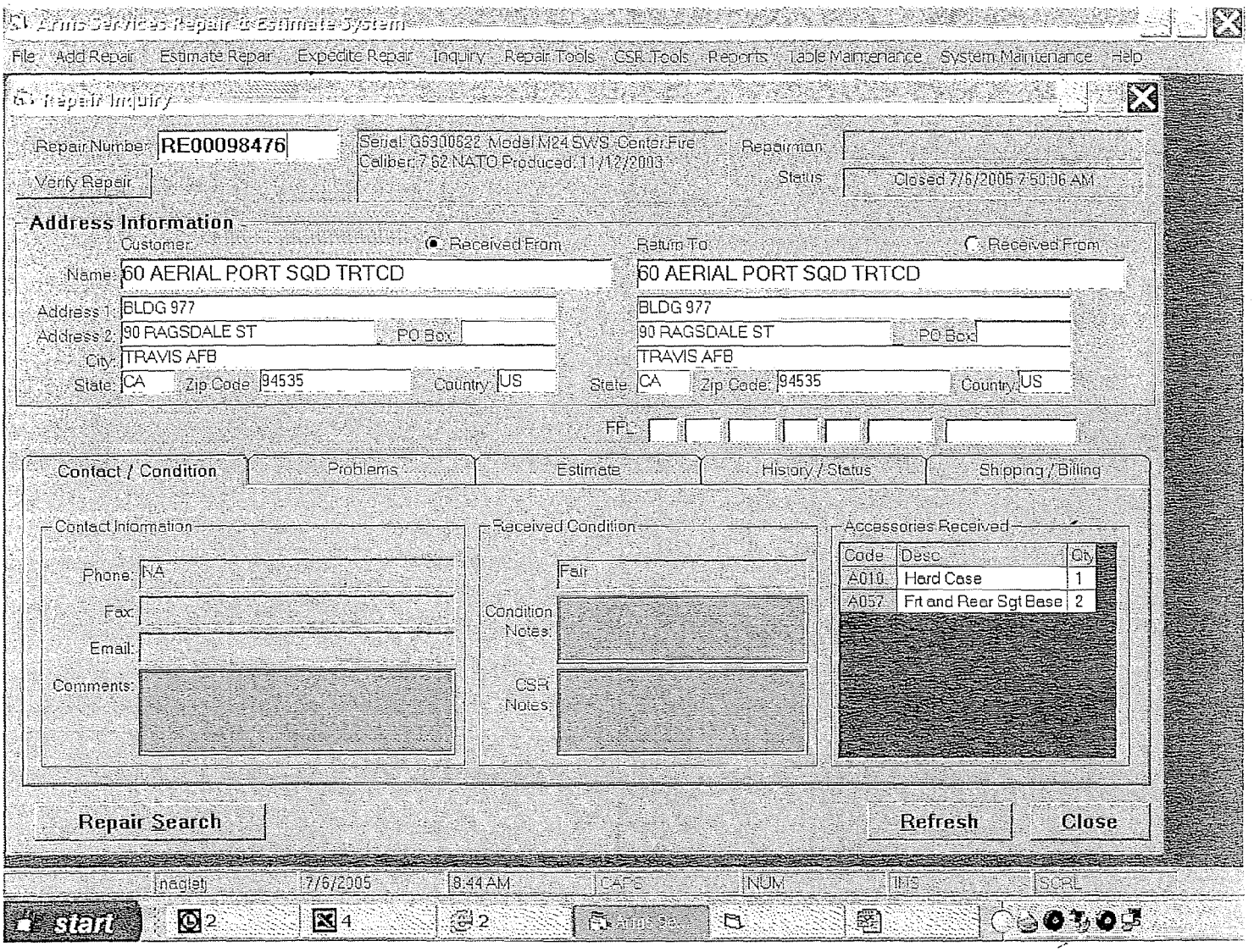
G63006222



Serial Number: G6300622

Model: M24 SWS

RE00098476

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

R & E NUMBER	98476		
SERIAL NUMBER	C06300622		
LOG-IN DATE	7-6-05		
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIA
550	DIS-ASSEMBLE GUN		
560 A	RE-BARREL	7-12-05	RTC
B	DRILL AND TAP		
575	ASSEMBLE		
600	PROOF		
605	CHECK HEADSPACE		
610	DIS-ASSEMBLE GUN	N.A.	
612	MAGNAFLUX		
615	ROLLMARK CALIBER		
618	ROTO-BLAST		
620	APPLY COATINGS	7-18-05	~~MT~~ HP
625 A	FINAL ASSEMBLY		
B	TRIGGER PULL TEST		
C	SAFETY "ON" FORCE	8-26-05	AC
D	SAFETY "OFF" FORCE	8-26-05	AC
E	FIRING PIN INDENT	8-26-05	AC
640	TARGET		
655	FINAL INSPECT	8-26-05	AC
660	PACK	8-27-05	WA
		SHIP DATE	
	QAR INSPECTION DATE		

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC

0 47700 25716 7

ORDER 25716

M/24 7.62 NATO S.W.S. (COMPLETE SYST

UPC

0 47700 25716 7

SERIAL NO.

G6300622

M/24 7.62 NATO S.W.S. (COMPLETE SYSTEM)

BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

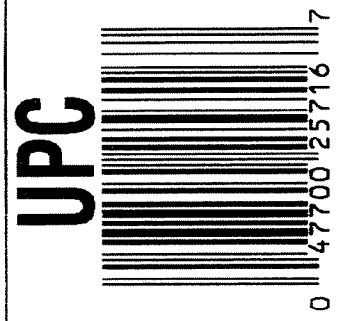
– INSTUCTION BOOK 3518

46 FORM

ORDER NO. 25716

BARREL LENGTH	24"
CAPACITY	6

G6300622



INSPECTION CHECKLIST-NEW GUNS

GUN SERIAL # G6300622

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		5/20/03	RTL
600	PROOF		5-21-03	AC
607	CHECK HEADSPACE	MAGNA - FLUX INSPECTED MAY 21 2003 OPERATOR	5/22/03	RTL
610	DIS-ASSEMBLE GUN		5/22/03	RTL
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER		6-2-03	JB
617	DRILL AND TAP SIGHT HOLES		5-28-03	TRW
