

G6285933

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G628 5933

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		11-18-02	RL
600	PROOF		11-19-02	AL
607	CHECK HEADSPACE		11-19-02	AL
610	DIS-ASSEMBLE GUN		12-2-02	RL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	RL		
615	ROLLMARK CALIBER		12-6-02	LB
617	DRILL AND TAP SIGHT HOLES		12-3-02	TRW
620	APPLY COATINGS (BARREL ACTION)		12-17	RA
	(BOLT)		12-17	TR
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		1-10-03	RA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		1-10-03	RA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		1-10-03	RA
	D) OIL FIRING PIN ASSEMBLY		1-10-03	RA
	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>7</u> <u>7</u> <u>6</u>	3-28-03	RED
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>3.5</u> <u>3.5</u> <u>3</u>	3-28-03	RW
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.0235</u> <u>.023</u> <u>.023</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	TRW
	MALFUNCTION	CORRECTION	3-28-03	TRW
	MALFUNCTION	CORRECTION	3-28-03	TRW
	MALFUNCTION	CORRECTION	3-28-03	TRW
	MALFUNCTION	CORRECTION	3-28-03	TRW
645	INSPECT FOR LIVE AMMO		3-28-03	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>2.89</u> <u>2.90</u> <u>2.87</u> <u>2.97</u>	3-29-03	RW
	C) FUNCTION		3-28-03	RW
660	PACK		4/2/03	SA

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6285933.__0

FILE DATE AND TIME: 03/29/2003 05:02

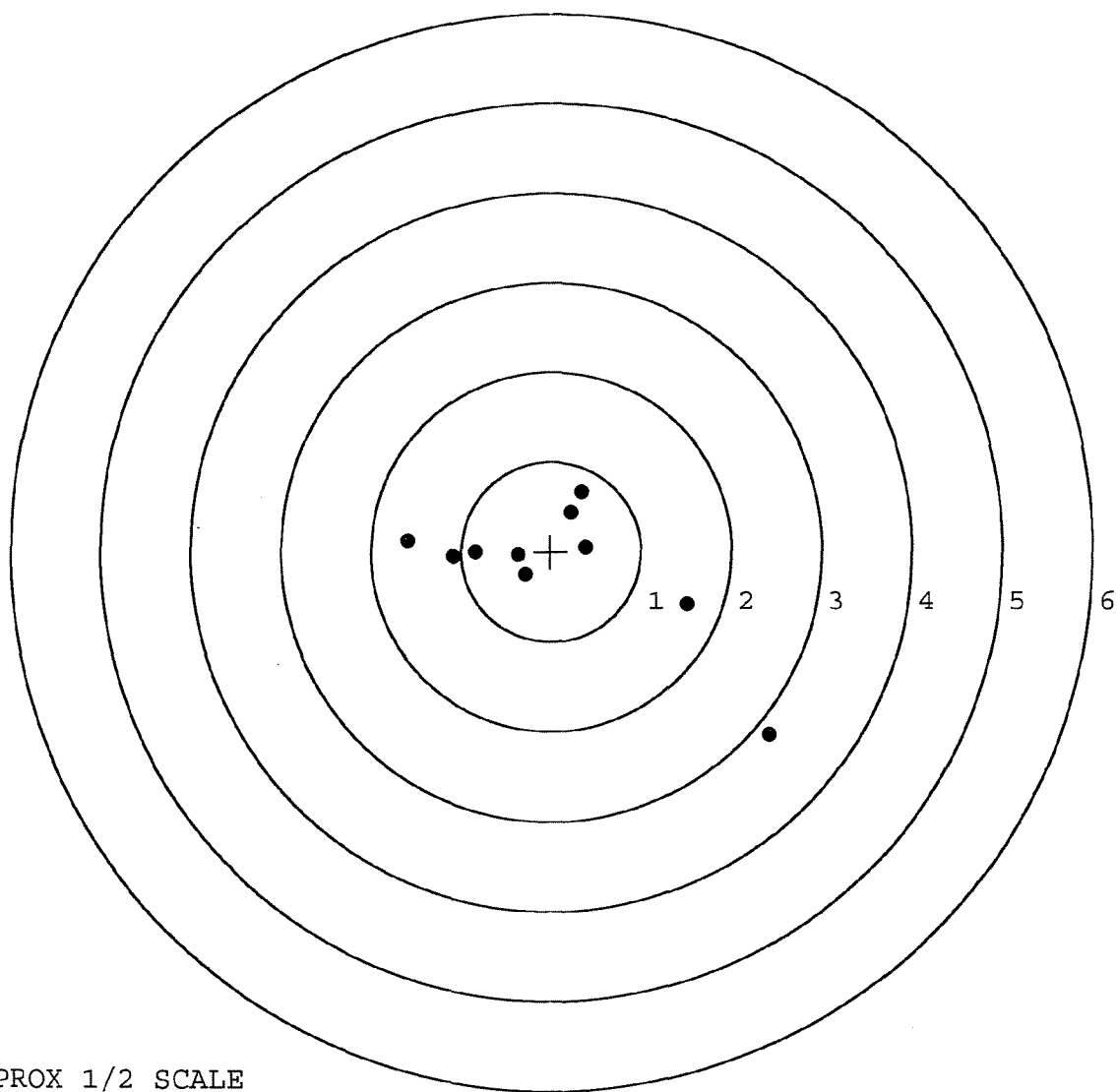
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.035
The Average Y Centroid of the Five Target Set:	-0.092
The Average Point of Impact of the Five Target Set:	0.099
The Average Mean Radius of the Five Target Set:	0.839
The Distance from POA to Centroid Target #1:	0.187
The Distance from Centroid Target #2 to Centroid Target #1:	0.093
The Distance from Centroid Target #3 to Centroid Target #1:	0.204
The Distance from Centroid Target #4 to Centroid Target #1:	0.579
The Distance from Centroid Target #5 to Centroid Target #1:	0.147

