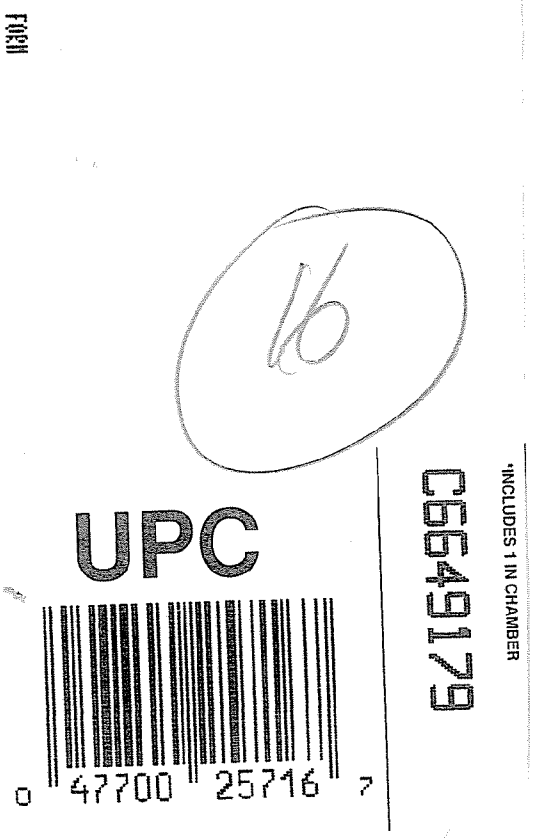
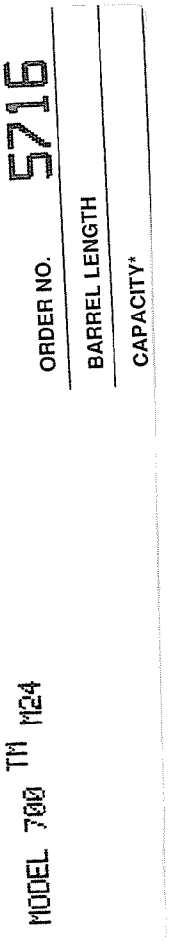

Front
UPC
0 47700 25716 7
C6649179
*INCLUDES 1 IN CHAMBER


ORDER NO. 5716
BARREL LENGTH
CAPACITY*
MODEL 700 TH M24

Remington

DU PONT REG. U.S. PAT. & TM. OFF

VERY IMPORTANT: Instruction Book enclosed to assure safe use of this firearm.

MODEL 700 TM M24

SERIAL NO. C6649179

20

ORDER NO. 5716

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

5716 C6649179

ORDER 5716
MODEL 700 TM M24
UPC

0 47700 25716 7

ORDER 5716
MODEL 700 TM M24
UPC

0 47700 25716 7

M-24

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649179

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	RW
600	Proof	10 1	91	RW
607	Check Headspace	10 1	91	RW
610	Dis-assemble Gun	10 1	91	RW
612	Magnaflux Barrel Action	OCT	1 0 1991	KR
	Magnaflux Bolt	OCT	1 0 1991	KR
615	Rollmark Caliber	OCT	1 0 1991	GS
617	Drill and Tap Sight Holes	OCT	1 0 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11-7-91	LB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		11/11/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		11/11/91	RW
	C) Inspect Ejector Hole for Chamfer		11/11/91	RW
	D) Oil Firing Pin Ass'y		11/11/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/26/91	WB

op. #	NAME BARBER M24 0065744	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 1/2	3 3/4	3 3/4			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	.0205	.0202	.0205			12/26/91	WB
	J) Assemble Stock						12/31/91	RW
	K) Assemble Swivel Studs						1/3/92	JH
	L) Attach Front and Rear Sight Assemblies						12/31/91	RW
	M) Iron Sight Alignment						12/31/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/31/91	RW
	O) Attach Scope to Rifle						12/31/91	RW
	P) Detach & Attach Scope 20 Times						12/31/91	RW
640	Gallery Target & Test						1-2-92	AC
	A) Time						1-2-92	AC
	B) Malfunctions						1-2-92	AC
	C) Pierced Primers						1-2-92	AC
	D) Optical Clearity of Scope						1-2-92	AC
645	Inspect for Live Ammo						1-2-92	AC
655	Final Inspection A) Headspace						1-3-92	JH
	B) Trigger Pull	2.73	2.75	2.72	2.79	2.63	1-2-92	AC
	C) Function						1-3-92	JH
660	Pack						2-25-92	VE

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649179
DATE 12/26/91
TESTER WS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.55	2.43	2.49	2.73	MIN. SETTING,
PULL #2	2.49	2.41	2.44	2.75	NO AVG. OF 5
PULL #3	2.44	2.27	2.46	2.72	READINGS ACCEPT-
PULL #4	2.50	2.33	2.25	2.79	ABLE LESS THAN 2#
PULL #5	2.47	2.34	2.46	2.63	
TOTAL	12.45	11.78	12.10	13.62	
AVG.	2.49	2.35	2.42	2.72	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.17	3.20		
PULL #2	3.20	3.16		
PULL #3	3.18	3.14		
PULL #4	3.20	3.17		
PULL #5	3.19	3.16		
TOTAL	15.94	15.83		
AVG.	3.19	3.17		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.06	4.06		4.06
PULL #2	4.12	4.10		4.16
PULL #3	4.11	4.14		4.15
PULL #4	4.12	4.06		4.12
PULL #5	4.13	4.12		4.10
TOTAL	20.54	20.48		20.59
AVG.	4.11	4.10		4.12

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649179
2 Jan 1992

CENTROIDAL DISTANCES

0	TO	1	.681502
1	TO	2	.464226
1	TO	3	.411579
1	TO	4	.656849
1	TO	5	.408208

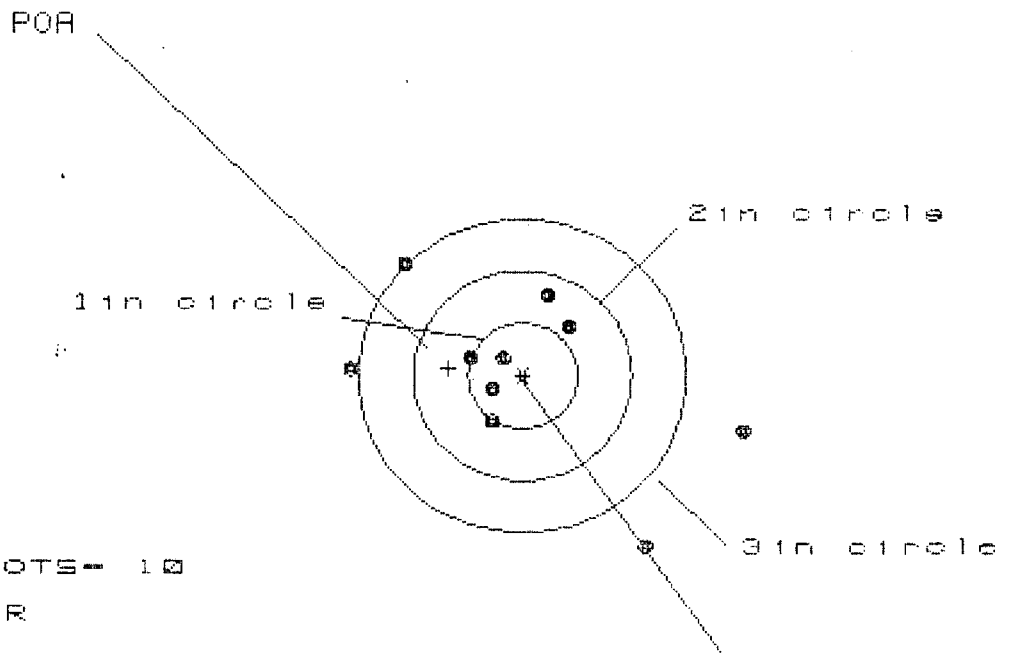
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3154
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1274
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .340159

THE AMR FOR THIS RIFLE IS: 1.165

2 Jan 1932 FILE:/PATTERNING/CENTERFIRE_PATT/C6649179

CENTERFIRE PATTERNS # 1

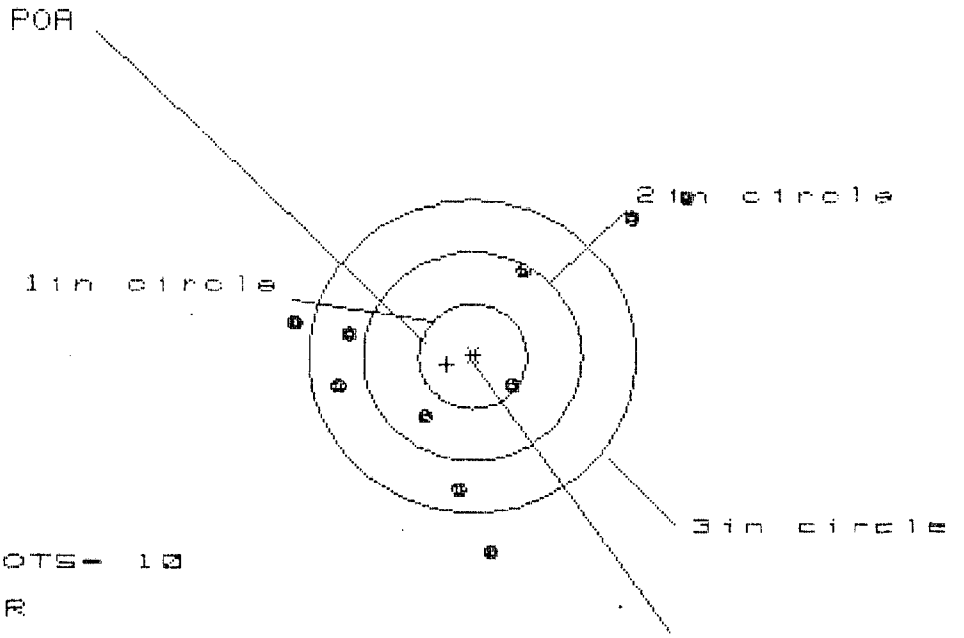


# OF SHOTS= 10
# IN CIR
1in = 3
2in = 6
3in = 6
HS= 3.528
VS= 2.741
GS= 3.581

PATTERN # :	1		
SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.986	1.306	.837
MINIMUM X :	-1.542	-1.322	-1.159
MAXIMUM Y :	1.107	1.047	.835
MINIMUM Y :	-1.634	-1.694	-.677
CENTROID X :	.678	.458	.294
CENTROID Y :	-.069	-.009	.203
POA TO CENTROID in.:	.682	.458	.358
MIN RADIUS :	.223	.114	.168
MEAN RADIUS :	1.000	.826	.674
MAX RADIUS :	2.059	2.139	1.177
HORIZONTAL SPREAD :	3.528	2.628	1.995
VERTICAL SPREAD :	2.741	2.741	1.512
EXTREME SPREAD :	3.581	3.493	2.037
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		6	

