

FORM

UPC



0 47700 25716 2

C6665830

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700™ M24**

SERIAL NO.

C6665830

ORDER NO.

5716

20

MADE IN ILION, N.Y. U.S.A. Reg. U.S. Pat & Tm. Off, Marca Registrada Marque Deposee.



5716 C6665830

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

ORDER 5716

MODEL 700™ M24

UPC

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # *C6665830*

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	<i>10 1</i>	<i>91</i>	<i>AW</i>
600	Proof	<i>10 1</i>	<i>91</i>	<i>AW</i>
607	Check Headspace	<i>10 1</i>	<i>91</i>	<i>AW</i>
610	Dis-assemble Gun	<i>10 1</i>	<i>91</i>	<i>AW</i>
612	Magnaflux Barrel Action		OCT 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	GL
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11-2-91	<i>[Signature]</i>
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		12/20/91	WB

op. #	BARBER - M24 0103080 OF. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12/26/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			12/26/91	WB
	H) Trigger Pull Test & Retainability						12/26/91	WB
	I) Firing Pin Indent	.0215	.022	.0215			12/26/91	WB
	J) Assemble Stock							
	K) Assemble Swivel Studs						12-31-91	WB
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						12-31-91	A
	A) Time						12-31-91	A
	B) Malfunctions						12-31-91	A
	C) Pierced Primers						12-31-91	A
	D) Optical Clarity of Scope						12-31-91	A
645	Inspect for Live Ammo						12-31-91	A
655	Final Inspection						12-31-91	A
	A) Headspace						12-31-91	A
	B) Trigger Pull	2.28	2.16	2.15	2.17	2.12	12/31/91	WB
	C) Function						12-31-91	A
660	Pack						2-25-92	VF

TTC STAG

CENTROIDAL DISTANCE CALCULATIONS

0001 FILE # 06665830

21 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.180801
1 TO 2	.182989
2 TO 3	.126823
3 TO 4	.152069
4 TO 5	.148553

24

-----POB

X-COORDINATE FOR THIS RIFLE IS: -.1486

Y-COORDINATE FOR THIS RIFLE IS: .09

AVERAGE POI RADIUS FOR THIS RIFLE IS: .17373

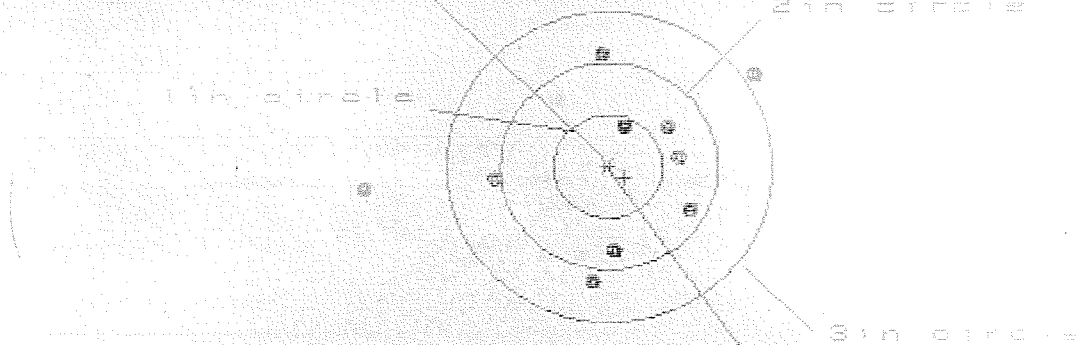
RIFLE IS: .9604

10 Oct 1997

FILE:/PATTERNING/CENTERFIRE_PATT/C6665930

CENTERFIRE PATTERNS

PCH



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 8

HS= 3.594

VS= 2.189

GS= 3.759

CENTROID #

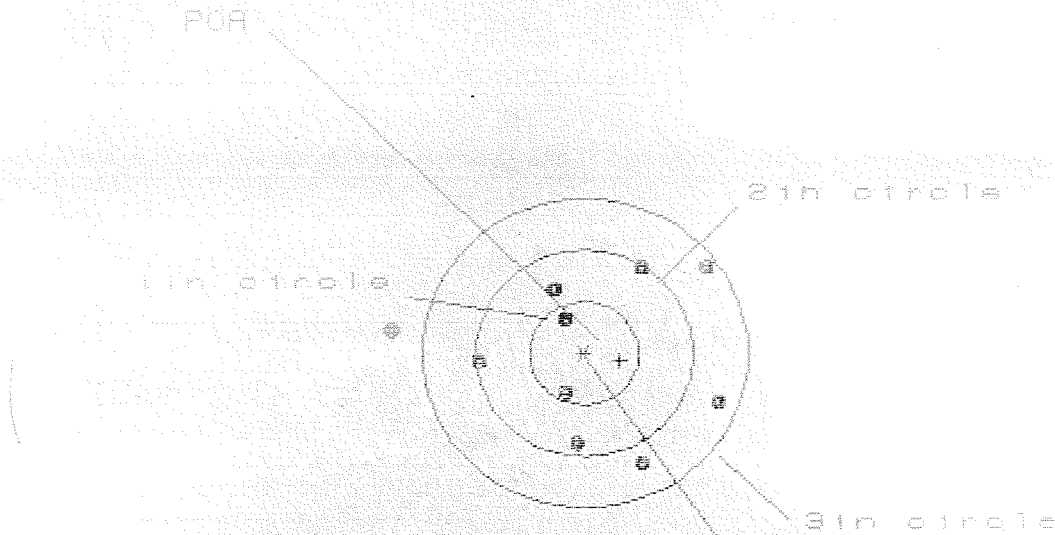
PATTERN

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.387	1.142	.691
MINIMUM X	-2.207	-1.344	-1.201
MAXIMUM Y	1.051	1.023	1.126
MINIMUM Y	-1.138	-1.166	-1.063
CENTROID X	-.145	.100	-.043
CENTROID Y	.108	.136	.033
FOR TO CENTROID IN.	.181	.169	.054
MIN RADIUS	.452	.395	.497
MEAN RADIUS	1.072	.890	.843
MAX RADIUS	2.221	1.408	1.201
HORIZONTAL SPREAD	3.594	2.486	1.892
VERTICAL SPREAD	2.189	2.189	2.189
EXTREME SPREAD	3.759	2.664	2.192
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	5	
NUMBER IN THREE INCH CIRCLE	=	8	

31 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06665830

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 9

CENTROID #

HS = 2.955

VS = 1.887

GS = 3.035

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.213	1.019	1.141
MINIMUM X	-1.742	-1.172	-1.050
MAXIMUM Y	.836	.857	.964
MINIMUM Y	-1.051	-1.030	-.923
CENTROID X	-.324	-.130	-.252
CENTROID Y	.070	.049	-.058
POA TO CENTROID IN.	.331	.139	.259
MIN RADIUS	.413	.551	.400
MEAN RADIUS	1.004	.927	.856
MAX RADIUS	1.752	1.299	1.202
HORIZONTAL SPREAD	2.955	2.191	2.191
VERTICAL SPREAD	1.887	1.887	1.887
EXTREME SPREAD	3.035	2.336	2.231
NUMBER IN ONE INCH CIRCLE	= 2		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 9		

01 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665830

CENTERFIRE PATTERNS # 3

PCA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 2

2in = 3

3in = 7

HS= 3.428

VS= 2.959

GS= 3.772

PATTERN #

3

SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.024	2.128	1.196
MINIMUM X	-1.404	-1.300	-1.034
MAXIMUM Y	2.011	1.204	1.135
MINIMUM Y	-1.948	-1.725	-1.794
CENTROID X	-0.667	-1.171	-1.437
CENTROID Y	.008	-.215	-.146
PCA TO CENTROID in.	.068	.275	.461
MIN RADIUS	.281	.386	.261
MEAN RADIUS	1.170	1.049	.894
MAX RADIUS	2.218	2.199	1.304
HORIZONTAL SPREAD	3.428	3.428	2.230
VERTICAL SPREAD	2.959	1.929	1.929
EXTREME SPREAD	3.772	3.432	2.516
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		7	

