

G 684 5854

Replaces

E 670 3536

Oxford

NO. 752 1/3

10%

Evaluate

naglet	2/13/2009	1:31 PM	CAPS	NUM	INS	SCRL
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C 684 5854

Serial Number: ~~E: 6703536~~

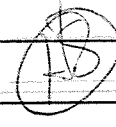
Model: M24 SWS



RE00161972

GUN SERIAL #

G 6845854 For E6703536

OP #	OPERATION NAME	READINGS	DATE	INITIAL
420	ASSEMBLE ACTION		4-3-09	SP
430	ASSEMBLE TO STOCK		4-3-09	SP
440	PROOF		4-3-09	SP
460	CHECK HEADSPACE		4-3-09	SP
470	DIS-ASSEMBLE ACTION		4-3-09	SP
472	SERIALIZE BOLT HANDLE	MAGNA-FLUX	7-6-09	RT
475	DRILL AND TAP SIGHT HOLES		4-6-09	SP
480	MAGNAFLUX BBL ACTION	OPERATOR 	4/8/09	
490	MAGNAFLUX BOLT			
500	ROLLMARK CALIBER		2/8/09	RT
520	GOFF BLAST BBL / REC		4-8	BT
542	APPLY COATINGS (BARREL ACTION)		4-13	C
545	(BOLT)			
560	RE-ASSEMBLE ACTION			
	A) CLEAN INSIDE OF BOLT ASSEMBLY		4-13-09	SP
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD		4-13-09	SP
	C) INSPECT EJECTOR HOLE FOR CHAMFER		4-13-09	SP
	D) OIL FIRING PIN ASSEMBLY			
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE 2.50 LBS +/- .5 LBS			

F004 REV 5/2006

BARBER - M24 00540472 LBS MIN				40	40	40	5-11-09	RJ	
560	F) SAFETY ON FORCE	10 LBS MAX							
CONT.									
	G) SAFETY OFF FORCE	2 LBS MIN	50	50	50	5-11-09	RJ		
	H) TRIGGER PULL TEST AND RETAINABILITY								
	I) FIRING PIN INDENT	.020 MIN	.023	.023	.023	5-11-09	RJ		
	J) ASSEMBLE STOCK								
	K) ASSEMBLE SWIVEL STUDS								
	L) ATTACH FRONT AND REAR SIGHT ASSY'S								
	M) IRON SIGHT ALIGNMENT								
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER								
640 & 650	FUNCTION TEST AND TARGET		PASS	FAIL		5-6-09	N/A		
			PASS	FAIL					
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION N/A						
	MALFUNCTION		CORRECTION						
	MALFUNCTION		CORRECTION						
660	INSPECT FOR LIVE AMMO					5-6-09	TAR		
670	FINAL INSPECTION A) HEADSPACE					5-11-09	RJ		
	B) TRIGGER PULL	+/- .5 LBS MIN 2.50 LBS MAX 4.0 LBS	259	262	263	268	268	5-7-09	RTZ
	C) FUNCTION					5-11-09	RJ		
690	PACK					5-15-09	Fm		

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: G6845854.___0

FILE DATE AND TIME: 05/07/2009 05:42

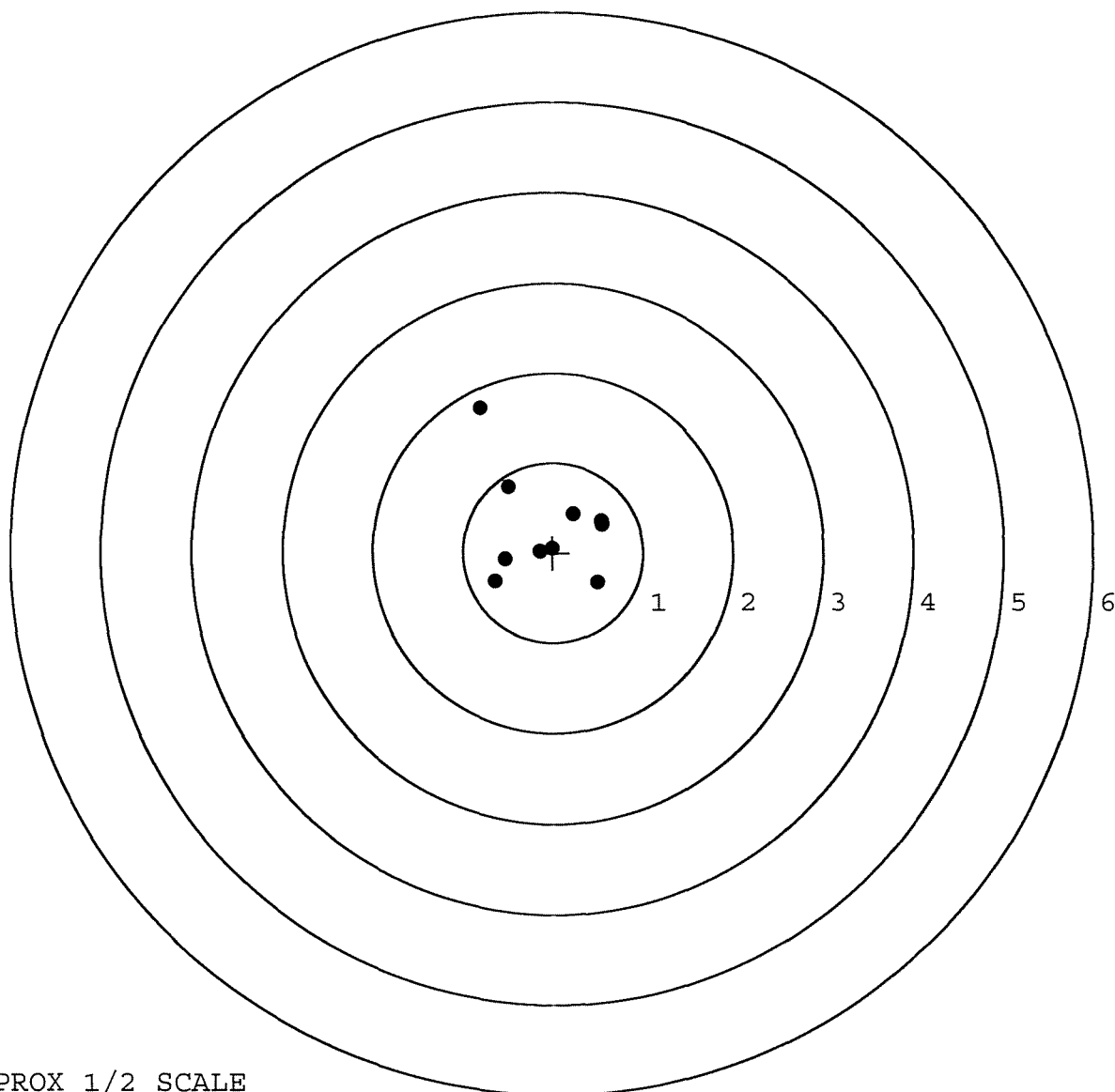
THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.009
The Average Y Centroid of the Five Target Set:	-0.005
The Average Point of Impact of the Five Target Set:	0.010
The Average Mean Radius of the Five Target Set:	0.610
The Distance from POA to Centroid Target #1:	0.288
The Distance from Centroid Target #2 to Centroid Target #1:	0.423
The Distance from Centroid Target #3 to Centroid Target #1:	0.371
The Distance from Centroid Target #4 to Centroid Target #1:	0.271
The Distance from Centroid Target #5 to Centroid Target #1:	0.418