2 Jan 1992 FILE:/PATTERNING/CENTERFIRE_PATT/C6B49179

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

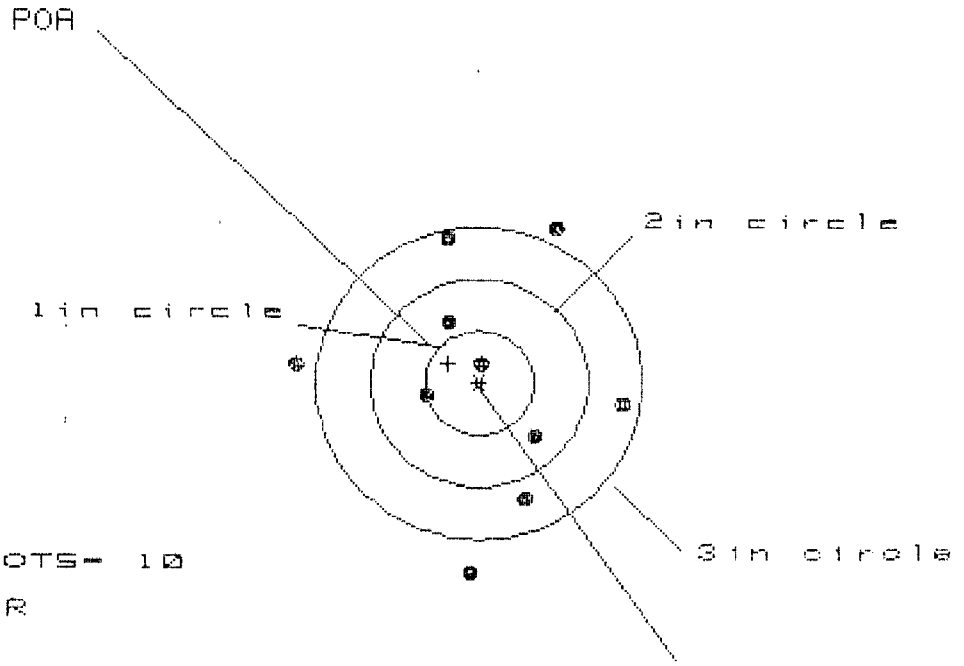
IN CIR
1 in = 1
2 in = 3
3 in = 6

HS= 3.601
VS= 3.345
GS= 3.792

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.970	1.718	.939
MINIMUM X	:	-1.631	-1.413	-1.198
MAXIMUM Y	:	1.500	1.527	1.209
MINIMUM Y	:	-1.845	-1.678	-1.487
CENTROID X	:	.237	.018	-.197
CENTROID Y	:	.076	-.091	-.282
POA TO CENTROID in.	:	.248	.092	.344
MIN RADIUS	:	.417	.478	.259
MEAN RADIUS	:	1.390	1.221	1.039
MAX RADIUS	:	2.476	2.299	1.610
HORIZONTAL SPREAD	:	3.601	3.131	2.137
VERTICAL SPREAD	:	3.345	3.205	2.696
EXTREME SPREAD	:	3.792	3.465	2.837
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

2 Jan 1992 FILE:/PATTERNING/CENTERFIRE_PATT/C6649179

CENTERFIRE PATTERNS # 3

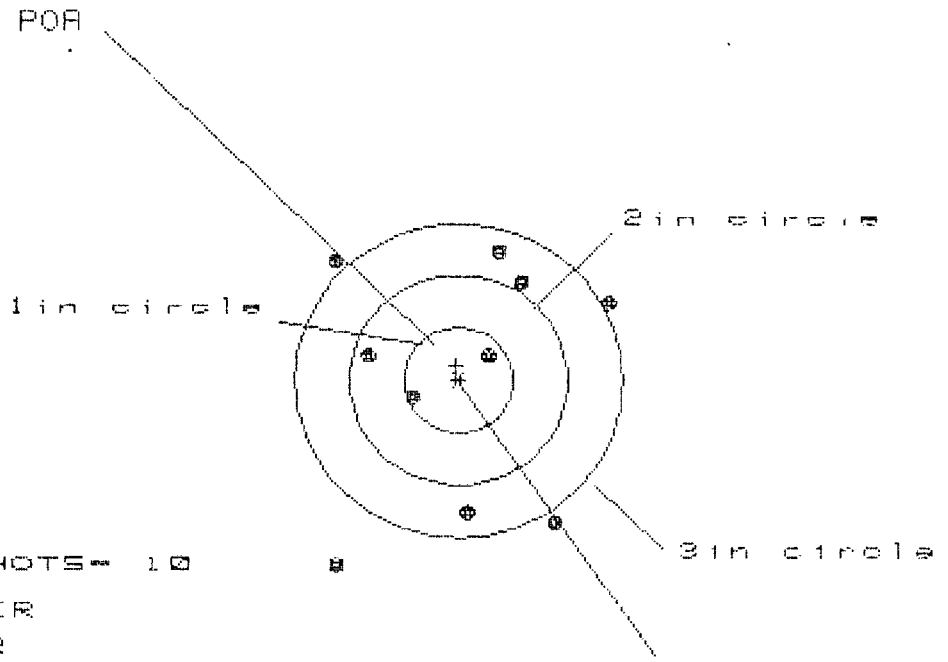


# OF SHOTS= 10
# IN CIR
1in = 2
2in = 4
3in = 7
HS= 3.027
VS= 3.251
GS= 3.369

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.307	1.293	1.076
MINIMUM X	:	-1.720	-1.734	-.700
MAXIMUM Y	:	1.486	1.290	1.287
MINIMUM Y	:	-1.765	-1.306	-1.309
CENTROID X	:	.284	.298	.515
CENTROID Y	:	-.188	.008	.011
POA TO CENTROID in.	:	.341	.298	.515
MIN RADIUS	:	.164	.058	.265
MEAN RADIUS	:	1.112	1.019	.956
MAX RADIUS	:	1.769	1.734	1.390
HORIZONTAL SPREAD	:	3.027	3.027	1.776
VERTICAL SPREAD	:	3.251	2.596	2.596
EXTREME SPREAD	:	3.369	3.055	2.622
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

2 Jan 1992 . FILE:/PATTERNING/CENTERFIRE_PATT/C6849179

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

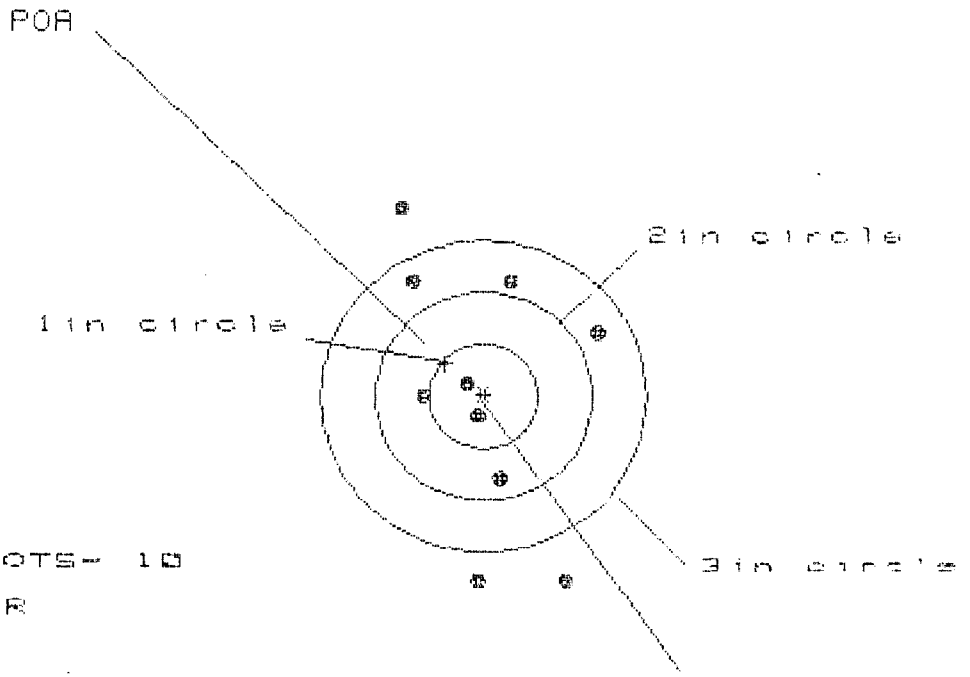
# IN CIR
1in = 2
2in = 3
3in = 6

HS= 2.562
VS= 2.983
GS= 3.545

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.413	1.291	1.386
MINIMUM X	:	-1.150	-1.271	-1.176
MAXIMUM Y	:	1.239	1.046	.850
MINIMUM Y	:	-1.744	-1.566	-1.622
CENTROID X	:	.025	.147	.052
CENTROID Y	:	-.140	.053	.249
POA TO CENTROID in.	:	.143	.157	.255
MIN RADIUS	:	.365	.174	.319
MEAN RADIUS	:	1.220	1.095	.999
MAX RADIUS	:	2.059	1.741	1.622
HORIZONTAL SPREAD	:	2.562	2.562	2.562
VERTICAL SPREAD	:	2.983	2.612	2.472
EXTREME SPREAD	:	3.545	3.208	2.634
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

