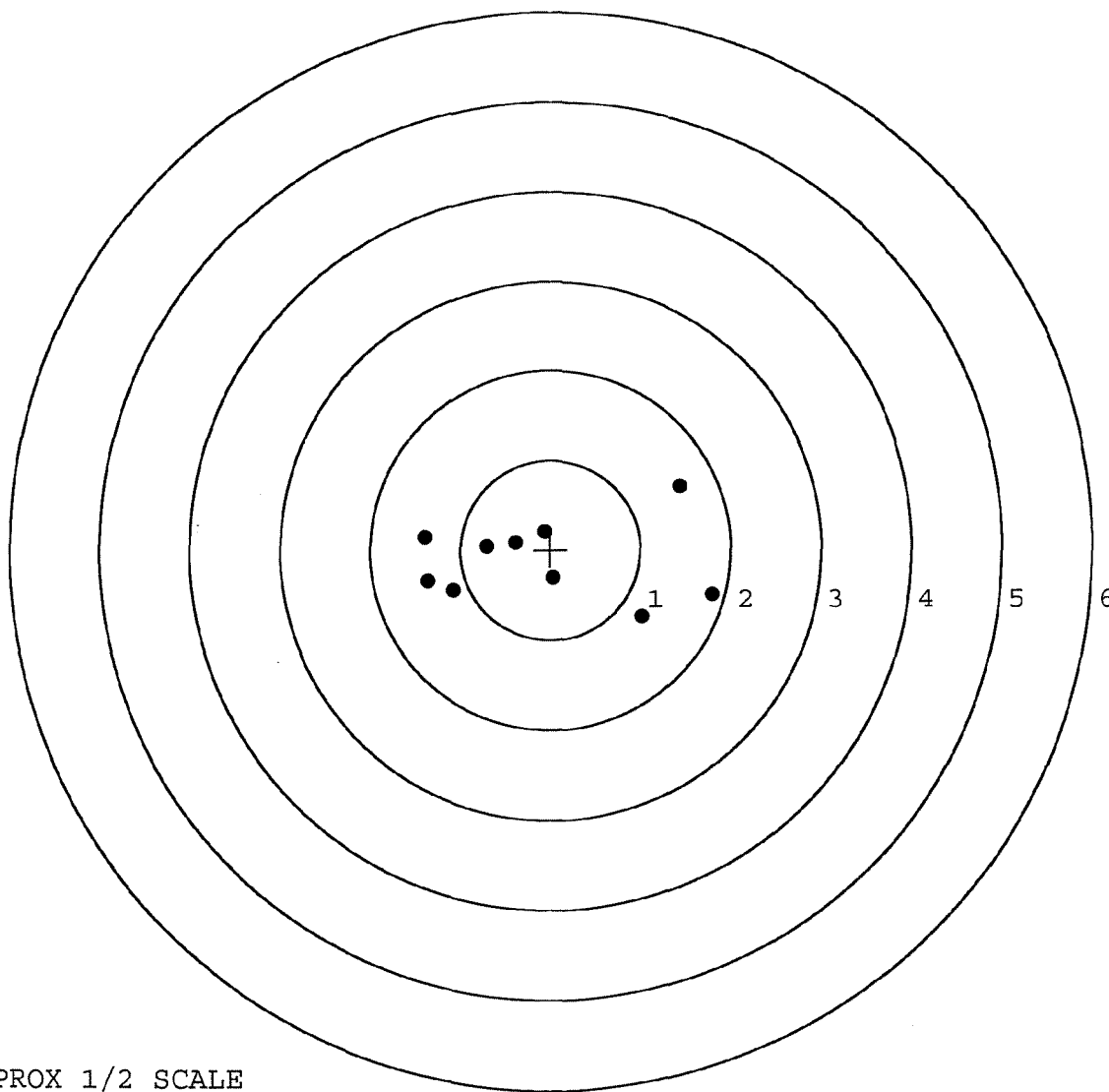
TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285929. __0
TARGET NUMBER: 2
FILE DATE: 03/28/2003
FILE TIME: 11:17

X CENTROID: -0.070
Y CENTROID: -0.119
POA TO CENTROID: 0.138
HORZ SPREAD: 3.192
VERT SPREAD: 1.457
GROUP SPREAD: 3.258
MIN RADIUS: 0.224
MAX RADIUS: 1.908
MEAN RADIUS: 1.019

IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 4
in 3 IN DIAMETER: 8

POINT#	X	Y
1:	1.019	-0.750
2:	1.798	-0.504
3:	1.435	0.707
4:	0.038	-0.315
5:	-0.062	0.203
6:	-0.393	0.082
7:	-0.707	0.046
8:	-1.077	-0.448
9:	-1.360	-0.353
10:	-1.394	0.146



