

C6523407

MODEL 700™ M24

Model **SMS**™

Action

Barrel Length

Capacity

Order No. **5716**

*Includes 1 in chamber.

Remington

RECEIVING AND ESTIMATING REPORT

R 94-17995

INITIAL		CUSTOMER ORDER NO.	
FJB		DAAA09-92-C-0834	
DATE RECEIVED	DATE OPENED	DATE CODE	
06/09/94	06/09/94		
ACCESSORIES			
HARD CASE			

ATTN: FRED MARTIN
W/10X SCOPE M-24 SNIPER
SERIAL NUMBER
C6523407

Scope # 90-1024
MODEL AND GRADE
700 7-62 NATO

W/DEPLOYMENT KIT

FROM:

SHIP TO:

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON

AL 36201-5025

COMMANDER (W52H094138H226)
DEFENSE DIST DEPOT ANNISTON
ATTN DDAA-UR BLDG 112
ANNISTON

AL

36201-5025

CUST NO: 098397 C.O.D.

ACCOUNT NUMBER	ACCOUNT NUMBER N/C
----------------	--------------------

WRITE ☐

PROM. DATE	ESTIMATED	VIA
		FRT

- GUN CONDITION
- ☐ NEW
 - ☐ LIGHTLY WORN
 - ☐ WORN
 - ☐ VERY WORN
 - ☐ UNREPAIRABLE
 - ☐ MARRED

REPAIR CHARGE
EXCISE
TAX
INSURANCE
UPS
PARCEL POST
TOTAL

CUSTOMER CONCERN	AMMO	FUNCTION	FINISH	ACCURACY	FIT	INSPECT
CYCLE	A1	B1				
TRIGGER GROUP		B2			E1	F1
BOLT ASSY.		B3			E2	F2
BARREL ASSY.		B4		D1	E3	F3
REC. ASSY.		B5		D2	E4	F4
WOOD			C1	D3	E5	F5
METAL			C2			

MAIN FAULT

PARTS	COMMENTS
Trigger Assy	
New Barrel	
Front Sight Assy	
Rear Sight Assy	

REPAIRMAN	PROOF	CLEAN	TEST	TARGET	PATTERN
GALLERY TESTER	DATE	DATE	DATE	DATE	DATE
			3/22/96	3/22/96	

OFFICE COPY

RD6925 REV. 1/94

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

BARBER - M24 M2400027573

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6523407DATE 3-7-96TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.63	2.71	2.71		MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.49	2.79	2.78		
PULL #3	2.44	2.71	2.81		
PULL #4	2.48	2.75	2.75		
PULL #5	2.52	2.71	2.77		
TOTAL	1256	1367	1382		
AVG.	2.51	2.71	2.76		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.22	3.31		
PULL #2	3.30	3.29		
PULL #3	3.34	3.29		
PULL #4	3.10	3.29		
PULL #5	3.26	3.25		
TOTAL	1622	1643		
AVG.	3.24	3.28		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.23		4.21
PULL #2	4.31	4.24		4.18
PULL #3	4.13	4.28		4.19
PULL #4	4.25	4.34		4.20
PULL #5	4.33	4.40		4.19
TOTAL	2129	2149		2097
AVG.	4.25	4.29		4.19

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523407
5 Feb 1980

CENTROIDAL DISTANCES

0 TO	1	.748315
1 TO	2	.0564358
1 TO	3	.0739256
1 TO	4	.134164
1 TO	5	.211265

4
+ <----POA

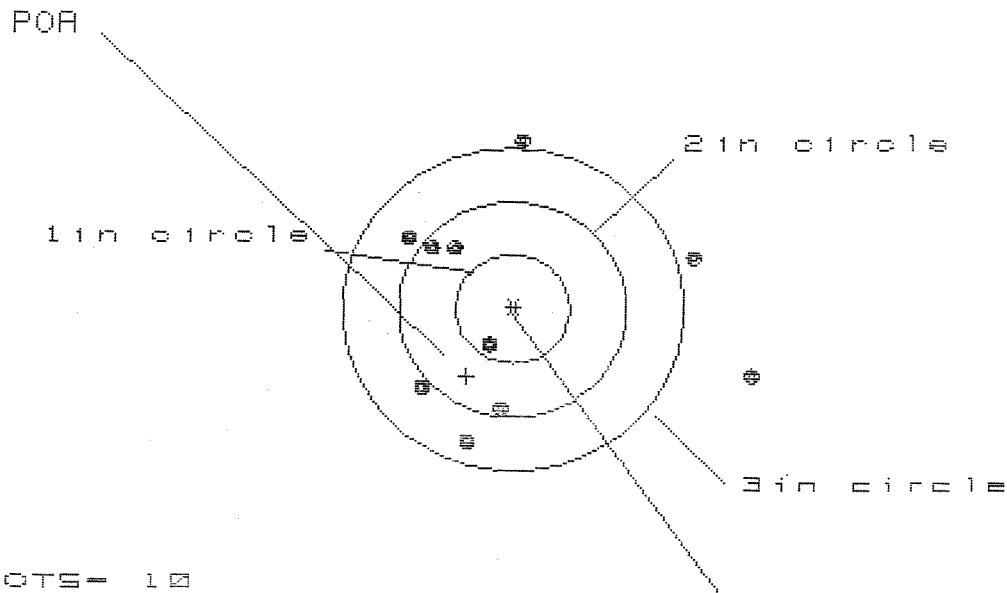
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3996
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .5354
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .668082
THE AMR FOR THIS RIFLE IS: .8954