2 Jan 1992 FILE:/PATTERNING/CENTERFIRE_PATT/C8849179

CENTERFIRE PATTERNS # 5



# OF SHOTS= 10
# IN CIR
1in = 2
2in = 4
3in = 7
HS= 1.785
VS= 3.581
GS= 3.903

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.011	1.098	1.012
MINIMUM X	:	-.774	-.687	-.666
MAXIMUM Y	:	1.773	1.572	1.096
MINIMUM Y	:	-1.808	-2.009	-1.813
CENTROID X	:	.253	.266	.352
CENTROID Y	:	-.316	-.115	-.311
POA TO CENTROID in.	:	.473	.290	.470
MIN RADIUS	:	.192	.131	.189
MEAN RADIUS	:	1.104	.996	.891
MAX RADIUS	:	1.969	2.010	1.813
HORIZONTAL SPREAD	:	1.785	1.785	1.618
VERTICAL SPREAD	:	3.581	3.581	2.909
EXTREME SPREAD	:	3.903	3.659	2.967
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

CAR TEST LOT RAC90J001-010

M-24

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6522356

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		8-21-90	DB
600	Proof		8-21-90	DB
607	Check Headspace		8-21-90	DB
610	Dis-assemble Gun		8-21-90	DB
612	Magnaflux Barrel Action	NEW BARREL 8/22/90	8/23/90	KCR
	Magnaflux Bolt		8/23/90	KCR
615	Rollmark Caliber		8/23/90	CJ
617	Drill and Tap Sight Holes		8/24/90	
618	Polish Barrel		8/24/90	
620	Apply Coatings (Barrel Action)		8/30/90	TJ
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		8/31/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/31/90	RW
	C) Inspect Ejector Hole for Chamfer		8/31/90	RW
	D) Oil Firing Pin Ass'y		8/31/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		9-1-90	RW

op. #	OP. NAME	READINGS			DATE	INIT
635 cont.	F) Safety On Force	6	6½	6	9/1/90	RW
	G) Safety Off Force	3½	4	4	9/1/90	RW
	H) Trigger Pull Test & Retainability				9-1-90	JH
	I) Firing Pin Indent	.0225	.023	.0225	9/1/90	RW
	J) Assemble Stock				9/1/90	RW
	K) Assemble Swivel Studs					
	L) Attach Front and Rear Sight Assemblies				9/1/90	RW
	M) Iron Sight Alignment				9/1/90	RW
	N) Detach Front & Rear Sights & place in numbered container				9/1/90	RW
	O) Attach Scope to Rifle				9/1/90	RW
	P) Detach & Attach Scope 20 Times				9/1/90	RW
640	Gallery Target & Test				9-1-90	DH
	A) Time				9-1-90	DH
	B) Malfunctions				9-1-90	DH
	C) Pierced Primers				9-1-90	DH
	D) Optical Clearity of Scope				9-1-90	DH
645	Inspect for Live Ammo				9-1-90	DH
655	Final Inspection A) Headspace					
	B) Trigger Pull					
	C) Function					
660	Pack					

SWS TRIGGER PULL TEST

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

SERIAL NO. C65 22356

DATE 9-1-90

TESTER JH.

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.54	2.46	2.44		MIN. SETTING,
PULL #2	2.44	2.33	2.48		NO AVG. OF 5
PULL #3	2.31	2.50	2.47		READINGS ACCEPT-
PULL #4	2.47	2.50	2.43		ABLE LESS THAN 2#
PULL #5	2.46	2.44	2.48		
TOTAL	12.12	12.23	12.30		
AVG.	2.424	2.446	2.46		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.20	3.52		
PULL #2	3.36	3.49		
PULL #3	3.42	3.49		
PULL #4	3.46	3.50		
PULL #5	3.46	3.46		
TOTAL	16.90	17.45		
AVG.	3.38	3.488		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.20	4.22		4.13
PULL #2	4.24	4.24		4.30
PULL #3	4.21	4.19		4.45
PULL #4	4.21	4.29		4.43
PULL #5	4.21	4.29		4.24
TOTAL	21.07	21.23		21.55
AVG.	4.214	4.246		4.31

SWS ENDURANCE TEST REPORT

SERIAL NO. CB522356 SHOOTER TF DATE 9-4-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK TF	NONE
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	20	" TF	"
		320		

320

SWS ENDURANCE TEST REPORT

SERIAL NO. C6522356 SHOOTER TF DATE 9-4-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK TF	NONE
	"	60	" TF	"
		120	Total	
		320	From page 1	
		440	Total	
		60	TARGET AC	9-5-90
		500		

500

SWS ENDURANCE TEST REPORT

SERIAL NO. C6522356 SHOOTER TF DATE 9-4-80

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK TF	NONE
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
		360	Total	

~~860~~
1460
360
1820

SWS ENDURANCE TEST REPORT

SERIAL NO. CC522356 SHOOTER TF DATE 9-5-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK TF	NONE
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
		600	Total	

SWS ENDURANCE TEST REPORT

SERIAL NO. C652356 SHOOTER EA DATE 9-5-80

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	NONE
		60	OK	NONE
		60	ok	NONE
		60	ok	none
		60	ok	none
		60	ok	none
		360		

~~1820~~ Total
2760 Total

SWS ENDURANCE TEST REPORT

SERIAL NO. CL522356 SHOOTER TF DATE 9-6-80

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK TF	NONE
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	20	" TF	"
		440	Total	Magnaflux

~~2100~~ 2800 Total

SWS ENDURANCE TEST REPORT

SERIAL NO. C652235 SHOOTER TF DATE 9-8-80

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK TF	NONE
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
		540 Total		

~~2800~~ 3400 Total

Sheet 8 of 18

SWS ENDURANCE TEST REPORT

9-10-90

SERIAL NO. CL522356 SHOOTER TF DATE ~~9-10~~ 20

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK TF	NONE
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
		600 Total		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6522356 SHOOTER EA DATE 9-10-20

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK EA	NONE
		60	OK EA	NONE
		60	OK EA	NONE
		60	OK EA	NONE
		60	OK EA	NONE
		60	OK EA	NONE
		60	OK EA	NONE
		60	OK EA	NONE
		480		

3880

SWS ENDURANCE TEST REPORT

SERIAL NO. CL522354 SHOOTER TF DATE 9-11-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK TF	NONE
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	20	" TF	"
		620	Total	
		4500	Total	
		60	Target + Ac	9-11-90 N2
		4560		

SWS ENDURANCE TEST REPORT

SERIAL NO C6522356 SHOOTER E H. DATE 9-11

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	ok EH	NONE
	"	60	ok EH	NONE
	"	60	ok EH	NONE
	"	60	ok EH	NONE
	"	60	ok EH	NONE
	"	60	ok EH	NONE
	"	60	ok EH	NONE
	"	20	ok EH	NONE
	"	380		
		4560		
		4940		
		60	TARGET + AC	9-12-90 DH.
		5000		

SWS ENDURANCE TEST REPORT

SERIAL NO. C65223.56 SHOOTER RB DATE 9/12

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	40	OK RB	NONE
		1000		
		5000		
		6000	TOTAL	

SWS ENDURANCE TEST REPORT

SERIAL NO. C652356 SHOOTER TF DATE 9-13-86

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK TF	NONE
	"	60	" TF	NONE
	"	60	" TF	NONE
	"	60	" TF	NONE
	"	60	" TF	NONE
	"	60	" TF	NONE
	"	60	" TF	NONE
	"	60	" TF	NONE
	"	60	" TF	NONE
	"	60	" TF	NONE
		540		
		6000		
		6540	Total	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6522356 SHOOTER RB DATE 9/13/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	40	OK RB	NONE
		460		
		6540		
		7000	TOTAL	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6522356 SHOOTER TF DATE 9-14-80

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK TF	NONE
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
		960		
		7000		
		7960	Total	

SWS ENDURANCE TEST REPORT

SERIAL NO. C65A2356 SHOOTER RB DATE 9/14/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	40	OK RB	NONE
		7960		
		8000	TOTAL	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6522356 SHOOTER TF DATE 9-17

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK TF	NONE
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	60	" TF	"
	"	20	" TF	"
		800		
		5000		
		8800	Total	- Magnaflux - @ Here

SWS ENDURANCE TEST REPORT

SERIAL NO. 66522356 SHOOTER RR DATE 9/17/90

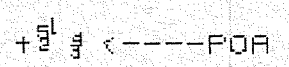
AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
	7.62	60	OK RB	NONE
		1200		
		8800		
		10,000	TOTAL	

0 Lounos

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522356
1 Sep 1990

CENTROIDAL DISTANCES

Ø	TO	1	.648968
1	TO	2	.371732
1	TO	3	.626081
1	TO	4	.523245
1	TO	5	.205643

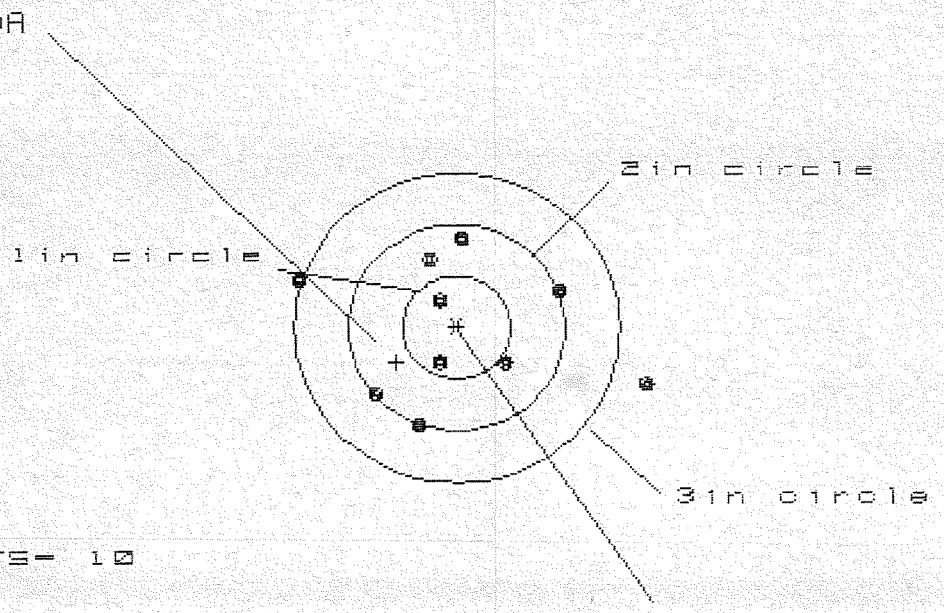


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .669
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1106
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .678081