SERIAL NUMBER: G6845854. __0
 TARGET NUMBER: 1
 FILE DATE: 05/07/2009
 FILE TIME: 05:42

X CENTROID: -0.082
 Y CENTROID: 0.277
 POA TO CENTROID: 0.288
 HORZ SPREAD: 1.352
 VERT SPREAD: 1.932
 GROUP SPREAD: 2.333
 MIN RADIUS: 0.238
 MAX RADIUS: 1.508
 MEAN RADIUS: 0.645
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 9

POINT#	X	Y
1:	0.535	0.357
2:	0.226	0.432
3:	-0.007	0.051
4:	-0.144	0.016
5:	0.500	-0.333
6:	-0.640	-0.326
7:	-0.527	-0.075
8:	-0.497	0.730
9:	-0.807	1.599
10:	0.545	0.315

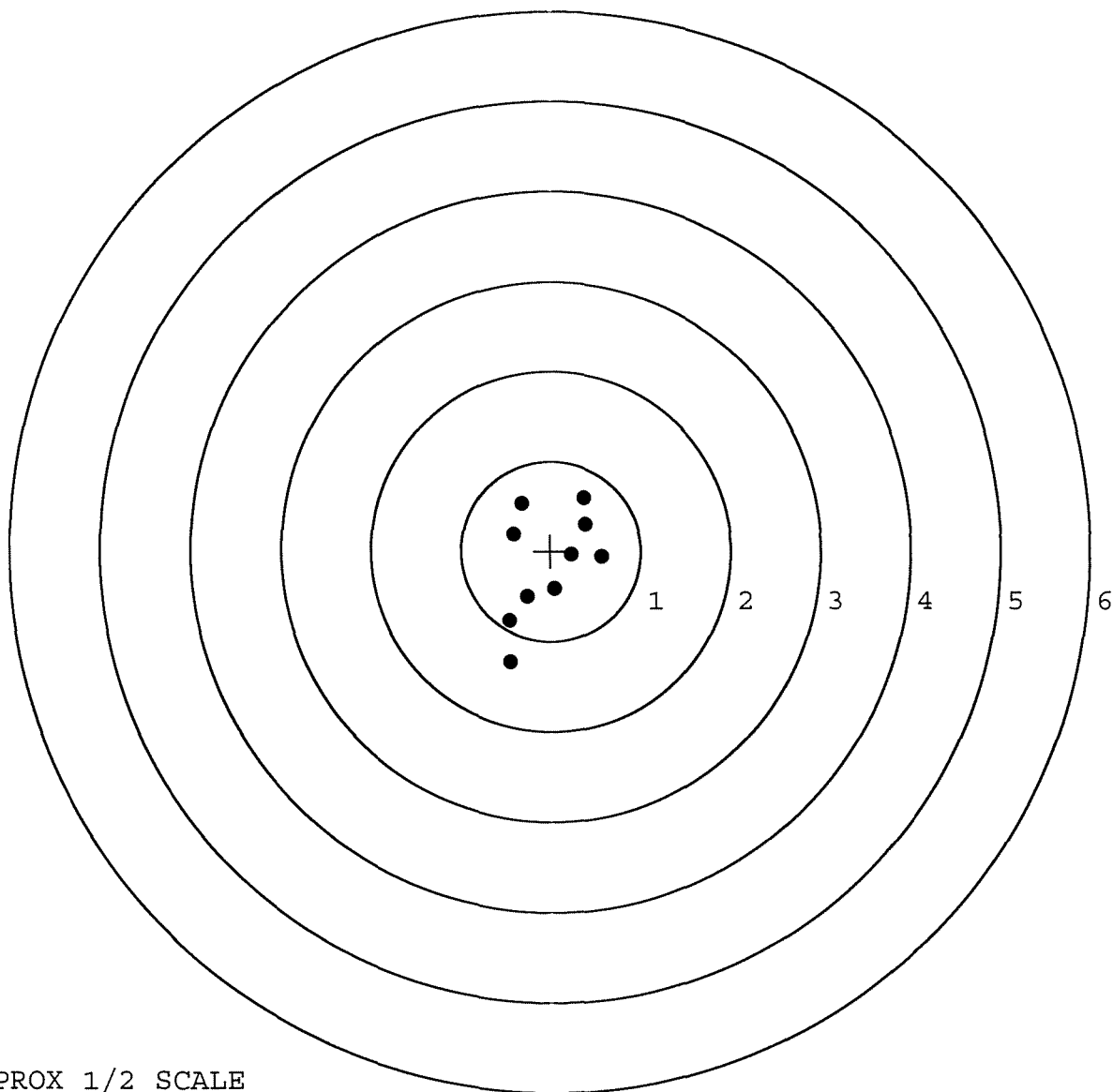


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6845854. 0
 TARGET NUMBER: 2
 FILE DATE: 05/07/2009
 FILE TIME: 05:42

X CENTROID: -0.030
 Y CENTROID: -0.143
 POA TO CENTROID: 0.147
 HORZ SPREAD: 1.032
 VERT SPREAD: 1.837
 GROUP SPREAD: 2.013
 MIN RADIUS: 0.279
 MAX RADIUS: 1.174
 MEAN RADIUS: 0.624
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	-0.452	-1.239
2:	-0.460	-0.779
3:	-0.261	-0.510
4:	0.044	-0.422
5:	0.572	-0.063
6:	0.230	-0.043
7:	0.386	0.306
8:	0.371	0.598
9:	-0.322	0.531
10:	-0.408	0.187