01 Dec 1981

FILE: \PATTERNING\CENTERFIRE_PATT\08685830

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

* OF SHOTS = 10

IN CIR

1 in = 0

2 in = 5

3 in = 8

HS = 2.309

VS = 2.813

GS = 3.769

CENTROID *

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.142

.990

.832

MINIMUM X

-1.367

-1.051

-.927

MAXIMUM Y

1.605

1.207

1.078

MINIMUM Y

-1.208

-1.029

-.899

CENTROID X

-.170

-.018

-.142

CENTROID Y

.285

.106

.235

POA TO CENTROID IN

.332

.108

.275

MIN RADIUS

.604

.380

.547

MEAN RADIUS

1.061

.921

.853

MAX RADIUS

2.108

1.429

1.078

HORIZONTAL SPREAD

2.509

2.041

1.759

VERTICAL SPREAD

2.813

2.236

1.977

EXTREME SPREAD

3.769

2.513

2.004

NUMBER IN ONE INCH CIRCLE =

0

NUMBER IN TWO INCH CIRCLE =

5

NUMBER IN THREE INCH CIRCLE =

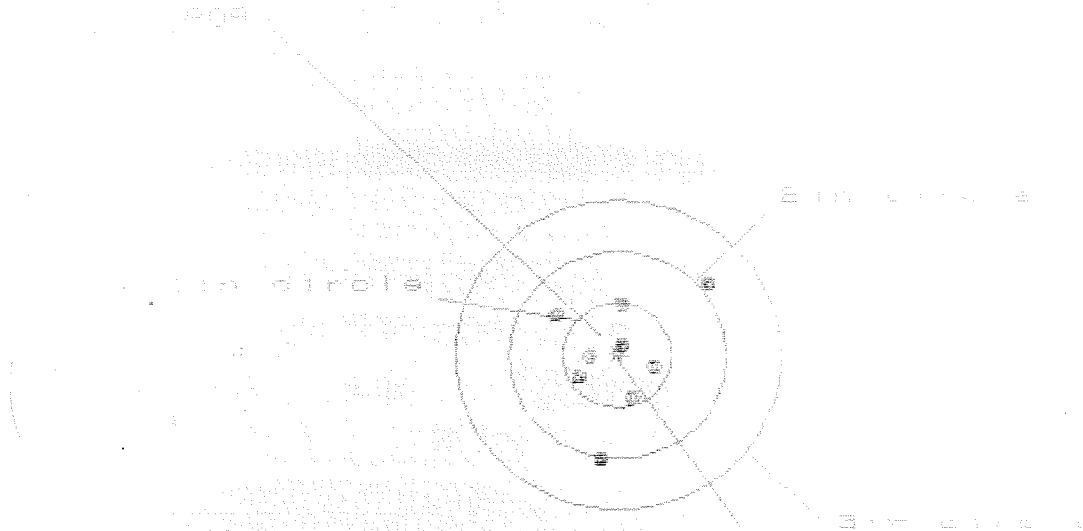
8

31 DEC 1991

FILE: PATTERNING/CENTERFIRE_PATT-06865030

CENTERFIRE PATTERNS

+ 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

CENTROID +

HS = 1.450

VS = 1.726

GS = 1.993

PATTERN #

5

SHOTS (BEST OF 5)	1	2	3
MAXIMUM X	.863	.394	.390
MINIMUM X	-.587	-.432	-.498
MAXIMUM Y	.706	.545	.428
MINIMUM Y	-1.020	-.942	-.443
CENTROID X	-.037	-.132	-.128
CENTROID Y	.006	-.072	.045
COG TO CENTROID IN	.037	.131	.136
MIN RADIUS	.067	.131	.105
MEAN RADIUS	.495	.432	.350
MAX RADIUS	1.115	.842	.638
HORIZONTAL SPREAD	1.450	.986	.886
VERTICAL SPREAD	1.726	1.487	.871
EXTREME SPREAD	1.993	1.529	1.134
SMALL 100 INCH CIRCLE	7	8	8
MEDIUM 100 INCH CIRCLE	8	8	8
LARGE 100 INCH CIRCLE	10	10	10

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

SERIAL NO. C6665830DATE 12/26/91TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.43	2.52	2.60	2.28	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.58	2.40	2.64	2.16	
PULL #3	2.54	2.38	2.63	2.15	
PULL #4	2.51	2.49	2.52	2.17	
PULL #5	2.47	2.46	2.57	2.12	
TOTAL	12.53	12.25	12.96	10.88	
AVG.	2.51	2.45	2.59	2.18	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	3.15		
PULL #2	3.08	3.15		
PULL #3	3.19	3.07		
PULL #4	3.00	3.13		
PULL #5	3.00	3.15		
TOTAL	15.35	15.65		
AVG.	3.07	3.13		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.34		4.32
PULL #2	4.19	4.38		4.36
PULL #3	4.26	4.22		4.23
PULL #4	4.17	4.24		4.34
PULL #5	4.20	4.29		4.36
TOTAL	21.02	21.47		21.61
AVG.	4.20	4.29		4.32

LOT RAC90C-001-
008

ENDURANCE GUN

GUN SERIAL #

C6348985

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		12-20 89	RW
600	Proof		12-20 89	#
607	Check Headspace		12-20 89	#
610	Dis-assemble Gun		12-20 89	RW
612	Magnaflux Barrel Action		1-5-90	KCR
	Magnaflux Bolt		1-5-90	
615	Rollmark Caliber		1/3/90	GB
617	Drill and Tap Sight Holes		1/8/90	FB
618	Polish Barrel <i>AB</i>		1/10/90	WB
620	Apply Coatings (Barrel Action)		1-15-90	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/17/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/17/90	RW
	C) Inspect Ejector Hole for Chamfer		1/17/90	RW
	D) Oil Firing Pin Ass'y		1/17/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		2/2/90	GB

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			1-22-90	AC
	G) Safety Off Force	4	4	4			1-22-90	AC
	H) Trigger Pull Test & Retainability						2/29/90	WB
	I) Firing Pin Indent	.020	.020	.020			1-22-90	AC
	J) Assemble Stock						1/29/90	RW
	K) Assemble Swivel Studs						2/28/90	WB
	L) Attach Front and Rear Sight Assemblies						1/29/90	RW
	M) Iron Sight Alignment						1/29/90	RW
	N) Detach Front & Rear Sights & place in numbered container						1/29/90	RW
	O) Attach Scope to Rifle						2/26/90	WB
	P) Detach & Attach Scope 20 Times						2/26/90	WB
640	Gallery Target & Test						2-26-90	AC
	A) Time						2-26-90	AC
	B) Malfunctions						2-26-90	AC
	C) Pierced Primers						2-26-90	AC
	D) Optical Clarity of Scope						2-26-90	AC
645	Inspect for Live Ammo						2-26-90	AC
655	Final Inspection A) Headspace						2/28/90	WB
	B) Trigger Pull	2.44	2.38	2.24	2.42	2.48	2/27/90	WB
	C) Function						2/28/90	WB
660	Pack							

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6348985DATE 22 Jan 90TESTER PJL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	252	233	239	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	229	207	223	
PULL #3	227	231	234	
PULL #4	225	210	214	
PULL #5	224	214	224	
TOTAL	1157	1095	1134	
AVG.	2314	219	2268	

	3.00# INITIAL	3.00# AFTER 20 CYCLES	COMMENTS
PULL #1	304	290	
PULL #2	297	291	
PULL #3	288	279	
PULL #4	290	299	
PULL #5	291	295	
TOTAL	1479	1454	
AVG.	2958	2908	

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	397	406		422
PULL #2	383	414		404
PULL #3	388	408		409
PULL #4	410	388		408
PULL #5	404	414		423
TOTAL	1982	2030		2066
AVG.	3964	406		4132

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348985 SHOOTER DH DATE 2/28/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60-DH	OK	MONIE
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	20-DH	11	11
	TOTAL	440		
		60	TARGET	
	TOTAL	(500)		
	11	60-DH	3-1-90	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	30-DH	11	11
	TOTAL	(570)		
	TOTAL PAGE 1	1070		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348985 SHOOTER DH DATE 3/2/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60-DH	OK	NONE
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	TOTAL	(540)		
			3/5/90	
	11	60-DH	OK	NONE
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	30-DH	11	11
	TOTAL	(570)		
	TOTAL page 2	(1110)		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348985 SHOOTER DH DATE 3/6/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
7.62	60-DH	OK		NONIE
11	60-DH	11		11
11	60-DH	11		11
11	60-DH	11		11
11	60-DH	11		11
11	20-DH	11		11
TOTAL	320			
TOTAL PAGE	1-2-3			
	2500		3/6/90	
			MAGNAFLUX	
			Replaced Sean	Safety Cam -
			showed signs	of wear
				7/6/90 3/6/90

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348985 SHOOTER DH DATE 3/6/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60-DH	OK	NONE
	11	60-DH	11	11
	TOTAL	(120)		
	7.62	60-DH	3/7/90 OK	NONE
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	TOTAL	(540)		
	7.62	60-DH	3/8/90 OK	NONE
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	TOTAL	420		
		(1080)		

TOTAL PAGE 4

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348985 SHOOTER DH DATE 3/8/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60-DH	OK	NONE
	11	60-DH	3/9/90 11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	20-DH	11	11
	TOTAL	560		
	11	60-DH	3/10/90 OK	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	TOTAL	360		
	TOTAL PAGE 5	920		
	TOTAL PAGES 1-2-3-4-5	4500		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348985 SHOOTER DH DATE 3/12/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
762	60-DH	TARGET & ACCURACY OK	NONE	
TOTAL	4560	3/12/90		
11	60-DH	11	11	
11	60-DH	11	11	
11	60-DH	11	11	
11	60-DH	11	11	
11	60-DH	11	11	
11	60-DH	11	11	
11	20-DH	11	11	
TOTAL	(380)			
PAGES 1-2-3-4-5-6	4940			
	60	3/12/90	TARGET & ACCURACY	
	5000			

