

C6225557

MODEL 700TM M24

Model SMSTM

Action

Barrel Length

Capacity

Order No. 5715

*Includes 1 in chamber.

Remington

Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: RE00154261

Serial: C6225557 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

Status:

Closed 10/30/2008 8:24:01 AM

Address Information

Customer:

☒ Received From

Return To:

☐ Received From

Name: ISD ARMSROOM

ISD ARMSROOM

Address 1: 8TH DESERT STORM

8TH DESERT STORM

Address 2: BLDG 5210 BAY DOOR #30

PO Box:

BLDG 5210 BAY DOOR #30

PO Box:

City: FORT CAMPBELL

FORT CAMPBELL

State: KY

Zip Code: 42223

Country: US

State: KY

Zip Code: 42223

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A026	Scope	1
D000	MARS RAIL	1

Repair Search

Refresh

Close

naglelj

10/30/2008

12:42 PM

CAPS

NUM

INS

SCPL

start

6M

2T

6M

P...

D...

A...

A...

U...

12:42 PM

Serial
Number:

C6225557

Model: M24 SWS



RE00154261

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER

154261

SERIAL NUMBER

C6225557

LOG-IN DATE

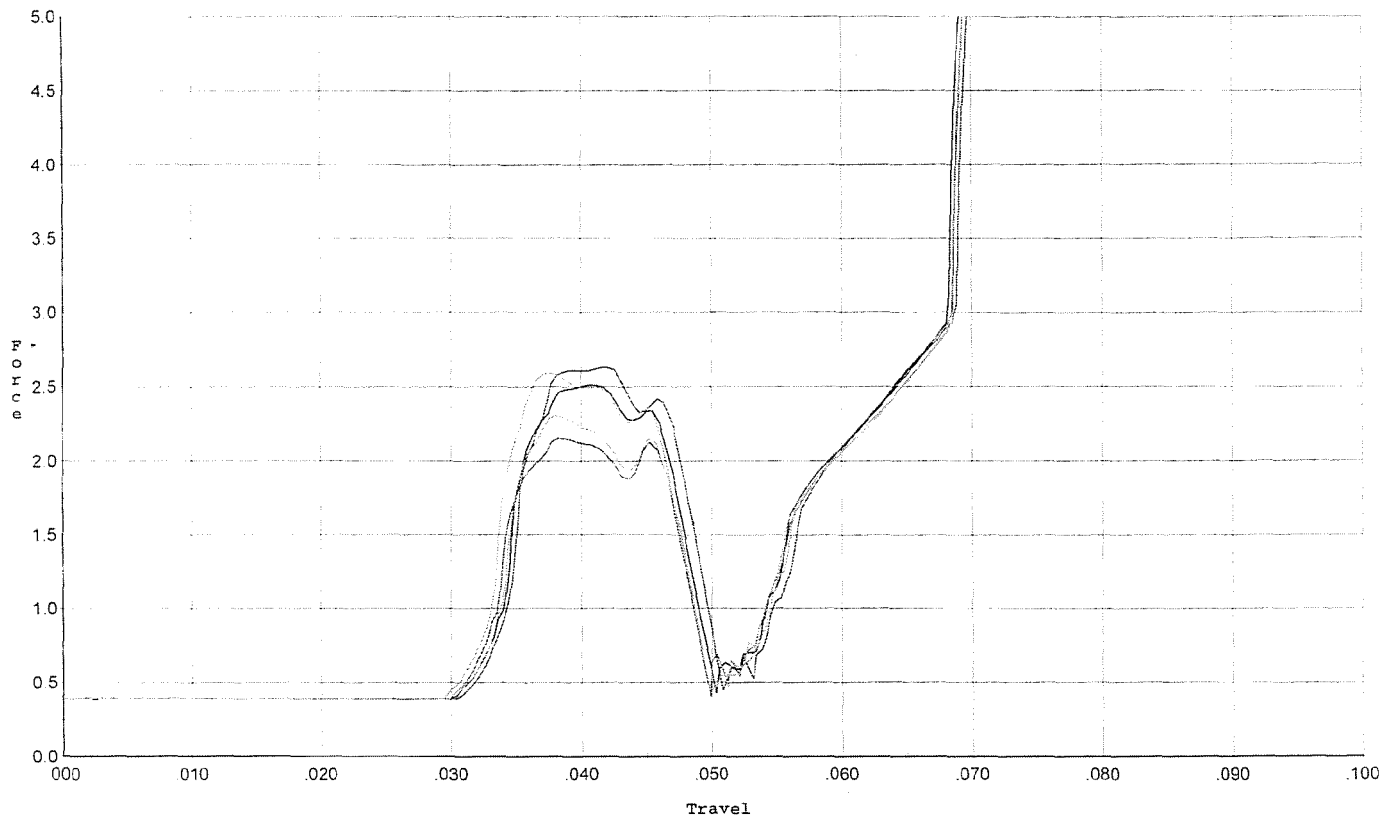
10-30-08

OPERATION #	OPERATION NAME		DATE	INITIAL
500	DIS-ASSEMBLE GUN		11-6-08	RTZ
505	RE-BARREL		11-7-08	RTZ
560	ASSEMBLE		11-7-08	RTZ
600	PROOF		11-11-08	SPD
605	CHECK HEADSPACE		11-11-08	SPD
610	DIS-ASSEMBLE GUN		11-11-08	SPD
612	MAGNAFLUX		11-12-08	S
510	DRILL AND TAP		11-17-08	RT
615	ROLLMARK CALIBER		11-17-08	RT
618	ROTO-BLAST			
620	APPLY COATINGS		11-21	
625	FINAL ASSEMBLY		12-1-08	RTZ
640	FUNCTION TEST AND	(PASS) FAIL	12-4-08	SPD
650	TARGET	(PASS) FAIL	12-4-08	SPD
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
	MALFUNCTION	CORRECTION		
670	FINAL INSPECTION		12-5-08	SPD
	A) HEADSPACE	(PASS) FAIL	12-5-08	SPD
	4 - 5 LBS MIN 2.50 LBS BI TRIGGER PULL MAX 4.0 LBS	260 259 254 254 255	12-5-08	SPD
	2 LBS MIN 10 LBS MAX FI SAFETY ON FORCE	49 39 30	12-5-08	SPD
	2 LBS FI SAFETY OFF FORCE	49 40 40	12-5-08	SPD
	I) FIRING PIN INDENT .020	.021 .021 .021	12-5-08	SPD
690	PACK		12-7-08	FM

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs ini +/- .50 lbs



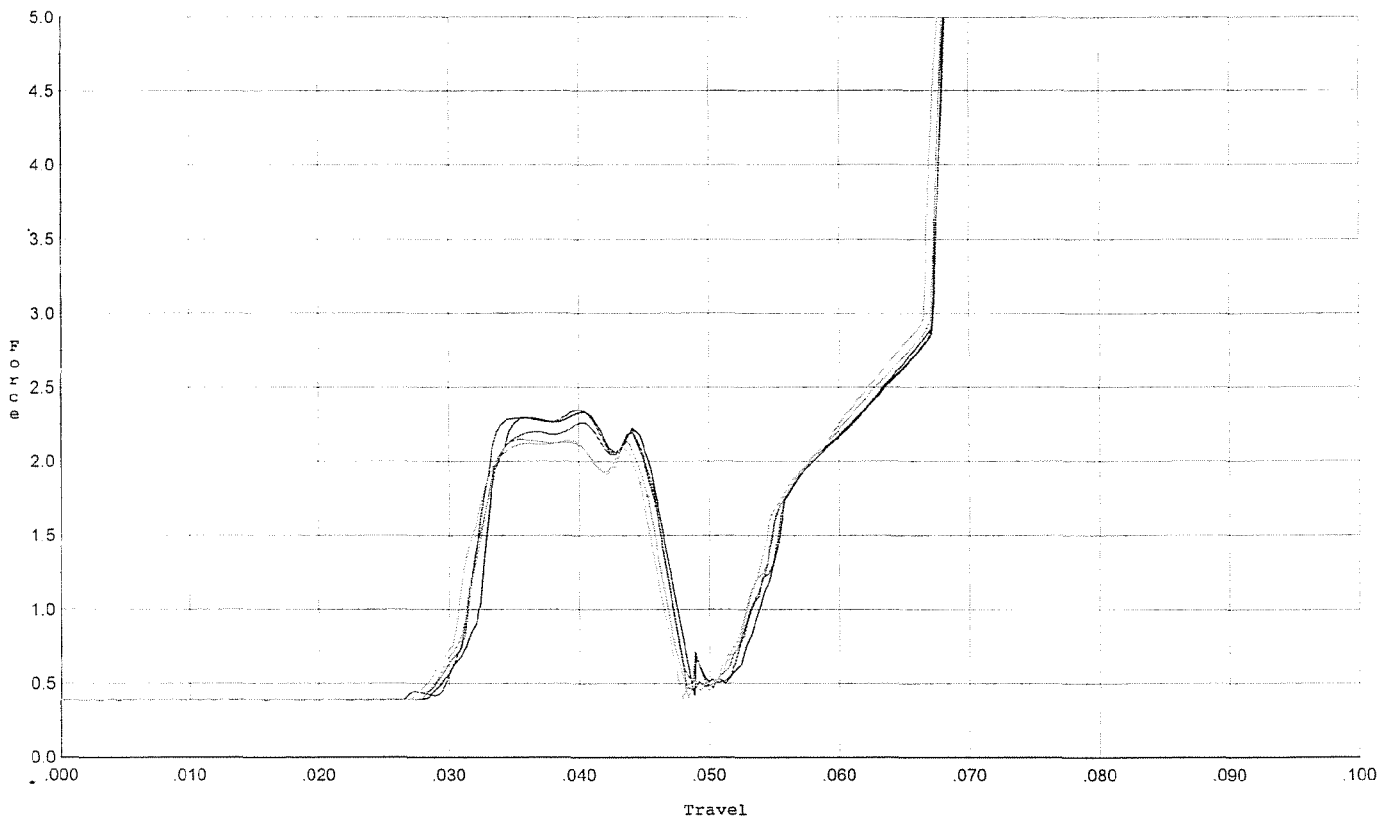
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.630	0.049	0.033	0.028	0.047		Set Trigger
2	2.512	0.047	0.032	0.028	0.044		Set Trigger
3	2.153	0.048	0.032	0.029	0.042		Set Trigger
4	2.595	0.048	0.031	0.028	0.047		Set Trigger
5	2.307	0.048	0.032	0.028	0.042		Set Trigger