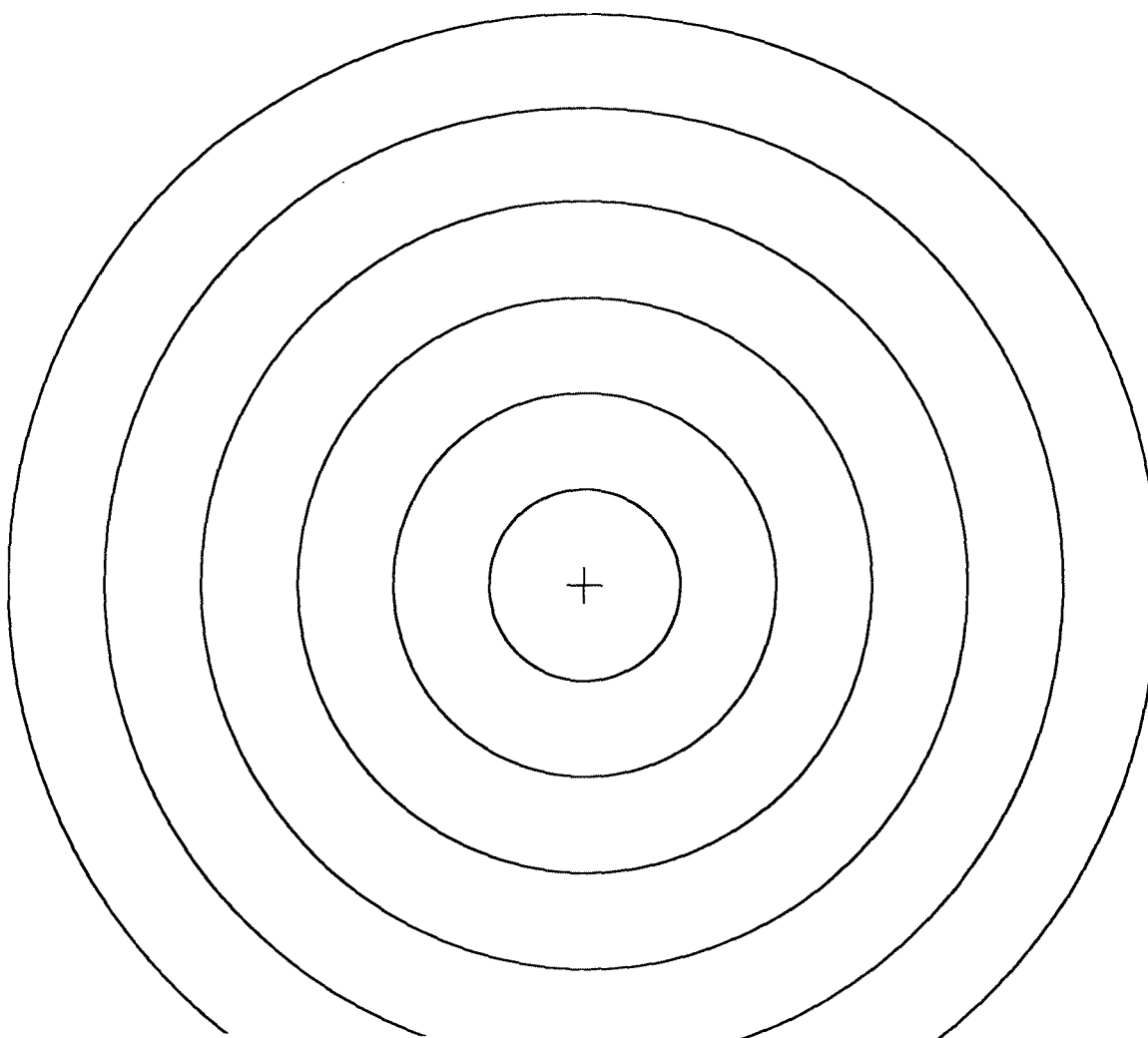


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6845854. 0
 TARGET NUMBER: 3
 FILE DATE: 05/07/2009
 FILE TIME: 05:42

POINT#	X	Y
1:	0.647	0.671
2:	0.522	0.414
3:	0.484	0.050
4:	0.319	0.130
5:	0.095	0.215
6:	-0.234	0.267
7:	-0.401	-0.260
8:	-0.343	-0.362
9:	-0.126	-0.989
10:	-1.018	-1.002

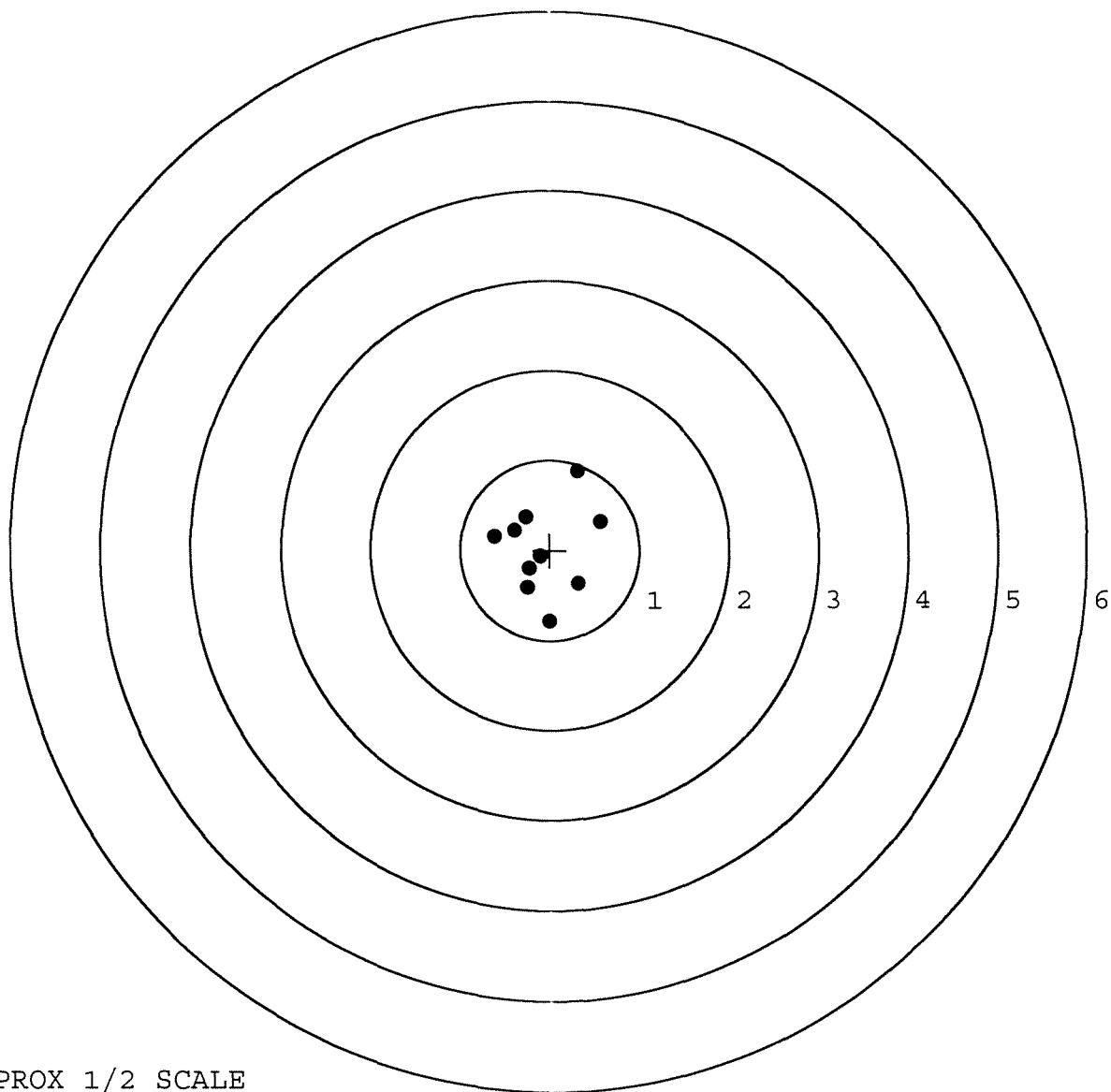
X CENTROID: -0.006
 Y CENTROID: -0.087
 POA TO CENTROID: 0.087
 HORZ SPREAD: 1.665
 VERT SPREAD: 1.673
 GROUP SPREAD: 2.360
 MIN RADIUS: 0.318
 MAX RADIUS: 1.365
 MEAN RADIUS: 0.651
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