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348985 SHOOTER DH DATE 3/13/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60-DH	OK	NO NIE
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	40-DH	"	"
	TOTAL	1000		
		5000		
		6000		

SWS ENDURANCE TEST REPORT

SERIAL NO. 6348985 SHOOTER DH DATE 3/14/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
762	60-DH	OK	NONE	
"	60-DH	"	"	
"	60-DH	"	"	
"	60-DH	"	"	
"	60-DH	"	"	
"	60-DH	"	"	
"	60-DH	"	"	
"	60-DH	"	"	
"	60-DH	"	"	
"	60-DH	"	"	
"	* 60-DH	"	"	
"	60-DH	"	"	
"	60-DH	"	"	
"	60-DH	"	"	
"	60-DH	"	"	
"	60-DH	"	"	
"	60-DH	"	"	
"	40-DH	"	"	
TOTAL	1000			
	6000			
	7000			

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348985 SHOOTER DH DATE 3/15/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	762	60-DH	OK	NONE
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	*60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	40-DH	"	"
	TOTAL	1000		
		7000		
		8000		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348985 SHOOTER DH DATE 3/16/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60-DH	OK	NONE
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	*60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	60-DH	11	11
	11	40-DH	11	11
	TOTAL	1000		
		8000		
		9000		

SWS ENDURANCE TEST REPORT

SERIAL NO. C 6348985 SHOOTER JU DATE 3-17-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60-84	ok	NONE
	"	60-94	ok	"
	"	60-94	ok	"
	"	60-94	ok	"
	"	60-94	ok	"
	"	60-94	ok	"
	"	60-94	ok	"
	TOTAL	420		
	7.62	60-DH	OK 3/19/90	NONE
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	60-DH	"	"
	"	40-DH	"	"
	TOTAL	580		
		1000		
		9000		
		10,000		

START

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348985
27 Feb 1990

CENTROIDAL DISTANCES

0 TO	1	.564732
1 TO	2	.522816
1 TO	3	.903137
1 TO	4	.338155
1 TO	5	.258211

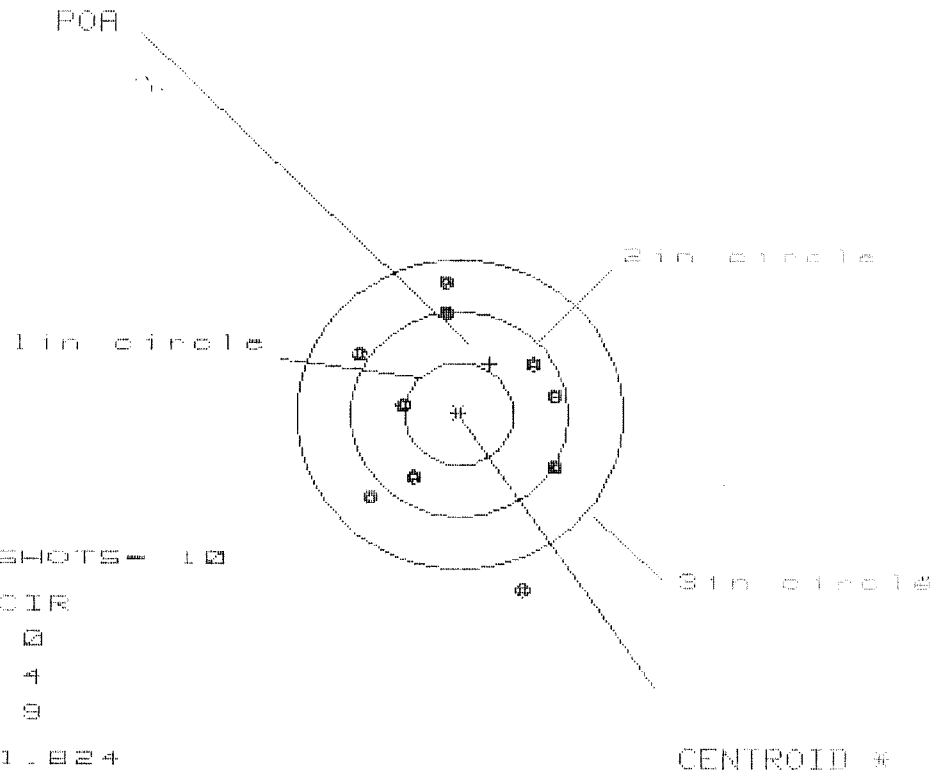
5³
4
K----POR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.035
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2384
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .240956
THE AMR FOR THIS RIFLE IS: .9678

26 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08348985

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 1.824

VS = 3.039

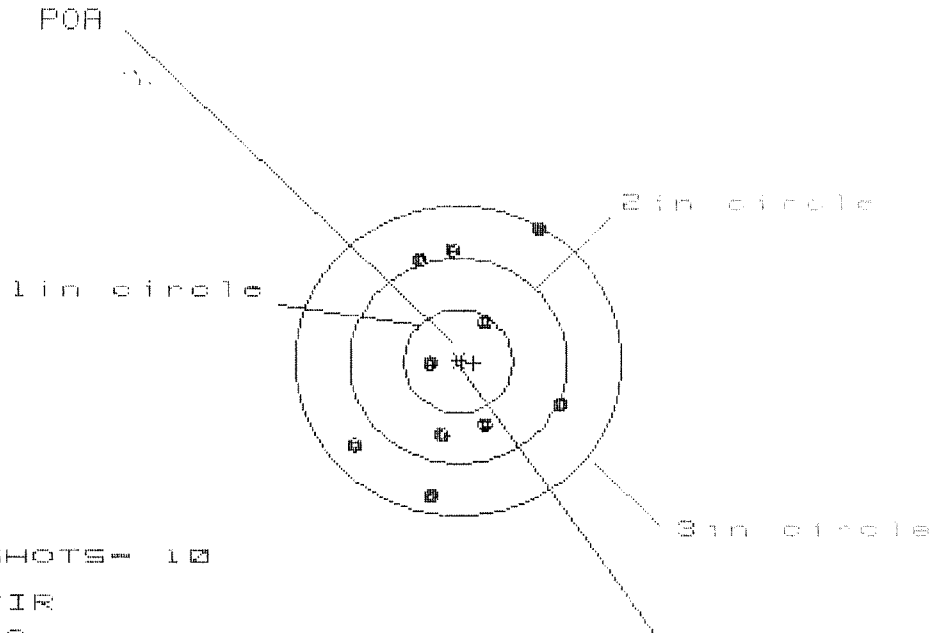
GS = 3.133

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.892	.959	.948
MINIMUM X	:	-.932	-.865	-.876
MAXIMUM Y	:	1.306	1.113	.961
MINIMUM Y	:	-1.733	-.996	-.856
CENTROID X	:	-.279	-.346	-.335
CENTROID Y	:	-.491	-.298	-.438
POA TO CENTROID in.	:	.565	.457	.551
MIN RADIUS	:	.503	.454	.444
MEAN RADIUS	:	1.048	.938	.911
MAX RADIUS	:	1.835	1.258	1.159
HORIZONTAL SPREAD	:	1.824	1.824	1.824
VERTICAL SPREAD	:	3.039	2.109	1.817
EXTREME SPREAD	:	3.133	2.215	2.148
NUMBER IN ONE INCH CIRCLE =	:	1	0	
NUMBER IN TWO INCH CIRCLE =	:	4		
NUMBER IN THREE INCH CIRCLE =	:	9		

26 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6346985

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in - 2

2 in - 5

3 in = 10

HS- 1.902

VS= 2.552

GS= 2.746

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.917	1.001	.981
MINIMUM X	:	-.985	-.901	-.921
MAXIMUM Y	:	1.269	1.248	1.105
MINIMUM Y	:	-1.283	-1.142	-.831
CENTROID X	:	-.140	-.224	-.204
CENTROID Y	:	.013	-.128	.015
POA TO CENTROID in.	:	.140	.258	.204
MIN RADIUS	:	.289	.258	.225
MEAN RADIUS	:	.935	.861	.818
MAX RADIUS	:	1.480	1.248	1.241
HORIZONTAL SPREAD	:	1.902	1.902	1.902
VERTICAL SPREAD	:	2.552	2.390	1.936
EXTREME SPREAD	:	2.746	2.396	2.136
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