5 Feb 1968

FILE:/PATTERNING/CENTERFIRE_PATT/C6523407

CENTERFIRE PATTERNS

1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS = 3.039

VS = 2.835

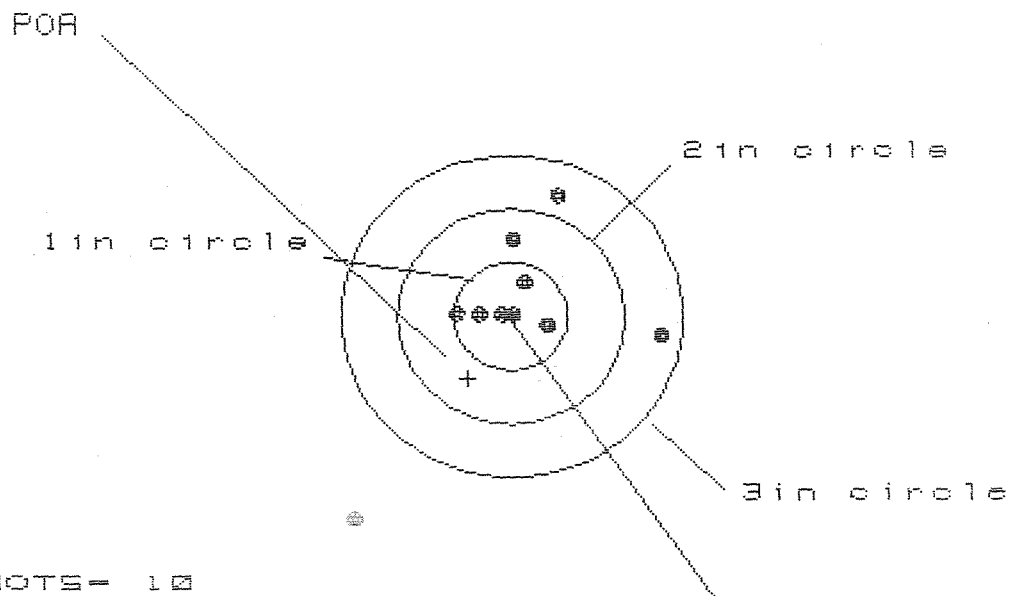
GS = 3.275

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	2.126	1.798	.558
MINIMUM X	-.913	-.677	-.452
MAXIMUM Y	1.588	1.522	1.570
MINIMUM Y	-1.247	-1.313	-1.265
CENTROID X	.410	.174	-.051
CENTROID Y	.626	.692	.644
POA TO CENTROID in.	.749	.713	.647
MIN RADIUS	.426	.422	.438
MEAN RADIUS	1.201	1.034	.894
MAX RADIUS	2.205	1.837	1.666
HORIZONTAL SPREAD	3.039	2.475	1.010
VERTICAL SPREAD	2.835	2.835	2.835
EXTREME SPREAD	3.275	2.881	2.881
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8523487