THE AMR FOR THIS RIFLE IS: 1.02

1 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522356

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

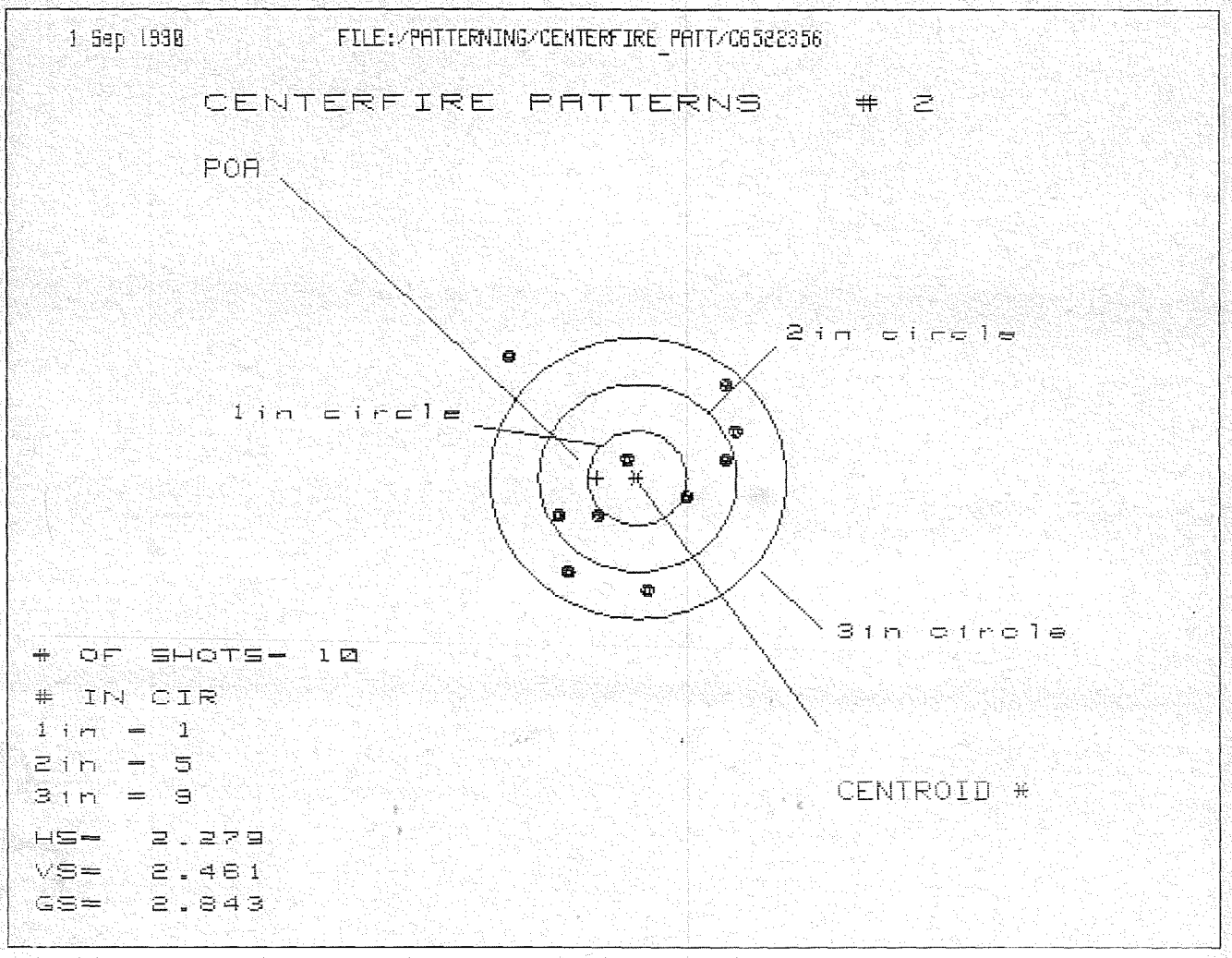
# IN CIR
1in = 2
2in = 7
3in = 8

HS= 3.145
VS= 1.832
GS= 3.331

PATTERN # : 1

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.699	1.133	.976
MINIMUM X :	-1.446	-1.258	-.706
MAXIMUM Y :	.897	.832	.888
MINIMUM Y :	-.935	-1.000	-.944
CENTROID X :	.554	.366	.523
CENTROID Y :	.338	.403	.347
POA TO CENTROID in.:	.649	.544	.628
MIN RADIUS :	.325	.188	.298
MEAN RADIUS :	.920	.802	.731
MAX RADIUS :	1.797	1.334	1.047
HORIZONTAL SPREAD :	3.145	2.391	1.682
VERTICAL SPREAD :	1.832	1.832	1.832
EXTREME SPREAD :	3.331	2.394	1.945

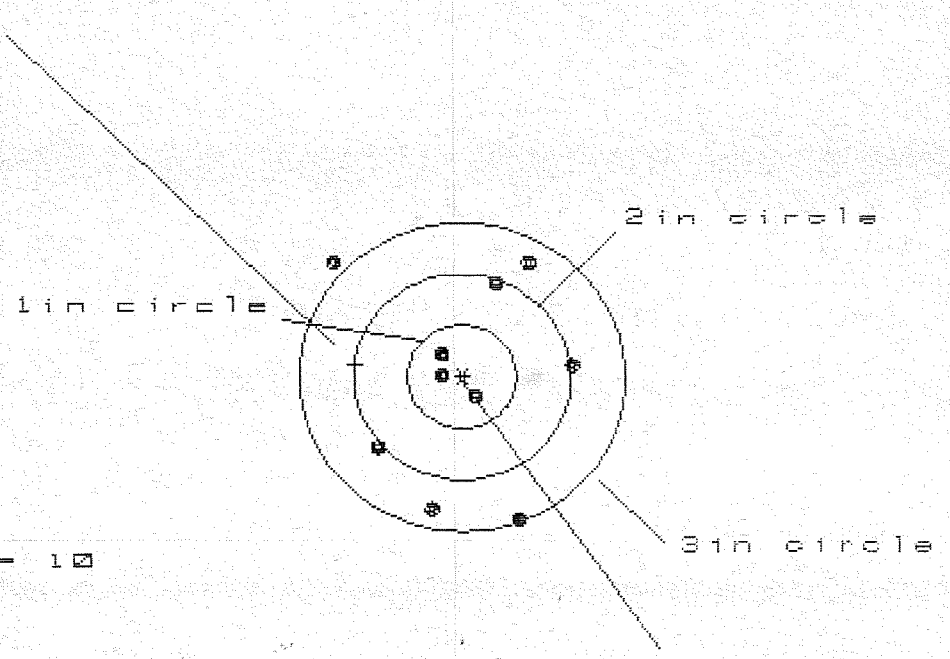
NUMBER IN ONE INCH CIRCLE = 2
NUMBER IN TWO INCH CIRCLE = 7
NUMBER IN THREE INCH CIRCLE = 8



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.958	.811	.901
MINIMUM X	:	-1.321	-.942	-.852
MAXIMUM Y	:	1.268	1.189	.761
MINIMUM Y	:	-1.193	-1.052	-.904
CENTROID X	:	.406	.553	.463
CENTROID Y	:	-.003	-.144	-.292
POA TO CENTROID in.	:	.406	.571	.547
MIN RADIUS	:	.288	.365	.447
MEAN RADIUS	:	.993	.885	.810
MAX RADIUS	:	1.831	1.392	1.180
HORIZONTAL SPREAD	:	2.279	1.753	1.753
VERTICAL SPREAD	:	2.461	2.241	1.665
EXTREME SPREAD	:	2.843	2.603	2.238
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

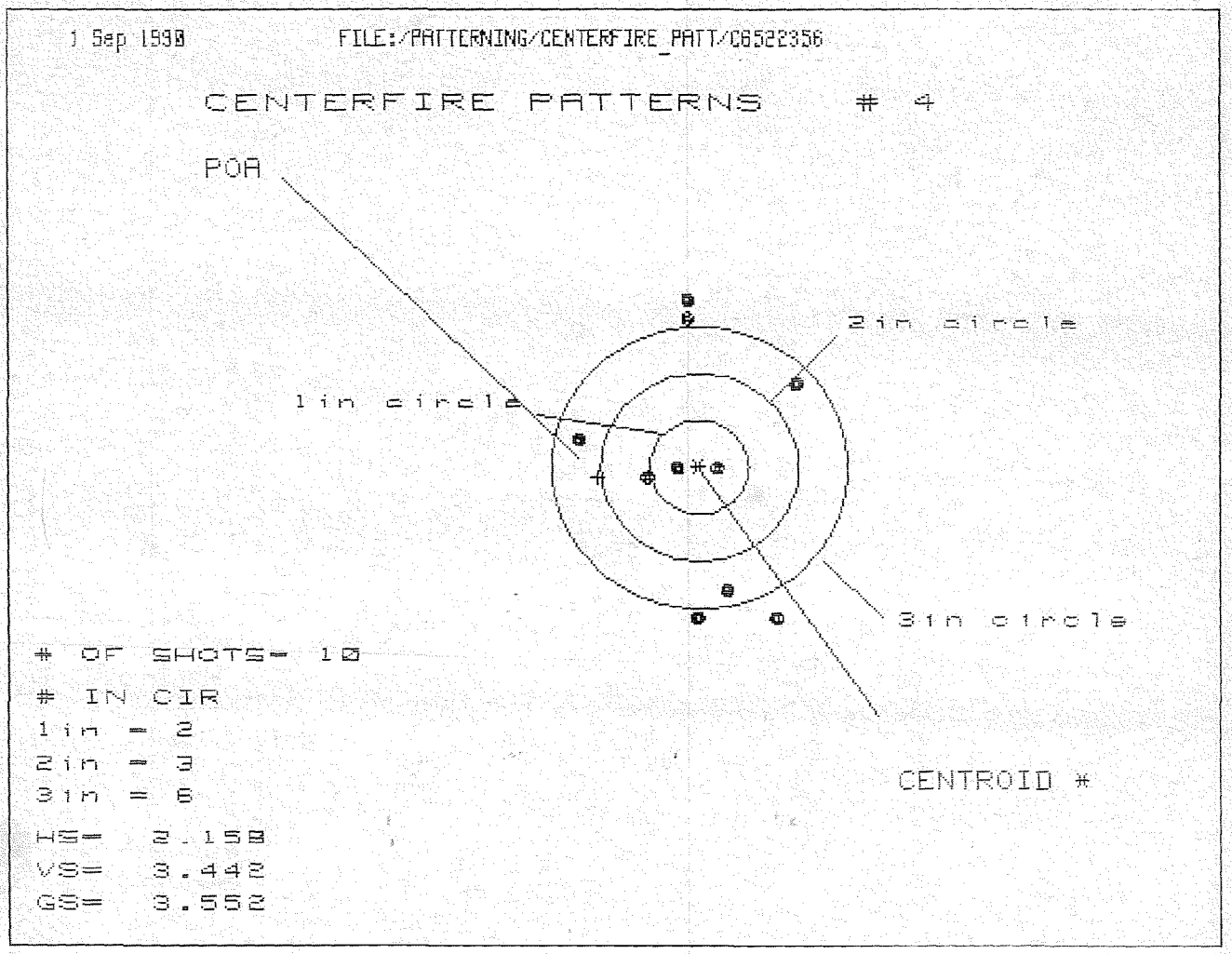
1 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522356

