

G6300 465

Serial Number: G6300465
Model: M24 SWS

RE00098493

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-D-0127

R & E NUMBER	98493		
SERIAL NUMBER	G6300465		
LOG-IN DATE	7-6-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	7-14-05	RTZ
560 A	RE-BARREL	N/A	
B	DRILL AND TAP		
575	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN		
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST	8-23-05	LB
620	APPLY COATINGS	8/25/05	RTZ
625 A	FINAL ASSEMBLY	8-30-05	RTZ
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	9-2-05	AC
D	SAFETY "OFF" FORCE	9-2-05	AC
E	FIRING PIN INDENT	9-2-05	AC
640	TARGET		
655	FINAL INSPECT	9-2-05	AC
660	PACK	9-2-05	RTZ
		SHIP DATE	
		QAR INSPECTION DATE	

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

- INSTRUCTION BOOK 3518

46 FORM

proof of purchase



owner registration sticker



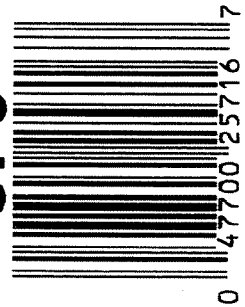
ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

G6300465

UPC



M2400160891

M-24
INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G 6300 465

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		5/19/03	RTZ
600	PROOF		5-20-03	AC
607	CHECK HEADSPACE	MAGNA-FLUX INSPECTED	5/21/03	RTZ
610	DIS-ASSEMBLE GUN	MAY 23 2003	5/21/03	RTZ
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT	OPERATOR <u>RL</u>		
615	ROLLMARK CALIBER		5/27/03	AB
617	DRILL AND TAP SIGHT HOLES		5-22-03	TRLW
620	APPLY COATINGS (BARREL ACTION)		6-11	TA
	(BOLT)		6-11	TA
625	FINAL ASSEMBLY			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		6-16-03	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		6-16-03	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		6-16-03	DA
	D) OIL FIRING PIN ASSEMBLY		6-16-03	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>8.9</u> <u>2.0</u> <u>6.0</u>	7-10-03	DA
CONT.				
	G) SAFETY OFF FORCE 2 LBS MIN	<u>2.0</u> <u>2.0</u> <u>2.0</u>	7-10-03	DA
	H) TRIGGER PULL TEST AND RETAINABILITY			
	I) FIRING PIN INDENT .020 MIN	<u>.024</u> <u>.023.5</u> <u>.022</u>	7-10-03	DA
	J) ASSEMBLE STOCK		10-19-03	RTL
	K) ASSEMBLE SWIVEL STUDS		11/10/03	RW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S		6-19-03	RTL
	M) IRON SIGHT ALIGNMENT		6-19-03	RTL
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER		6-19-03	RTL
640	GALLERY TEST AND TARGET	PASS FAIL	7-1-03	A
	MALFUNCTION	CORRECTION	7-1-03	A
	MALFUNCTION	CORRECTION	7-1-03	A
	MALFUNCTION	CORRECTION	7-1-03	A
	MALFUNCTION	CORRECTION	7-1-03	A
645	INSPECT FOR LIVE AMMO		7-1-03	A
655	FINAL INSPECTION A) HEADSPACE		11/10/03	RW
	B) TRIGGER PULL +/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	<u>2.29</u> <u>2.35</u> <u>2.40</u> <u>2.35</u> <u>2.34</u>	7-10-03	DA
	C) FUNCTION		11/10/03	RW
660	PACK		11/11/03	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 6-12-03

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.22	2.17		2.33	
PULL #2	2.17	2.38		2.17	
PULL #3	2.13	2.33		2.31	
PULL #4	2.00	2.31		2.33	
PULL #5	2.27	2.24		2.29	
TOTAL	10.79	11.43		11.43	
AVERAGE	2.15	2.28		2.28	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.40	3.09		
PULL #2	3.41	3.10		
PULL #3	3.40	3.09		
PULL #4	3.30	3.11		
PULL #5	3.35	3.14		
TOTAL	16.86	15.53		
AVERAGE	3.37	3.10		