620	APPLY COATINGS (BARREL ACTION)		6-13	DA
	(BOLT)		6-13	DA
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		7-7-03	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		7-7-03	DA
	C) INSPECT EJECTOR HOLE FOR CHAMFER		7-7-03	DA
	D) OIL FIRING PIN ASSEMBLY		7-7-03	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)	5.5	6.0	5.5	8/12/03	DA
CONT.	G) SAFETY OFF FORCE (2 LBS MIN)	2.0	2.5	2.0	8/12/03	DA
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT (.020 MIN)	.021	.021	.021	8/12/03	DA
	J) ASSEMBLE STOCK				7/30/03	RW
	K) ASSEMBLE SWIVEL STUDS				11/11/03	RW
	L) ATTACH FRONT AND REAR SIGHT ASSY'S				7/30/03	RW
	M) IRON SIGHT ALIGNMENT				7/30/03	RW
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER				7/30/03	RW
640	GALLERY TEST AND TARGET	PASS	FAIL		8-5-03	AC
	MALFUNCTION	CORRECTION			8-5-03	AC
	MALFUNCTION	CORRECTION			8-5-03	AC
	MALFUNCTION	CORRECTION			8-5-03	AC
	MALFUNCTION	CORRECTION			8-5-03	AC
645	INSPECT FOR LIVE AMMO				8-5-03	AC
655	FINAL INSPECTION A) HEADSPACE				11/11/03	RW
	B) TRIGGER PULL (+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS)	2.40	2.47	2.49	2.45	2.37	8/12/03	DA
	C) FUNCTION				11/11/03	RW
660	PACK				11/12/03	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 7-22-03

TESTER TRW

	2.50 LBS INITIAL	2.50 LBS AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50 LBS		COMMENTS
PULL #1	2.43	2.44		2.28	
PULL #2	2.60	2.36		2.17	
PULL #3	2.61	2.40		2.20	
PULL #4	2.66	2.39		2.34	
PULL #5	2.62	2.20		2.30	
TOTAL	12.92	11.79		11.29	
AVERAGE	2.58	2.35		2.25	