CENTERFIRE PATTERNS # 3



# OF SHOTS= 10
# IN CIR
1in = 3
2in = 4
3in = 9
HS= 2.188
VS= 2.532
GS= 3.053

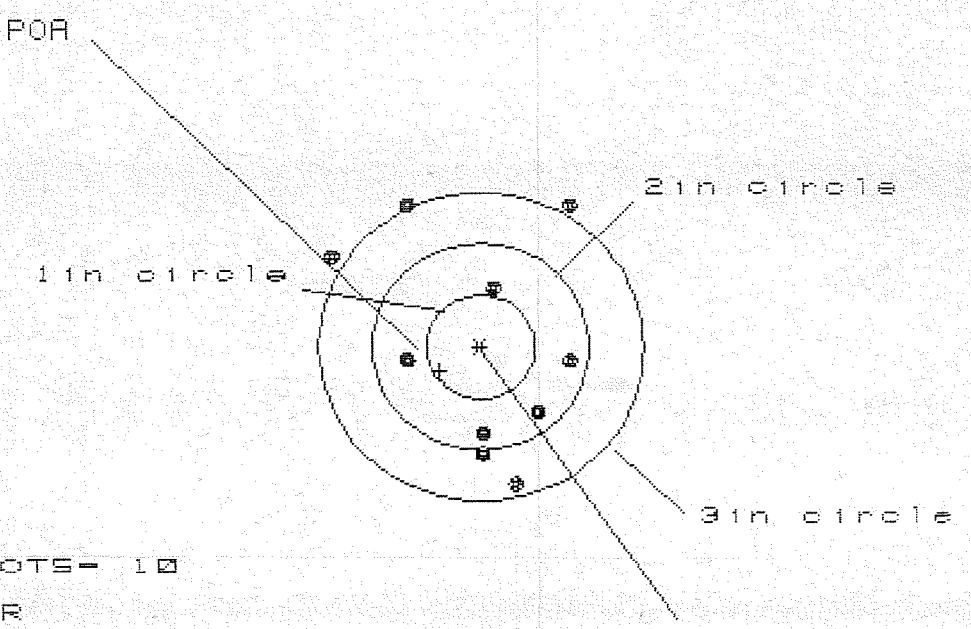
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.004	.872	.921
MINIMUM X	:	-1.184	-.951	-.902
MAXIMUM Y	:	1.158	1.276	1.121
MINIMUM Y	:	-1.374	-1.246	-1.327
CENTROID X	:	.983	1.115	1.066
CENTROID Y	:	-.118	-.246	-.091
POA TO CENTROID in.	:	.990	1.142	1.070
MIN RADIUS	:	.185	.099	.252
MEAN RADIUS	:	.953	.876	.807
MAX RADIUS	:	1.656	1.376	1.365
HORIZONTAL SPREAD	:	2.188	1.823	1.823
VERTICAL SPREAD	:	2.532	2.522	2.448
EXTREME SPREAD	:	3.053	2.601	2.601
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	4.		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.959	.947	1.041
MINIMUM X	:	-1.199	-1.211	-1.117
MAXIMUM Y	:	1.833	1.815	1.639
MINIMUM Y	:	-1.609	-1.405	-1.540
CENTROID X	:	1.023	1.035	.941
CENTROID Y	:	.106	-.098	.078
POA TO CENTROID in.	:	1.028	1.040	.945
MIN RADIUS	:	.183	.258	.111
MEAN RADIUS	:	1.158	1.079	.984
MAX RADIUS	:	1.836	1.821	1.640
HORIZONTAL SPREAD	:	2.158	2.158	2.158
VERTICAL SPREAD	:	3.442	3.220	3.179
EXTREME SPREAD	:	3.552	3.346	3.181
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		6	

1 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522356

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 2.163

VS= 2.647

GS= 2.840

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.793	.641	.721
MINIMUM X	:	-1.370	-.872	-.792
MAXIMUM Y	:	1.335	1.433	1.610
MINIMUM Y	:	-1.312	-1.214	-1.037
CENTROID X	:	.379	.531	.451
CENTROID Y	:	.230	.132	-.045
POA TO CENTROID in.	:	.443	.547	.453
MIN RADIUS	:	.554	.613	.524
MEAN RADIUS	:	1.076	.985	.879
MAX RADIUS	:	1.625	1.648	1.769
HORIZONTAL SPREAD	:	2.163	1.513	1.513
VERTICAL SPREAD	:	2.647	2.647	2.647
EXTREME SPREAD	:	2.840	2.840	2.840
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