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 8

2in = 7

3in = 9

HS= 2.594

VS= 2.976

GS= 3.440

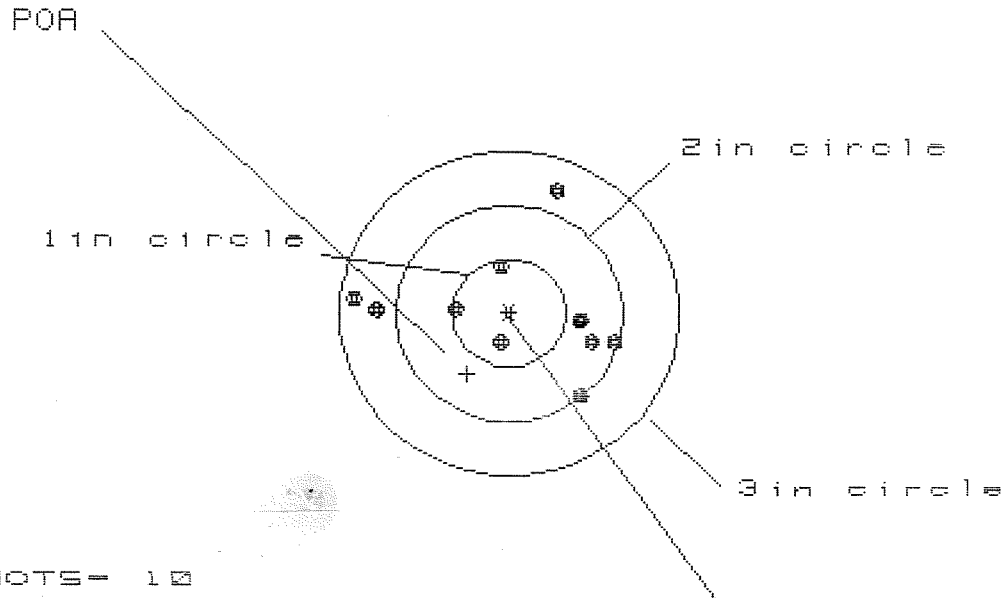
CENTROID *

PATTERN #	:			
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.358	1.210	.392
MINIMUM X	:	-1.336	-.644	-.493
MAXIMUM Y	:	1.149	.946	.895
MINIMUM Y	:	-1.827	-.403	-.373
CENTROID X	:	.382	.530	.379
CENTROID Y	:	.577	.780	.831
POA TO CENTROID in.	:	.692	.943	.913
MIN RADIUS	:	.064	.147	.120
MEAN RADIUS	:	.724	.559	.444
MAX RADIUS	:	2.263	1.275	.977
HORIZONTAL SPREAD	:	2.694	1.854	.885
VERTICAL SPREAD	:	2.976	1.349	1.269
EXTREME SPREAD	:	3.440	1.863	1.467
NUMBER IN ONE INCH CIRCLE =			6	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8523487

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 2.263

VS= 1.864

GS= 2.298

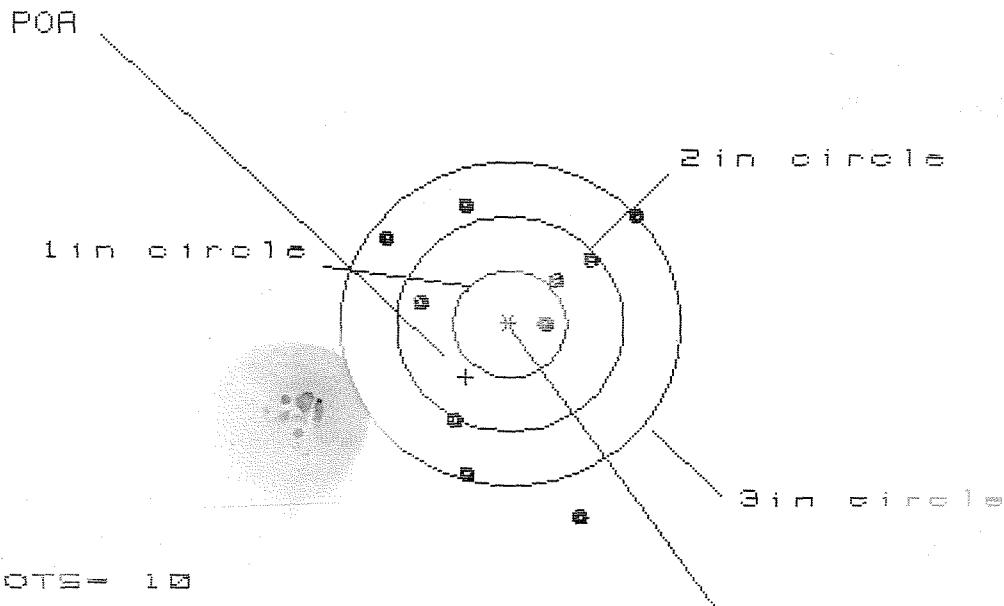
CENTROID *

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.899	.748	.582
MINIMUM X	:	-1.364	-1.326	-.803
MAXIMUM Y	:	1.098	1.109	1.110
MINIMUM Y	:	-.766	-.755	-.754
CENTROID X	:	.373	.524	.690
CENTROID Y	:	.562	.551	.550
POA TO CENTROID in.	:	.674	.761	.883
MIN RADIUS	:	.327	.396	.317
MEAN RADIUS	:	.829	.753	.660
MAX RADIUS	:	1.368	1.326	1.114
HORIZONTAL SPREAD	:	2.263	2.074	1.385
VERTICAL SPREAD	:	1.864	1.864	1.864
EXTREME SPREAD	:	2.298	2.094	1.872
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C8523487