	3.00 LBS INITIAL	3.00 LBS AFTER 20 CYCLES		COMMENTS
PULL #1	3.25	3.03		
PULL #2	3.13	3.18		
PULL #3	3.05	3.14		
PULL #4	3.03	3.20		
PULL #5	3.18	3.00		
TOTAL	15.64	15.55		
AVERAGE	3.12	3.11		

	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	4.28	4.38		4.11
PULL #2	4.06	4.30		4.25
PULL #3	4.06	4.14		4.34
PULL #4	4.10	4.31		4.17
PULL #5	4.15	4.17		4.14
TOTAL	20.65	21.30		21.01
AVERAGE	4.13	4.26		4.20

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFOMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6300622.__0
FILE DATE AND TIME: 08/05/2003 06:50

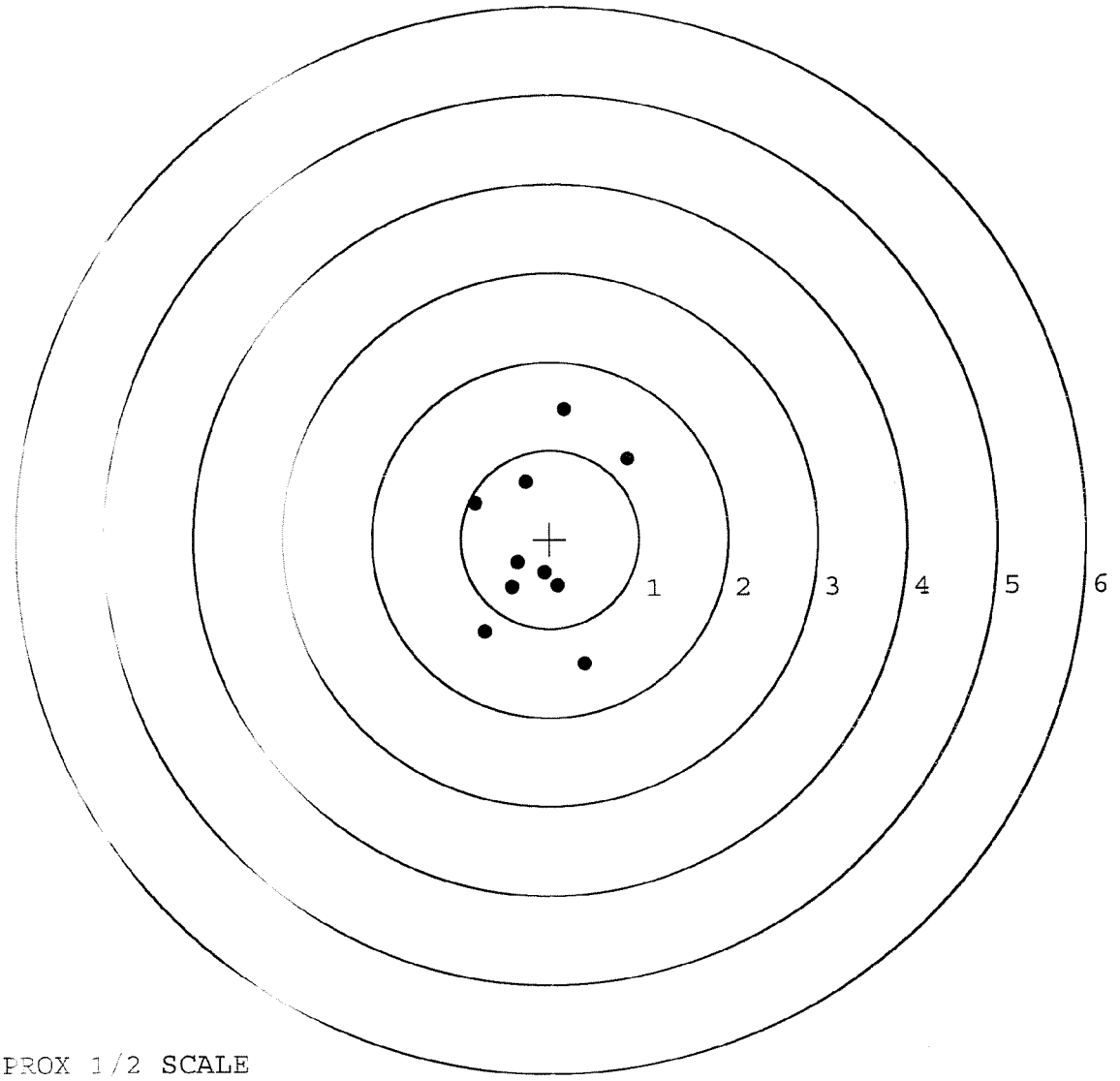
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.074
The Average Y Centroid of the Five Target Set:	-0.004
The Average Point of Impact of the Five Target Set:	0.074
The Average Mean Radius of the Five Target Set:	0.781
The Distance from POA to Centroid Target #1:	0.137
The Distance from Centroid Target #2 to Centroid Target #1:	0.242
The Distance from Centroid Target #3 to Centroid Target #1:	0.187
The Distance from Centroid Target #4 to Centroid Target #1:	0.010
The Distance from Centroid Target #5 to Centroid Target #1:	0.188