	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	4.02	4.32		4.40
PULL #2	4.30	4.24		4.18
PULL #3	4.37	4.49		4.35
PULL #4	4.34	4.50		4.18
PULL #5	4.49	4.26		4.30
TOTAL	21.52	21.81		21.41
AVERAGE	4.30	4.36		4.28

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6300465.___0
FILE DATE AND TIME: 07/01/2003 06:51

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.039
The Average Y Centroid of the Five Target Set:	-0.046
The Average Point of Impact of the Five Target Set:	0.060
The Average Mean Radius of the Five Target Set:	0.766
The Distance from POA to Centroid Target #1:	0.190
The Distance from Centroid Target #2 to Centroid Target #1:	0.326
The Distance from Centroid Target #3 to Centroid Target #1:	0.086
The Distance from Centroid Target #4 to Centroid Target #1:	0.127
The Distance from Centroid Target #5 to Centroid Target #1:	0.367

SERIAL NUMBER: G6300465. __0

TARGET NUMBER: 1

FILE DATE: 07/01/2003

FILE TIME: 06:51

X CENTROID: -0.188

Y CENTROID: -0.023

POA TO CENTROID: 0.190

HORZ SPREAD: 1.834

VERT SPREAD: 2.125

GROUP SPREAD: 2.130

MIN RADIUS: 0.511

MAX RADIUS: 1.352

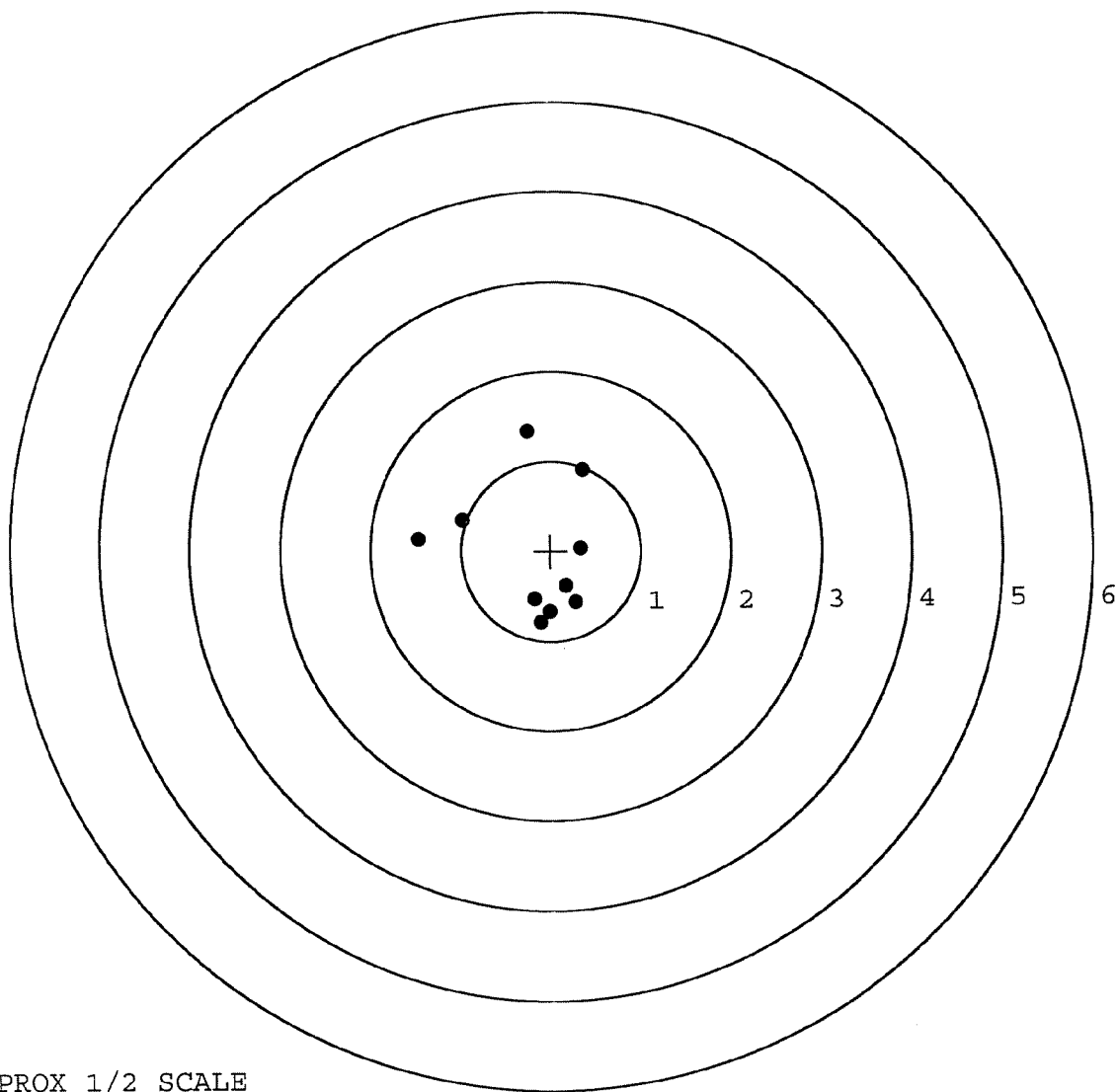
MEAN RADIUS: 0.832

IN 1 IN DIAMETER: 0

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.984	0.344
2:	-1.470	0.135
3:	0.364	0.901
4:	-0.259	1.327
5:	0.337	0.029
6:	-0.119	-0.798
7:	-0.183	-0.534
8:	-0.017	-0.675
9:	0.277	-0.571
10:	0.171	-0.389



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300465. 0

TARGET NUMBER: 2

FILE DATE: 07/01/2003

FILE TIME: 06:51

POINT#	X	Y
1:	1.157	-0.978
2:	-0.603	-0.571
3:	-0.884	0.273
4:	-0.267	0.777
5:	0.024	0.599
6:	0.041	-0.314
7:	0.227	0.039
8:	0.402	-0.230
9:	0.656	-0.432
10:	0.432	-0.501