CENTERFIRE PATTERNS # 4



IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.149

VS= 2.812

GS= 3.001

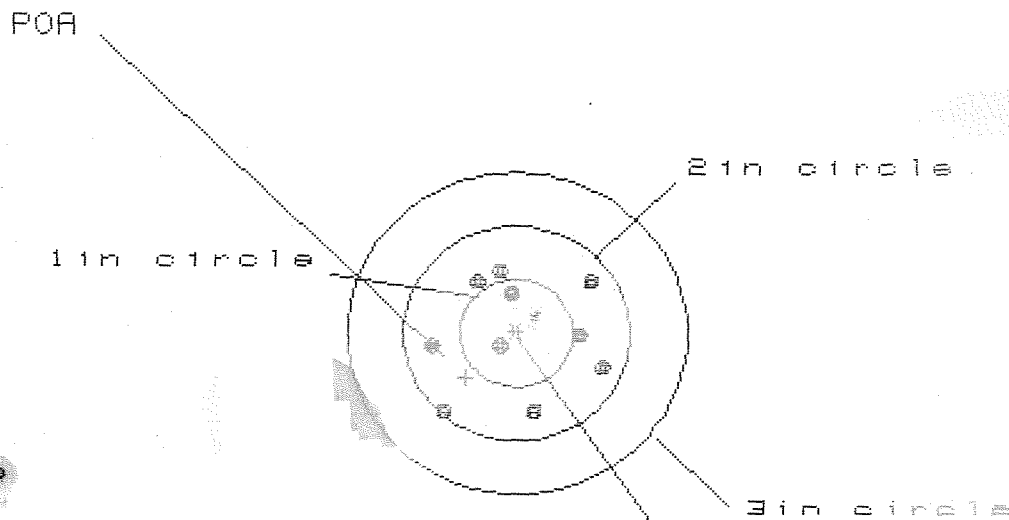
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.086	1.151	1.108
MINIMUM X	:	-1.063	-0.998	-1.041
MAXIMUM Y	:	1.058	.864	.660
MINIMUM Y	:	-1.754	-1.629	-1.247
CENTROID X	:	.386	.321	.364
CENTROID Y	:	.494	.688	.892
POA TO CENTROID in.	:	.526	.708	.904
MIN RADIUS	:	.282	.408	.482
MEAN RADIUS	:	1.085	.979	.869
MAX RADIUS	:	1.847	1.666	1.315
HORIZONTAL SPREAD	:	2.149	2.149	2.149
VERTICAL SPREAD	:	2.812	2.493	1.907
EXTREME SPREAD	:	3.001	2.846	2.386
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

5 Feb 1988

FILE:/PATTERNING/CENTERFIRE_PATT/C6523407

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 10

3in = 10

HS= 1.476

VS= 1.338

GS= 1.774

CENTROID #

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.734	.666	.741
MINIMUM X	:	-.742	-.810	-.735
MAXIMUM Y	:	.609	.528	.580
MINIMUM Y	:	-.729	-.758	-.706
CENTROID X	:	.447	.515	.440
CENTROID Y	:	.418	.499	.447
POA TO CENTROID in.	:	.612	.717	.627
MIN RADIUS	:	.208	.309	.218
MEAN RADIUS	:	.638	.596	.572
MAX RADIUS	:	.952	.834	.824
HORIZONTAL SPREAD	:	1.476	1.476	1.476
VERTICAL SPREAD	:	1.338	1.286	1.286
EXTREME SPREAD	:	1.774	1.539	1.491
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		10	
NUMBER IN THREE INCH CIRCLE	=		10	

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 6523407

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock			
600	Proof			
607.	Check Headspace			
610	Dis-assemble Gun			
612	Magnaflux Barrel Action			
	Magnaflux Bolt			
615	Rollmark Caliber			
617	Drill and Tap Sight Holes			
618	Polish Barrel			
620	Apply Coatings (Barrel Action)			
	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			

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6 1/2	6 1/2	6 1/2			5/6/96	WB
	G) Safety Off Force	3	3	3			5/6/96	WB
	H) Trigger Pull Test & Retainability							
	I) Firing Pin Indent							
	J) Assemble Stock							
	K) Assemble Swivel Studs							
	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							
	A) Time							
	B) Malfunctions							
	C) Pierced Primers							
	D) Optical Clarity of Scope							
645	Inspect for Live Ammo							
655	Final Inspection							
	A) Headspace							
	B) Trigger Pull	2.76	2.80	2.80	2.67	2.78	4/18/96	WB
	C) Function							
660	Pack							

Remington  REG. U.S. PAT. & TM. OFF.