SERIAL NUMBER: G6300622__0
TARGET NUMBER: 1
FILE DATE: 08/0[illegible]/2003
FILE TIME: 06:5[illegible]

X CENTROID:	-0.1[illegible]
Y CENTROID:	-0.0[illegible]
POA TO CENTROID:	0.1[illegible]
HORZ SPREAD:	1.7[illegible]
VERT SPREAD:	2.8[illegible]
GROUP SPREAD:	2.8[illegible]
MIN RADIUS:	0.3[illegible]
MAX RADIUS:	1.5[illegible]
MEAN RADIUS:	0.8[illegible]
# IN 1 IN DIAMETER:	3
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	0.171	1.463
2:	0.879	0.895
3:	-0.268	0.640
4:	-0.839	0.413
5:	0.092	-0.522
6:	-0.061	-0.377
7:	-0.363	-0.264
8:	-0.427	-0.538
9:	-0.738	-1.040
10:	0.393	-1.403

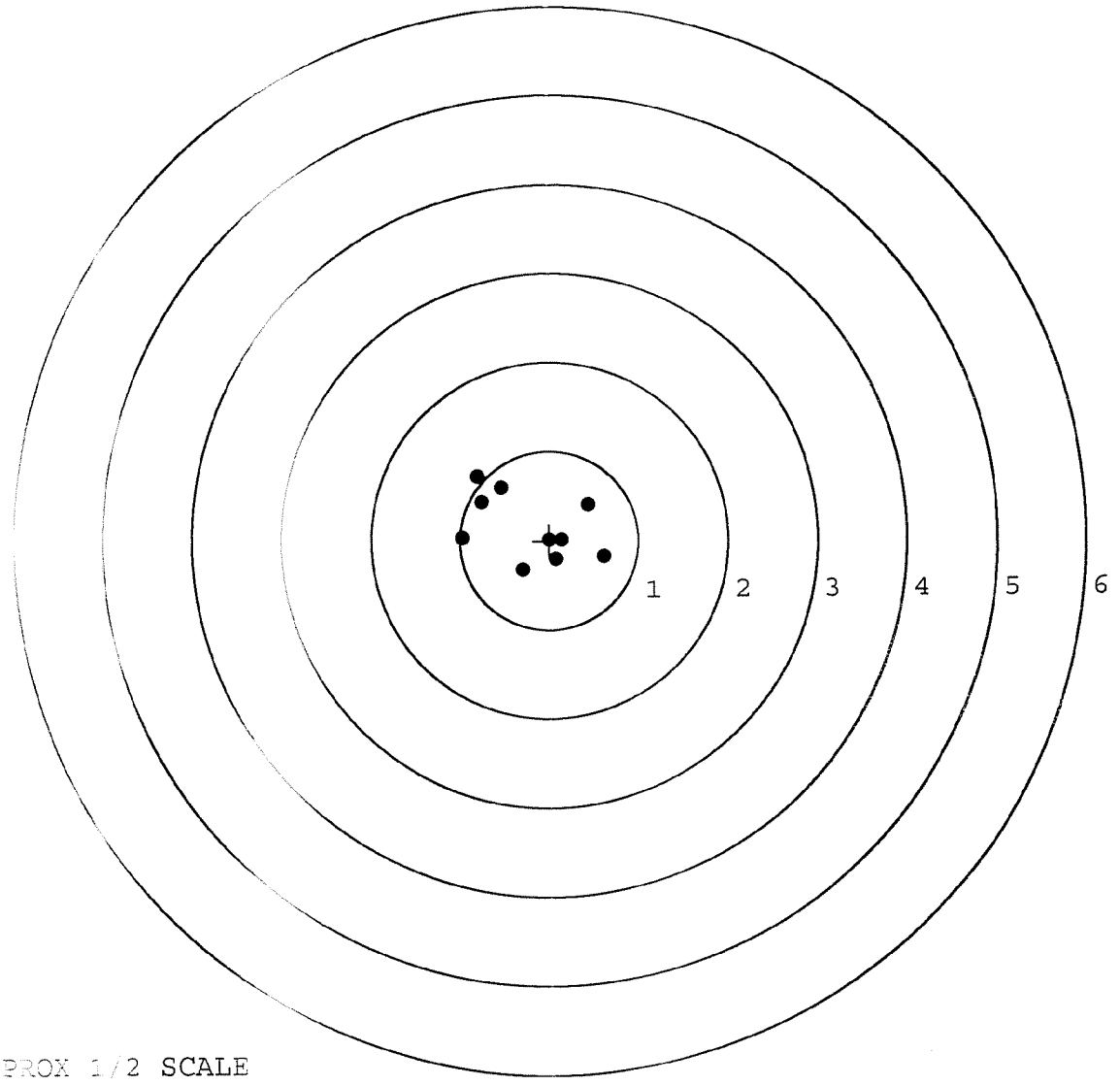


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300622.__0
TARGET NUMBER: 2
FILE DATE: 08/0[illegible]/2003
FILE TIME: 06:5[illegible]

X CENTROID:	-0.210
Y CENTROID:	0.150
POA TO CENTROID:	0.258
HORZ SPREAD:	1.590
VERT SPREAD:	1.058
GROUP SPREAD:	1.685
MIN RADIUS:	0.248
MAX RADIUS:	0.891
MEAN RADIUS:	0.593
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	10
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.804	0.722
2:	-0.537	0.594
3:	-0.758	0.438
4:	-0.974	0.040
5:	0.442	0.402
6:	0.616	-0.185
7:	0.143	0.013
8:	-0.003	0.013
9:	-0.296	-0.330
10:	0.074	-0.209