A2-43

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

Model: M/24
 Serial No: Form #F005
 Trigger: 2.5 lbs after 50 cycles+/- .50 lbs



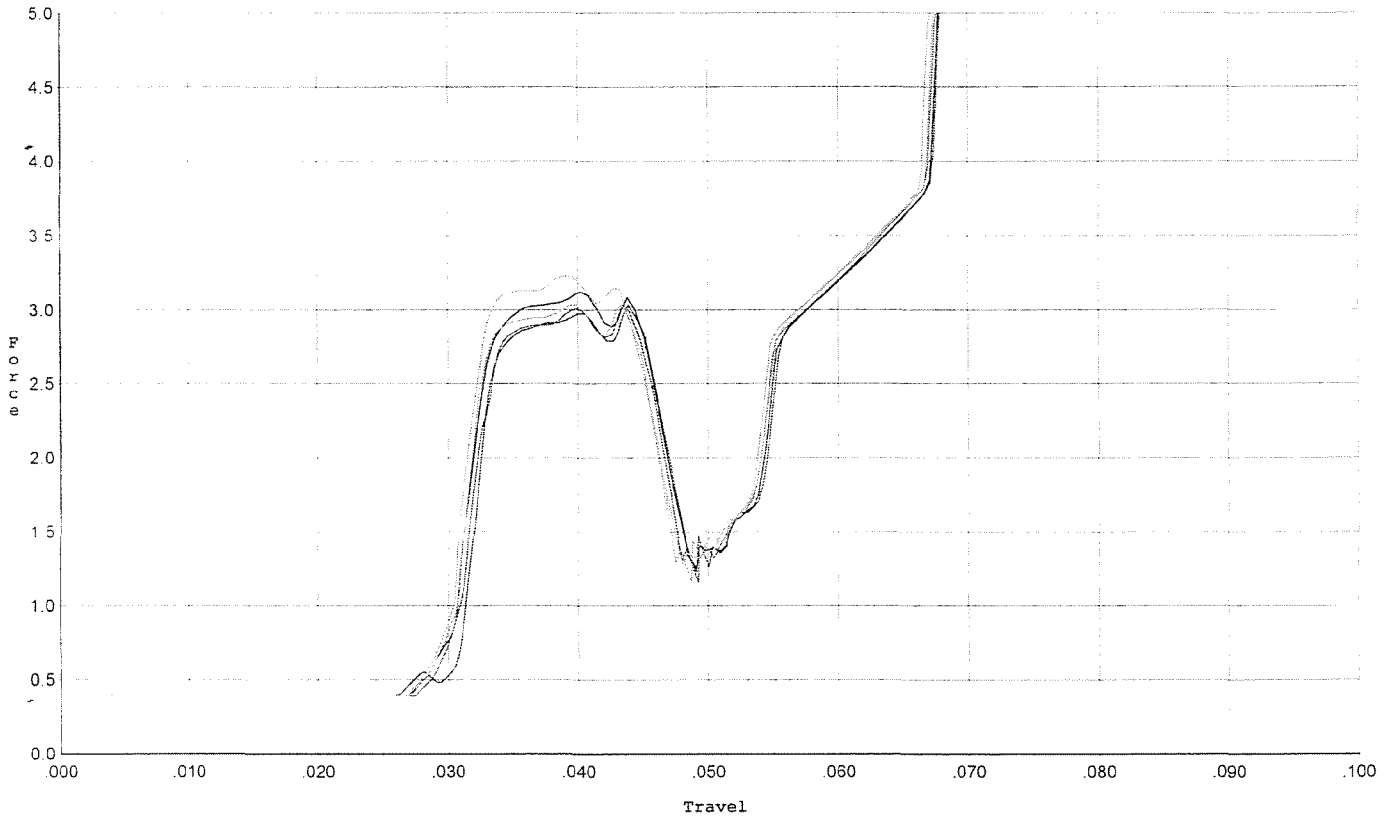
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.343	0.046	0.030	0.029	0.044		Set Trigger
2	2.331	0.047	0.031	0.028	0.044		Set Trigger
3	2.261	0.046	0.030	0.029	0.043		Set Trigger
4	2.140	0.045	0.029	0.029	0.041		Set Trigger
5	2.146	0.045	0.029	0.029	0.041		Set Trigger

A-2-24

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs ini +/- .75 lbs



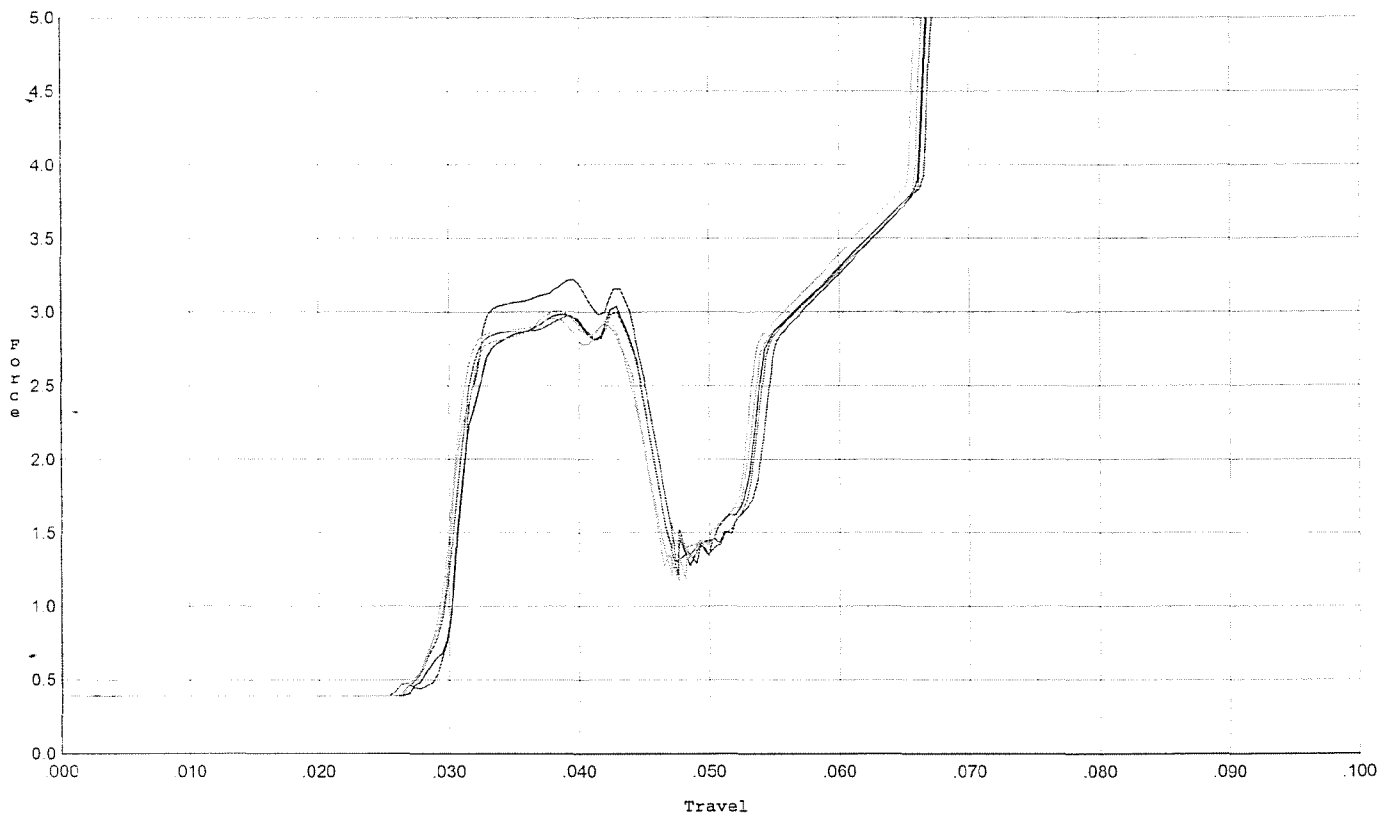
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.037	0.045	0.031	0.027	0.053		Set Trigger
2	3.119	0.045	0.029	0.027	0.055		Set Trigger
3	3.017	0.046	0.029	0.027	0.054		Set Trigger
4	3.039	0.045	0.029	0.028	0.054		Set Trigger
5	3.231	0.045	0.029	0.027	0.056		Set Trigger

A-3.08

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

Model: M/24
 Serial No: Form #F005
 Trigger: 3.0 lbs after 20 cycles+/- .75 lbs



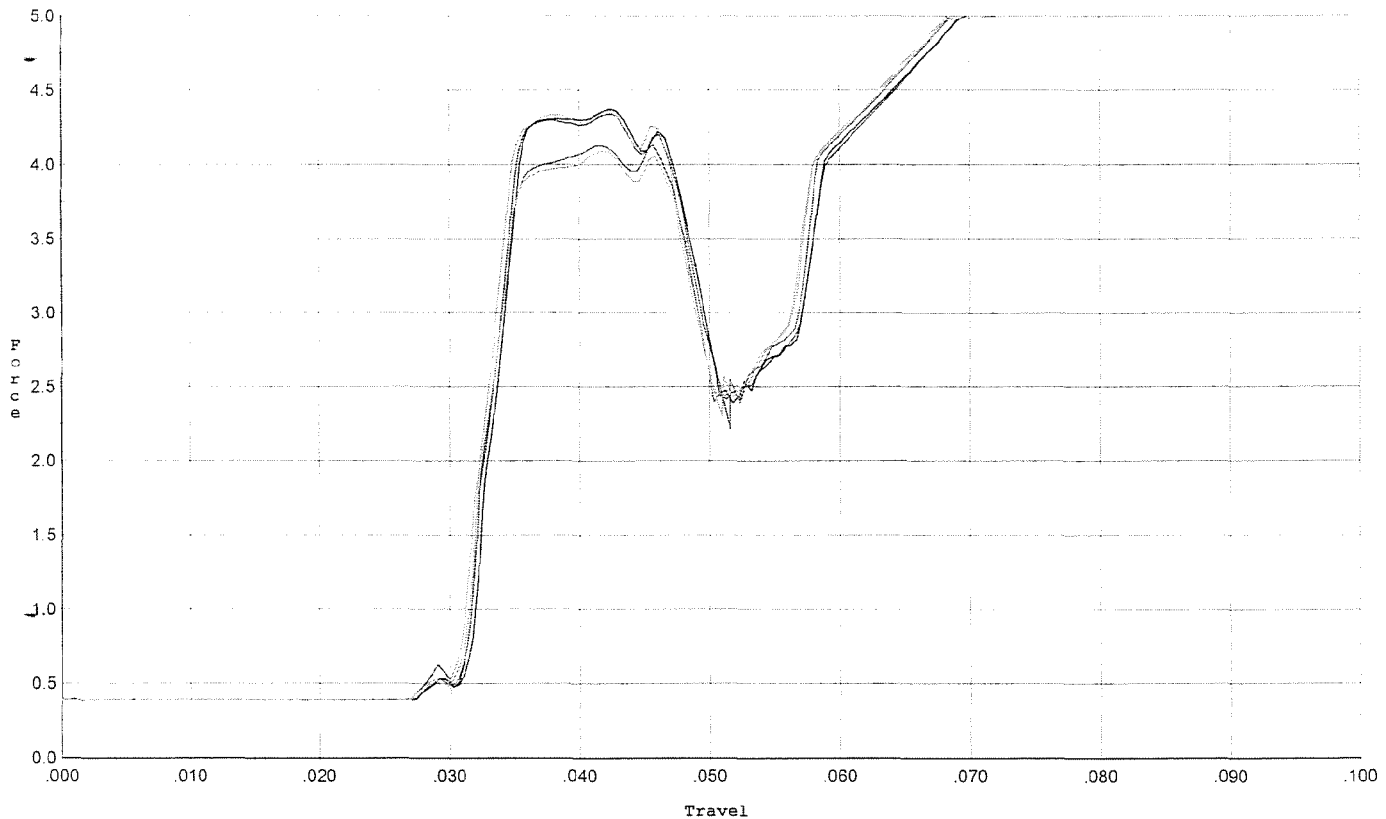
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.218	0.045	0.029	0.027	0.057		Set Trigger
2	3.038	0.044	0.029	0.027	0.053		Set Trigger
3	3.000	0.044	0.027	0.027	0.054		Set Trigger
4	3.012	0.044	0.028	0.028	0.053		Set Trigger
5	2.952	0.044	0.027	0.027	0.053		Set Trigger