MODEL 700TM M24

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

01

SERIAL NO.
C6523407

ORDER NO.
5716


5716 C6523407

UPC


0 47700 25716 7

MOD. _____		GA. CAL. _____	GUN # _____
# TEST	DATE	MALFUNCTION/DEFECT	ASSEM. #
	1st	<i>Bolt Rel.</i>	<i>AS</i>
	2nd	<i>Rep'd. 11/12/90</i>	<i>KS</i>
	3rd		
	4th		

FUNCTION _____

RD 6654 Rev 1

TEST INIT. ACTION TO CORRECT		ASSEM. #
PROOF		
TEST		
TGT		
PROOF		
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		
PROOF	ENGINEER	
TEST		
TGT		

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6523407

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		10/4/90	KS
600	Proof		10/4/90	KS
607	Check Headspace		10/4/90	KS
610	Dis-assemble Gun		10/4/90	KS
612	Magnaflux Barrel Action		10/9/90	KR
	Magnaflux Bolt		10/9/90	KR
615	Rollmark Caliber		10/9/90	ES
617	Drill and Tap Sight Holes		10/11/90	FB
618	Polish Barrel RB		10/12/90	WB
620	Apply Coatings (Barrel Action)		10-13-90	TH
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/2/90	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/8/90	KS
	C) Inspect Ejector Hole for Chamfer		11/17/90	KS
	D) Oil Firing Pin Ass'y		11/18/90	KS
	E) Adjust Trigger Pull to Min Setting and Stake		11-19-90	JH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			11/9/90	WB
	G) Safety Off Force	2 1/4	2 1/4	2 1/4			11/9/90	WB
	H) Trigger Pull Test & Retainability						11-9-90	JH
	I) Firing Pin Indent	.021	.0205	.021			11/9/90	WB
	J) Assemble Stock						11/9/90	KS
	K) Assemble Swivel Studs						11-20-90	DH
	L) Attach Front and Rear Sight Assemblies						11/9/90	KS
	M) Iron Sight Alignment						11/9/90	KS
	N) Detach Front & Rear Sights & place in numbered container						11/9/90	KS
	O) Attach Scope to Rifle						11/9/90	KS
	P) Detach & Attach Scope 20 Times						11/9/90	KS
640	Gallery Target & Test						11-12-90	F
	A) Time						"	F
	B) Malfunctions						"	F
	C) Pierced Primers						"	F
	D) Optical Clarity of Scope						"	F
645	Inspect for Live Ammo						11-12-90	F
655	Final Inspection							
	A) Headspace						11-20-90	DH
	B) Trigger Pull	2.31	2.39	2.34	2.40	2.44	11-20-90	DH
	C) Function						11-20-90	DH
660	Pack						12/14/90	VF

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6523407DATE 11-9-90TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.28	2.38	2.18	2.31	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.24	2.45	2.26	2.39	
PULL #3	2.16	2.42	2.42	2.34	
PULL #4	2.18	2.48	2.48	2.40	
PULL #5	2.46	2.47	2.27	2.44	
TOTAL	11.32	12.20	11.61		
AVG.	2.264	2.44	2.322		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.48	3.23		
PULL #2	3.30	3.30		
PULL #3	3.23	3.22		
PULL #4	3.31	3.20		
PULL #5	3.25	3.31		
TOTAL	16.57	16.24		
AVG.	3.314	3.248		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.45	4.24		4.30
PULL #2	4.20	4.25		4.30
PULL #3	4.17	4.22		4.35
PULL #4	4.35	4.29		4.34
PULL #5	4.33	4.22		4.37
TOTAL	21.50	21.22		21.66
AVG.	4.3	4.244		4.332