SERIAL NUMBER: G6845854. 0
 TARGET NUMBER: 4
 FILE DATE: 05/07/2009
 FILE TIME: 05:42

X CENTROID: -0.069
 Y CENTROID: 0.006
 POA TO CENTROID: 0.070
 HORZ SPREAD: 1.174
 VERT SPREAD: 1.666
 GROUP SPREAD: 1.697
 MIN RADIUS: 0.089
 MAX RADIUS: 0.950
 MEAN RADIUS: 0.516
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 10
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.312	0.876
2:	0.560	0.314
3:	-0.272	0.363
4:	-0.614	0.149
5:	-0.112	-0.072
6:	-0.233	-0.201
7:	-0.250	-0.417
8:	0.316	-0.373
9:	-0.013	-0.790
10:	-0.387	0.214

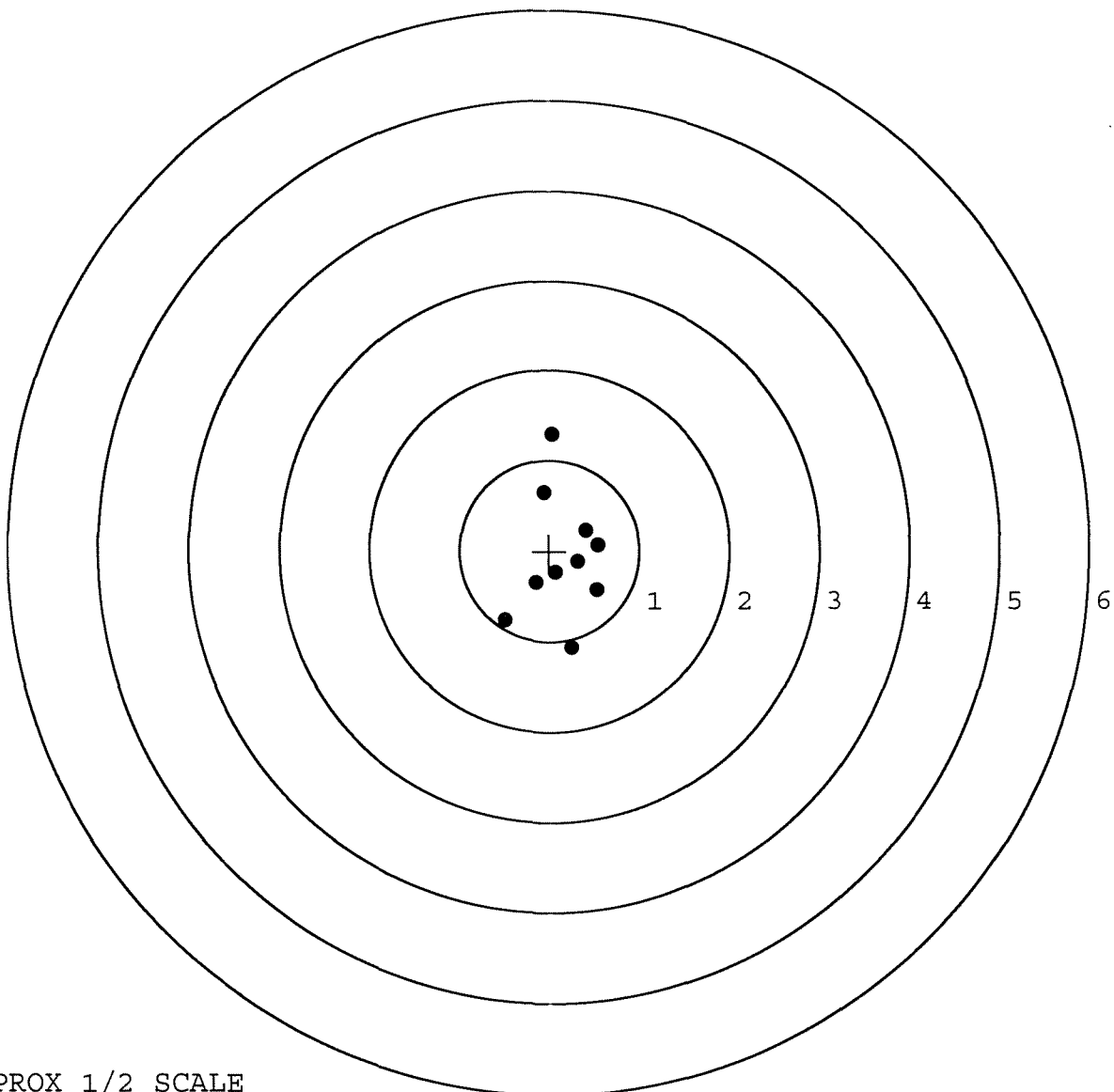


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: G6845854. 0
 TARGET NUMBER: 5
 FILE DATE: 05/07/2009
 FILE TIME: 05:42

X CENTROID: 0.143
 Y CENTROID: -0.075
 POA TO CENTROID: 0.162
 HORZ SPREAD: 1.041
 VERT SPREAD: 2.353
 GROUP SPREAD: 2.362
 MIN RADIUS: 0.175
 MAX RADIUS: 1.361
 MEAN RADIUS: 0.616
 # IN 1 IN DIAMETER: 5
 # IN 2 IN DIAMETER: 8
 # in 3 IN DIAMETER: 10

POINT#	X	Y
1:	0.036	1.281
2:	-0.065	0.646
3:	0.404	0.227
4:	0.545	0.067
5:	0.527	-0.430
6:	0.314	-0.115
7:	0.070	-0.239
8:	-0.147	-0.350
9:	-0.496	-0.770
10:	0.246	-1.072



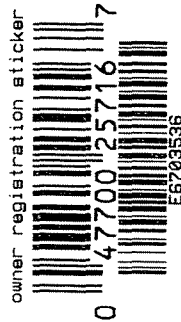
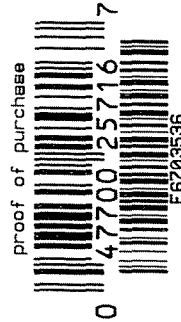
TARGET APPROX 1/2 SCALE

MODEL 700™ M24
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATO

DOCUMENT ENVELOPE ASSEMBLY:

- INSTRUCTION BOOK
- PRODUCT OWNER'S CARD
- SAFETY BOOKLET

46 FORM 1444

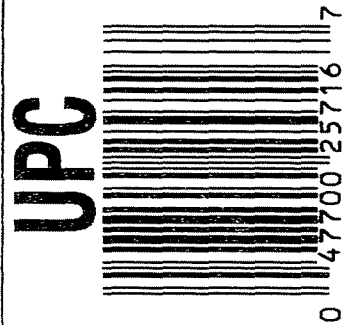


ORDER NO. **25716**

BARREL LENGTH **24"**

CAPACITY **6**

E6703536



Remington.[®]VERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700TH M24**
BOLT ACTION CENTERFIRE RIFLE
24" BARREL 7.62 NATOSERIAL NO. **J**
E6703536ORDER NO.
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SERIAL NO.