A 3.04

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: C Schults 10/30/2008

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs ini +/- 1.0 lbs



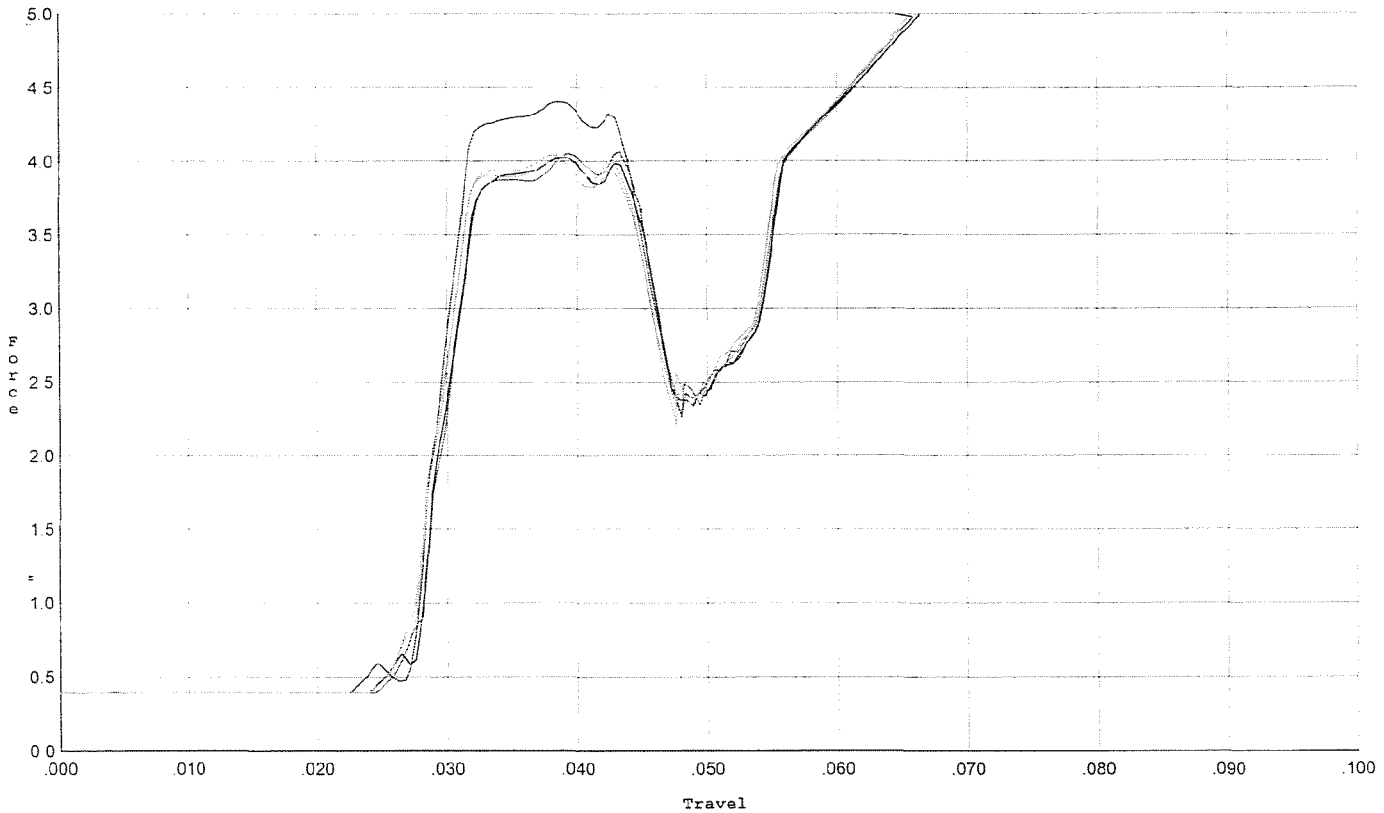
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.345	0.048	0.029	0.026	0.078		Set Trigger
2	4.374	0.049	0.031	0.025	0.080		Set Trigger
3	4.133	0.048	0.031	0.025	0.076		Set Trigger
4	4.093	0.047	0.031	0.026	0.073		Set Trigger
5	4.364	0.049	0.030	0.025	0.080		Set Trigger

A-4-26

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

Model: M/24
 Serial No: Form #F005
 Trigger: 4.0 lbs after 20 cycles+/- 1.0 lbs



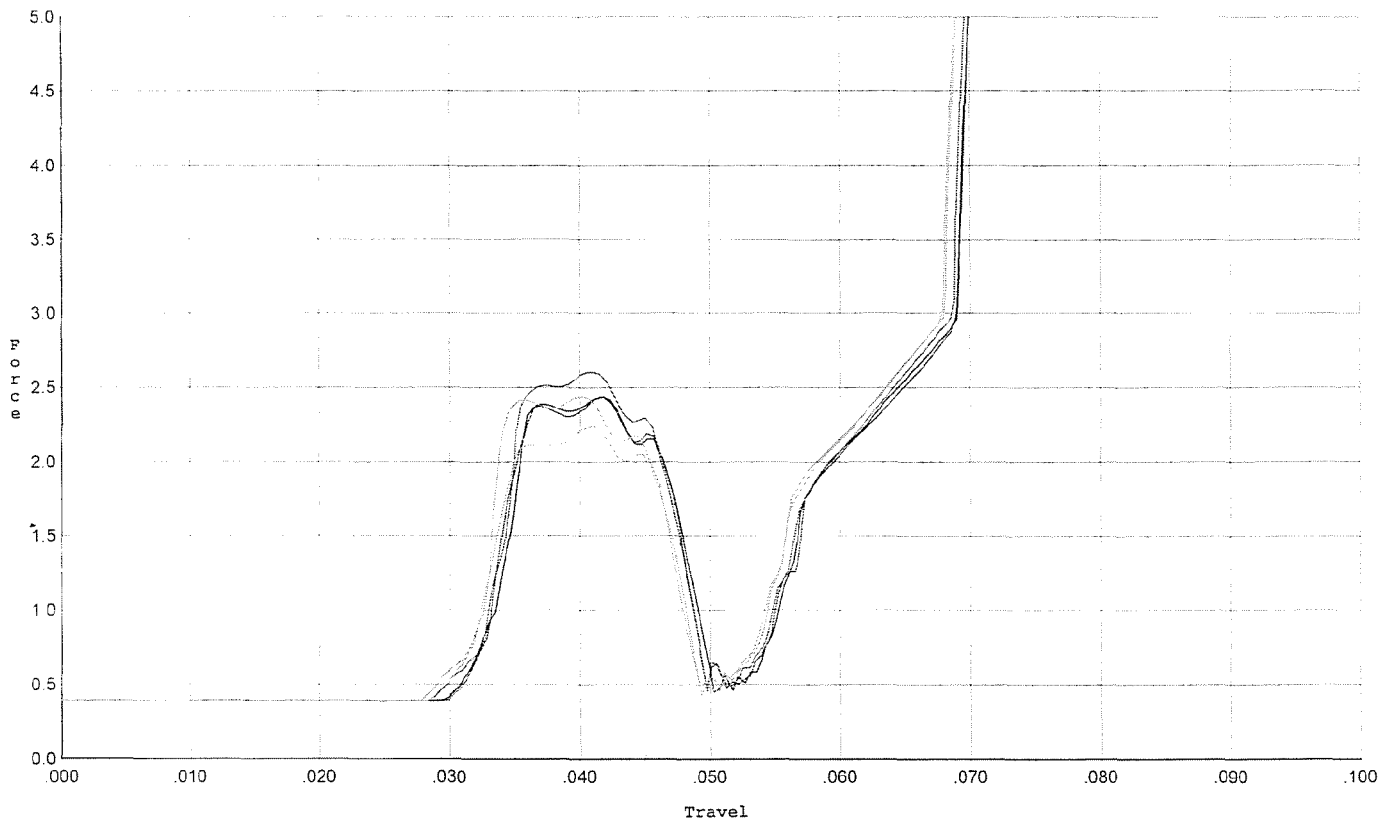
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.403	0.044	0.027	0.026	0.077		Set Trigger
2	4.020	0.045	0.026	0.025	0.074		Set Trigger
3	4.066	0.045	0.026	0.026	0.074		Set Trigger
4	4.040	0.044	0.026	0.026	0.074		Set Trigger
5	3.999	0.045	0.026	0.026	0.073		Set Trigger

A-4.10

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

Model: M/24
 Serial No: Form #F005
 Trigger: reset to 2.5 lbs +/- .50 lbs for final test



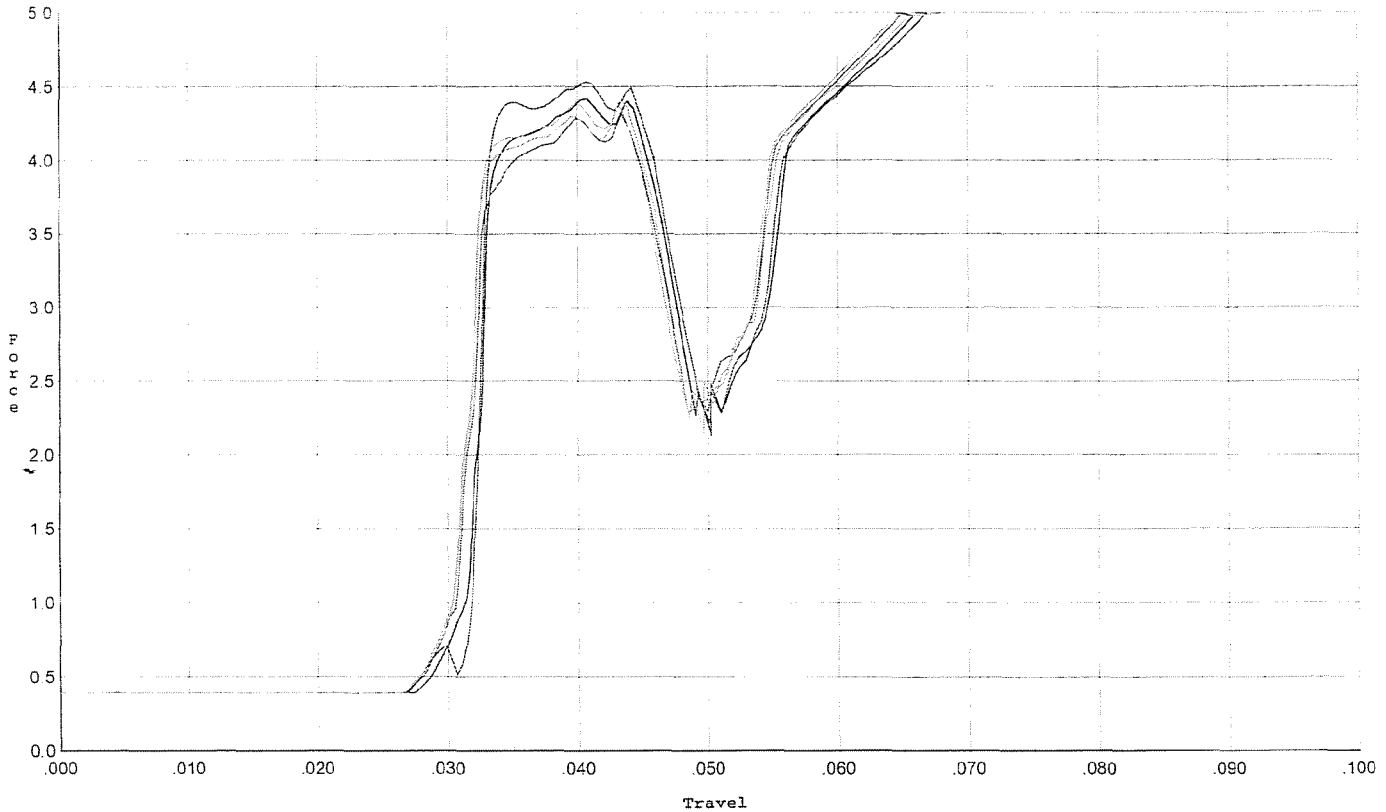
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.436	0.048	0.032	0.029	0.045		Set Trigger
2	2.436	0.049	0.031	0.028	0.046		Set Trigger
3	2.602	0.047	0.033	0.029	0.046		Set Trigger
4 -	2.242	0.047	0.031	0.028	0.043		Set Trigger
5	2.439	0.046	0.031	0.029	0.044		Set Trigger