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6523407
12 Nov 1990

CENTROIDAL DISTANCES

0 TO	1	.0900278
1 TO	2	.141174
1 TO	3	.284888
1 TO	4	.0502494
1 TO	5	.300885

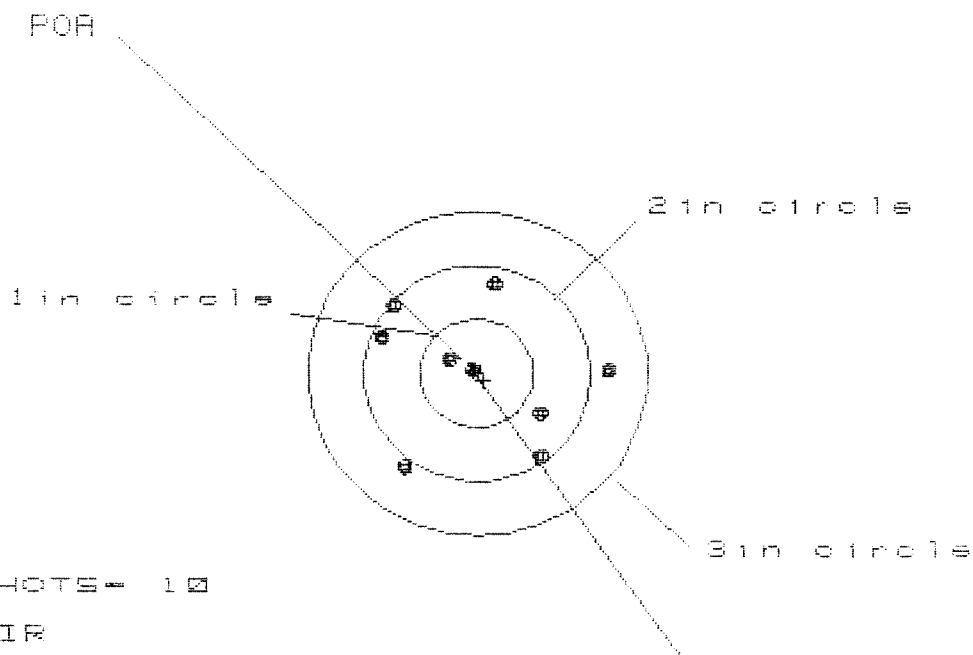
#5 <----POI

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.016
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.029
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .033121
THE AMP FOR THIS RIFLE IS: .0672

12 May 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8523407

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 1.993

VS = 1.769

GS = 2.014

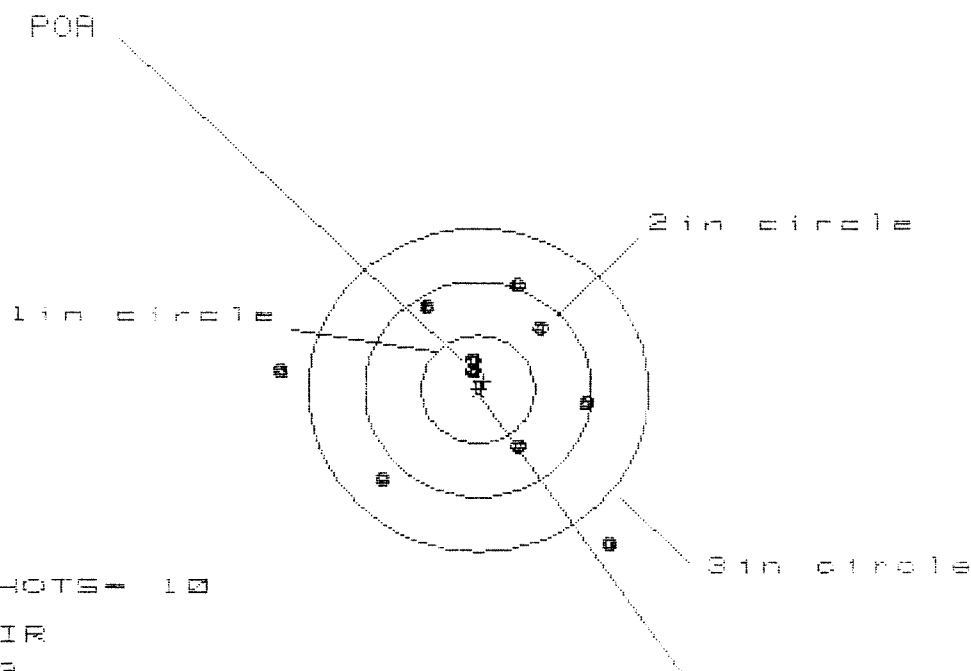
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.153	.688	.628
MINIMUM X	-.840	-.712	-.772
MAXIMUM Y	.870	.873	.761
MINIMUM Y	-.898	-.896	-.877
CENTROID X	-.059	-.187	-.127
CENTROID Y	.068	.065	.177
POA TO CENTROID in.	.090	.198	.218
MIN RADIUS	.001	.115	.123
MEAN RADIUS	.687	.644	.589
MAX RADIUS	1.153	1.029	1.079
HORIZONTAL SPREAD	1.993	1.400	1.400
VERTICAL SPREAD	1.769	1.769	1.638
EXTREME SPREAD	2.014	1.931	1.906
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