26 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8348985

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID +

OF SHOTS- 10

IN CIR

1 in - 1

2 in - 7

3 in = 10

HS= 2.404

VS= 2.205

GS= 2.826

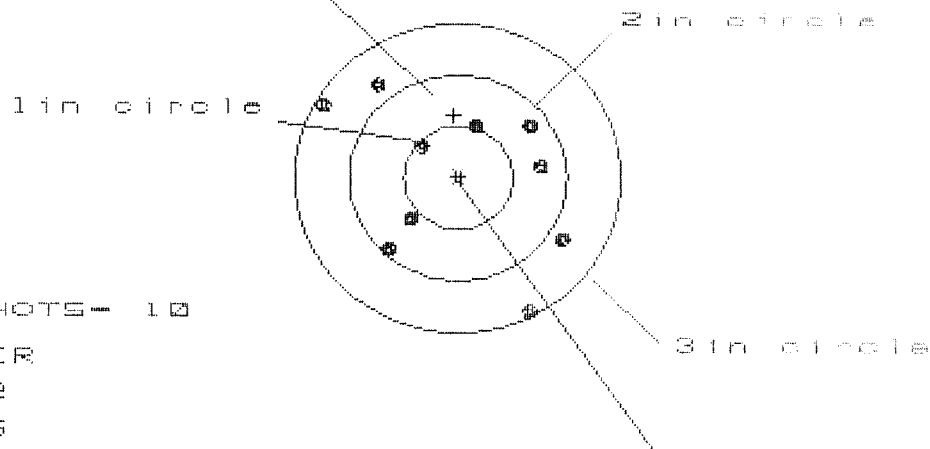
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.046	.895	.892
MINIMUM X	:	-1.358	-.882	-.770
MAXIMUM Y	:	1.250	1.190	1.300
MINIMUM Y	:	-.955	-1.015	-.905
CENTROID X	:	.331	.482	.370
CENTROID Y	:	.175	.235	.125
POA TO CENTROID in.	:	.375	.537	.391
MIN RADIUS	:	.497	.520	.474
MEAN RADIUS	:	.957	.901	.834
MAX RADIUS	:	1.462	1.258	1.309
HORIZONTAL SPREAD	:	2.404	1.777	1.662
VERTICAL SPREAD	:	2.205	2.205	2.205
EXTREME SPREAD	:	2.826	2.351	2.206
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

26 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08348985

CENTERFIRE PATTERNS # 4

POA 10



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.213

VS= 2.177

GS= 2.801

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.986	1.063	.920
MINIMUM X	:	-1.227	-1.150	-.762
MAXIMUM Y	:	.876	.731	.805
MINIMUM Y	:	-1.301	-.859	-.785
CENTROID X	:	.039	-.038	.105
CENTROID Y	:	-.606	-.461	-.535
POA TO CENTROID in.	:	.607	.463	.545
MIN RADIUS	:	.420	.268	.410
MEAN RADIUS	:	.919	.833	.776
MAX RADIUS	:	1.477	1.298	1.139
HORIZONTAL SPREAD	:	2.213	2.213	1.682
VERTICAL SPREAD	:	2.177	1.590	1.590
EXTREME SPREAD	:	2.801	2.584	2.238
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

26 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C834B985

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS = 2.515

VS = 2.205

GS = 2.643

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.135	.905	.748
MINIMUM X	:	-1.380	-1.254	-.993
MAXIMUM Y	:	1.232	1.124	1.090
MINIMUM Y	:	-.973	-.829	-.863
CENTROID X	:	-.126	-.252	-.095
CENTROID Y	:	-.283	-.175	-.141
POA TO CENTROID in.	:	.310	.307	.170
MIN RADIUS	:	.051	.136	.097
MEAN RADIUS	:	.980	.916	.862
MAX RADIUS	:	1.495	1.282	1.169
HORIZONTAL SPREAD	:	2.515	2.159	1.741
VERTICAL SPREAD	:	2.205	1.953	1.953
EXTREME SPREAD	:	2.643	2.302	2.272
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

440
RoundsCENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348985-2
28 Feb 1990

CENTROIDAL DISTANCES

0 TO	1	.331616
1 TO	2	.364244
1 TO	3	.394127
1 TO	4	.386167
1 TO	5	.71441

 $\frac{1}{5}$ <----POA

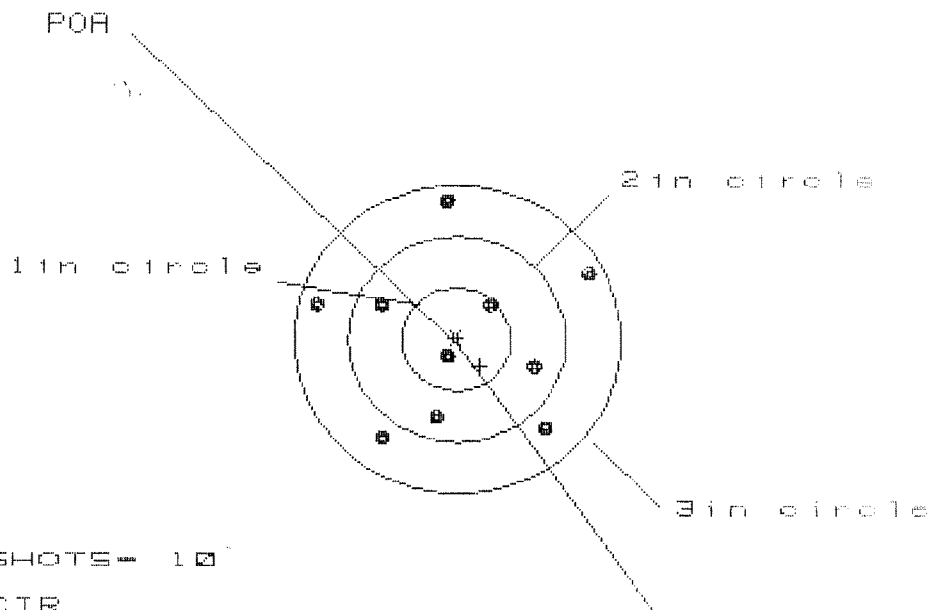
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0038
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0252
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0254849
THE AMR FOR THIS RIFLE IS: .924

28 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6346385.1

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.446

VS= 2.302

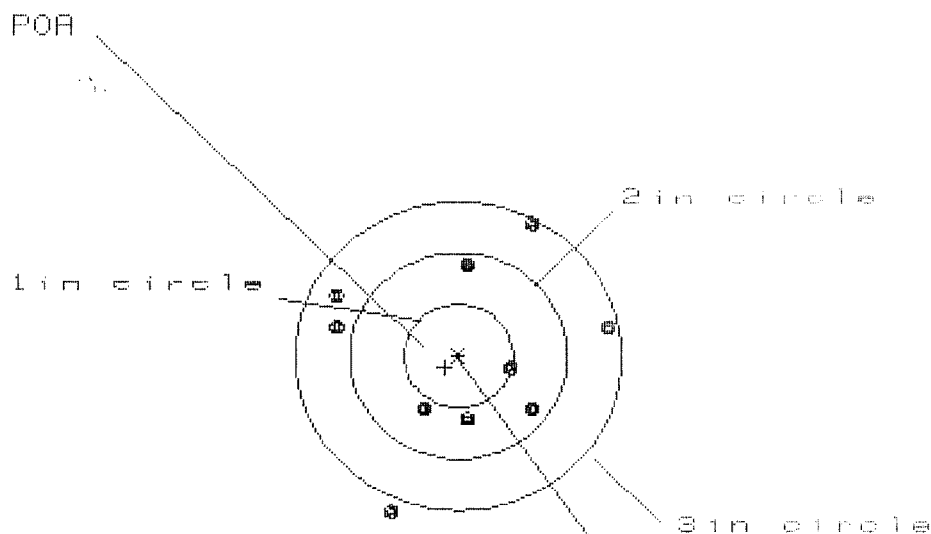
GS= 2.539

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.164	.909	.765
MINIMUM X	-1.282	-1.153	-.750
MAXIMUM Y	1.310	1.387	1.434
MINIMUM Y	-.992	-.915	-.868
CENTROID X	-.212	-.341	-.197
CENTROID Y	.255	.178	.131
POA TO CENTROID in.	.331	.385	.236
MIN RADIUS	.183	.083	.117
MEAN RADIUS	.927	.865	.809
MAX RADIUS	1.354	1.390	1.435
HORIZONTAL SPREAD	2.446	2.062	1.515
VERTICAL SPREAD	2.302	2.302	2.302
EXTREME SPREAD	2.539	2.405	2.405
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

28 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C684B3B5.)