E6703536

CONTRACT # DAAE20-01-C-0007

GUN SERIAL # E 670 3536

OP #	OPERATION NAME	READINGS	DATE	INITIAL
575 & 580	ASSEMBLE ACTION AND STOCK		3/21/01	REP
600	PROOF			
607	CHECK HEADSPACE			
610	DIS-ASSEMBLE GUN			
612	MAGNAFLUX BBL ACTION MAGNAFLUX BOLT			
615	ROLLMARK CALIBER			
617	DRILL AND TAP SIGHT HOLES		3/21/01	DA
618	POLISH BARREL			
620	APPLY COATINGS (BARREL ACTION)			
	(BOLT)			
625	FINAL ASSEMBLY A) CLEAN INSIDE OF BOLT ASSEMBLY		4/4/01	DA
	B) INSPECT REAR FIRING PIN HOLE FOR CHAMFER IN BOLT HEAD			
	C) INSPECT EJECTOR HOLE FOR CHAMFER			
	D) OIL FIRING PIN ASSEMBLY		4/5/01	CK
	E) ADJUST TRIGGER PULL TO MIN. SETTING AND STAKE		11	2

OP #	OPERATION NAME	READINGS			DATE	INITIAL
625	F) SAFETY ON FORCE	<u>6.0</u>	<u>6.0</u>	<u>6.0</u>	4/4/01	DA
CONT.					"	"
	G) SAFETY OFF FORCE	<u>3.5</u>	<u>3.5</u>	<u>3.0</u>		
	H) TRIGGER PULL TEST AND RETAINABILITY					
	I) FIRING PIN INDENT	<u>.021</u>	<u>.022</u>	<u>.022</u>	4/4/01	DA
	J) ASSEMBLE STOCK					
	K) ASSEMBLE SWIVEL STUDS					
	L) ATTACH FRONT AND REAR SIGHT ASSY'S					
	M) IRON SIGHT ALIGNMENT					
	N) DETACH FRONT AND REAR SIGHTS AND PLACE IN NUMBERED CONTAINER					
640	GALLERY TEST AND TARGET			^{HC} 3/29	3-21-01	RW
	A) MALFUNCTIONS			^{HC} 3/29	3-21-01	RW
	B) PIERCED PRIMERS			^{HC} 3/29	3-21-01	RW
645	INSPECT FOR LIVE AMMO			^C 3/29	3-21-01	RW
655	FINAL INSPECTION A) HEADSPACE				4/3/01	RW
	B) TRIGGER PULL	<u>2.65</u>	<u>2.57</u>	<u>2.50</u> <u>2.50</u> <u>2.48</u>	4/4/01	DA
	C) FUNCTION					
660	PACK				4/4/01	DA

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703536
30 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .121
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0984
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .15596

THE AMR FOR THIS RIFLE IS: 1.094

CENTROIDAL DISTANCES

Ø TO	1	.0949368
1 TO	2	.317404
1 TO	3	.31258
1 TO	4	.391369
1 TO	5	.188693

+¹₅ ₃ <----POA
4

REMINGTON CENTERFIRE ACCURACY TEST

REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .095

MIN RADIUS : .482

MEAN RADIUS : 1.272

MAX RADIUS : 2.292

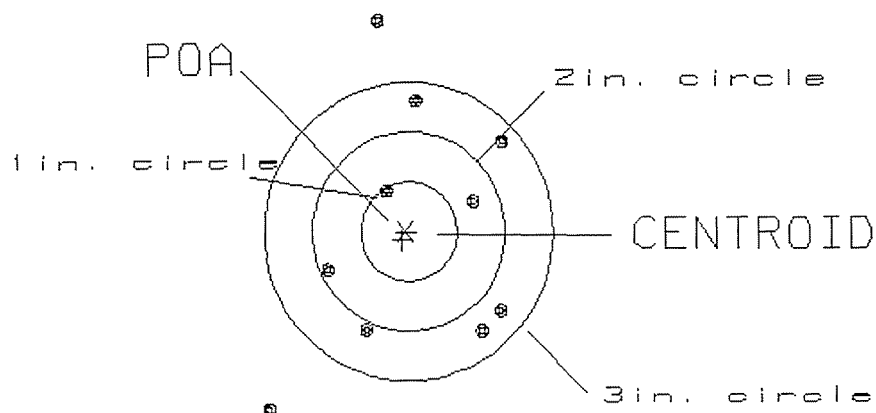
CENTROID X : .038

CENTROID Y : .087

30 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536.1.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.46

1

VS= 3.82

3

GS= 3.98

8

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .236

MIN RADIUS : .354

MEAN RADIUS : 1.292

MAX RADIUS : 2.428

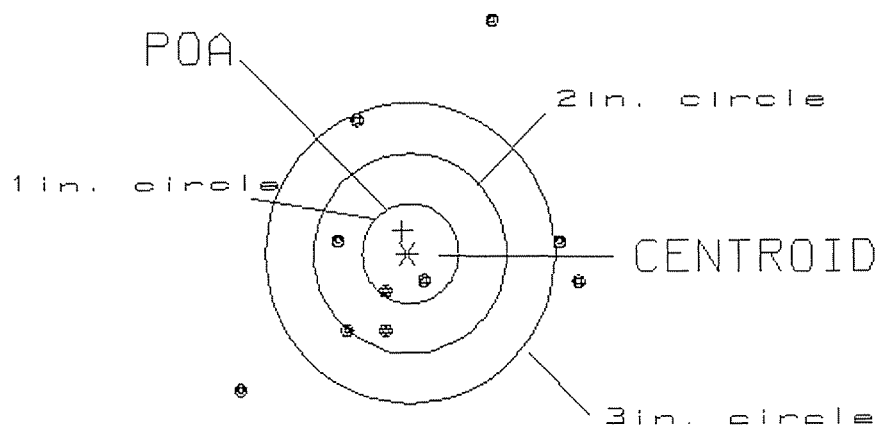
CENTROID X : .054

CENTROID Y : -.230

30 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536.1.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 3.58