SERIAL NUMBER: G6285933. __0
TARGET NUMBER: 1
FILE DATE: 03/29/2003
FILE TIME: 05:02

X CENTROID: 0.071
Y CENTROID: -0.172
POA TO CENTROID: 0.187
HORZ SPREAD: 4.012
VERT SPREAD: 2.718
GROUP SPREAD: 4.565
MIN RADIUS: 0.367
MAX RADIUS: 3.005
MEAN RADIUS: 1.100
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 6
in 3 IN DIAMETER: 7

POINT#	X	Y
1:	2.416	-2.052
2:	1.513	-0.592
3:	0.383	0.047
4:	0.222	0.434
5:	0.346	0.666
6:	-0.285	-0.258
7:	-0.366	-0.039
8:	-0.834	-0.003
9:	-1.084	-0.054
10:	-1.596	0.126



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285933. __0

TARGET NUMBER: 2

FILE DATE: 03/29/2003

FILE TIME: 05:02

POINT#	X	Y
1:	0.845	-0.790
2:	0.776	-0.566
3:	0.478	-0.110
4:	0.564	0.147
5:	0.097	0.328
6:	-0.538	0.420
7:	-0.460	0.038
8:	-0.244	-0.214
9:	0.140	-0.633
10:	-0.108	0.074