X CENTROID: 0.118

Y CENTROID: -0.134

POA TO CENTROID: 0.179

HORZ SPREAD: 2.041

VERT SPREAD: 1.755

GROUP SPREAD: 2.394

MIN RADIUS: 0.196

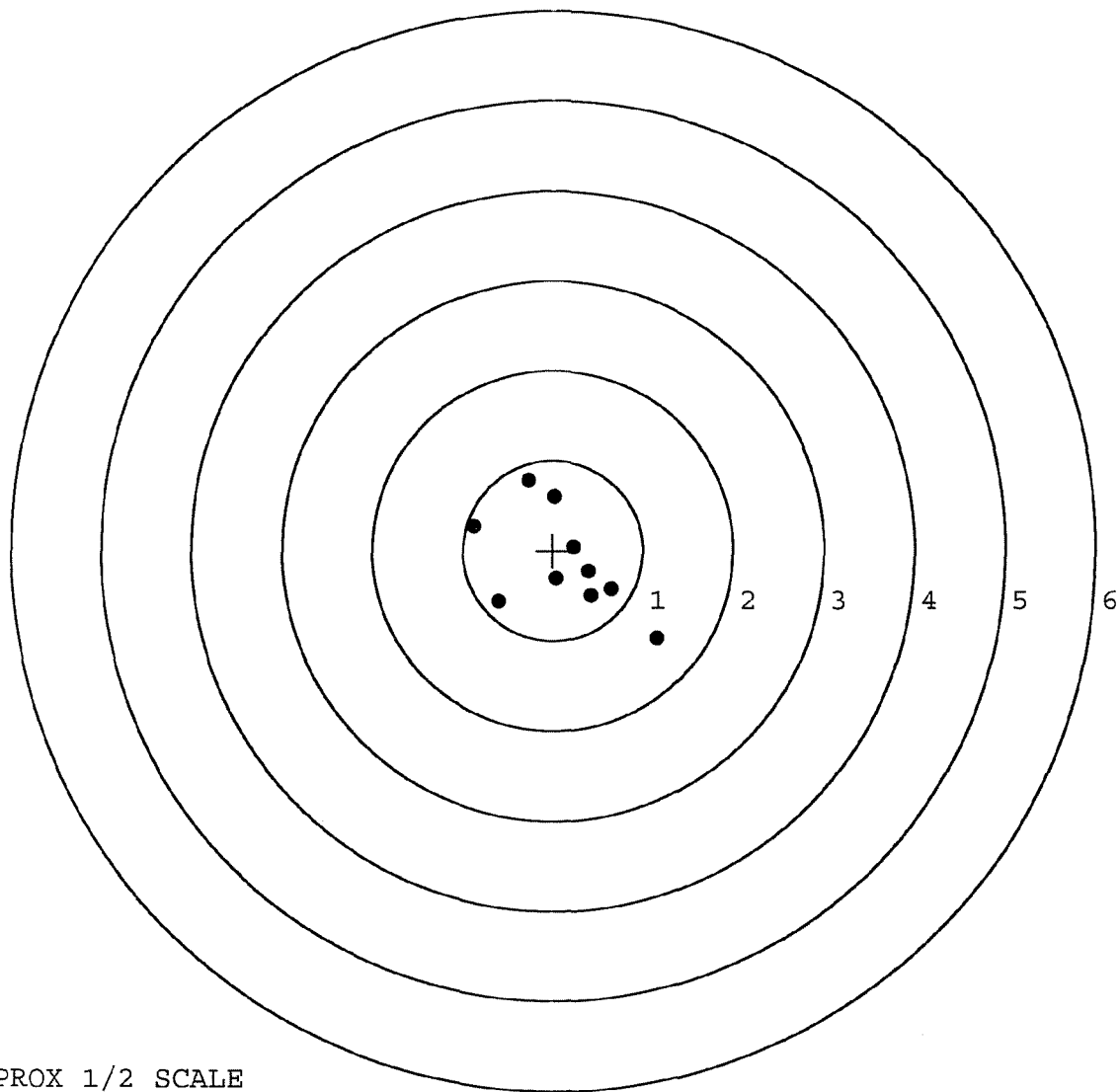
MAX RADIUS: 1.338

MEAN RADIUS: 0.679

IN 1 IN DIAMETER: 4

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300465. __0

TARGET NUMBER: 3

FILE DATE: 07/01/2003

FILE TIME: 06:51

X CENTROID: -0.119

Y CENTROID: 0.029

POA TO CENTROID: 0.123

HORZ SPREAD: 1.839

VERT SPREAD: 1.926

GROUP SPREAD: 2.409

MIN RADIUS: 0.247

MAX RADIUS: 1.376

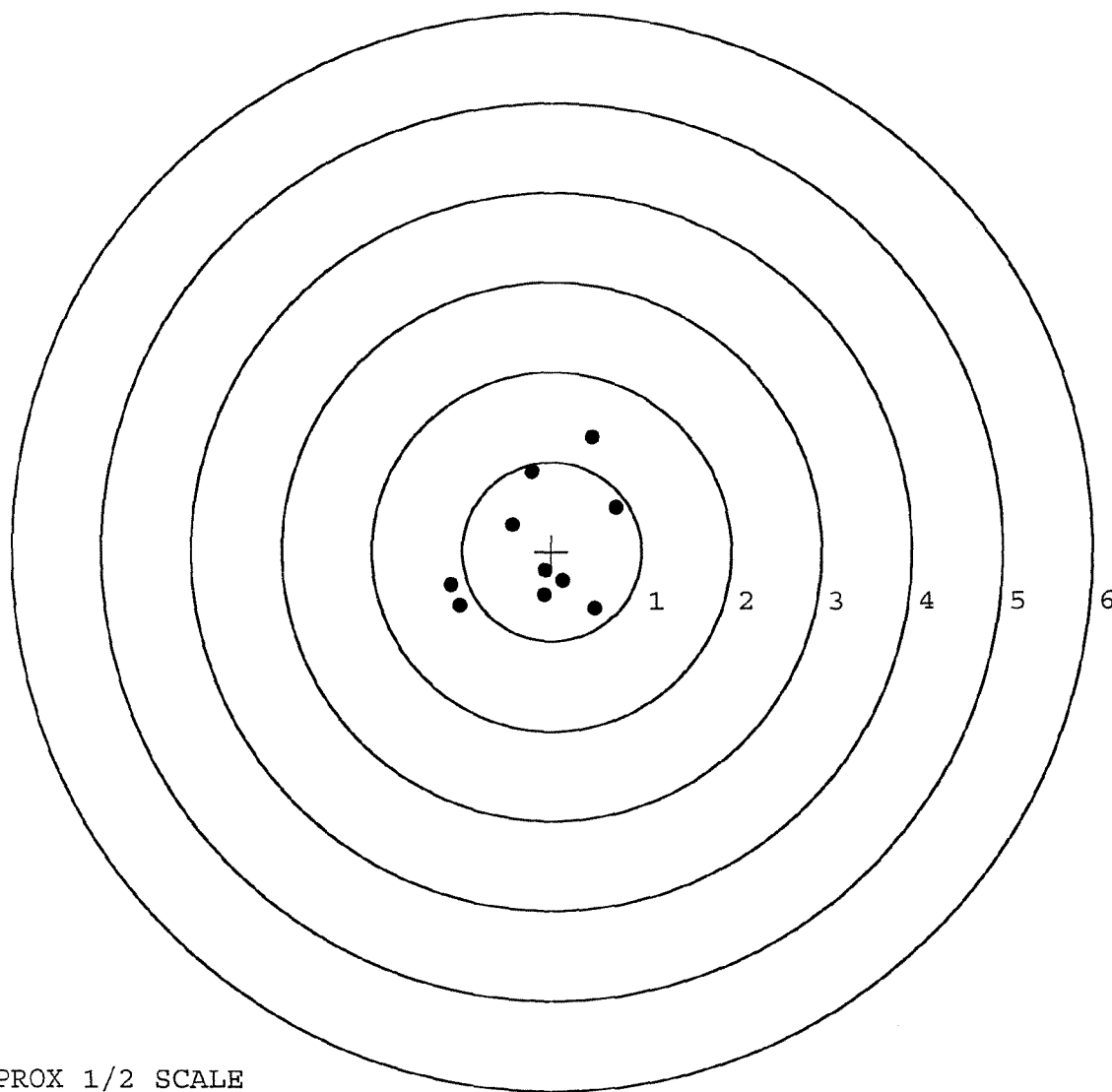
MEAN RADIUS: 0.793

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.030	-0.618
2:	-1.123	-0.385
3:	0.716	0.497
4:	0.454	1.280
5:	-0.225	0.892
6:	-0.437	0.302
7:	0.485	-0.646
8:	0.127	-0.328
9:	-0.083	-0.492
10:	-0.075	-0.214



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300465. __0

TARGET NUMBER: 4

FILE DATE: 07/01/2003

FILE TIME: 06:51

POINT#	X	Y
1:	0.436	-1.124
2:	0.513	0.548
3:	-2.172	-0.144
4:	0.072	0.341
5:	-0.141	0.504
6:	-0.370	0.514
7:	0.037	-0.213
8:	0.001	-0.444
9:	0.011	-0.635
10:	-0.136	-0.840