A-2.43

Trigger Profile [lbs,inch]

Profile SWS
 GunType: Rifle
 Make: Remington
 Note: C Schults 10/30/2008

Model: M/24
 Serial No: Form #F005
 Trigger: set to 4.0 lbs ini +/- 1.0 lb for final test



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.528	0.046	0.028	0.025	0.076		Set Trigger
2	4.420	0.047	0.029	0.025	0.075		Set Trigger
3	4.313	0.046	0.029	0.025	0.074		Set Trigger
4	4.405	0.046	0.029	0.025	0.076		Set Trigger
5	4.365	0.045	0.029	0.025	0.073		Set Trigger

A 4.40

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6225557.___0

FILE DATE AND TIME: 12/05/2008 09:20

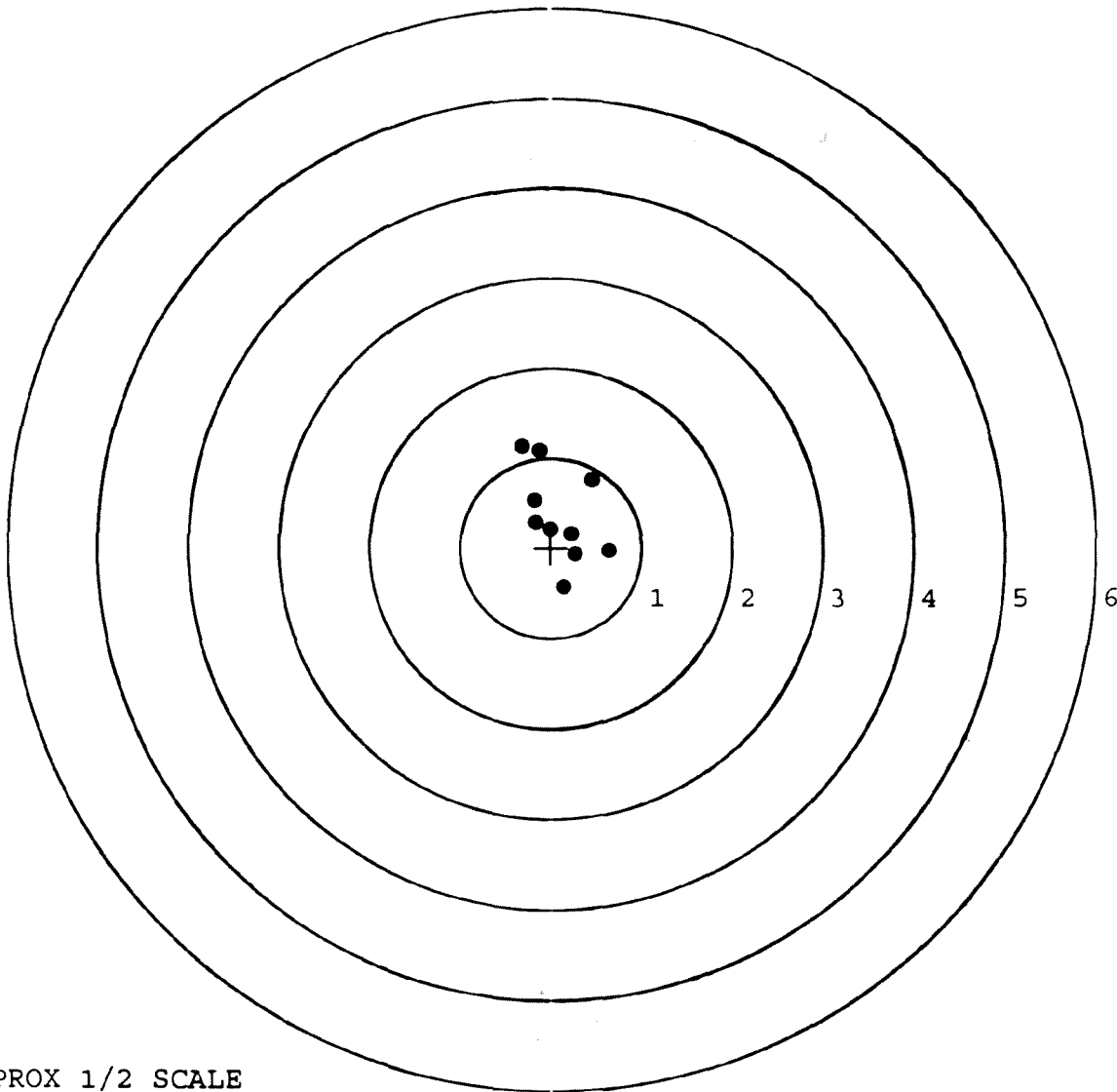
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.009
The Average Y Centroid of the Five Target Set:	0.034
The Average Point of Impact of the Five Target Set:	0.035
The Average Mean Radius of the Five Target Set:	0.628
The Distance from POA to Centroid Target #1:	0.374
The Distance from Centroid Target #2 to Centroid Target #1:	0.415
The Distance from Centroid Target #3 to Centroid Target #1:	0.671
The Distance from Centroid Target #4 to Centroid Target #1:	0.456
The Distance from Centroid Target #5 to Centroid Target #1:	0.319

SERIAL NUMBER: C6225557. __0
 TARGET NUMBER: 1
 FILE DATE: 12/05/2008
 FILE TIME: 09:20

POINT#	X	Y
1:	-0.317	1.138
2:	-0.122	1.087
3:	0.454	0.759
4:	-0.180	0.531
5:	-0.162	0.281
6:	0.001	0.211
7:	0.224	0.160
8:	0.269	-0.075
9:	0.643	-0.036
10:	0.145	-0.439

X CENTROID: 0.095
 Y CENTROID: 0.362
 POA TO CENTROID: 0.374
 HORZ SPREAD: 0.960
 VERT SPREAD: 1.577
 GROUP SPREAD: 1.643
 MIN RADIUS: 0.178
 MAX RADIUS: 0.879
 MEAN RADIUS: 0.513
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

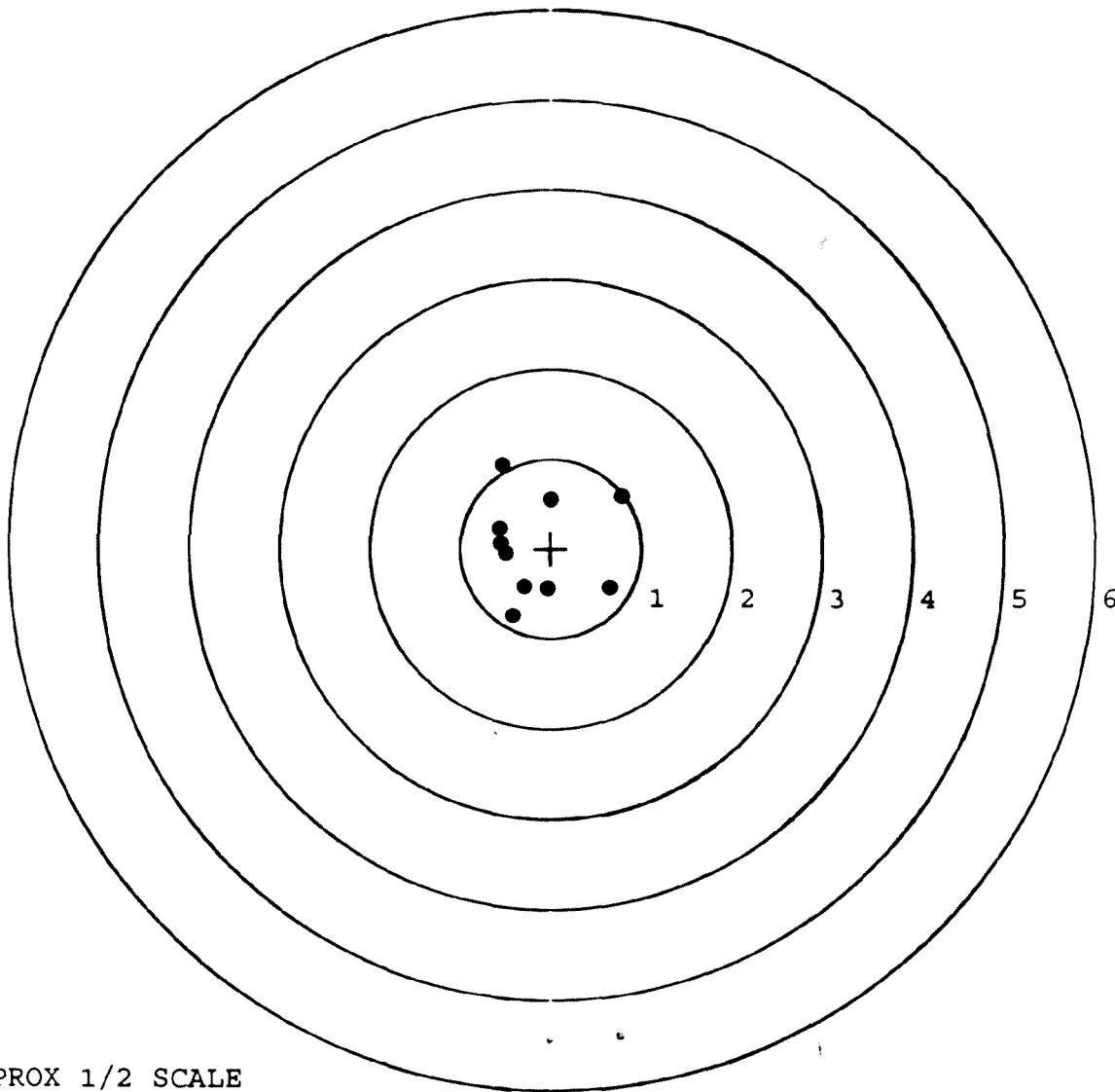


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225557. __0
 TARGET NUMBER: 2
 FILE DATE: 12/05/2008
 FILE TIME: 09:20

POINT#	X	Y
1:	-0.538	0.935
2:	-0.002	0.552
3:	0.782	0.593
4:	0.652	-0.434
5:	-0.036	-0.447
6:	-0.299	-0.427
7:	-0.421	-0.750
8:	-0.496	-0.059
9:	-0.553	0.061
10:	-0.566	0.233

X CENTROID: -0.148
 Y CENTROID: 0.026
 POA TO CENTROID: 0.150
 HORZ SPREAD: 1.348
 VERT SPREAD: 1.685
 GROUP SPREAD: 1.803
 MIN RADIUS: 0.358
 MAX RADIUS: 1.089
 MEAN RADIUS: 0.656
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225557. 0