X CENTROID: 0.155

Y CENTROID: -0.131

POA TO CENTROID: 0.203

HORZ SPREAD: 1.383

VERT SPREAD: 1.210

GROUP SPREAD: 1.838

MIN RADIUS: 0.324

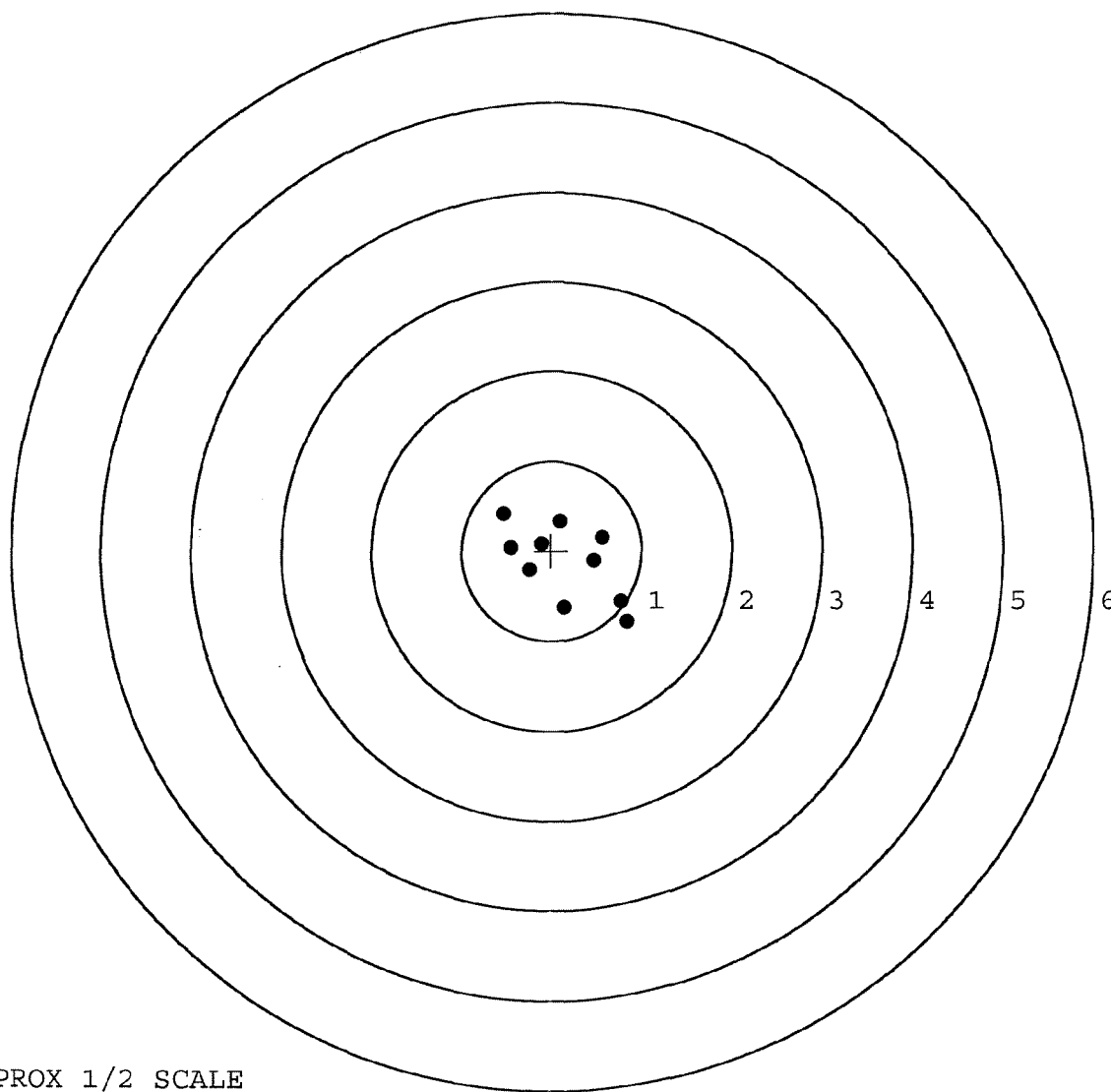
MAX RADIUS: 0.954

MEAN RADIUS: 0.576

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285933. __0

TARGET NUMBER: 3

FILE DATE: 03/29/2003

FILE TIME: 05:02

X CENTROID: -0.069

Y CENTROID: -0.025

POA TO CENTROID: 0.073

HORZ SPREAD: 2.495

VERT SPREAD: 0.964

GROUP SPREAD: 2.503

MIN RADIUS: 0.122

MAX RADIUS: 1.395

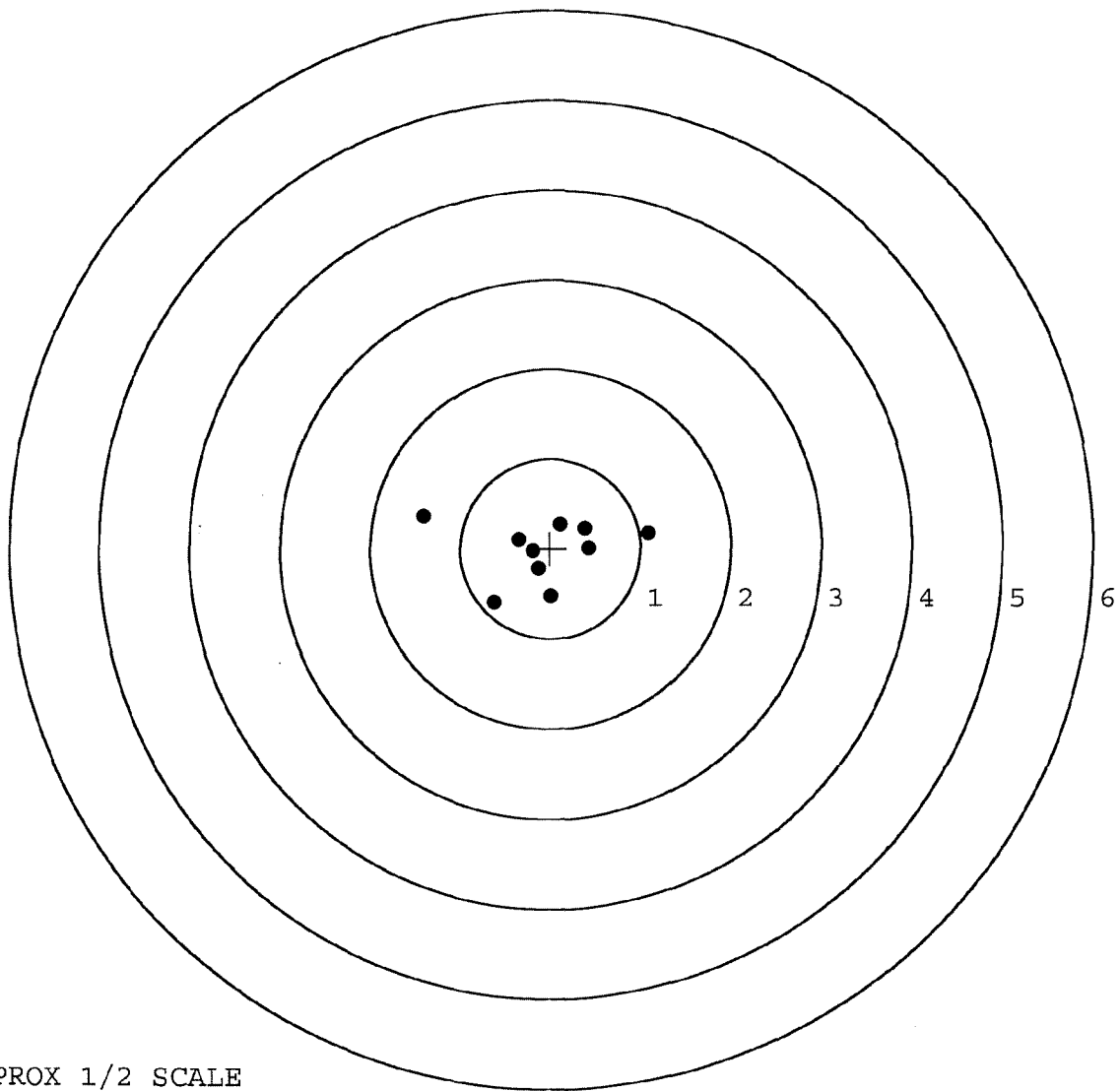
MEAN RADIUS: 0.589

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	1.086	0.167
2:	0.385	0.231
3:	0.426	0.013
4:	0.112	0.269
5:	-0.191	-0.029
6:	-0.127	-0.227
7:	0.013	-0.535
8:	-0.625	-0.602
9:	-1.409	0.362
10:	-0.358	0.102



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285933. __0

TARGET NUMBER: 4

FILE DATE: 03/29/2003

FILE TIME: 05:02

POINT#	X	Y
1:	0.825	-0.259
2:	0.632	0.094
3:	0.261	0.116
4:	0.252	-0.198
5:	0.135	-0.720
6:	-0.633	0.013
7:	-1.015	-0.087
8:	-1.412	-0.426
9:	-0.886	0.639
10:	-3.151	0.100