500 Rounds

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522356
5 Sep 1990

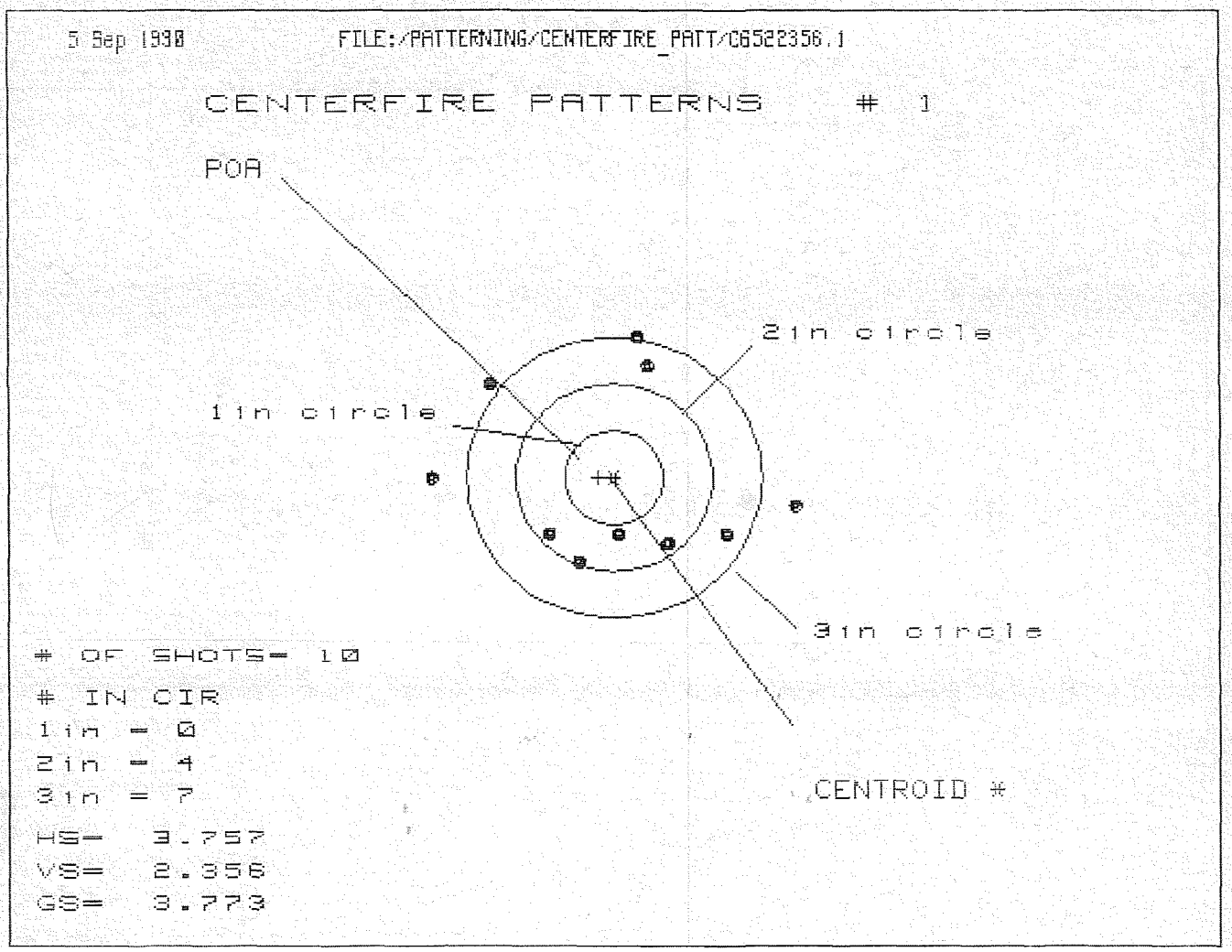
CENTROIDAL DISTANCES

0	TO	1	.156003
1	TO	2	.684796
1	TO	3	.558413
1	TO	4	.145207
1	TO	5	.350464

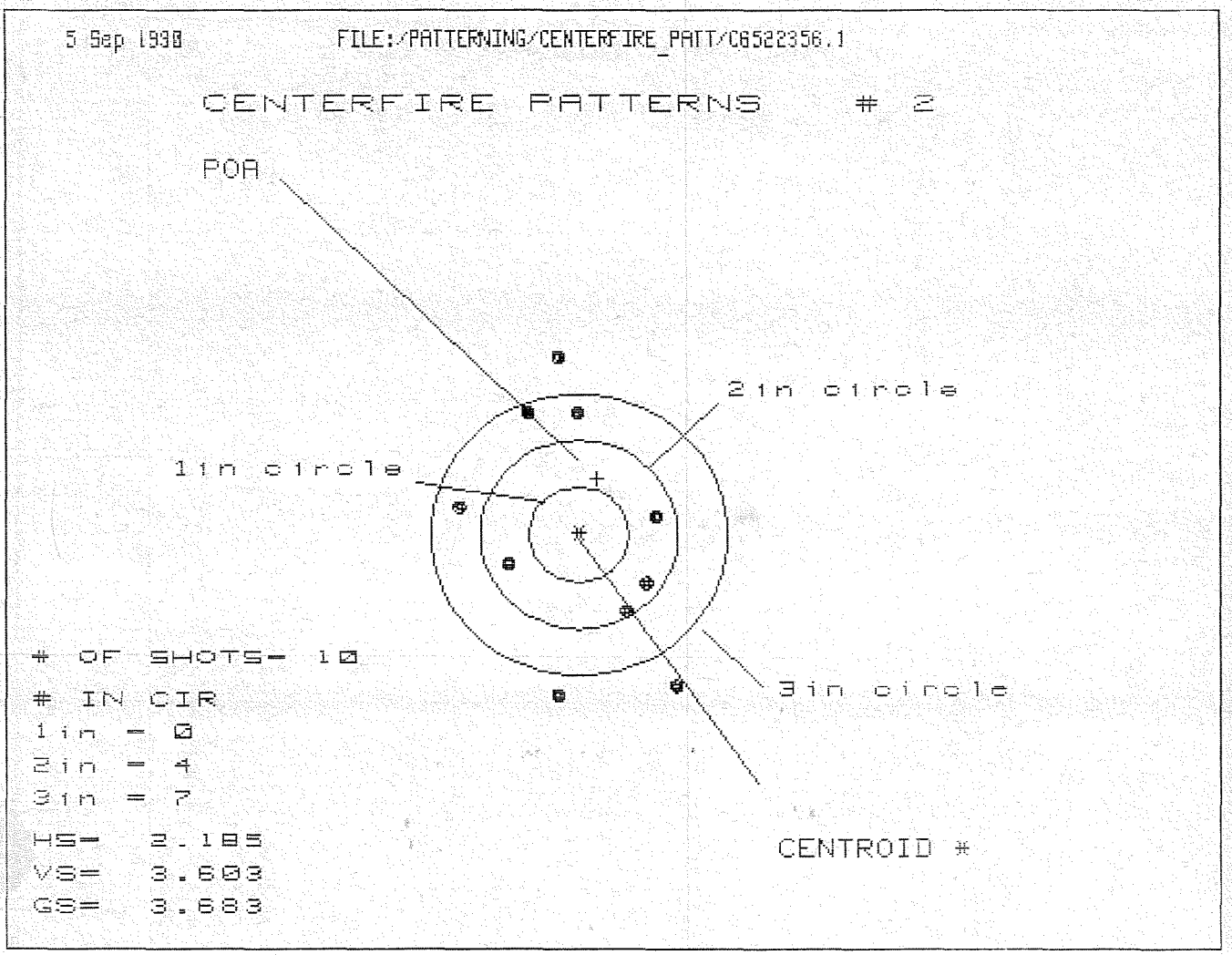
<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0322
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2266
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .228876

THE AMR FOR THIS RIFLE IS: 1.145



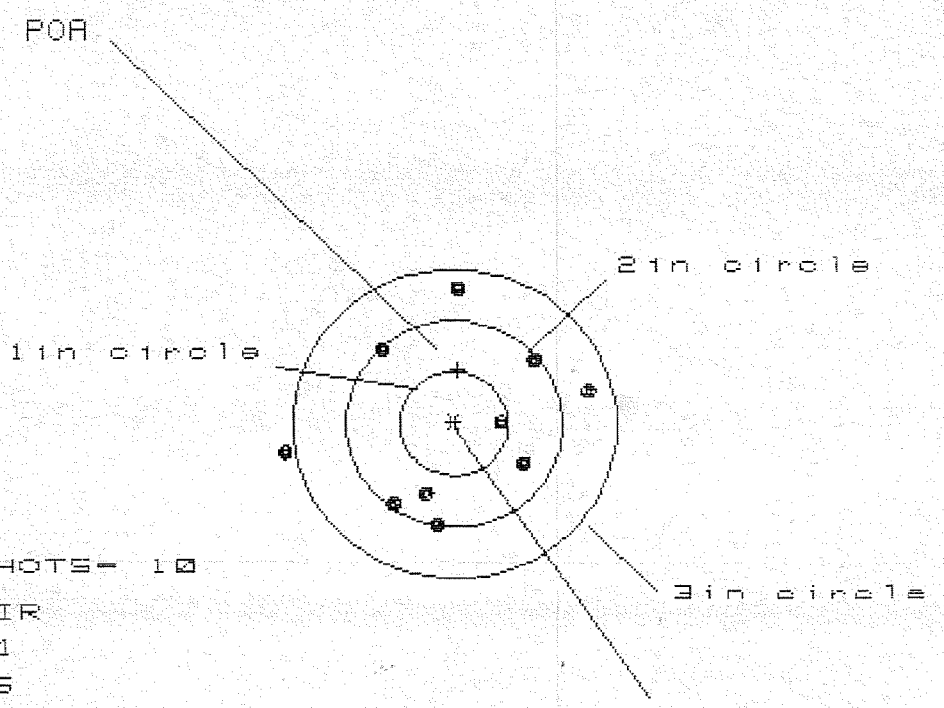
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.870	1.329	1.119
MINIMUM X	:	-1.887	-1.680	-1.300
MAXIMUM Y	:	1.457	1.419	1.414
MINIMUM Y	:	-.899	-.937	-.942
CENTROID X	:	.156	-.051	.159
CENTROID Y	:	.001	.039	.044
POA TO CENTROID in.	:	.156	.065	.164
MIN RADIUS	:	.584	.683	.626
MEAN RADIUS	:	1.277	1.207	1.130
MAX RADIUS	:	1.901	1.680	1.632
HORIZONTAL SPREAD	:	3.757	3.009	2.420
VERTICAL SPREAD	:	2.356	2.356	2.356
EXTREME SPREAD	:	3.773	3.060	2.891
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.990	.961	.839
MINIMUM X	:	-1.196	-1.224	-1.104
MAXIMUM Y	:	1.870	1.527	1.353
MINIMUM Y	:	-1.733	-1.525	-1.699
CENTROID X	:	-.183	-.155	-.275
CENTROID Y	:	-.594	-.802	-.628
POA TO CENTROID in.	:	.622	.817	.686
MIN RADIUS	:	.779	.733	.682
MEAN RADIUS	:	1.286	1.198	1.136
MAX RADIUS	:	1.888	1.688	1.707
HORIZONTAL SPREAD	:	2.185	2.185	1.943
VERTICAL SPREAD	:	3.603	3.052	3.052
EXTREME SPREAD	:	3.683	3.293	3.065
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