X CENTROID: -0.175

Y CENTROID: -0.149

POA TO CENTROID: 0.230

HORZ SPREAD: 2.685

VERT SPREAD: 1.672

GROUP SPREAD: 2.786

MIN RADIUS: 0.221

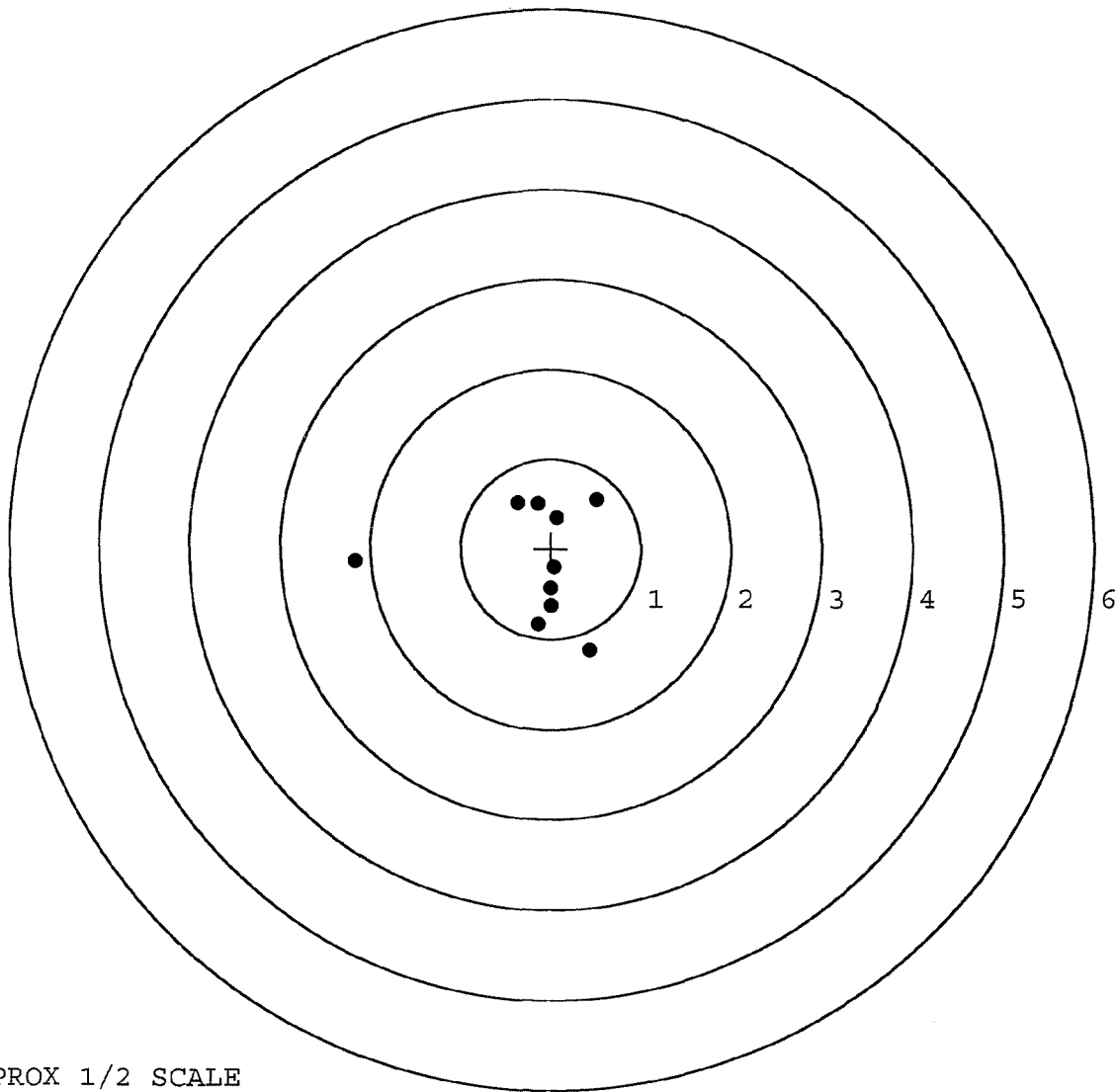
MAX RADIUS: 1.997

MEAN RADIUS: 0.780

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300465. __0

TARGET NUMBER: 5

FILE DATE: 07/01/2003

FILE TIME: 06:51

X CENTROID: 0.171

Y CENTROID: 0.048

POA TO CENTROID: 0.178