TARGET APPROX 1/2 SCALE

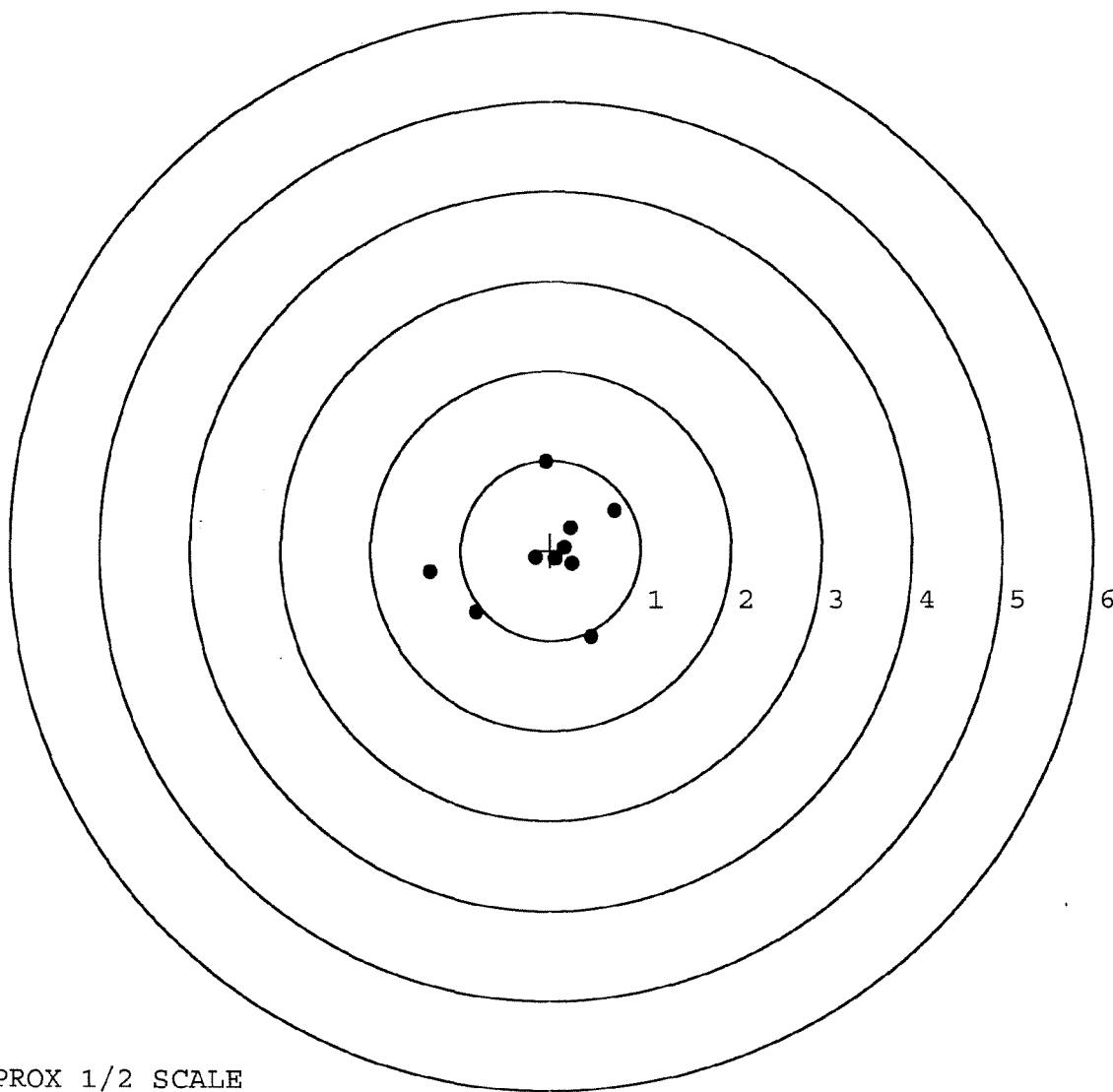
SERIAL NUMBER: G6285929. __ 0

TARGET NUMBER: 3

FILE DATE: 03/28/2003

FILE TIME: 11:17

	POINT#	X	Y
	1:	0.452	-0.961
	2:	-0.828	-0.685
	3:	-1.339	-0.244
	4:	-0.049	0.983
X CENTROID:	5:	0.713	0.436
Y CENTROID:	6:	0.222	0.252
POA TO CENTROID:	7:	-0.164	-0.086
HORZ SPREAD:	8:	0.245	-0.151
VERT SPREAD:	9:	0.056	-0.095
GROUP SPREAD:	10:	0.159	0.031
MIN RADIUS:		0.116	
MAX RADIUS:		1.300	
MEAN RADIUS:		0.647	
# IN 1 IN DIAMETER:		5	
# IN 2 IN DIAMETER:		6	
# in 3 IN DIAMETER:		10	