X CENTROID: -0.499

Y CENTROID: -0.073

POA TO CENTROID: 0.504

HORZ SPREAD: 3.976

VERT SPREAD: 1.359

GROUP SPREAD: 3.992

MIN RADIUS: 0.159

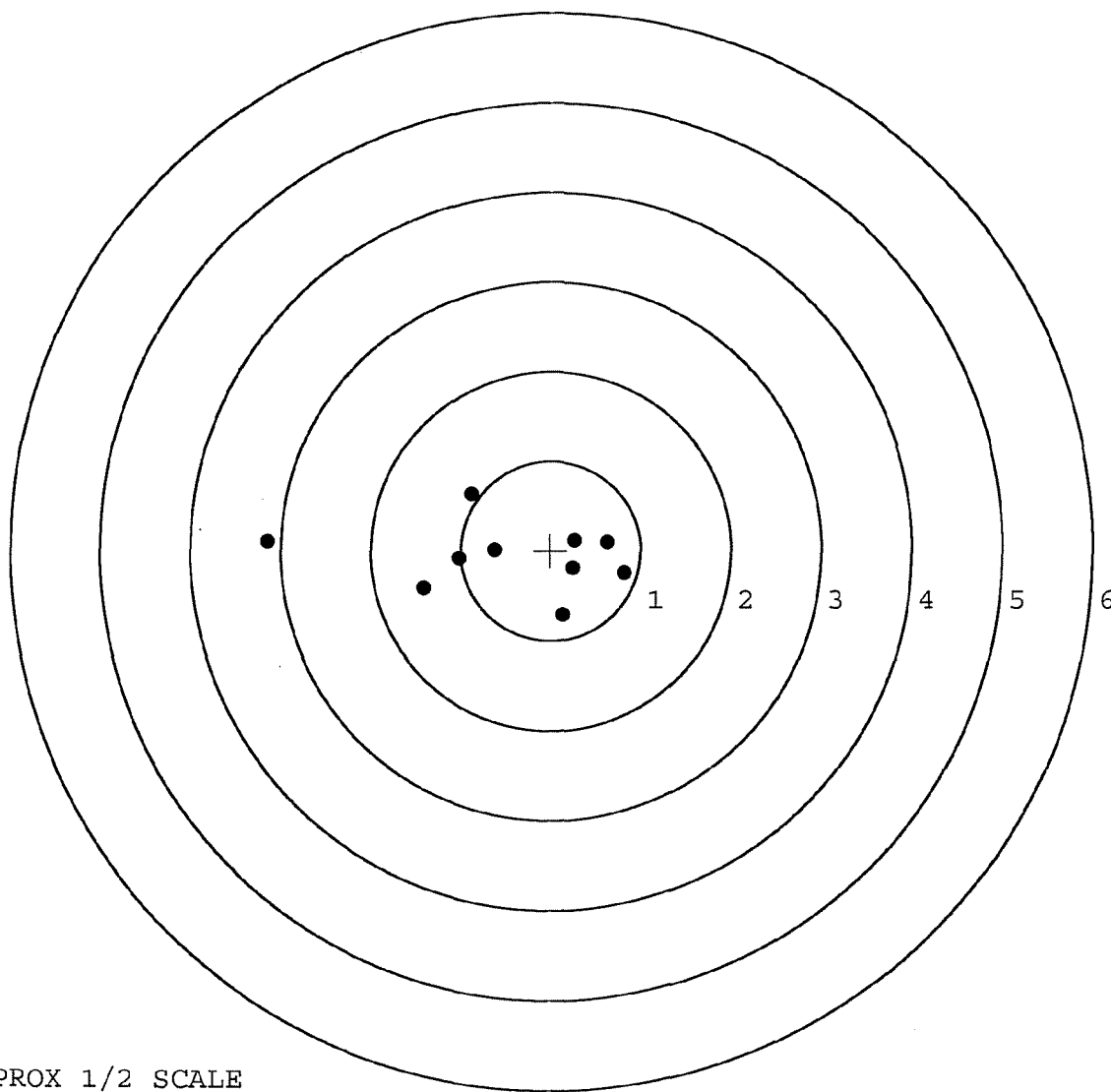
MAX RADIUS: 2.657

MEAN RADIUS: 1.005

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6285933. __ 0

TARGET NUMBER: 5

FILE DATE: 03/29/2003

FILE TIME: 05:02

X CENTROID: 0.166

Y CENTROID: -0.060

POA TO CENTROID: 0.176

HORZ SPREAD: 2.552

VERT SPREAD: 2.159

GROUP SPREAD: 2.563

MIN RADIUS: 0.307

MAX RADIUS: 1.510

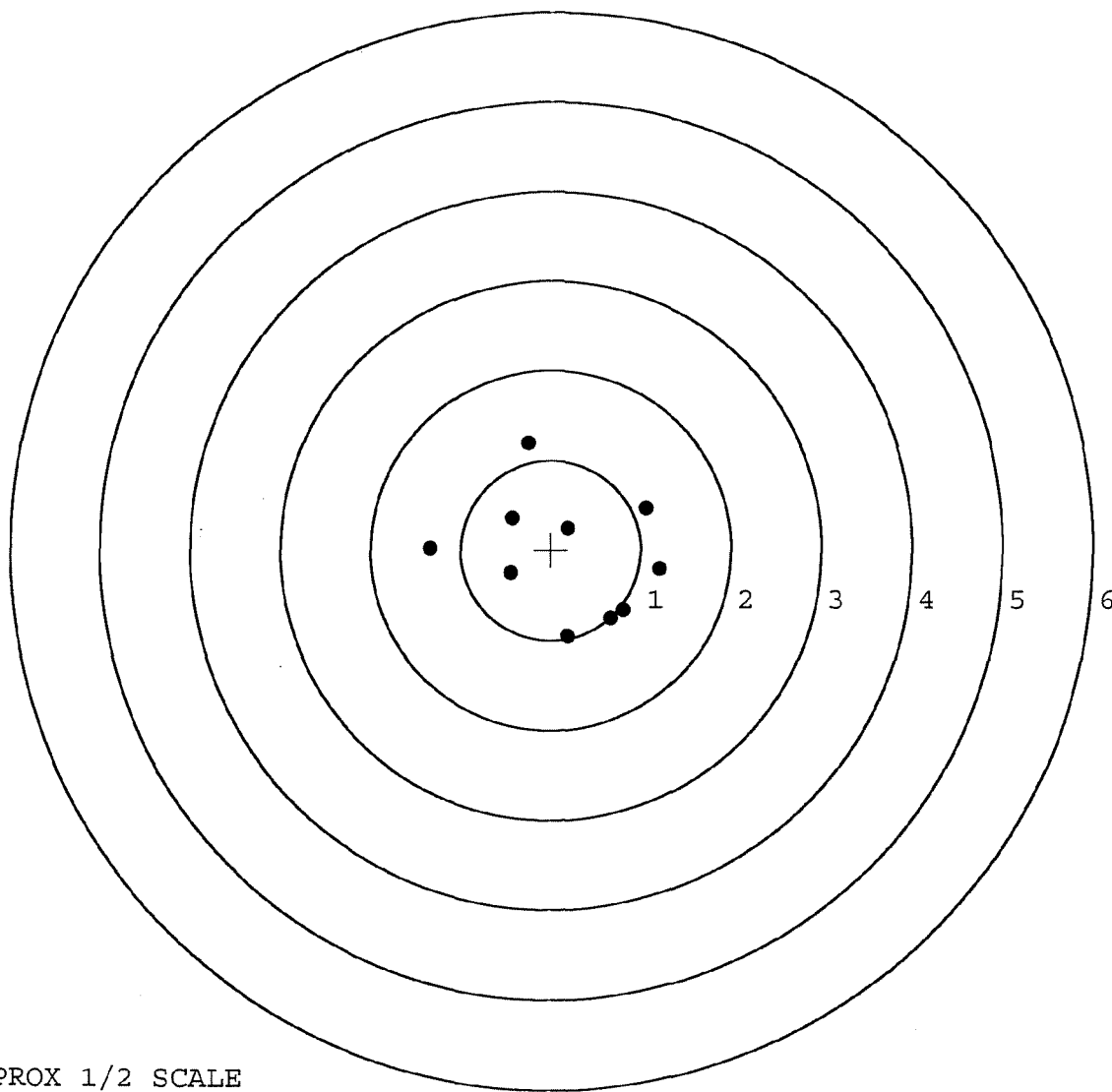
MEAN RADIUS: 0.926

IN 1 IN DIAMETER: 1

IN 2 IN DIAMETER: 6

in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.190	-0.966
2:	0.669	-0.766
3:	0.813	-0.670
4:	1.210	-0.215
5:	1.059	0.464
6:	0.189	0.246
7:	-0.428	0.354
8:	-0.444	-0.259
9:	-1.342	0.020
10:	-0.258	1.193



TARGET APPROX 1/2 SCALE

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	2.56	2.58		2.53	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT ABLE LESS THAN
PULL #2	2.54	2.54		2.51	
PULL #3	2.30	2.47		2.55	
PULL #4	2.44	2.51		2.52	
PULL #5	2.45	2.46		2.50	
TOTAL	12.29	12.56		12.61	
AVG.	2.45	2.51		2.52	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.37		
PULL #2	3.12	3.19		
PULL #3	3.11	3.20		
PULL #4	3.10	3.27		
PULL #5	3.11	3.41		
TOTAL	15.60	16.44		
AVG.	3.12	3.28		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# TARGET & ACCU
PULL #1	4.45	4.34		4.43
PULL #2	4.32	4.35		4.21
PULL #3	4.40	4.31		4.22
PULL #4	4.42	4.29		4.20
PULL #5	4.34	4.30		4.21
TOTAL	21.93	21.59		21.27
AVG.	4.38	4.31		4.25