5 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522356.1

CENTERFIRE PATTERNS # 3

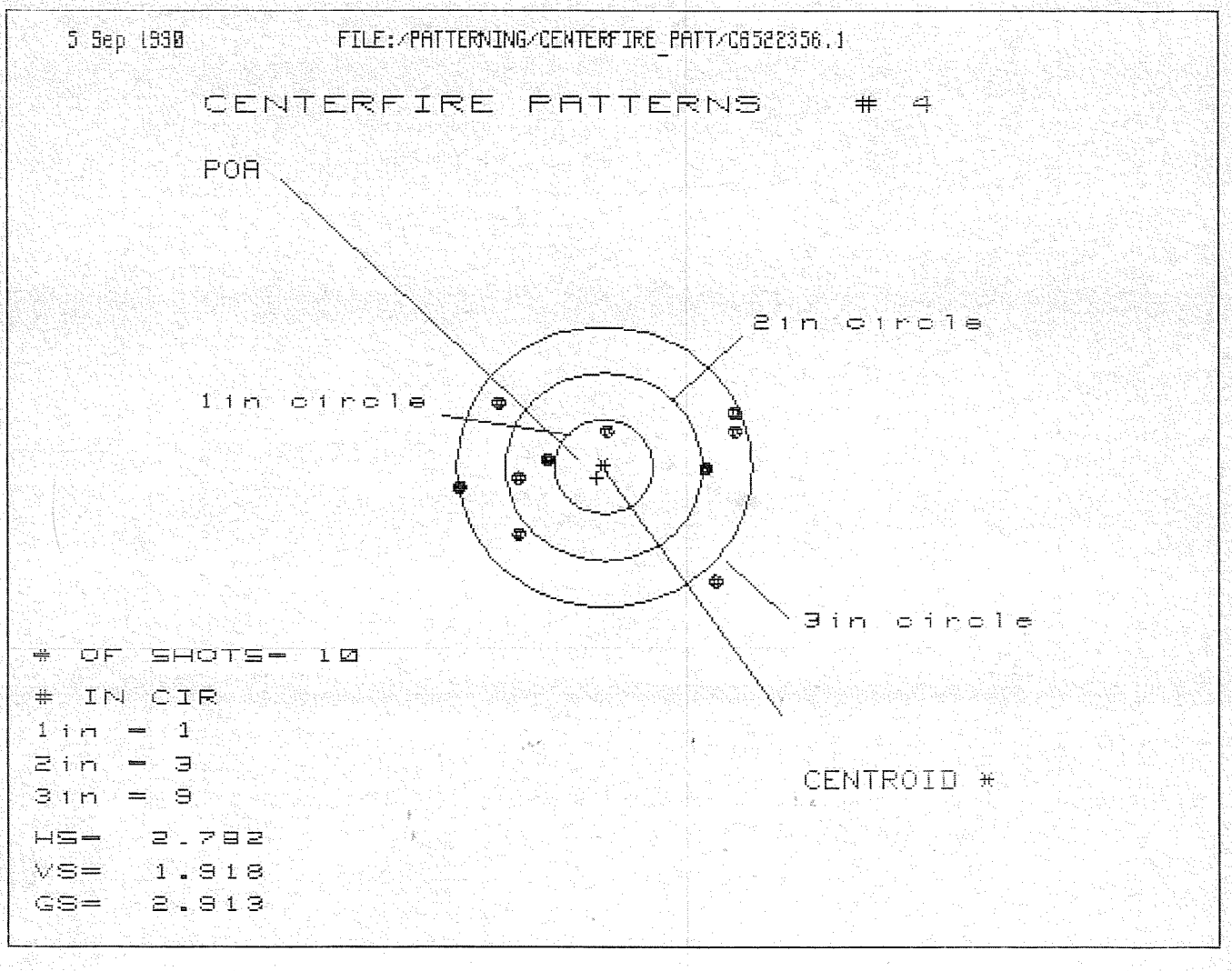


# OF SHOTS= 10
# IN CIR
1in = 1
2in = 6
3in = 9
HS= 2.750
VS= 2.322
GS= 2.800

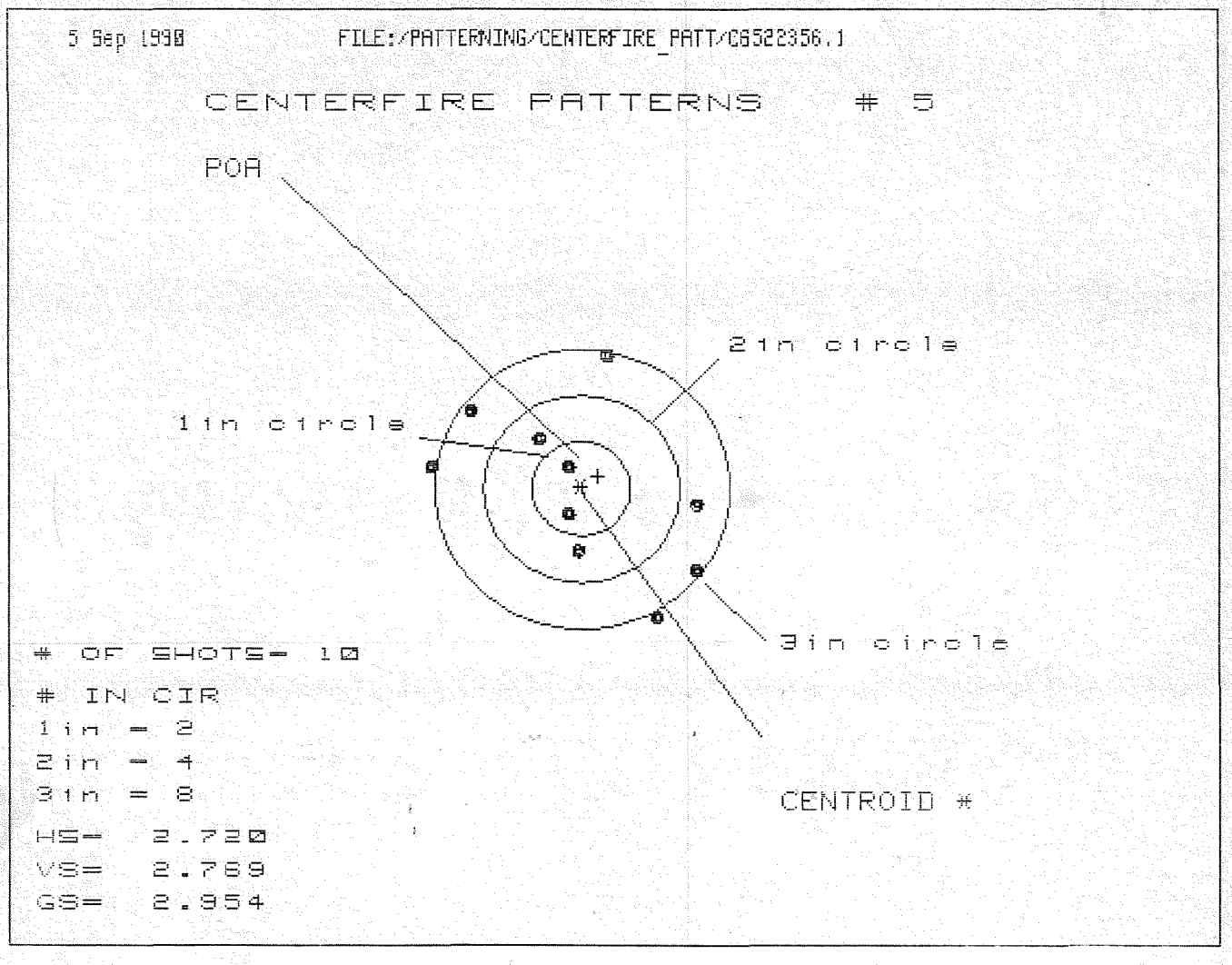
PATTERN # : 3

SHOTS (BEST OF) :	10	9	8
MAXIMUM X :	1.236	1.068	1.058
MINIMUM X :	-1.514	-.817	-.827
MAXIMUM Y :	1.339	1.314	.853
MINIMUM Y :	-.983	-1.008	-.844
CENTROID X :	-.037	.131	.141
CENTROID Y :	-.523	-.498	-.662
POA TO CENTROID in.:	.525	.515	.677
MIN RADIUS :	.463	.293	.338
MEAN RADIUS :	.993	.907	.837
MAX RADIUS :	1.531	1.317	1.188
HORIZONTAL SPREAD :	2.750	1.885	1.885
VERTICAL SPREAD :	2.322	2.322	1.697
EXTREME SPREAD :	2.800	2.339	2.089

NUMBER IN ONE INCH CIRCLE = 1
NUMBER IN TWO INCH CIRCLE = 6
NUMBER IN THREE INCH CIRCLE = 9



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.342	1.466	1.595
MINIMUM X	:	-1.440	-1.316	-1.133
MAXIMUM Y	:	.712	.578	.639
MINIMUM Y	:	-1.206	-.825	-.763
CENTROID X	:	.070	-.054	-.238
CENTROID Y	:	.118	.252	.191
POA TO CENTROID in.	:	.137	.258	.304
MIN RADIUS	:	.420	.340	.241
MEAN RADIUS	:	1.119	1.029	.925
MAX RADIUS	:	1.643	1.547	1.623
HORIZONTAL SPREAD	:	2.782	2.782	2.727
VERTICAL SPREAD	:	1.918	1.403	1.403
EXTREME SPREAD	:	2.913	2.913	2.795
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.216	1.306	1.129
MINIMUM X	:	-1.504	-1.414	-1.243
MAXIMUM Y	:	1.396	1.243	1.258
MINIMUM Y	:	-1.373	-.973	-.958
CENTROID X	:	-.167	-.258	-.081
CENTROID Y	:	-.135	.018	.003
POA TO CENTROID in.	:	.215	.259	.081
MIN RADIUS	:	.242	.064	.219
MEAN RADIUS	:	1.048	.963	.926
MAX RADIUS	:	1.597	1.629	1.481
HORIZONTAL SPREAD	:	2.720	2.720	2.372
VERTICAL SPREAD	:	2.769	2.216	2.216
EXTREME SPREAD	:	2.954	2.932	2.888
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

4500 Rounds

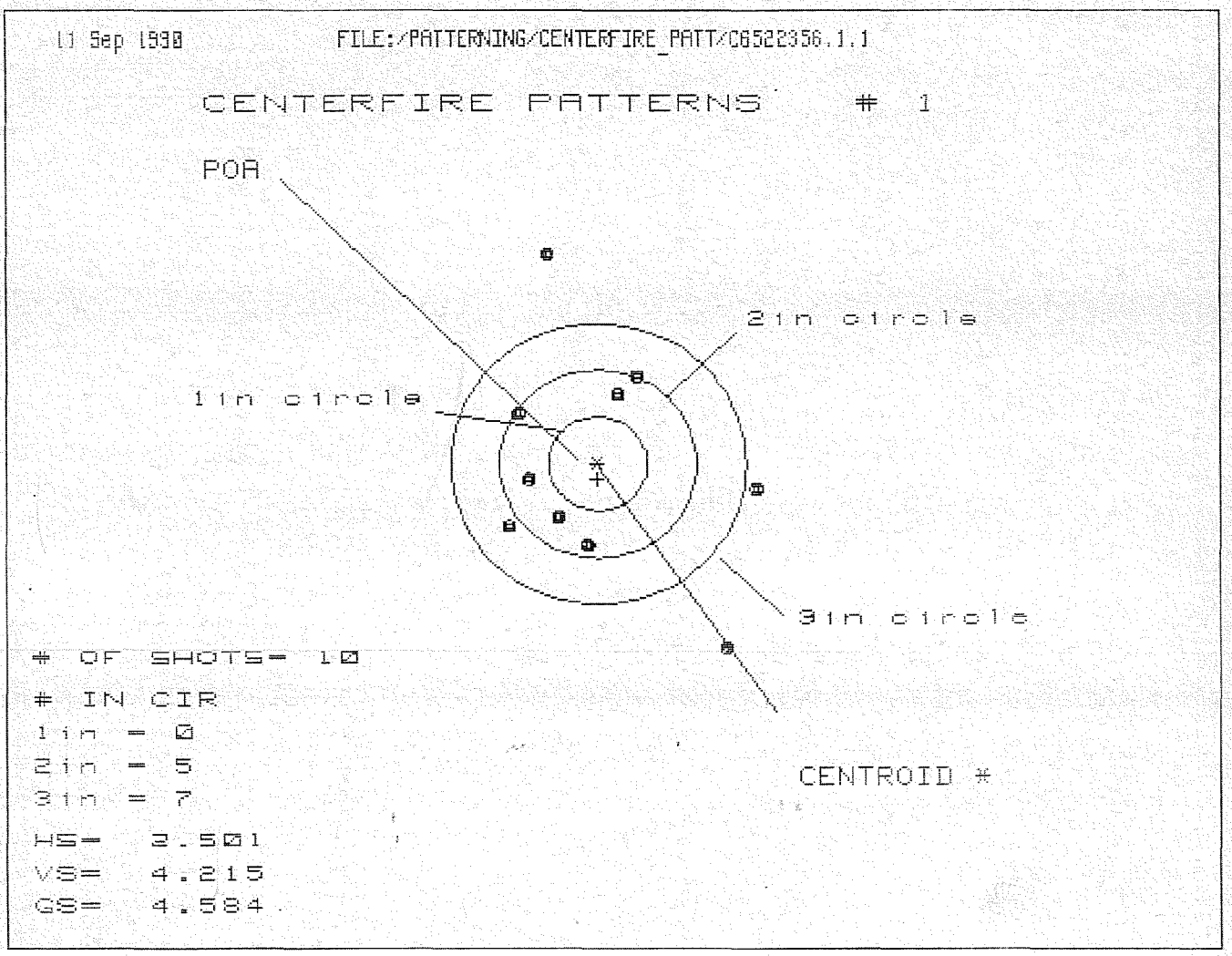
CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522356
12 Sep 1990