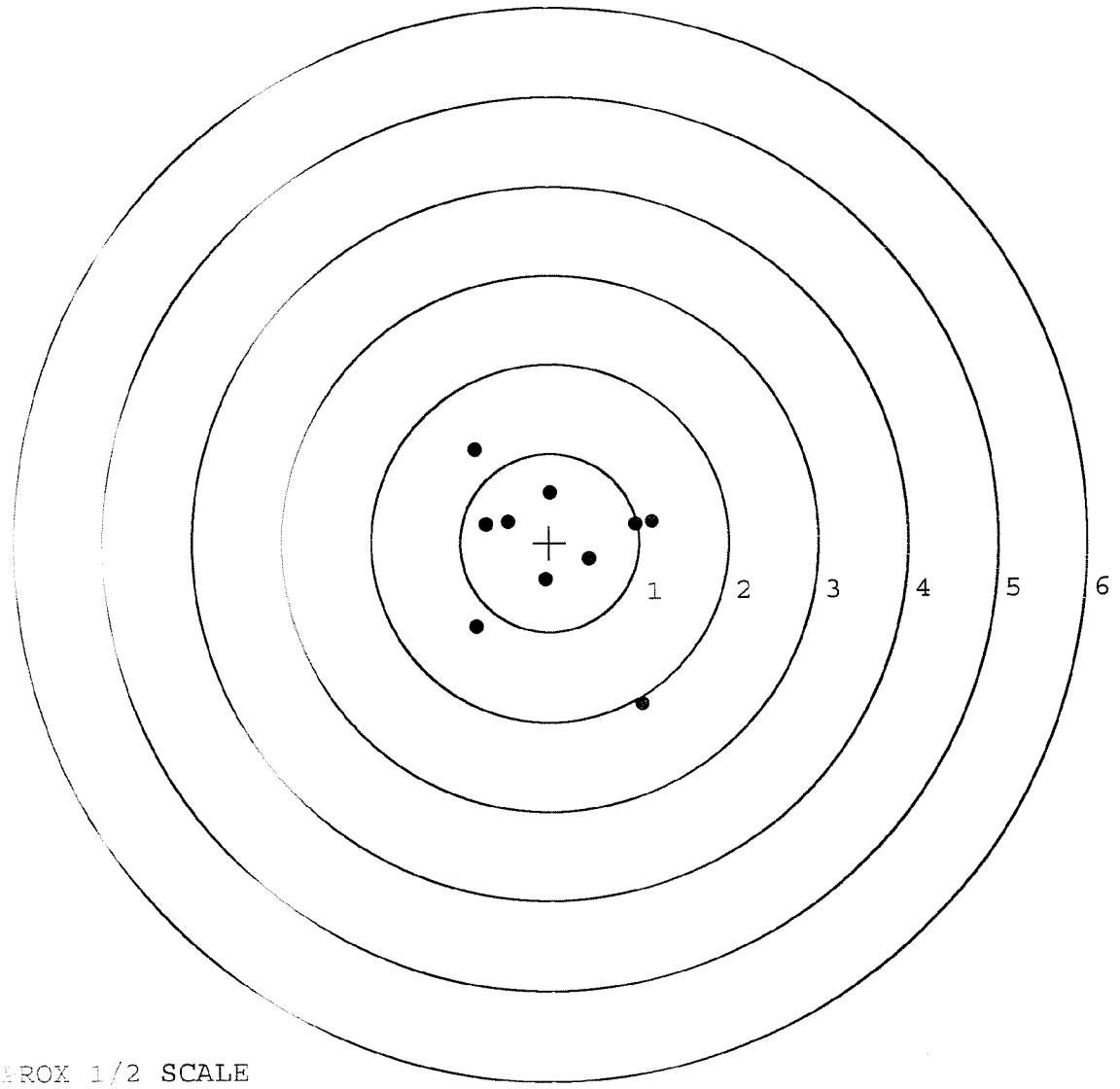


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300622.__0
TARGET NUMBER: 3
FILE DATE: 08/0[illegible]/2003
FILE TIME: 06:5[illegible]

X CENTROID:	0.070
Y CENTROID:	-0.086
POA TO CENTROID:	0.111
HORZ SPREAD:	1.975
VERT SPREAD:	2.863
GROUP SPREAD:	3.412
MIN RADIUS:	0.354
MAX RADIUS:	1.971
MEAN RADIUS:	0.957
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	6
# in 3 IN DIAMETER:	9

POINT#	X	Y
1:	1.023	-1.811
2:	-0.833	1.052
3:	-0.713	0.209
4:	-0.463	0.238
5:	-0.824	-0.941
6:	-0.051	-0.418
7:	0.011	0.562
8:	0.445	-0.187
9:	0.966	0.206
10:	1.142	0.232