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.556

VS= 2.771

GS= 3.041

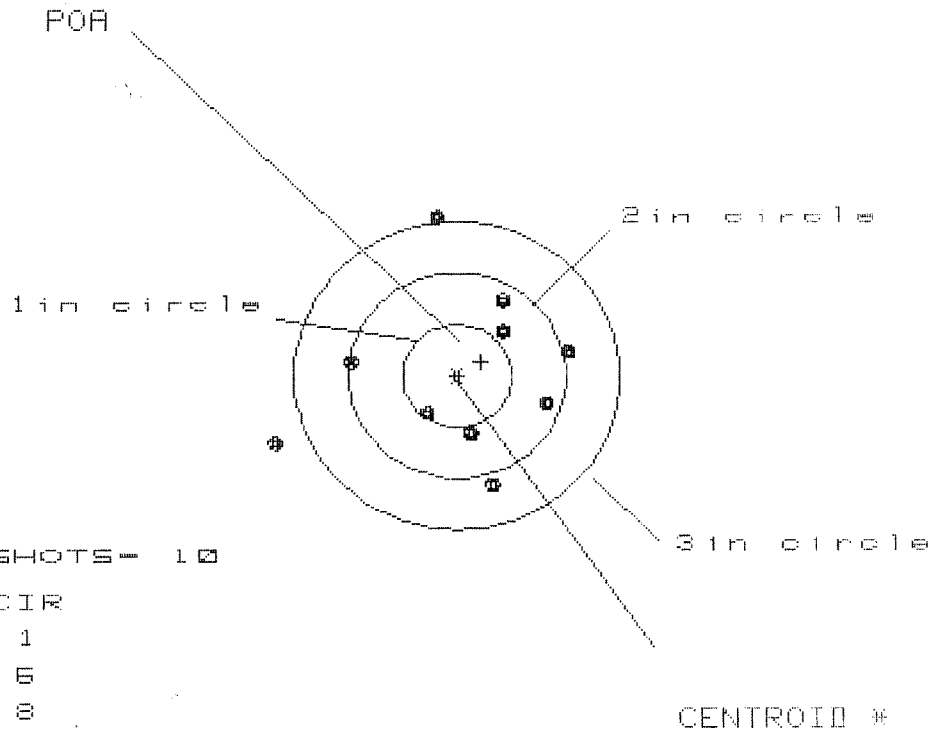
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.391	1.322	.750
MINIMUM X	:	-1.165	-1.234	-1.069
MAXIMUM Y	:	1.260	1.092	1.113
MINIMUM Y	:	-1.512	-.784	-.763
CENTROID X	:	.123	.192	.027
CENTROID Y	:	.112	.280	.259
POA TO CENTROID in.	:	.167	.340	.261
MIN RADIUS	:	.452	.475	.600
MEAN RADIUS	:	1.039	.976	.926
MAX RADIUS	:	1.632	1.333	1.332
HORIZONTAL SPREAD	:	2.556	2.556	1.819
VERTICAL SPREAD	:	2.771	1.876	1.876
EXTREME SPREAD	:	3.041	2.570	2.153
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Feb 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C634B985.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in - 1

2in - 6

3in = 8

HS- 2.697

VS- 2.633

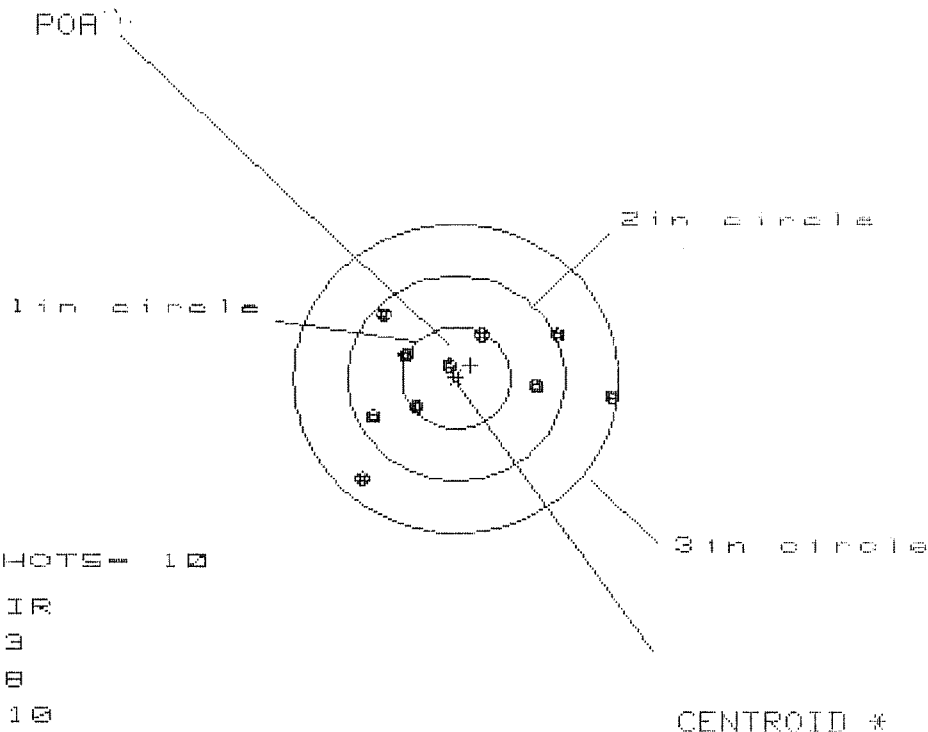
GS- 2.827

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.003	.815	.770
MINIMUM X	:	-1.694	-1.138	-1.183
MAXIMUM Y	:	1.552	1.480	.822
MINIMUM Y	:	-1.081	-1.153	-.968
CENTROID X	:	-.222	-.034	.011
CENTROID Y	:	-.139	-.067	-.252
POA TO CENTROID in.	:	.262	.075	.252
MIN RADIUS	:	.465	.413	.470
MEAN RADIUS	:	.982	.863	.759
MAX RADIUS	:	1.814	1.523	1.201
HORIZONTAL SPREAD	:	2.697	1.953	1.953
VERTICAL SPREAD	:	2.633	2.633	1.796
EXTREME SPREAD	:	2.827	2.671	1.956
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

28 Feb 1998

FILE:/PATTERNING/CENTERFIRE_PATT/0634B985.1

CENTERFIRE PATTERNS . # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 2.263

VS= 1.603

GS= 2.402

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.383	1.037	.946
MINIMUM X	:	-.880	-.726	-.753
MAXIMUM Y	:	.630	.611	.487
MINIMUM Y	:	-.973	-.992	-.532
CENTROID X	:	-.133	-.287	-.196
CENTROID Y	:	-.123	-.104	.020
POA TO CENTROID in.	:	.181	.305	.197
MIN RADIUS	:	.173	.131	.040
MEAN RADIUS	:	.788	.696	.611
MAX RADIUS	:	1.394	1.229	.997
HORIZONTAL SPREAD	:	2.263	1.763	1.699
VERTICAL SPREAD	:	1.603	1.603	1.019
EXTREME SPREAD	:	2.402	2.269	1.897
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

28 Feb 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6346985.1

CENTERFIRE PATTERNS

5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 1.781

VS= 2.483

GS= 2.504

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.829	.820	.850
MINIMUM X	:	-.952	-.961	-.931
MAXIMUM Y	:	1.352	1.013	.891
MINIMUM Y	:	-1.131	-.981	-.645
CENTROID X	:	.463	.472	.442
CENTROID Y	:	.021	-.129	-.007
POA TO CENTROID in.	:	.464	.489	.442
MIN RADIUS	:	.469	.357	.443
MEAN RADIUS	:	.884	.810	.787
MAX RADIUS	:	1.354	1.235	1.168
HORIZONTAL SPREAD	:	1.781	1.781	1.781
VERTICAL SPREAD	:	2.483	1.994	1.536
EXTREME SPREAD	:	2.504	2.183	2.183
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

4940
ROUNDSCENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348985
12 Mar 1990

CENTROIDAL DISTANCES

0 TO	1	.0679779
1 TO	2	.187409
1 TO	3	.510416
1 TO	4	.316986
1 TO	5	.0328938

39
20 <----POA

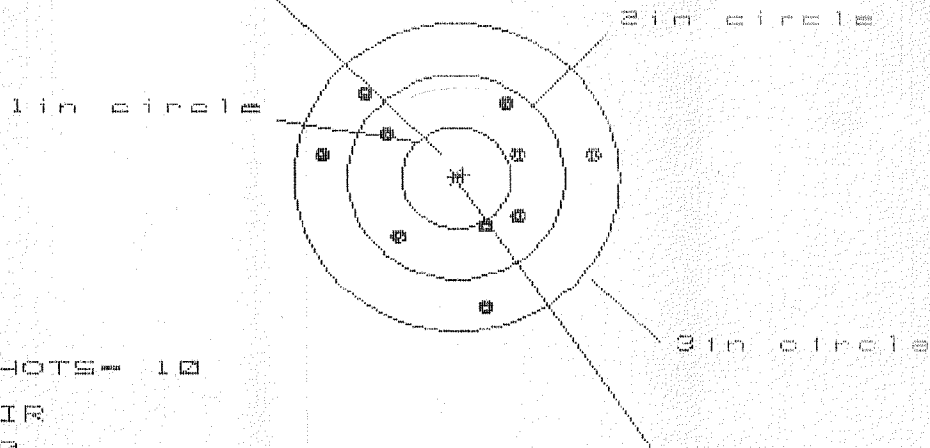
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2346
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0266
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .236103
THE AMR FOR THIS RIFLE IS: .8118