TARGET NUMBER: 3

FILE DATE: 12/05/2008

FILE TIME: 09:20

X CENTROID: -0.059

Y CENTROID: -0.291

POA TO CENTROID: 0.297

HORZ SPREAD: 1.730

VERT SPREAD: 1.307

GROUP SPREAD: 2.018

MIN RADIUS: 0.049

MAX RADIUS: 1.179

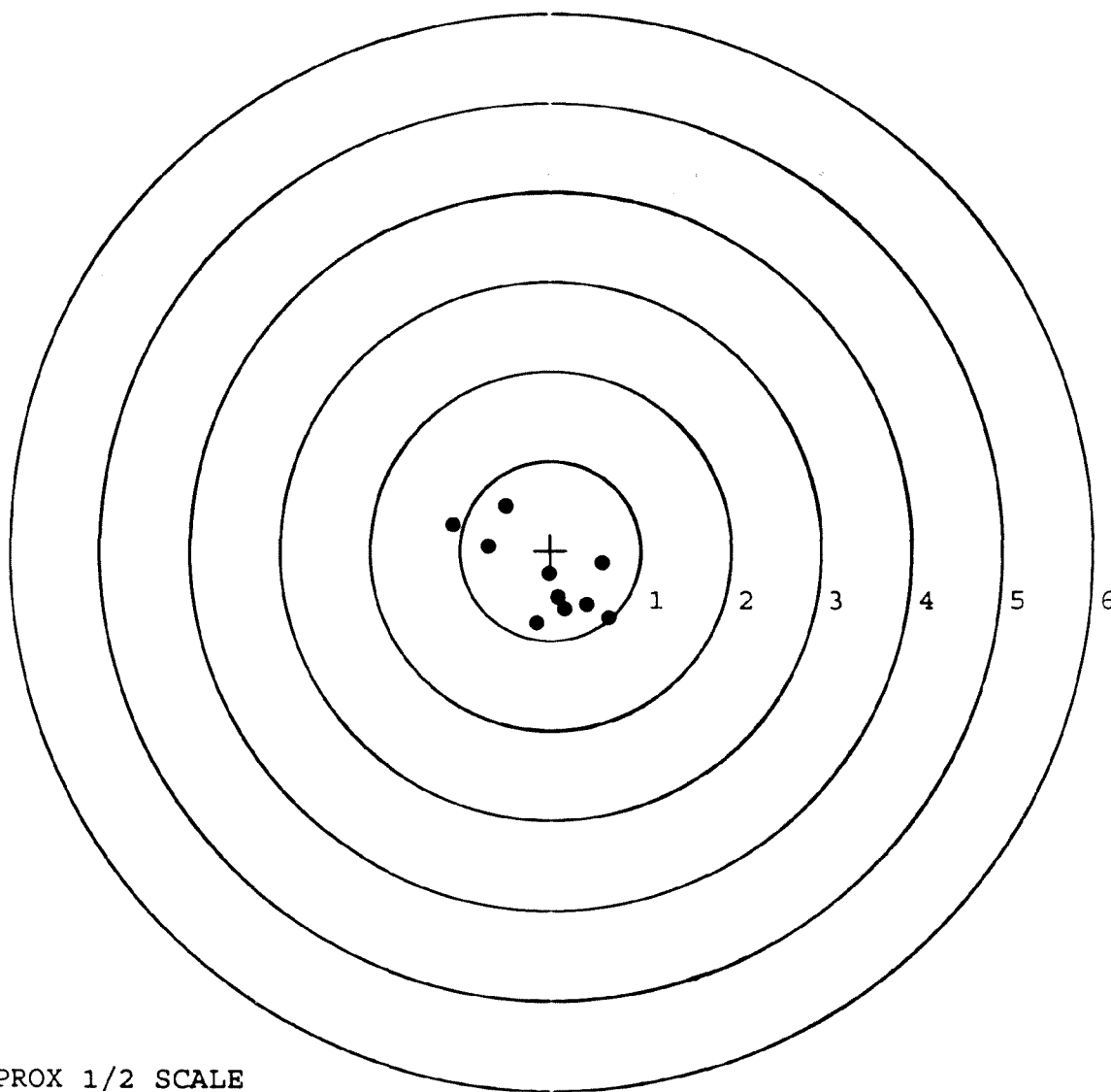
MEAN RADIUS: 0.613

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 9

in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-1.085	0.289
2:	-0.500	0.495
3:	-0.693	0.052
4:	-0.018	-0.265
5:	0.085	-0.524
6:	0.157	-0.659
7:	-0.158	-0.812
8:	0.402	-0.600
9:	0.645	-0.750
10:	0.578	-0.140

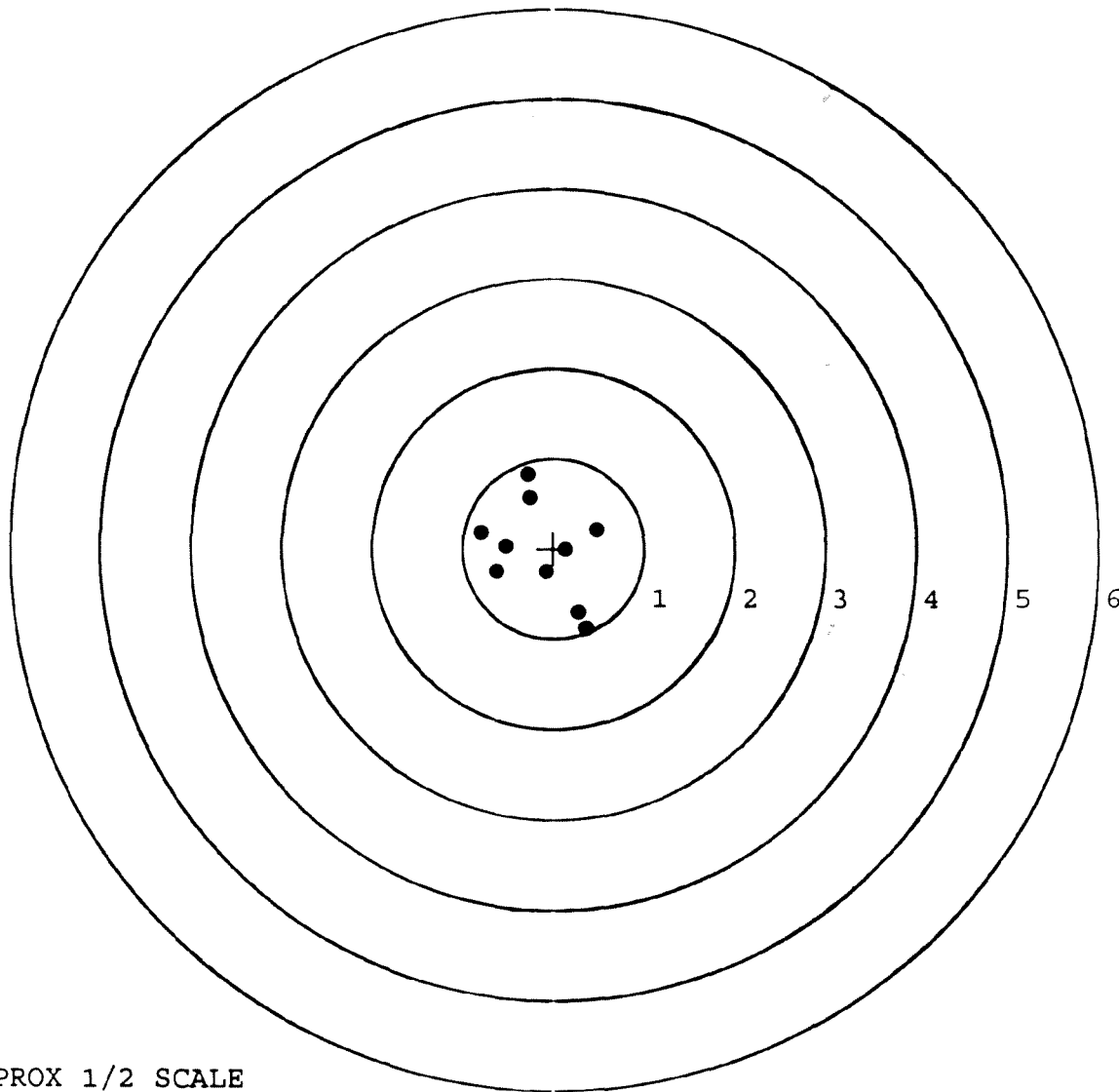


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6225557. 0
 TARGET NUMBER: 4
 FILE DATE: 12/05/2008
 FILE TIME: 09:20

POINT#	X	Y
1:	-0.281	0.821
2:	-0.266	0.566
3:	-0.802	0.174
4:	-0.525	0.032
5:	-0.624	-0.255
6:	-0.081	-0.262
7:	0.135	-0.016
8:	0.478	0.213
9:	0.274	-0.710
10:	0.359	-0.890

X CENTROID: -0.133
 Y CENTROID: -0.033
 POA TO CENTROID: 0.137
 HORZ SPREAD: 1.280
 VERT SPREAD: 1.711
 GROUP SPREAD: 1.827
 MIN RADIUS: 0.235
 MAX RADIUS: 0.989
 MEAN RADIUS: 0.606
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10