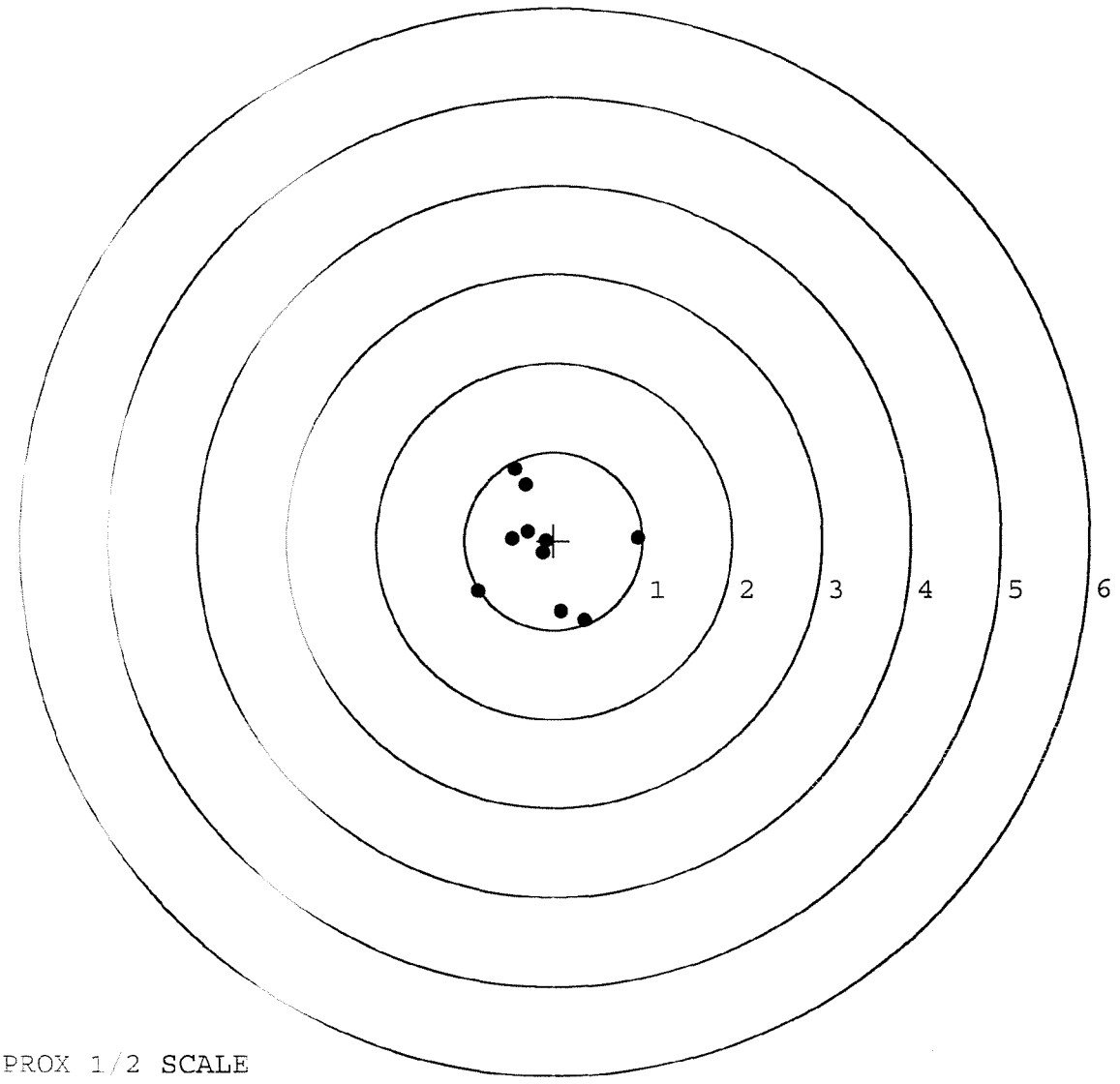


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300622.__0
TARGET NUMBER: 4
FILE DATE: 08/0[illegible]/2003
FILE TIME: 06:5[illegible]

X CENTROID:	-0.118
Y CENTROID:	-0.083
POA TO CENTROID:	0.144
HORZ SPREAD:	1.804
VERT SPREAD:	1.708
GROUP SPREAD:	1.901
MIN RADIUS:	0.063
MAX RADIUS:	1.076
MEAN RADIUS:	0.608
# IN 1 IN DIAMETER:	4
# IN 2 IN DIAMETER:	9
# in 3 IN DIAMETER:	10

POINT#	X	Y
1:	-0.439	0.813
2:	-0.314	0.628
3:	-0.852	-0.571
4:	0.083	-0.796
5:	0.350	-0.895
6:	0.952	0.028
7:	-0.293	0.101
8:	-0.460	0.023
9:	-0.088	-0.013
10:	-0.123	-0.146