12 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/06523407

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 8

HS= 2.875

VS= 2.321

GS= 3.272

CENTROID *

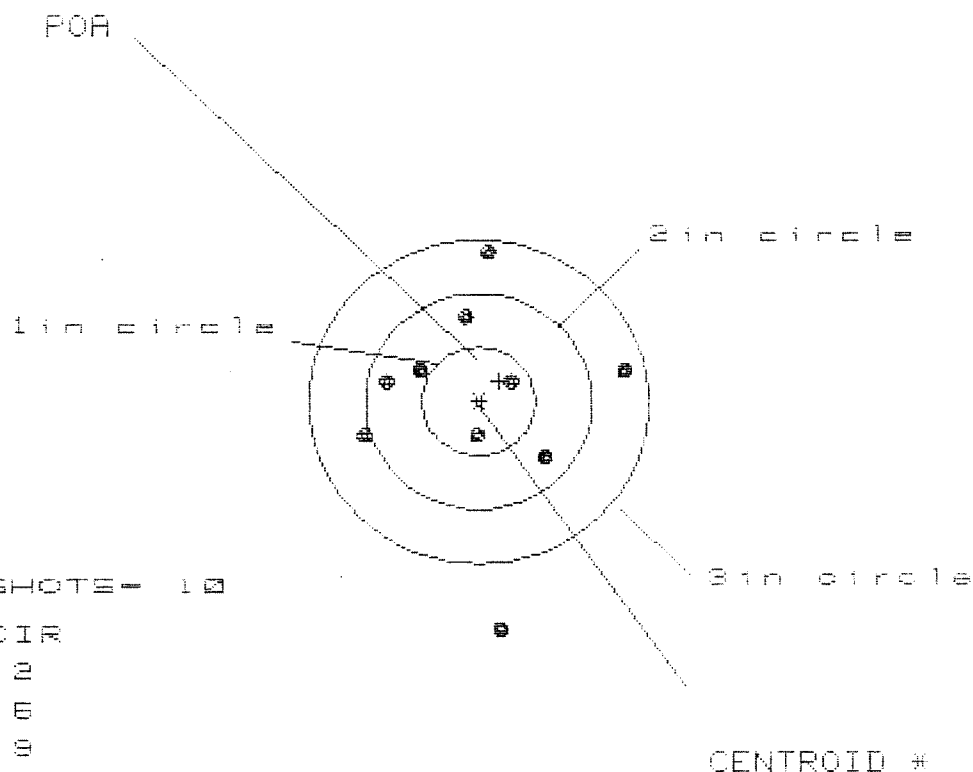
PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.129	1.074	.871
MINIMUM X	-1.746	-1.621	-.933
MAXIMUM Y	.935	.781	.784
MINIMUM Y	-1.386	-1.002	-.999
CENTROID X	-.052	-.178	.025
CENTROID Y	-.073	.081	.078
POA TO CENTROID in.	.090	.195	.082
MIN RADIUS	.160	.048	.157
MEAN RADIUS	.940	.812	.699
MAX RADIUS	1.787	1.621	1.367
HORIZONTAL SPREAD	2.875	2.695	1.884
VERTICAL SPREAD	2.321	1.783	1.783
EXTREME SPREAD	3.272	2.707	2.143
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		8	

12 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8523407

CENTERFIRE PATTERNS

3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 2.252

VS = 3.552

GS = 3.555

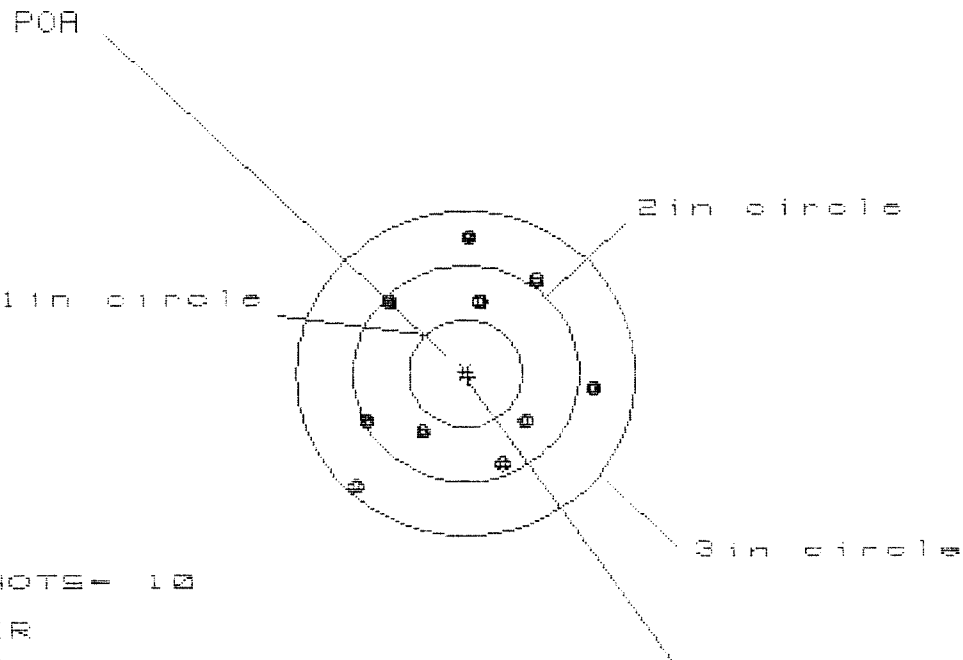
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.272	1.296	1.309
MINIMUM X	:	-.980	-.956	-.943
MAXIMUM Y	:	1.407	1.169	.723
MINIMUM Y	:	-2.145	-.742	-.596
CENTROID X	:	-.184	-.208	-.221
CENTROID Y	:	-.188	.050	-.096
POA TO CENTROID in.	:	.263	.214	.241
MIN RADIUS	:	.282	.316	.358
MEAN RADIUS	:	.965	.811	.755
MAX RADIUS	:	2.157	1.297	1.323
HORIZONTAL SPREAD	:	2.252	2.252	2.252
VERTICAL SPREAD	:	3.552	1.911	1.319
EXTREME SPREAD	:	3.555	2.333	2.333
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Nov 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08523487