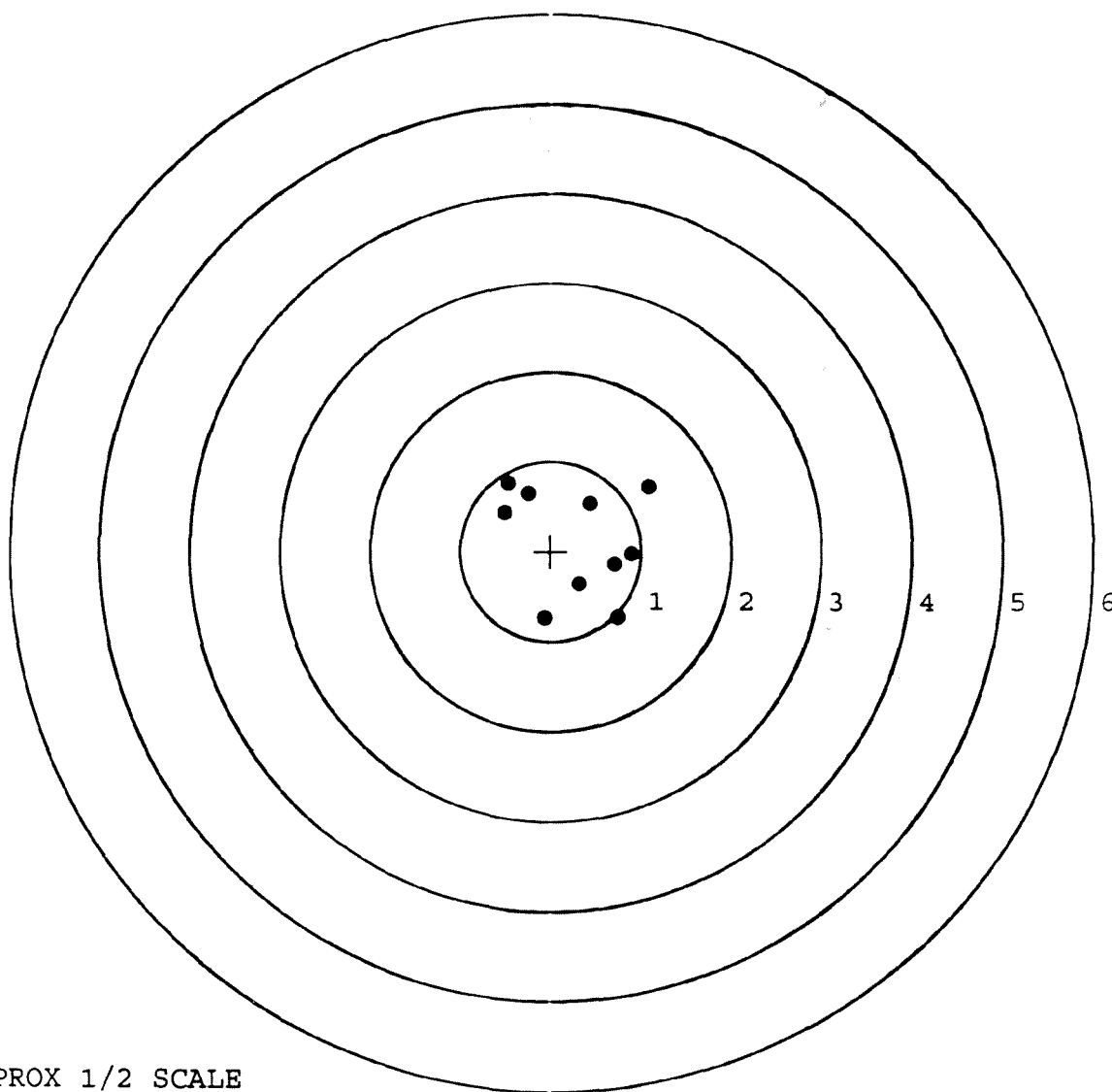
TARGET APPROX 1/2 SCALE

BARBER - M24 0051415

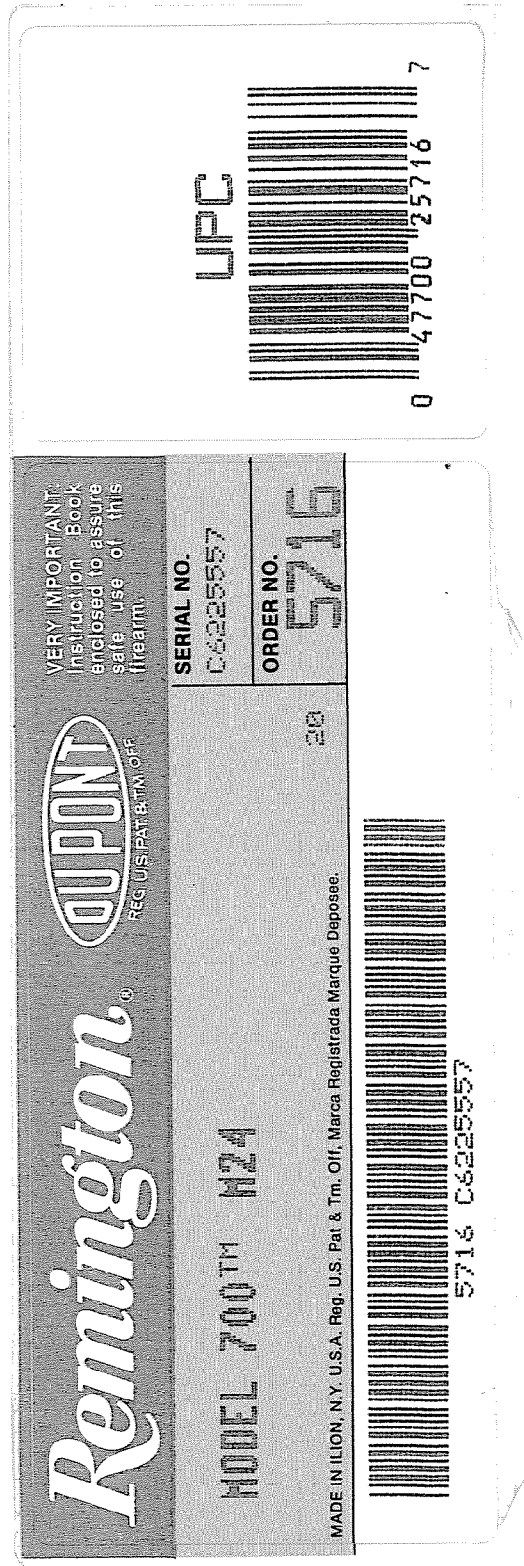
SERIAL NUMBER: C6225557. __0
 TARGET NUMBER: 5
 FILE DATE: 12/05/2008
 FILE TIME: 09:20

POINT#	X	Y
1:	-0.472	0.757
2:	-0.249	0.642
3:	-0.513	0.431
4:	0.434	0.529
5:	1.081	0.720
6:	0.899	-0.033
7:	0.709	-0.140
8:	0.319	-0.369
9:	-0.072	-0.740
10:	0.743	-0.728

X CENTROID: 0.288
 Y CENTROID: 0.107
 POA TO CENTROID: 0.307
 HORZ SPREAD: 1.594
 VERT SPREAD: 1.497
 GROUP SPREAD: 1.860
 MIN RADIUS: 0.447
 MAX RADIUS: 1.002
 MEAN RADIUS: 0.753
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE



CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6225557

OP. #	OP. NAME	READINGS	DATE	INITIAL
575 & 580	Assemble Action and Stock	12 9 88		RW
600	Proof	12 9 88		RW
607	Check Headspace	12 9 88		RW
610	Dis-assemble Gun	12 9 88		RW
612	Magnaflux Barrel Action	INTERCHANGEABILITY	12.22.88	RJC.
	Magnaflux Bolt		1-3-89	RJC.
615	Rollmark Caliber		12/22/88	M.D.C.
617	Drill and Tap Sight Holes	1 3 89		FB
618	Polish Barrel	12 2 88		WJT
620	Apply Coatings (Barrel Action)		1-18-89	ISA
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly		1/23/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/23/89	RW
	C) Inspect Ejector Hole for Chamfer		1/23/89	RW
	D) Oil Firing Pin Ass'y		1/23/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		23/1/89	RS

BARBER - M24 0051418

op. #	OP. NAME	READINGS					DATE	INITIAL
625 cont.	F) Safety On Force	6	6	6			25 Jan 89	JS
	G) Safety Off Force	4	4	4			25 Jan 89	JS
	H) Trigger Pull Test & Retainability						23 Jan 89	JS
	I) Firing Pin Indent	.021	.0205	.0205			25 Jan 89	JS
	J) Assemble Stock						1/30/89	RW
	K) Assemble Swivel Studs						3 Feb 89	JS
	L) Attach Front and Rear Sight Assemblies						1/30/89	RW
	M) Iron Sight Alignment						1/30/89	RW
	N) Detach Front & Rear Sights & place in numbered container						1/30/89	RW
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times						31 Jan 89	JS
640	Gallery Target & Test	51R	108L				1/31/89	AC
	A) Time						11	AC
	B) Malfunctions			NONE			11	AC
	C) Pierced Primers			NONE			11	AC
	D) Optical Clarity of Scope			OK			1/31/89	AC
645	Inspect for Live Ammo			NONE			1/31/89	AC
655	Final Inspection							
	A) Headspace						3 Feb 89	JS
	B) Trigger Pull	2.34	2.35	2.37	2.32	2.32	3 Feb 89	JS
	C) Function						3 Feb 89	JS
660	Pack						22 Mar 89	JS

BARBER - M24 0051419

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. 6225557DATE 4-6-90TESTER D/H

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#	COMMENTS
PULL #1	2.43	2.39	2.52	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.40	2.37	2.46	
PULL #3	2.39	2.31	2.46	
PULL #4	2.33	2.22	2.43	
PULL #5	2.30	2.38	2.42	
TOTAL	11.85	11.67	12.29	
AVG.	2.37	2.33	2.45	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.18	3.09		
PULL #2	3.16	3.16		
PULL #3	3.10	3.12		
PULL #4	3.13	3.16		
PULL #5	3.14	3.01		
TOTAL	15.71	15.54		
AVG.	3.14	3.11		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.36		
PULL #2	4.40	4.40		
PULL #3	4.43	4.37		
PULL #4	4.40	4.36		
PULL #5	4.44	4.38		
TOTAL	22.03	21.87		
AVG.	4.41	4.37		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225557
2 Feb 1989

CENTROIDAL DISTANCES

0 TO	1	.504386
1 TO	2	.823253
1 TO	3	.356585
1 TO	4	.47555
1 TO	5	.396073

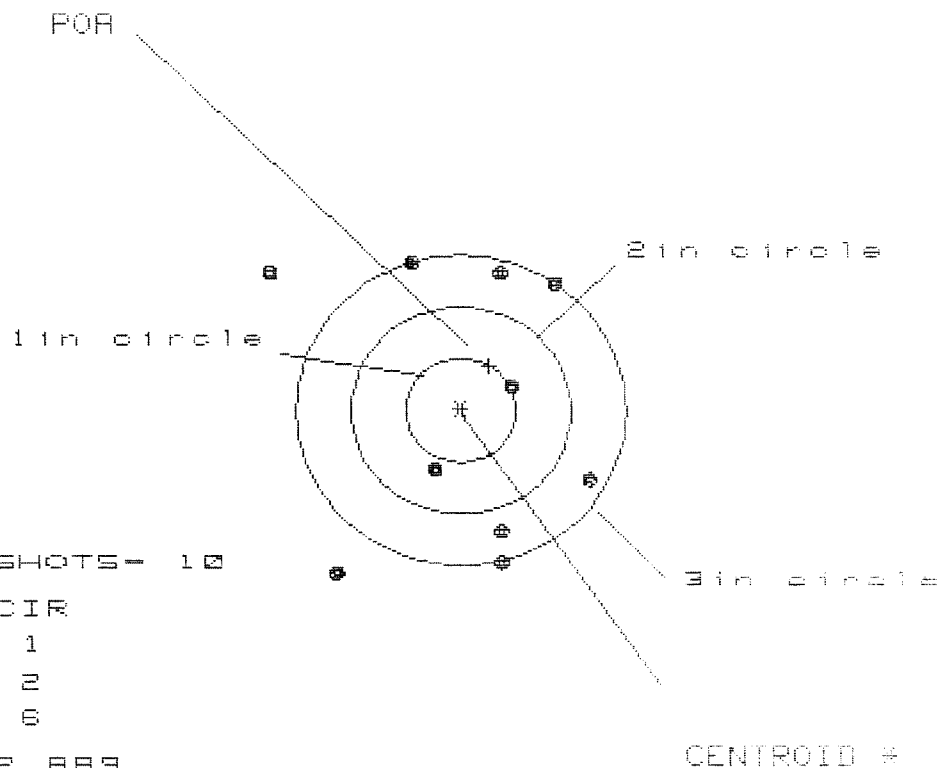
$\frac{\sum x^2}{n}$ (----POA)

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0134
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1744
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .174914
THE AMR FOR THIS RIFLE IS: 1.157