HORZ SPREAD: 1.171

VERT SPREAD: 1.943

GROUP SPREAD: 1.984

MIN RADIUS: 0.201

MAX RADIUS: 1.043

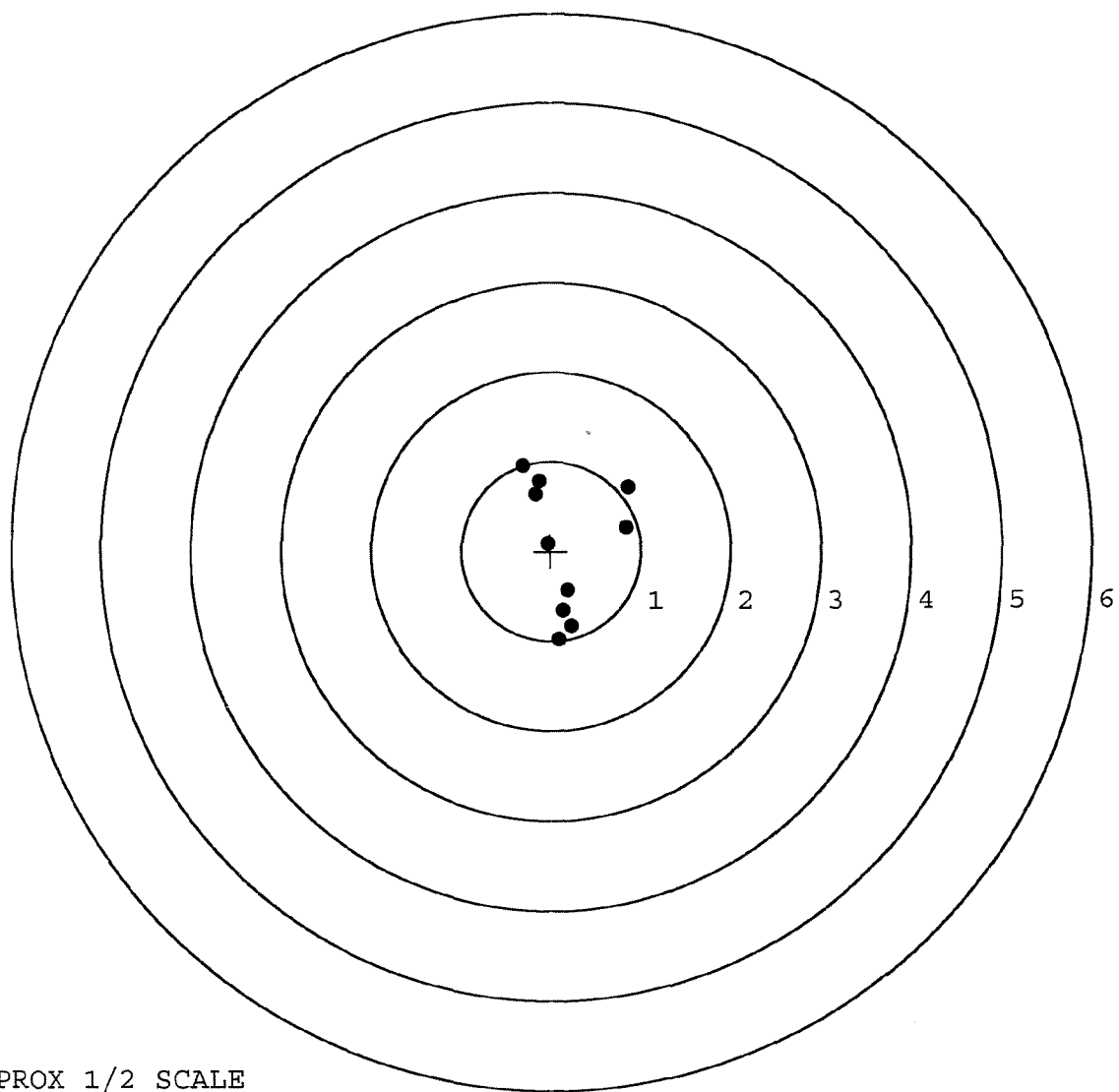
MEAN RADIUS: 0.747

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.838	0.264
2:	0.862	0.708
3:	0.092	-0.992
4:	0.229	-0.835
5:	0.140	-0.665
6:	0.188	-0.437
7:	-0.027	0.081
8:	-0.173	0.628
9:	-0.128	0.779
10:	-0.309	0.951



TARGET APPROX 1/2 SCALE