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1in = 0

2in = 6

3in = 10

HS = 2.102

VS = 2.294

GS = 2.483

CENTROID *

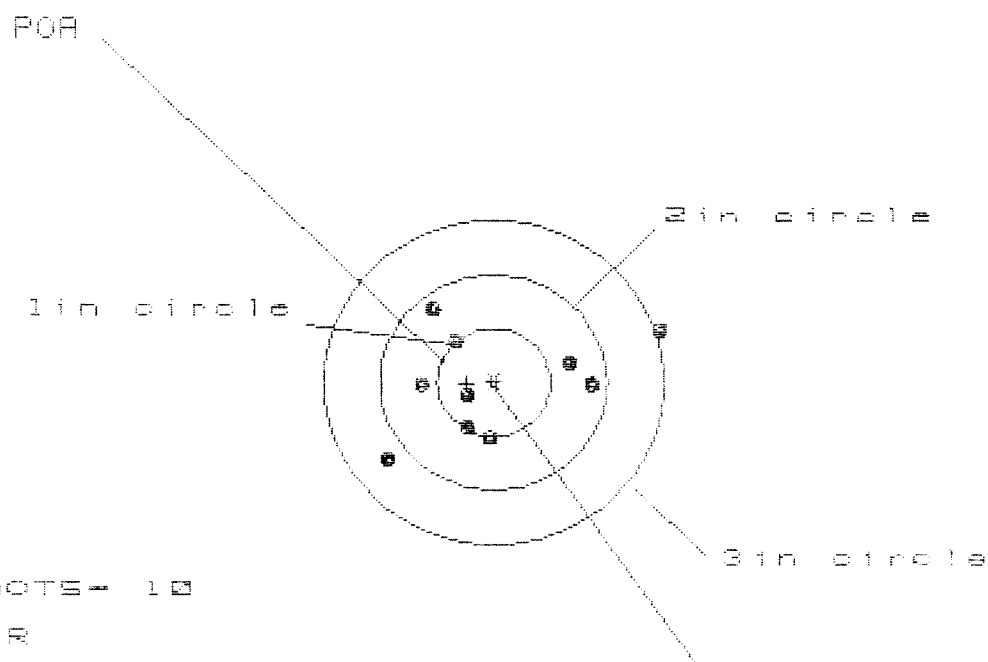
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.159	1.055	1.042
MINIMUM X	:	-.943	-.970	-.983
MAXIMUM Y	:	1.248	1.132	.869
MINIMUM Y	:	-1.046	-.975	-.834
CENTROID X	:	-.022	.082	.095
CENTROID Y	:	.034	.150	.009
POA TO CENTROID in.	:	.041	.172	.095
MIN RADIUS	:	.614	.599	.623
MEAN RADIUS	:	.975	.919	.880
MAX RADIUS	:	1.408	1.136	1.060
HORIZONTAL SPREAD	:	2.102	2.025	2.025
VERTICAL SPREAD	:	2.294	2.107	1.703
EXTREME SPREAD	:	2.483	2.127	2.039
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

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CENTERFIRE PATTERNS

5



OF SHOTS - 10

IN CIR

1in = 2

2in = 8

3in = 9

HS = 2.423

VS = 1.400

GS = 2.697

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.450	1.027	.926
MINIMUM X	:	-.973	-.812	-.611
MAXIMUM Y	:	.674	.725	.641
MINIMUM Y	:	-.726	-.675	-.594
CENTROID X	:	.237	.076	.177
CENTROID Y	:	.014	-.037	.047
POA TO CENTROID in.	:	.237	.084	.183
MIN RADIUS	:	.256	.093	.225
MEAN RADIUS	:	.769	.646	.611
MAX RADIUS	:	1.521	1.056	.926
HORIZONTAL SPREAD	:	2.423	1.839	1.537
VERTICAL SPREAD	:	1.400	1.400	1.235
EXTREME SPREAD	:	2.697	1.984	1.582
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	