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285929. __0

TARGET NUMBER: 4

FILE DATE: 03/28/2003

FILE TIME: 11:17

X CENTROID: -0.297

Y CENTROID: -0.075

POA TO CENTROID: 0.307

HORZ SPREAD: 2.239

VERT SPREAD: 2.147

GROUP SPREAD: 2.396

MIN RADIUS: 0.368

MAX RADIUS: 1.713

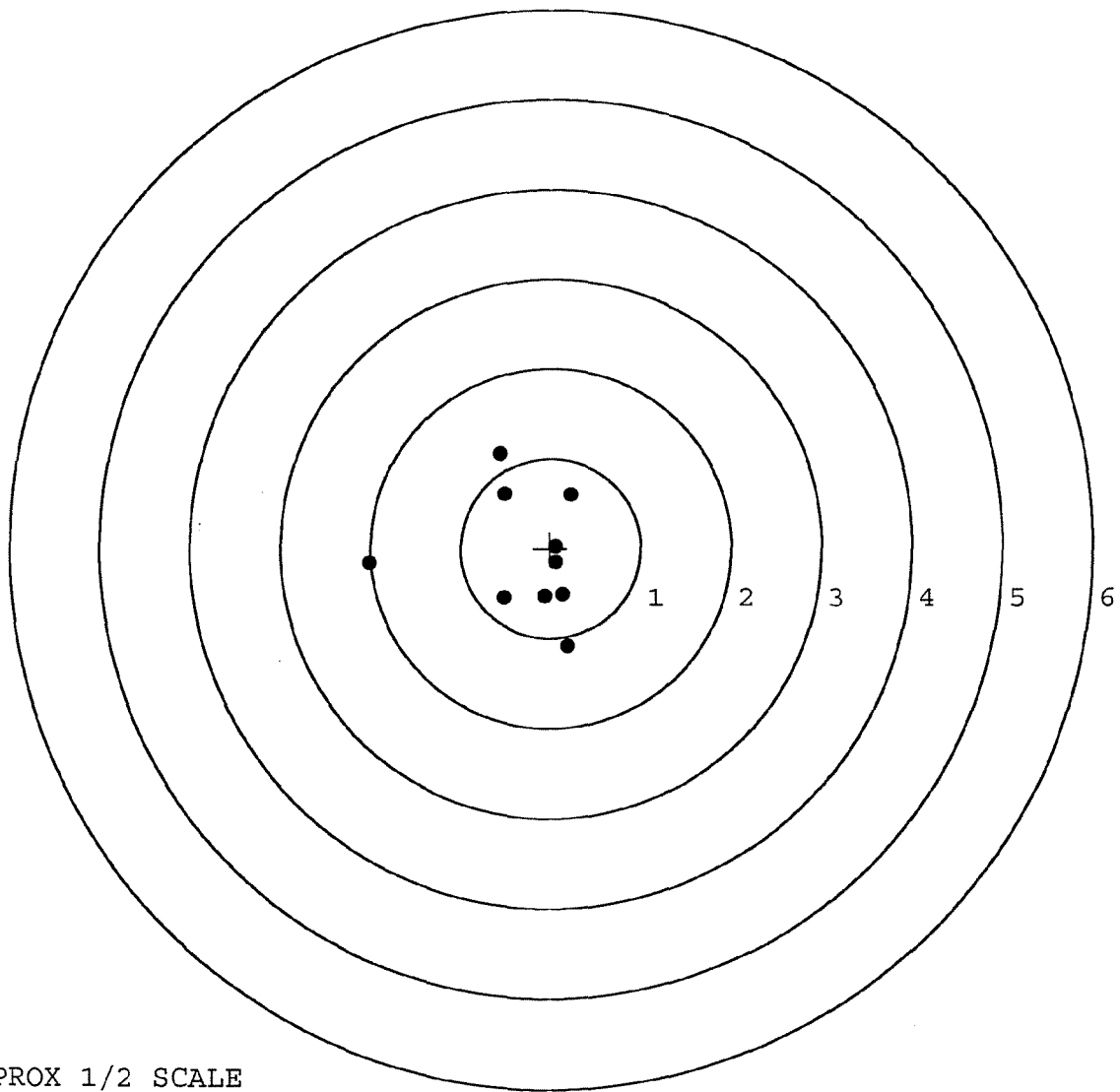
MEAN RADIUS: 0.798

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9

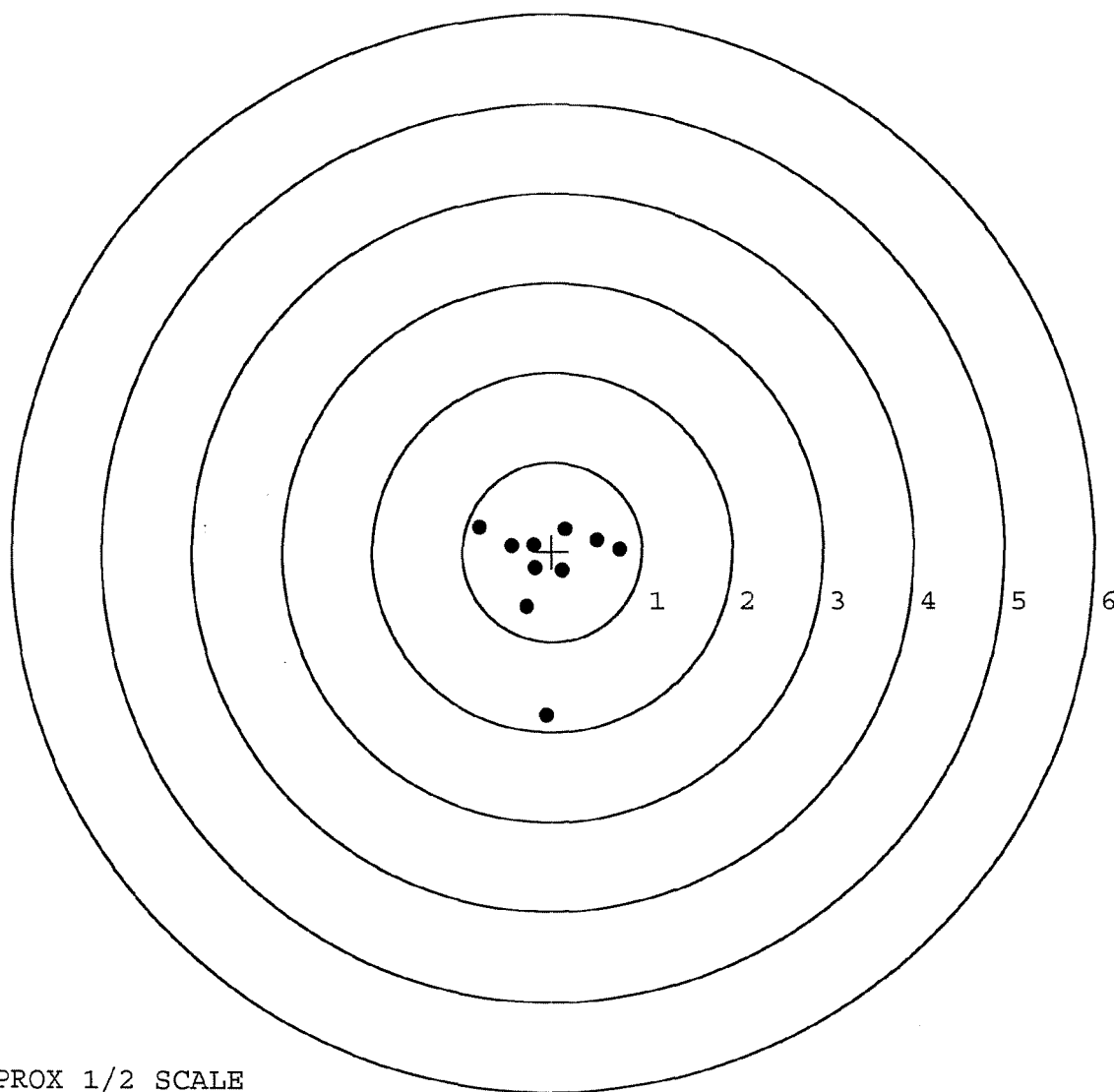
POINT#	X	Y
1:	0.200	-1.095
2:	-0.518	-0.558
3:	-2.008	-0.165
4:	-0.512	0.604
5:	-0.566	1.052
6:	0.231	0.594
7:	0.064	0.021
8:	0.061	-0.158
9:	0.139	-0.514
10:	-0.064	-0.535



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285929. __0
TARGET NUMBER: 5
FILE DATE: 03/28/2003
FILE TIME: 11:17

	POINT#	X	Y
	1:	-0.064	-1.825
	2:	-0.286	-0.618
	3:	-0.818	0.279
	4:	0.754	0.026
	5:	0.494	0.128
	6:	0.142	0.252
	7:	-0.202	0.070
	8:	-0.458	0.064
	9:	0.119	-0.220
	10:	-0.193	-0.187
X CENTROID:		-0.051	
Y CENTROID:		-0.203	
POA TO CENTROID:		0.209	
HORZ SPREAD:		1.572	
VERT SPREAD:		2.104	
GROUP SPREAD:		2.235	
MIN RADIUS:		0.143	
MAX RADIUS:		1.622	
MEAN RADIUS:		0.609	
# IN 1 IN DIAMETER:		6	
# IN 2 IN DIAMETER:		9	
# in 3 IN DIAMETER:		9	



TARGET APPROX 1/2 SCALE