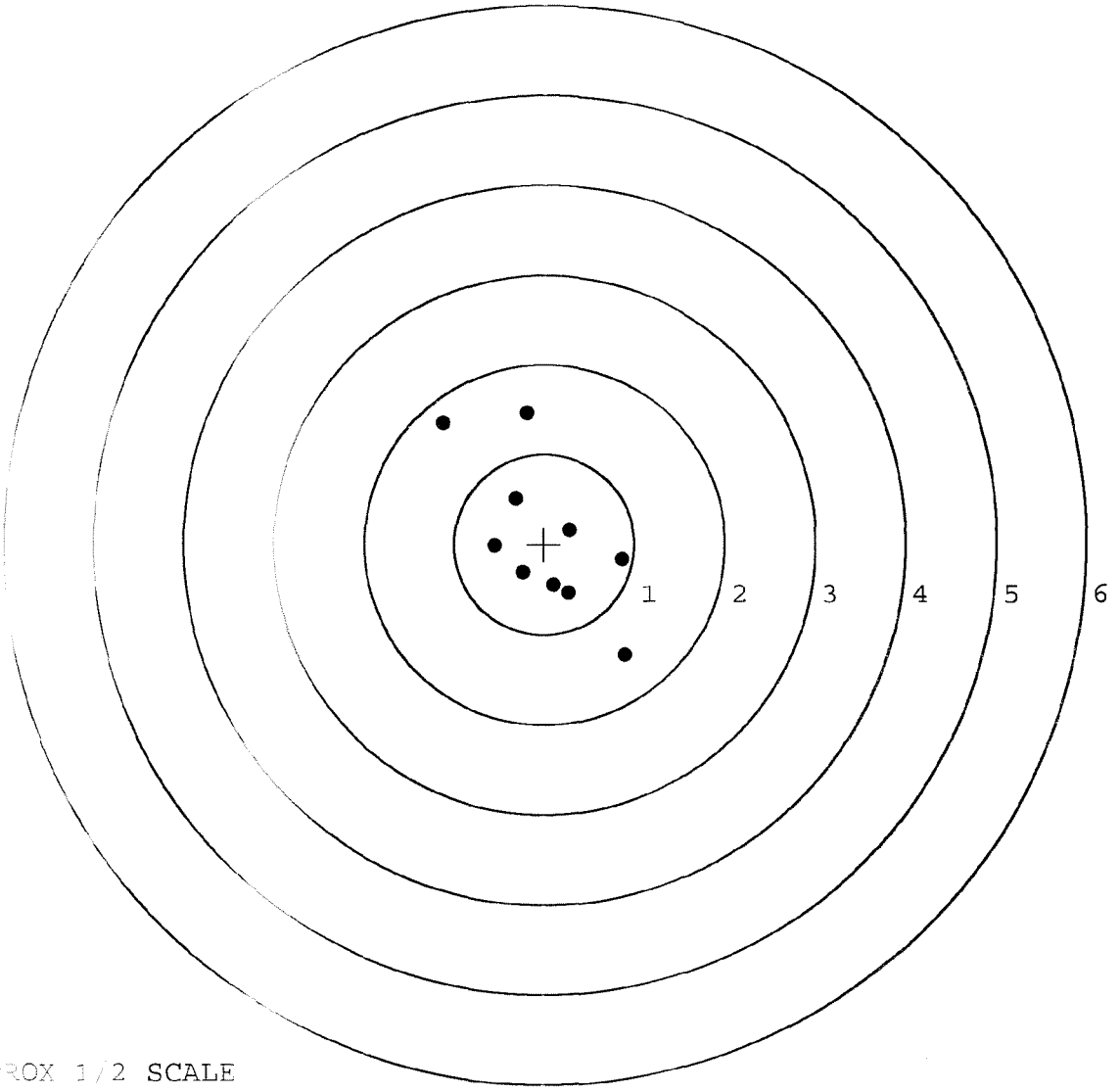


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6300622.__0
TARGET NUMBER: 5
FILE DATE: 08/05/2003
FILE TIME: 06:50

X CENTROID:	0.003
Y CENTROID:	0.073
POA TO CENTROID:	0.073
HORZ SPREAD:	2.022
VERT SPREAD:	2.687
GROUP SPREAD:	3.274
MIN RADIUS:	0.293
MAX RADIUS:	1.696
MEAN RADIUS:	0.865
# IN 1 IN DIAMETER:	2
# IN 2 IN DIAMETER:	7
# in 3 IN DIAMETER:	8

POINT#	X	Y
1:	-1.121	1.343
2:	-0.196	1.455
3:	-0.317	0.506
4:	0.288	0.160
5:	0.873	-0.169
6:	0.901	-1.232
7:	0.278	-0.546
8:	0.110	-0.454
9:	-0.239	-0.319
10:	-0.552	-0.017



TARGET APPROX 1/2 SCALE