12 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C634B9B5.1.1.1

CENTERFIRE PATTERNS # 1

POA



OF SHOTS = 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS = 2.563

VS = 2.096

GS = 2.563

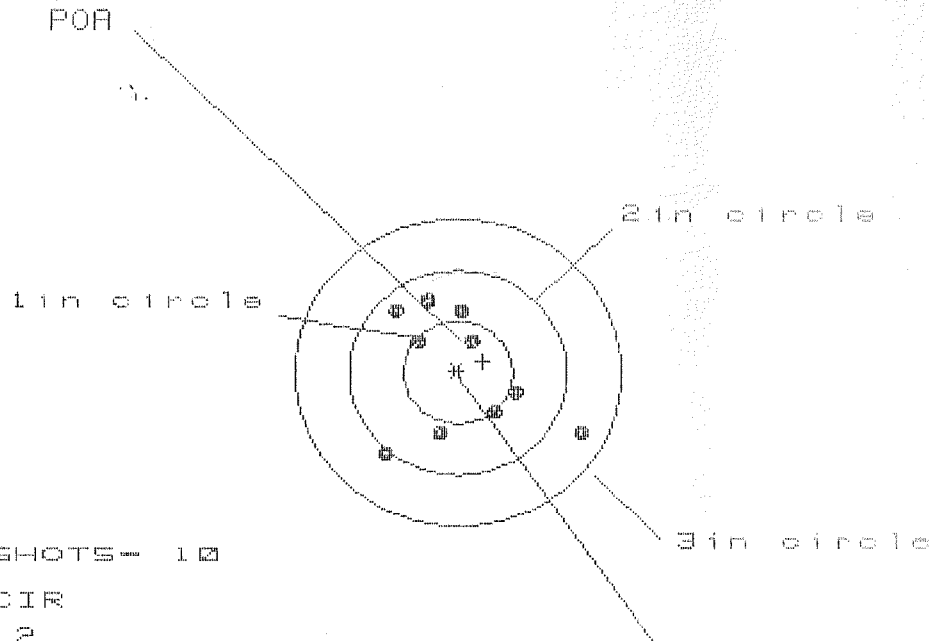
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.299	.698	.558
MINIMUM X	-1.264	-1.120	-.858
MAXIMUM Y	.853	.874	.901
MINIMUM Y	-1.243	-1.222	-1.195
CENTROID X	-.061	-.205	-.065
CENTROID Y	-.030	-.051	-.078
POA TO CENTROID in.	.068	.211	.102
MIN RADIUS	.529	.602	.491
MEAN RADIUS	.920	.877	.822
MAX RADIUS	1.312	1.274	1.244
HORIZONTAL SPREAD	2.563	1.818	1.416
VERTICAL SPREAD	2.096	2.096	2.096
EXTREME SPREAD	2.563	2.357	2.357
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

12 Mar 1990

FILE:/PATTERNING/CENTERFIRE_PATT/CS348985.1.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 8

3 in = 10

HS= 1.842

VS= 1.482

GS= 2.088

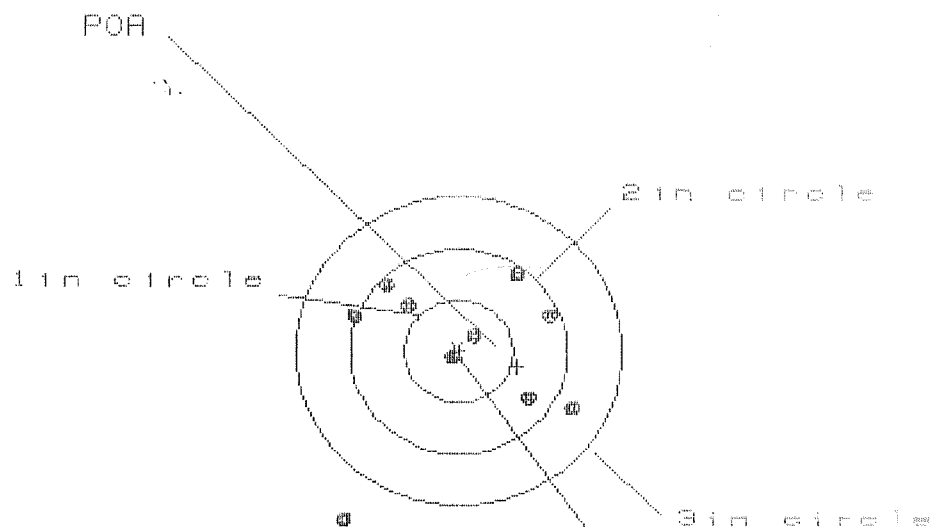
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.172	.657	.589
MINIMUM X	:	-.670	-.540	-.499
MAXIMUM Y	:	.676	.616	.508
MINIMUM Y	:	-.806	-.866	-.801
CENTROID X	:	-.230	-.360	-.292
CENTROID Y	:	-.111	-.051	.057
POA TO CENTROID in.	:	.255	.363	.298
MIN RADIUS	:	.372	.367	.250
MEAN RADIUS	:	.709	.631	.555
MAX RADIUS	:	1.291	1.021	.812
HORIZONTAL SPREAD	:	1.842	1.197	1.088
VERTICAL SPREAD	:	1.482	1.482	1.309
EXTREME SPREAD	:	2.088	1.565	1.379
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

12 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CS34B3B5.1.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.106

VS= 2.327

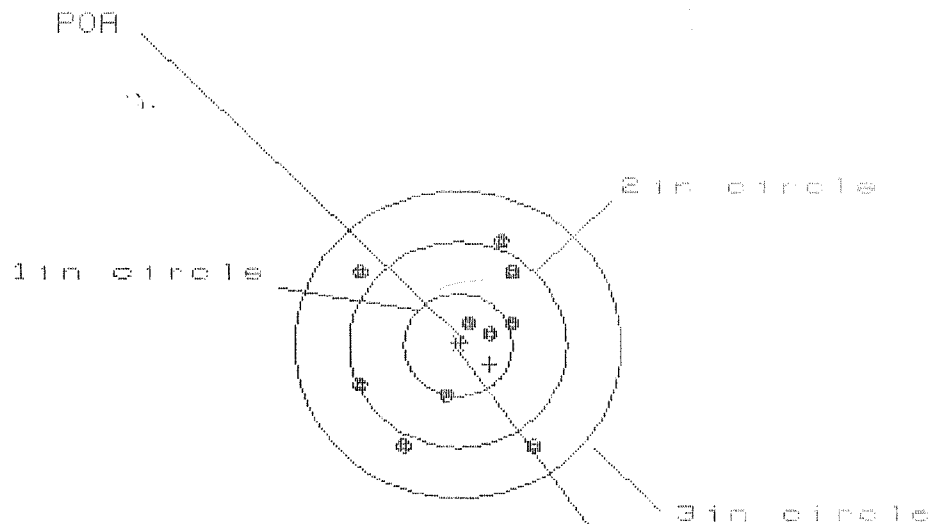
GS= 2.839

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.045	.927	.831
MINIMUM X	:	-1.061	-1.087	-.971
MAXIMUM Y	:	.717	.538	.449
MINIMUM Y	:	-1.610	-.717	-.697
CENTROID X	:	-.539	-.421	-.537
CENTROID Y	:	.149	.328	.417
POA TO CENTROID in.	:	.559	.534	.680
MIN RADIUS	:	.102	.021	.168
MEAN RADIUS	:	.854	.704	.652
MAX RADIUS	:	1.928	1.172	.974
HORIZONTAL SPREAD	:	2.106	2.014	1.802
VERTICAL SPREAD	:	2.327	1.255	1.146
EXTREME SPREAD	:	2.839	2.199	1.802
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

12 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CS348985.1.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.586

VS= 2.006

GS= 2.286

CENTROID #

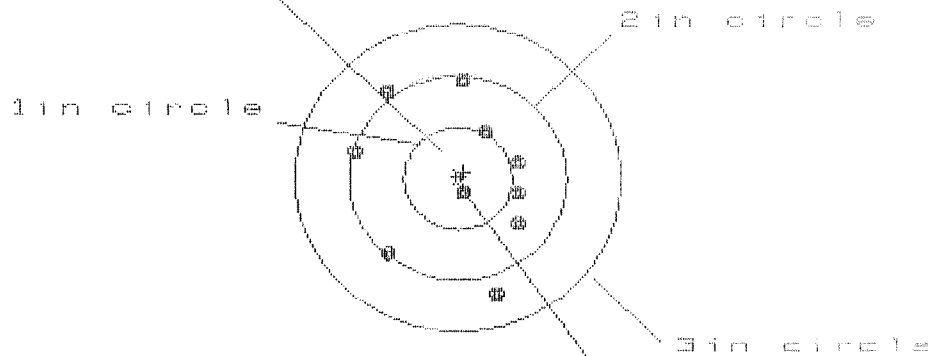
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.676	.617	.564
MINIMUM X	-.910	-.835	-.888
MAXIMUM Y	.981	.871	.729
MINIMUM Y	-1.025	-1.135	-.756
CENTROID X	-.293	-.368	-.315
CENTROID Y	.186	.296	.438
POA TO CENTROID in.	.347	.472	.539
MIN RADIUS	.259	.205	.088
MEAN RADIUS	.794	.746	.659
MAX RADIUS	1.198	1.212	1.092
HORIZONTAL SPREAD	1.586	1.452	1.452
VERTICAL SPREAD	2.006	2.006	1.485
EXTREME SPREAD	2.286	2.190	1.877
NUMBER IN ONE INCH CIRCLE	2		
NUMBER IN TWO INCH CIRCLE	6		
NUMBER IN THREE INCH CIRCLE	10		