2

VS= 3.60

4

GS= 4.46

6

PATTERN #: 3

POA TO CENTROID: .310

MIN RADIUS : .193

MEAN RADIUS : 1.006

MAX RADIUS : 1.816

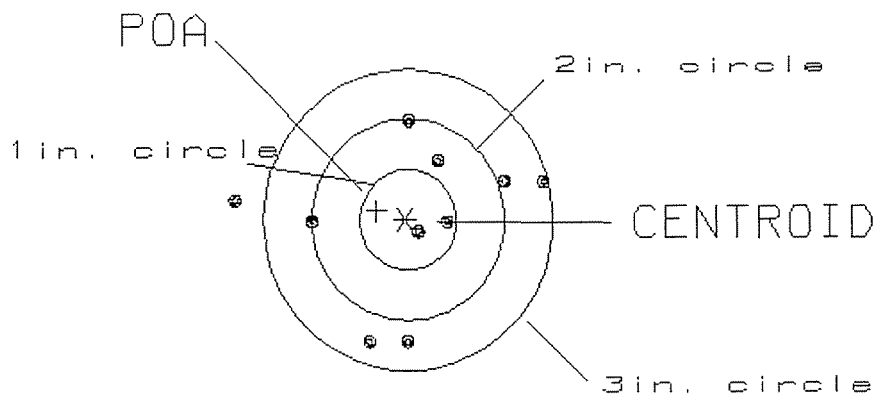
CENTROID X : .297

CENTROID Y : -.088

30 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536.1.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.23

2

VS= 2.18

4

GS= 3.23

9

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .302

MIN RADIUS : .336

MEAN RADIUS : .921

MAX RADIUS : 1.862

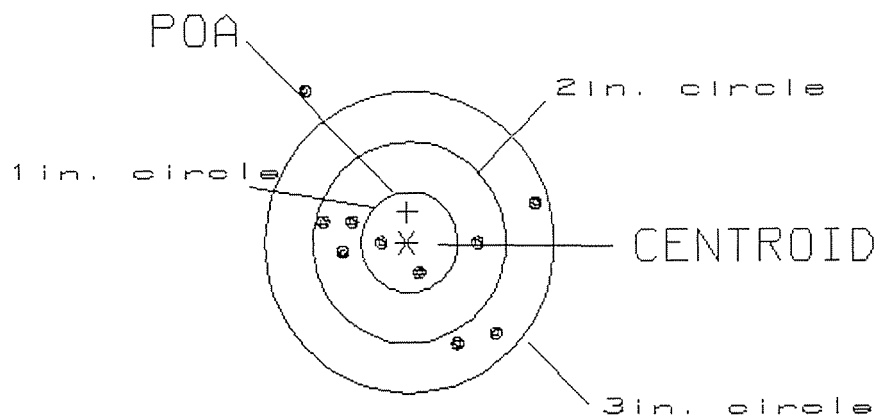
CENTROID X : -.005

CENTROID Y : -.302

30 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536.1.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.41

2

VS= 2.48

6

GS= 3.11

9

REMINGTON CENTERFIRE ACCURACY TEST

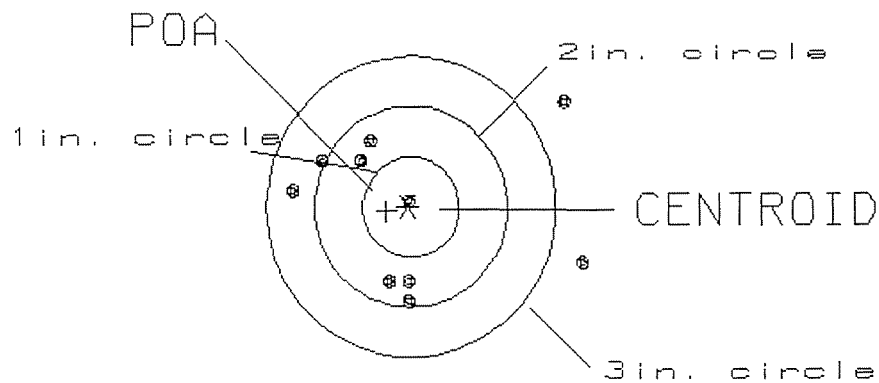
REMINGTON TEST LAB, ILION, N.Y.

PATTERN #: 5
 POA TO CENTROID: .224
 MIN RADIUS : .049
 MEAN RADIUS : .980
 MAX RADIUS : 1.844
 CENTROID X : .221
 CENTROID Y : .041

30 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536.1.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.93

1

VS= 1.93

6

GS= 3.01

8

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703536
24 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1852
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0142
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .185744