31 Jan 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225557

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 2

3 in = 6

HS= 2.889

VS= 3.004

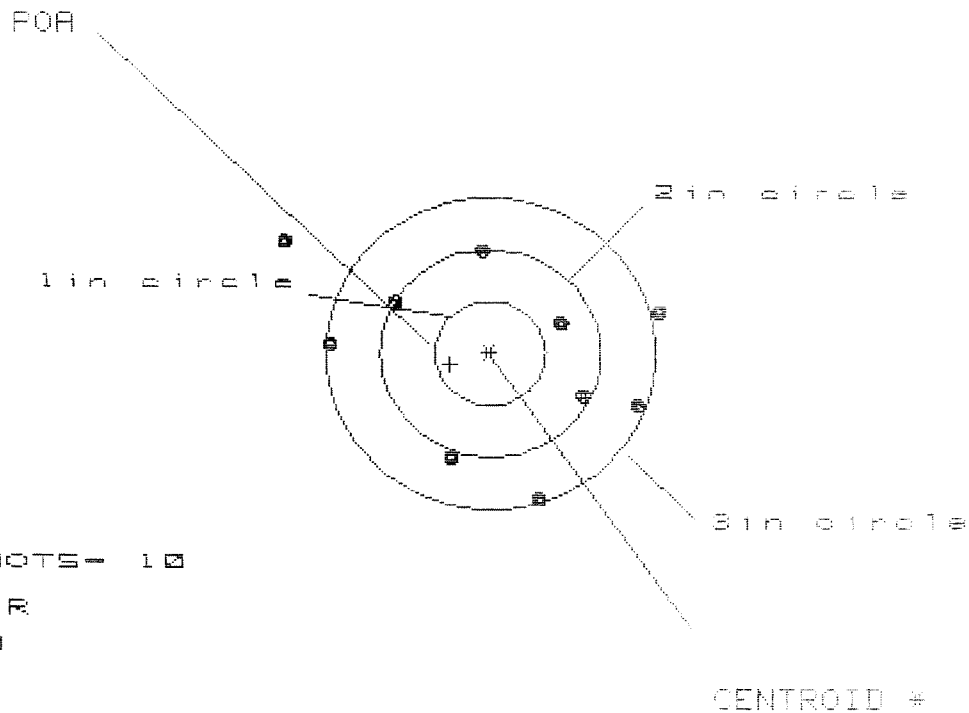
GS= 3.544

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.135	.940	.772
MINIMUM X	-1.754	-1.343	-.799
MAXIMUM Y	1.457	1.605	1.431
MINIMUM Y	-1.547	-1.399	-1.501
CENTROID X	-.262	-.067	.101
CENTROID Y	-.431	-.579	-.405
POA TO CENTROID in.	.504	.583	.417
MIN RADIUS	.487	.454	.227
MEAN RADIUS	1.373	1.243	1.132
MAX RADIUS	2.206	1.939	1.639
HORIZONTAL SPREAD	2.889	2.283	1.572
VERTICAL SPREAD	3.004	3.004	2.932
EXTREME SPREAD	3.544	3.405	3.049
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	6		

31 Jan 1985

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CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 3.423

VS= 2.472

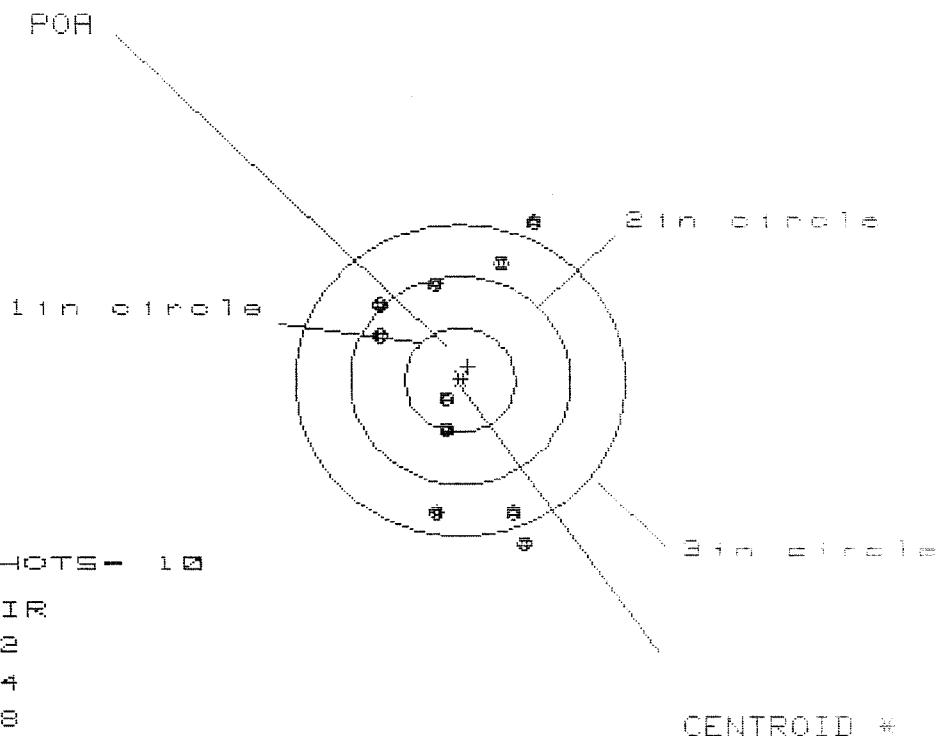
GS= 3.614

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.519	1.307	1.307
MINIMUM X	:	-1.904	-1.687	-1.523
MAXIMUM Y	:	1.072	1.098	1.160
MINIMUM Y	:	-1.400	-1.281	-1.219
CENTROID X	:	.362	.574	.410
CENTROID Y	:	.106	-.013	-.075
POA TO CENTROID in.	:	.377	.574	.417
MIN RADIUS	:	.660	.546	.710
MEAN RADIUS	:	1.278	1.143	1.118
MAX RADIUS	:	2.185	1.703	1.552
HORIZONTAL SPREAD	:	3.423	2.994	2.830
VERTICAL SPREAD	:	2.472	2.379	2.379
EXTREME SPREAD	:	3.614	3.005	2.894
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

31 Jan 1989

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 2

2 in = 4

3 in = 8

HS = 1.369

VS = 3.043

GS = 3.043

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.627	.693	.632
MINIMUM X	-.742	-.676	-.589
MAXIMUM Y	1.503	1.331	1.090
MINIMUM Y	-1.540	-1.448	-1.291
CENTROID X	-.074	-.140	-.227
CENTROID Y	-.128	.043	-.124
POA TO CENTROID in.	.148	.146	.258
MIN RADIUS	.186	.316	.147
MEAN RADIUS	1.058	.979	.887
MAX RADIUS	1.651	1.547	1.429
HORIZONTAL SPREAD	1.369	1.369	1.221
VERTICAL SPREAD	3.043	2.779	2.371
EXTREME SPREAD	3.043	2.891	2.434
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

31 Jan 1989

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CENTERFIRE PATTERNS # 4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 3.188

VS= 1.707

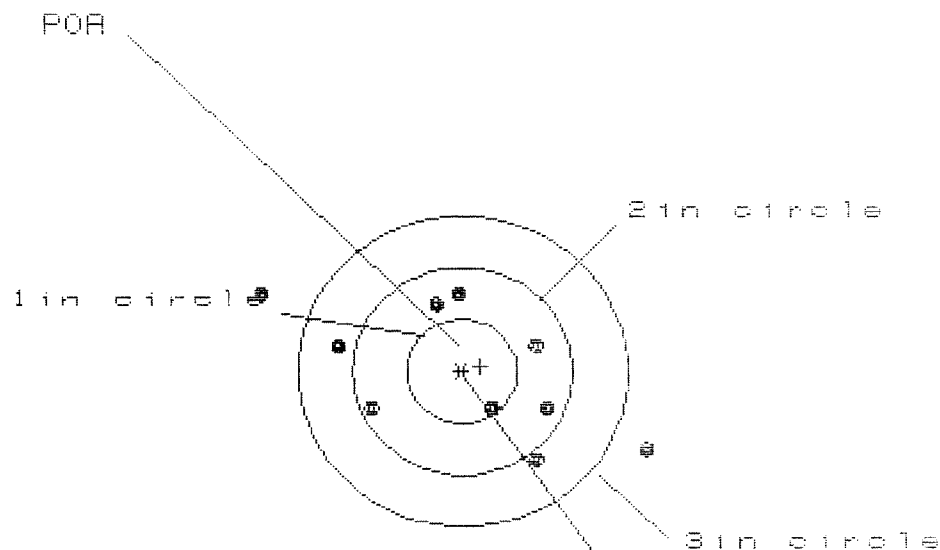
GS= 3.614

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.316	1.108	.861
MINIMUM X	:	-1.870	-1.569	-1.431
MAXIMUM Y	:	.735	.622	.511
MINIMUM Y	:	-.972	-.890	-.685
CENTROID X	:	.210	.418	.280
CENTROID Y	:	-.373	-.455	-.344
POA TO CENTROID in.	:	.428	.618	.443
MIN RADIUS	:	.499	.507	.439
MEAN RADIUS	:	1.039	.900	.835
MAX RADIUS	:	2.010	1.582	1.433
HORIZONTAL SPREAD	:	3.186	2.677	2.292
VERTICAL SPREAD	:	1.707	1.512	1.196
EXTREME SPREAD	:	3.614	2.890	2.316
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

31 Jan 1989

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 3.561

VS = 1.619

GS = 3.860

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.712
MINIMUM X	-1.849
MAXIMUM Y	.768
MINIMUM Y	-.851
CENTROID X	-.169
CENTROID Y	-.046
POA TO CENTROID in.	.175
MIN RADIUS	.446
MEAN RADIUS	1.036
MAX RADIUS	2.002
HORIZONTAL SPREAD	3.561
VERTICAL SPREAD	1.619
EXTREME SPREAD	3.860
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8

INTERCHANGEABILITY

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06225557
17 Mar 1989

CENTROIDAL DISTANCES

0 TO	1	.846676
1 TO	2	1.24925
1 TO	3	.649055
1 TO	4	1.13825
1 TO	5	1.02452

1
2 + <----POA
2

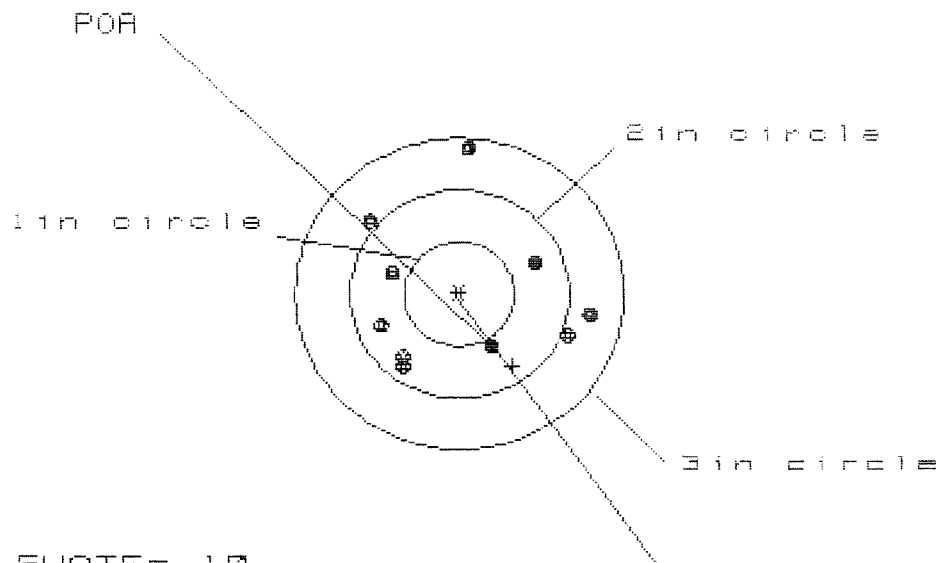
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.7066
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0398
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .70772

THE AMR FOR THIS RIFLE IS: .8008

16 Mar 1989

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CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS= 1.969