12 Mar 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C63489B5.1.1.1

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 1

2in = 7

3in = 10

HS= 1.584

VS= 2.174

GS= 2.215

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.592	.626	.548
MINIMUM X	:	-.992	-.958	-1.036
MAXIMUM Y	:	.992	.861	.947
MINIMUM Y	:	-1.182	-.839	-.754
CENTROID X	:	-.050	-.084	-.006
CENTROID Y	:	-.061	.070	-.015
POA TO CENTROID in.	:	.079	.109	.017
MIN RADIUS	:	.173	.308	.217
MEAN RADIUS	:	.782	.736	.688
MAX RADIUS	:	1.220	1.050	1.050
HORIZONTAL SPREAD	:	1.584	1.584	1.584
VERTICAL SPREAD	:	2.174	1.700	1.700
EXTREME SPREAD	:	2.215	1.831	1.831
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

4500
ROUNDSCENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348985
12 Mar 1990

CENTROIDAL DISTANCES

0 TO 1 .204002
1 TO 2 .0636396
1 TO 3 .373162
1 TO 4 .413473
1 TO 5 .153574

451
3 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3198
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1174
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .340668

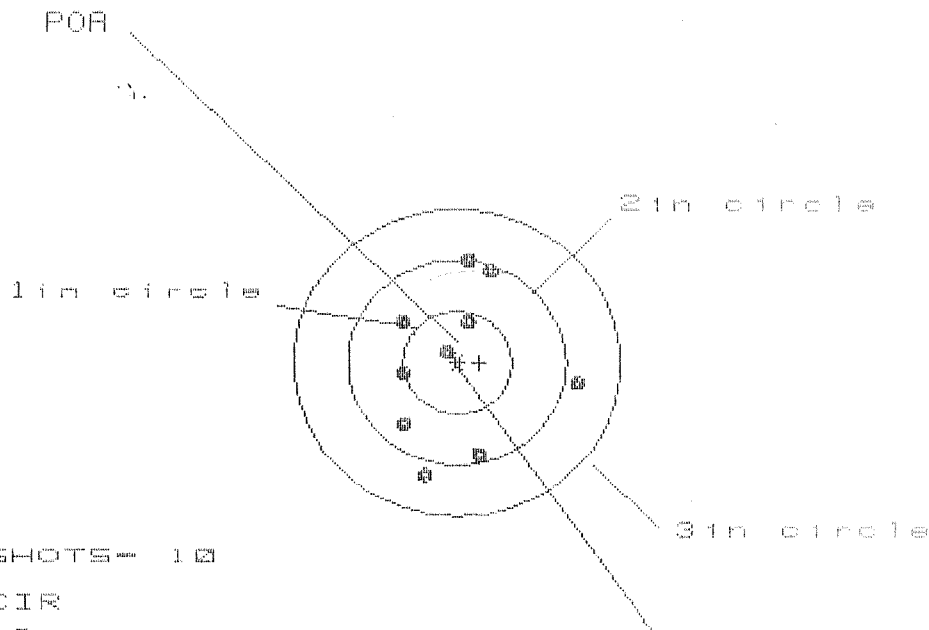
THE AMR FOR THIS RIFLE IS: .8958

4500
2.12405

12 Mar 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C634B9B5.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1in - 3

2in - 8

3in - 10

CENTROID #

HS= 1.605

VS= 2.032

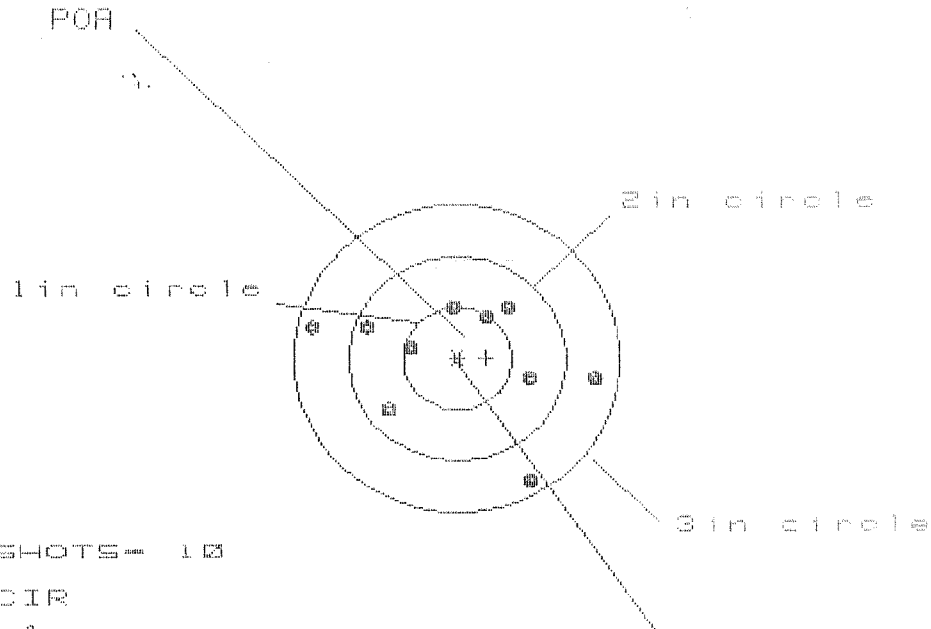
GS= 2.078

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.093	.470	.449
MINIMUM X	-.512	-.391	-.412
MAXIMUM Y	.968	.944	.808
MINIMUM Y	-1.064	-1.088	-1.048
CENTROID X	-.204	-.325	-.304
CENTROID Y	-.001	.023	.159
POA TO CENTROID in.	.204	.326	.343
MIN RADIUS	.133	.070	.070
MEAN RADIUS	.757	.691	.623
MAX RADIUS	1.115	1.101	1.093
HORIZONTAL SPREAD	1.605	.861	.861
VERTICAL SPREAD	2.032	2.032	1.856
EXTREME SPREAD	2.078	2.078	1.859
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

12 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6348985.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 10

HS= 2.658

VS= 1.668

GS= 2.706

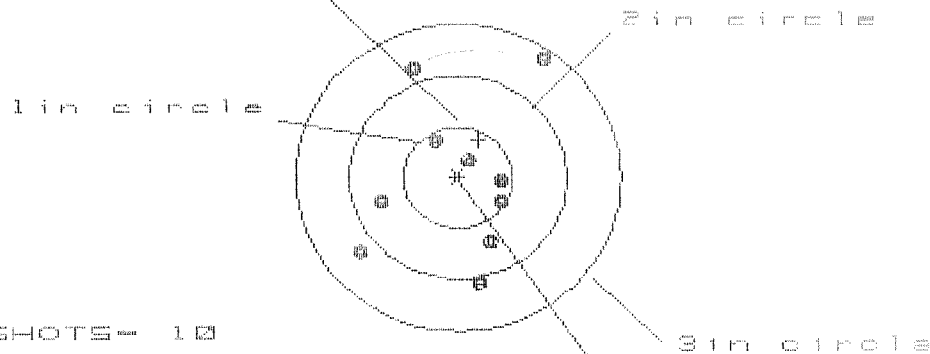
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.311	1.161	.626
MINIMUM X	:	-1.347	-.957	-.812
MAXIMUM Y	:	.522	.553	.528
MINIMUM Y	:	-1.146	-1.115	-1.140
CENTROID X	:	-.267	-.117	-.262
CENTROID Y	:	-.010	-.041	-.016
POA TO CENTROID in.	:	.267	.124	.263
MIN RADIUS	:	.471	.481	.476
MEAN RADIUS	:	.847	.785	.721
MAX RADIUS	:	1.375	1.215	1.301
HORIZONTAL SPREAD	:	2.658	2.118	1.438
VERTICAL SPREAD	:	1.668	1.668	1.668
EXTREME SPREAD	:	2.706	2.174	2.012
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