THE AMR FOR THIS RIFLE IS: 1.298

CENTROIDAL DISTANCES

0	TO	1	.290451
1	TO	2	.123491
1	TO	3	.263078
1	TO	4	.155052
1	TO	5	.236212

$\begin{matrix} 5 \\ +4 \\ 3 \end{matrix} \frac{1}{2} <----POA$

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .290

MIN RADIUS : .817

MEAN RADIUS : 1.603

MAX RADIUS : 3.159

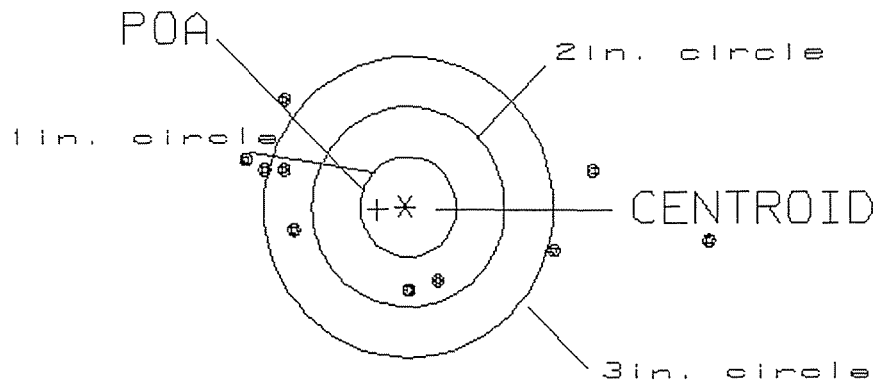
CENTROID X : .289

CENTROID Y : .029

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.81

0

VS= 1.99

2

GS= 4.88

5

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .344

MIN RADIUS : .839

MEAN RADIUS : 1.599

MAX RADIUS : 2.989

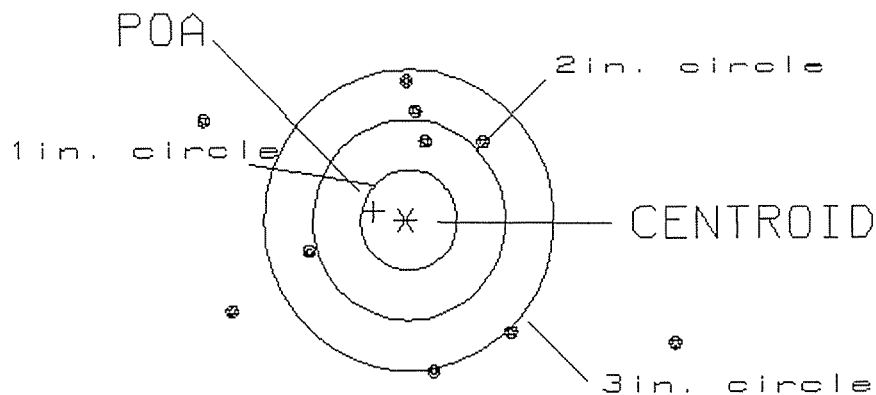
CENTROID X : .334

CENTROID Y : -.086

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 4.83

0

VS= 2.96

1

GS= 5.29

6

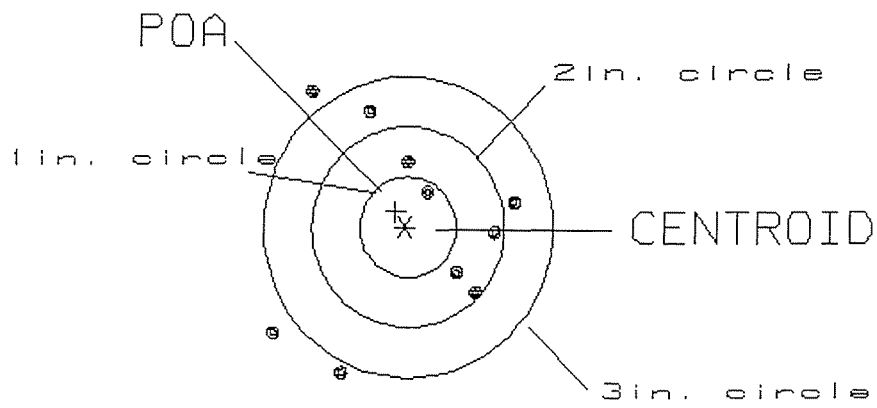
PATTERN #: ☐ 3 ☐

FOA TO CENTROID: .184
 MIN RADIUS : .396
 MEAN RADIUS : 1.100
 MAX RADIUS : 1.735
 CENTROID X : .100
 CENTROID Y : -.154

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.45

1

VS= 2.64

4

GS= 2.86

7

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .136

MIN RADIUS : .705

MEAN RADIUS : 1.090

MAX RADIUS : 1.567

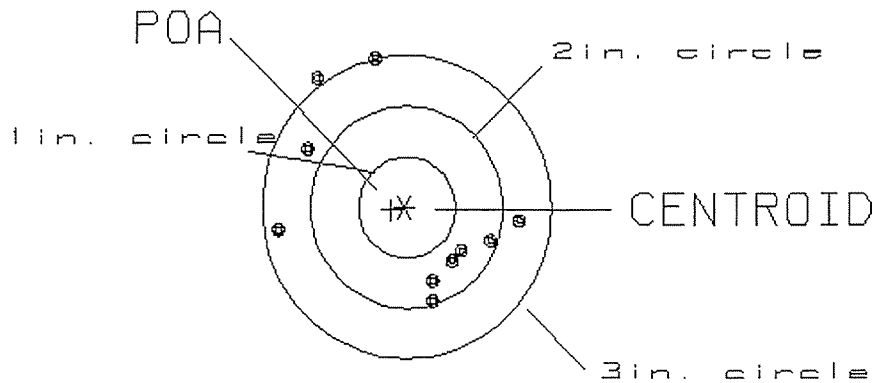
CENTROID X : .134

CENTROID Y : .025

24 Mar 2001

FILE:/Hqbasic/Accuracy/Patterning/Centerfire_Patt/e6703536.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.49

0

VS= 2.47

5

GS= 2.55

8

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .134

MIN RADIUS : .266

MEAN RADIUS : 1.096

MAX RADIUS : 2.192

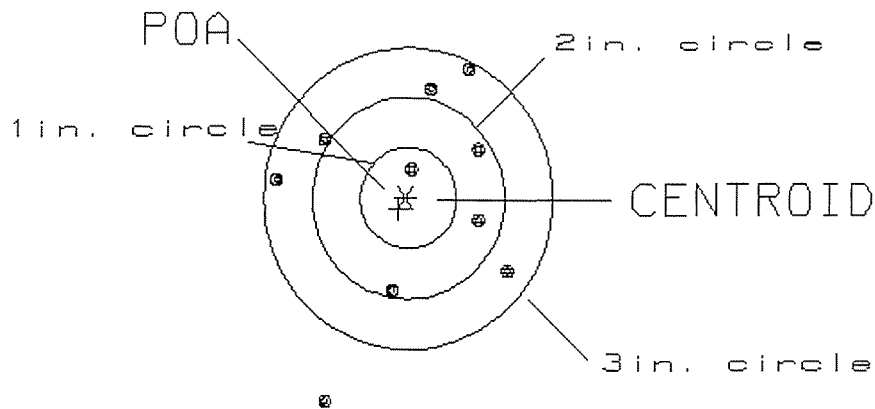
CENTROID X : .069

CENTROID Y : .115

24 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536.1

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 2.33

1

VS= 3.25

5

GS= 3.57

9

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # e6703536
22 Mar 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .109
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2726
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .293584
THE AMR FOR THIS RIFLE IS: 1.347