VS= 2.055

GS= 2.178

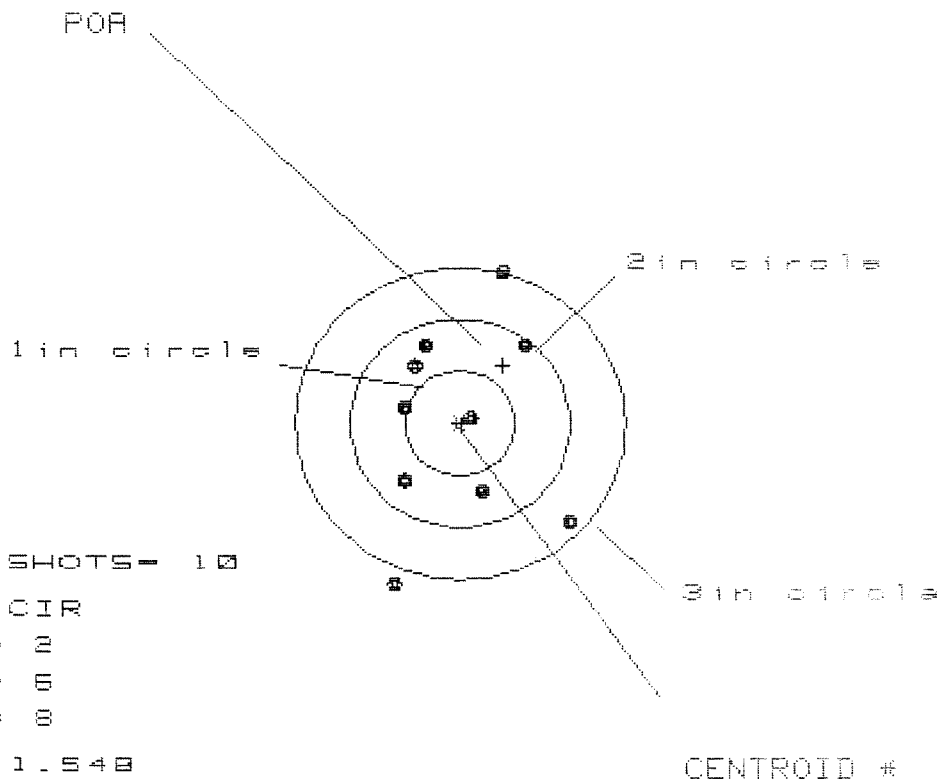
CENTROID X

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.140	1.152	1.091
MINIMUM X	-.829	-.817	-.673
MAXIMUM Y	1.373	.869	.862
MINIMUM Y	-.682	-.530	-.537
CENTROID X	-.485	-.497	-.641
CENTROID Y	.694	.542	.549
POA TO CENTROID in.	.847	.735	.844
MIN RADIUS	.537	.417	.525
MEAN RADIUS	.900	.822	.759
MAX RADIUS	1.377	1.193	1.117
HORIZONTAL SPREAD	1.969	1.969	1.764
VERTICAL SPREAD	2.055	1.399	1.399
EXTREME SPREAD	2.178	2.178	2.080
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

16 Mar 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8225557

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.548

VS= 3.037

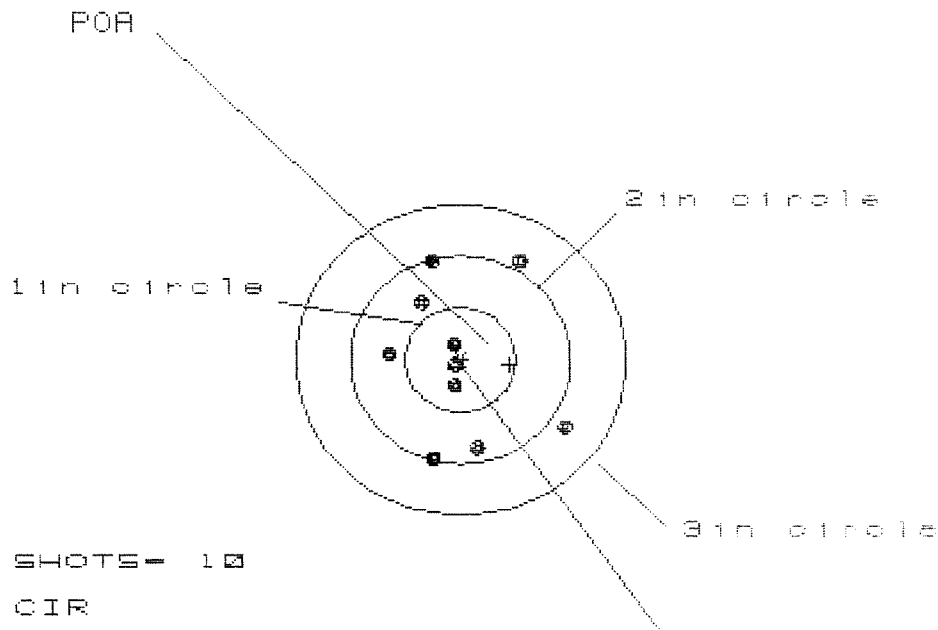
GS= 3.193

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.980
MINIMUM X	:	-.568
MAXIMUM Y	:	1.475
MINIMUM Y	:	-1.562
CENTROID X	:	-.395
CENTROID Y	:	-.552
POA TO CENTROID in.	:	.679
MIN RADIUS	:	.117
MEAN RADIUS	:	.907
MAX RADIUS	:	1.662
HORIZONTAL SPREAD	:	1.548
VERTICAL SPREAD	:	3.037
EXTREME SPREAD	:	3.193
NUMBER IN ONE INCH CIRCLE =	:	2
NUMBER IN TWO INCH CIRCLE =	:	6
NUMBER IN THREE INCH CIRCLE =	:	8

16 Mar 1985

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CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 1.504

VS = 1.861

GS = 2.024

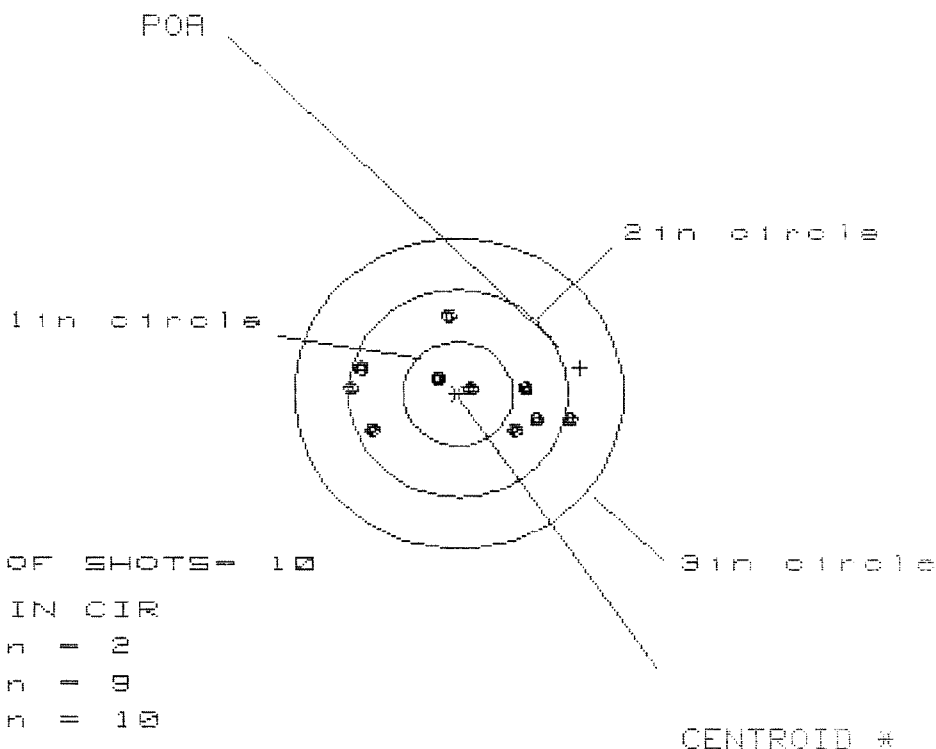
CENTROID #

PATTERN #	:	3	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.898	.636	.345
MINIMUM X	:	-.606	-.506	-.427
MAXIMUM Y	:	.929	.861	.968
MINIMUM Y	:	-.932	-1.000	-.893
CENTROID X	:	-.448	-.548	-.627
CENTROID Y	:	.046	.114	.087
POA TO CENTROID in.	:	.450	.560	.627
MIN RADIUS	:	.081	.069	.106
MEAN RADIUS	:	.668	.603	.548
MAX RADIUS	:	1.088	1.066	.968
HORIZONTAL SPREAD	:	1.504	1.142	.772
VERTICAL SPREAD	:	1.861	1.861	1.861
EXTREME SPREAD	:	2.024	2.024	1.862
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

16 Mar 1989

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CENTERFIRE PATTERNS # 4

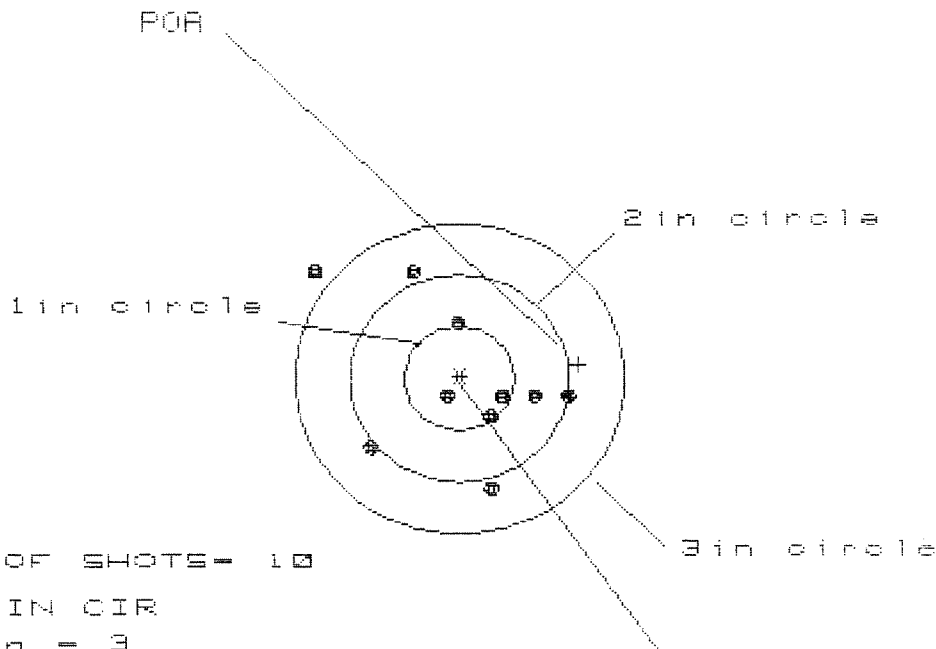


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.997	.798	.692
MINIMUM X	:	-.965	-.855	-.916
MAXIMUM Y	:	.780	.749	.746
MINIMUM Y	:	-.384	-.415	-.418
CENTROID X	:	-1.118	-1.228	-1.121
CENTROID Y	:	-.252	-.221	-.218
POA TO CENTROID in.	:	1.146	1.248	1.142
MIN RADIUS	:	.139	.146	.141
MEAN RADIUS	:	.706	.669	.631
MAX RADIUS	:	1.035	.855	.950
HORIZONTAL SPREAD	:	1.962	1.653	1.600
VERTICAL SPREAD	:	1.164	1.164	1.164
EXTREME SPREAD	:	1.997	1.687	1.687
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Mar 1989

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CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 9

HS = 2.310

VS = 2.093

GS = 2.619

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.017
MINIMUM X	-1.293
MAXIMUM Y	1.051
MINIMUM Y	-1.042
CENTROID X	-1.087
CENTROID Y	-.135
POA TO CENTROID in.	1.095
MIN RADIUS	.191
MEAN RADIUS	.823
MAX RADIUS	1.666
HORIZONTAL SPREAD	2.310
VERTICAL SPREAD	2.093
EXTREME SPREAD	2.619
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	9