12 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/CG34B985.1.1

CENTERFIRE PATTERNS # 3

POA



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 1.712

VS= 2.145

GS= 2.526

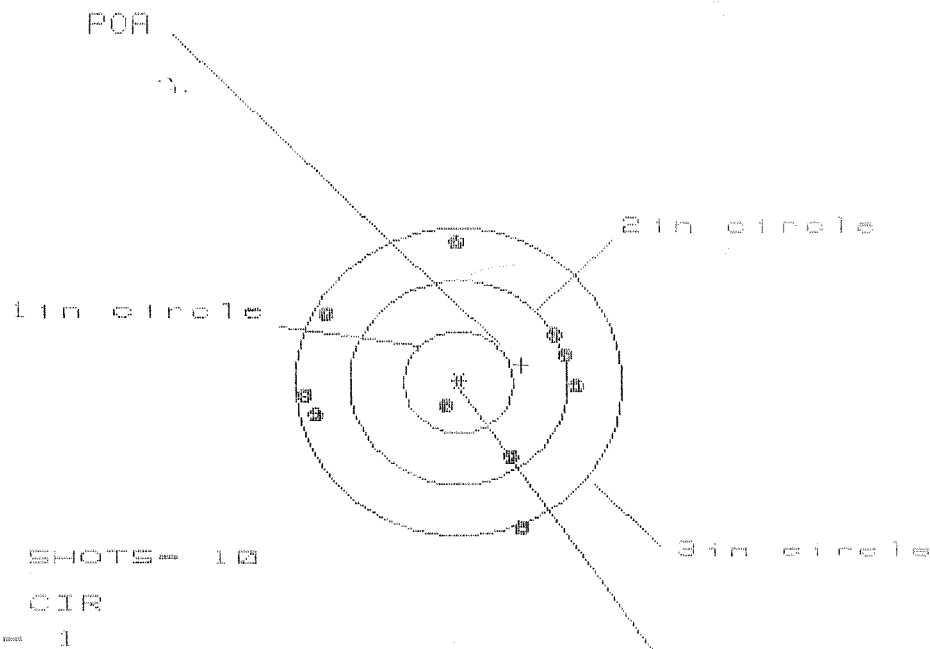
CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.786	.505	.468
MINIMUM X	-.926	-.839	-.876
MAXIMUM Y	1.169	1.242	.676
MINIMUM Y	-.976	-.846	-.691
CENTROID X	-.193	-.280	-.243
CENTROID Y	-.374	-.504	-.659
POA TO CENTROID in.	.421	.576	.703
MIN RADIUS	.166	.322	.436
MEAN RADIUS	.766	.701	.620
MAX RADIUS	1.408	1.276	.964
HORIZONTAL SPREAD	1.712	1.344	1.344
VERTICAL SPREAD	2.145	2.088	1.367
EXTREME SPREAD	2.526	2.171	1.495
NUMBER IN ONE INCH CIRCLE	4		
NUMBER IN TWO INCH CIRCLE	7		
NUMBER IN THREE INCH CIRCLE	10		

12 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C634B985.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 2.453

VS= 2.787

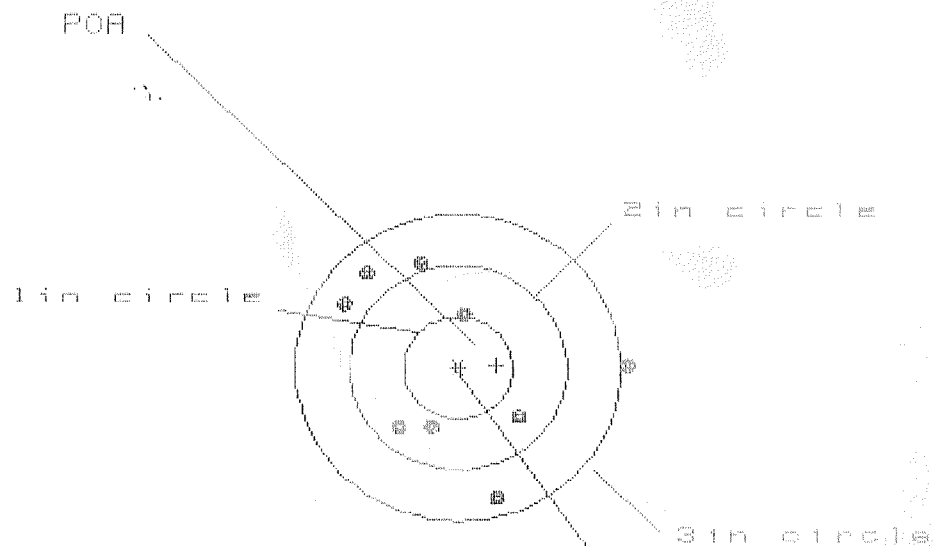
GS= 2.862

PATTERN #	:	10	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.030	1.100	.931
MINIMUM X	:	-1.423	-1.353	-1.397
MAXIMUM Y	:	1.391	1.236	1.205
MINIMUM Y	:	-1.396	-.858	-.889
CENTROID X	:	-.580	-.650	-.481
CENTROID Y	:	-.173	-.018	.013
POA TO CENTROID in.	:	.606	.650	.481
MIN RADIUS	:	.222	.352	.433
MEAN RADIUS	:	1.124	1.088	1.028
MAX RADIUS	:	1.530	1.376	1.496
HORIZONTAL SPREAD	:	2.453	2.453	2.328
VERTICAL SPREAD	:	2.787	2.094	2.094
EXTREME SPREAD	:	2.862	2.453	2.375
NUMBER IN ONE INCH CIRCLE	=	1	3	9
NUMBER IN TWO INCH CIRCLE	=	3	9	9
NUMBER IN THREE INCH CIRCLE	=	9	9	9

12 Mar 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C834B985.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 9

HS= 2.547

VS= 2.338

GS= 2.615

CENTROID #

PATTERN #	10	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.508	.755	.822
MINIMUM X	-1.039	-.872	-.805
MAXIMUM Y	1.049	1.058	.898
MINIMUM Y	-1.289	-1.280	-.741
CENTROID X	-.355	-.522	-.589
CENTROID Y	-.029	-.038	.122
POA TO CENTROID in.	.356	.523	.602
MIN RADIUS	.515	.541	.439
MEAN RADIUS	.985	.919	.854
MAX RADIUS	1.510	1.388	1.045
HORIZONTAL SPREAD	2.547	1.627	1.627
VERTICAL SPREAD	2.338	2.338	1.639
EXTREME SPREAD	2.615	2.586	2.035
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	9		

ENDURANCE

BBL ASSEMBLY + BOLT

QP-0041

3/6/90

MAGNETIC PARTICLE INSPECTION

PART NUMBER

C-6348985

PART NAME Final Bbl.Assem.MATERIAL Bbl. Rem.Spec.#155-Rec.Spec.4137M

OPERATION NUMBER 615

METHOD	SINGLE PARTS			MULTIPLE PARTS		
	HEAD SHOT	CENTRAL CONDUCTOR	COIL SHOT	HEAD SHOT	CENTRAL CONDUCTOR	COIL SHOT IN BASKET AMPERES

NON-FLUORESCENT
CONTINUOUS WET

FLUORESCENT
CONTINUOUS WET Yes

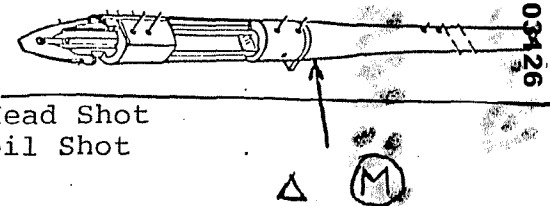
Yes (2 Overlapping)

900-1100-Head Shot
600-800-Coil Shot

NON-FLUORESCENT
RESIDUAL WET

FLUORESCENT
RESIDUAL WET

SKETCH AND/OR REMARKS



APPROVAL:

INSP. _____ LEV III _____
DATE: _____ DATE: _____

ACCEPTANCE STANDARD

STEEL STAMP ON. Triangular stamp Δ and letter "M" circled

OTHER Location-right side near Receiver.

No Indications acceptable in the
Locking Lug area of Receiver or
chamber area of Bbl.

PROCEDURE:

1. All parts must be cleaned before testing.
2. All parts shall be satisfactorily demagnetized after all magnetization has been completed.
3. The magnetic substance shall be completely removed from all parts after inspection and demagnetization.
4. All accepted parts must be marked with a mangaflux stamp, acid etch, or ink stamp (If the part is too small or is a critical part, contact inspection supervisor).
5. Parts having indications not acceptable shall be segregated and identified, and are to be reviewed by Metallurgy and inspection groups.
6. All areas to be inspected 100%.
7. Inspection to be performed by a certified Level I, acceptance or rejection of product will be done by a certified Level II, or Level III.

USE BACK SIDE OF THIS CARD TO RECORD EACH LOT INSPECTED.

ALL BLOCKS MUST BE PROPERLY FILLED IN.

LEV III. _____
INSP. _____

FORM QP-0041-1

ENDURANCE

B/A + BOLT

QP 0041

C-6348985

MAGNAFLUX

DATE	RECORDS		SERIAL #	QUANTITY OF PARTS	
	ORDER NO.	QUANTITY		ACCEPTED	REJECTED
3/6/90	2,500	1	OK		
3/13/90	5,000	1	OK		
3/14/90	6,000	1	OK		
3/15/90	7,000	1	OK		
3/16/90	8,000	1	OK		
3/17/90	9,000	1	OK		
3/19/90	10,000	1	OK		

Karl C Rice
8158-8096

"H" Stamp