CENTROIDAL DISTANCES

0	TO	1	.390386
1	TO	2	.420202
1	TO	3	.728093
1	TO	4	.687949
1	TO	5	.604802

3
4
5 2
+ 1 <----POA

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .390

MIN RADIUS : .291

MEAN RADIUS : 1.591

MAX RADIUS : 3.732

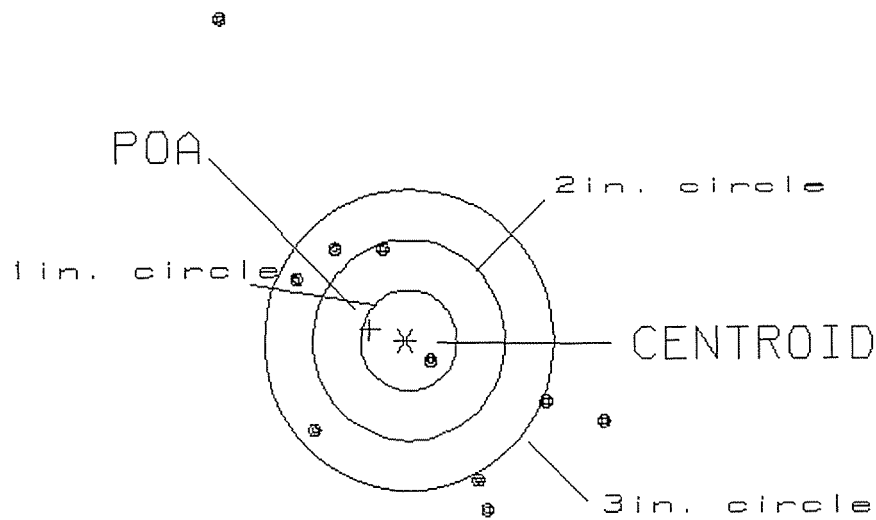
CENTROID X : .376

CENTROID Y : -.105

22 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 3.94

1

VS= 4.88

2

GS= 5.62

5

PATTERN #: ☐ 2 ☐

POA TO CENTROID: .263

MIN RADIUS : .564

MEAN RADIUS : 1.368

MAX RADIUS : 1.959

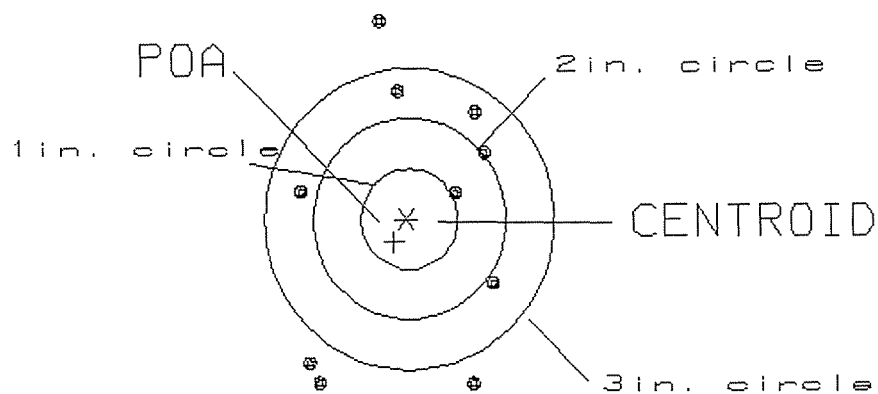
CENTROID X : .125

CENTROID Y : .232

22 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 1.93

0

VS= 3.60

1

GS= 3.69

6

PATTERN #: ☐ 3 ☐

POA TO CENTROID: .678

MIN RADIUS : .413

MEAN RADIUS : 1.017

MAX RADIUS : 1.954

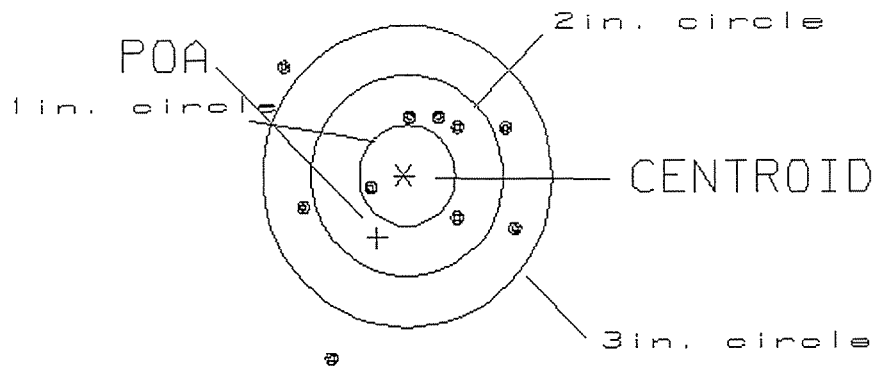
CENTROID X : .282

CENTROID Y : .617

22 Mar 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 2.44

1

VS= 2.85

5

GS= 2.90

8

PATTERN #: ☐ 4 ☐

POA TO CENTROID: .383

MIN RADIUS : .749

MEAN RADIUS : 1.419

MAX RADIUS : 3.077

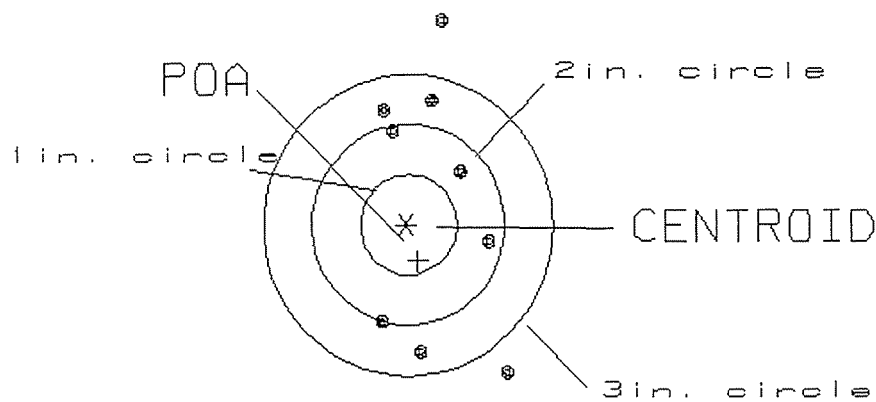
CENTROID X : -.131

CENTROID Y : .360

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FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.50

0

VS= 3.87

3

GS= 4.75

7

PATTERN #: ☐ 5 ☐

POA TO CENTROID: .280

MIN RADIUS : .177

MEAN RADIUS : 1.338

MAX RADIUS : 2.676

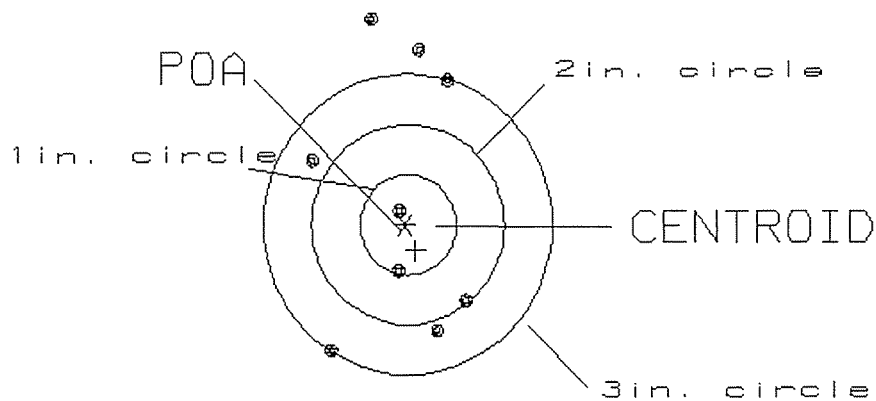
CENTROID X : -.107

CENTROID Y : .259

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FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/e6703536

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 1.95

1

VS= 4.54

3

GS= 4.74

7

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. E6703536DATE 2-15-01TESTER DA

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.62	2.61		2.46	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.63	2.64		2.54	
PULL #3	2.58	2.72		2.40	
PULL #4	2.70	2.57		2.45	
PULL #5	2.66	2.80		2.43	
TOTAL	1319	1334		1228	
AVG.	2.63	2.66		2.45	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.11	3.07		
PULL #2	3.21	3.00		
PULL #3	3.13	2.95		
PULL #4	3.17	3.01		
PULL #5	3.00	3.07		
TOTAL	1562	1510		
AVG.	3.12	3.02		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.07	4.02		4.10
PULL #2	4.08	4.00		4.10
PULL #3	4.06	4.17		4.07
PULL #4	4.02	3.95		3.98
PULL #5	4.10	4.05		4.11
TOTAL	2033	2019		2036
AVG.	4.06	4.03		4.07