CENTROIDAL DISTANCES

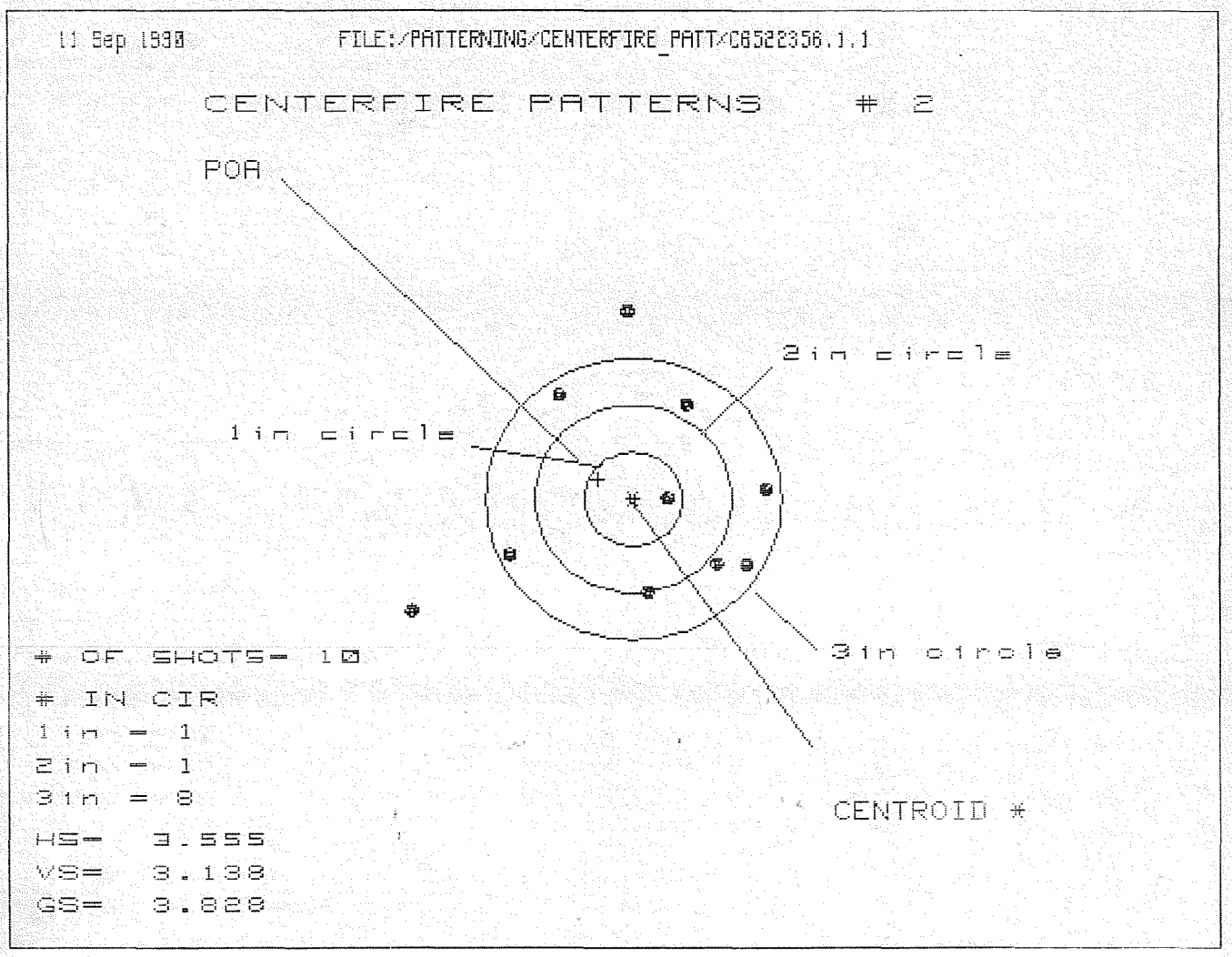
0	TO	1	.162111
1	TO	2	.509449
1	TO	3	.5036
1	TO	4	.114039
1	TO	5	.0674463

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0072
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0194
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .020693

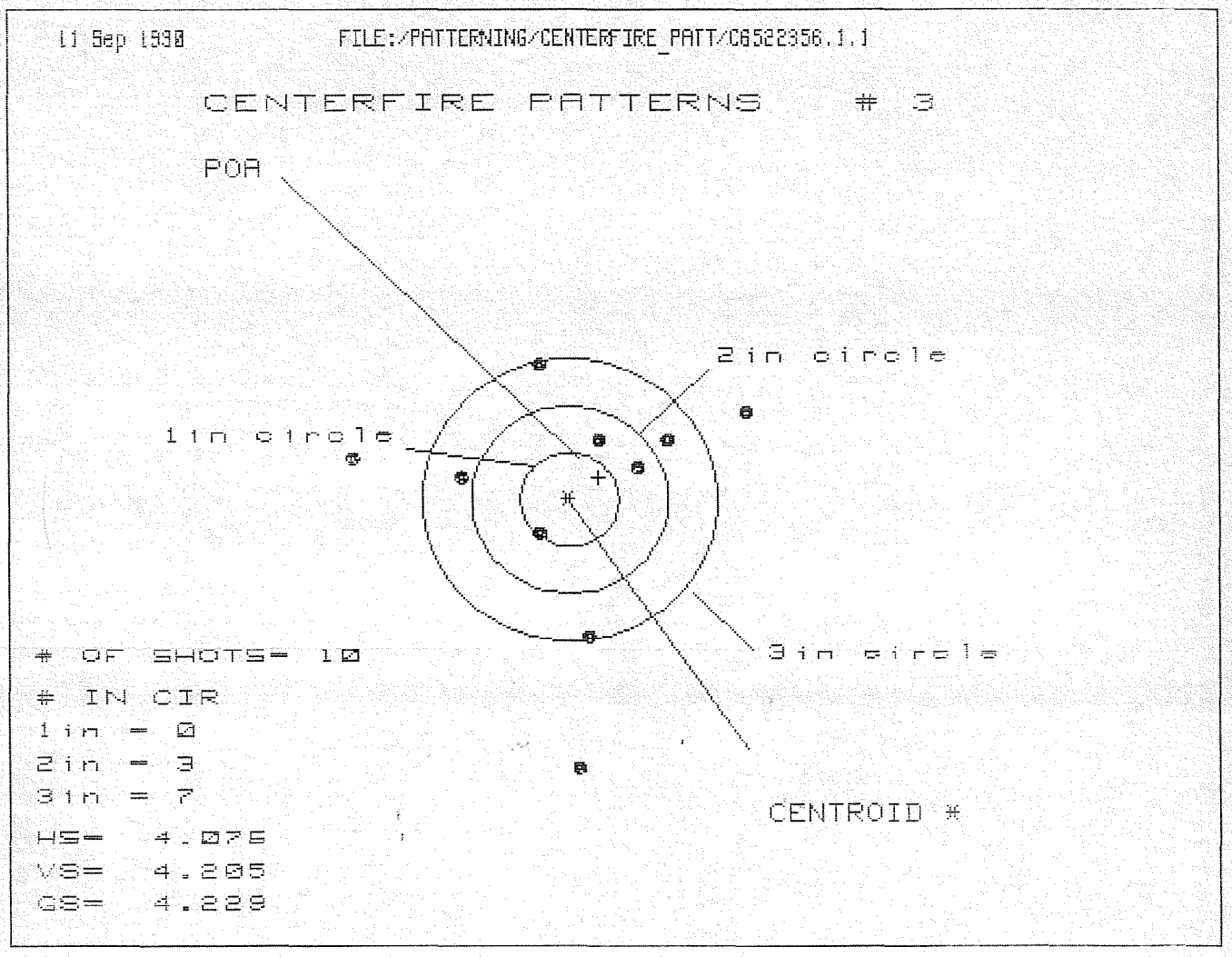
THE AMR FOR THIS RIFLE IS: 1.281



PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.619	1.759	1.710
MINIMUM X	:	-.883	-.742	-.791
MAXIMUM Y	:	2.263	2.046	1.010
MINIMUM Y	:	-1.952	-1.122	-.867
CENTROID X	:	.006	-.135	-.086
CENTROID Y	:	.162	.379	.124
POA TO CENTROID in.	:	.162	.403	.150
MIN RADIUS	:	.691	.629	.607
MEAN RADIUS	:	1.255	1.113	.968
MAX RADIUS	:	2.327	2.084	1.723
HORIZONTAL SPREAD	:	2.501	2.501	2.501
VERTICAL SPREAD	:	4.215	3.168	1.885
EXTREME SPREAD	:	4.584	3.312	2.543
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		7	

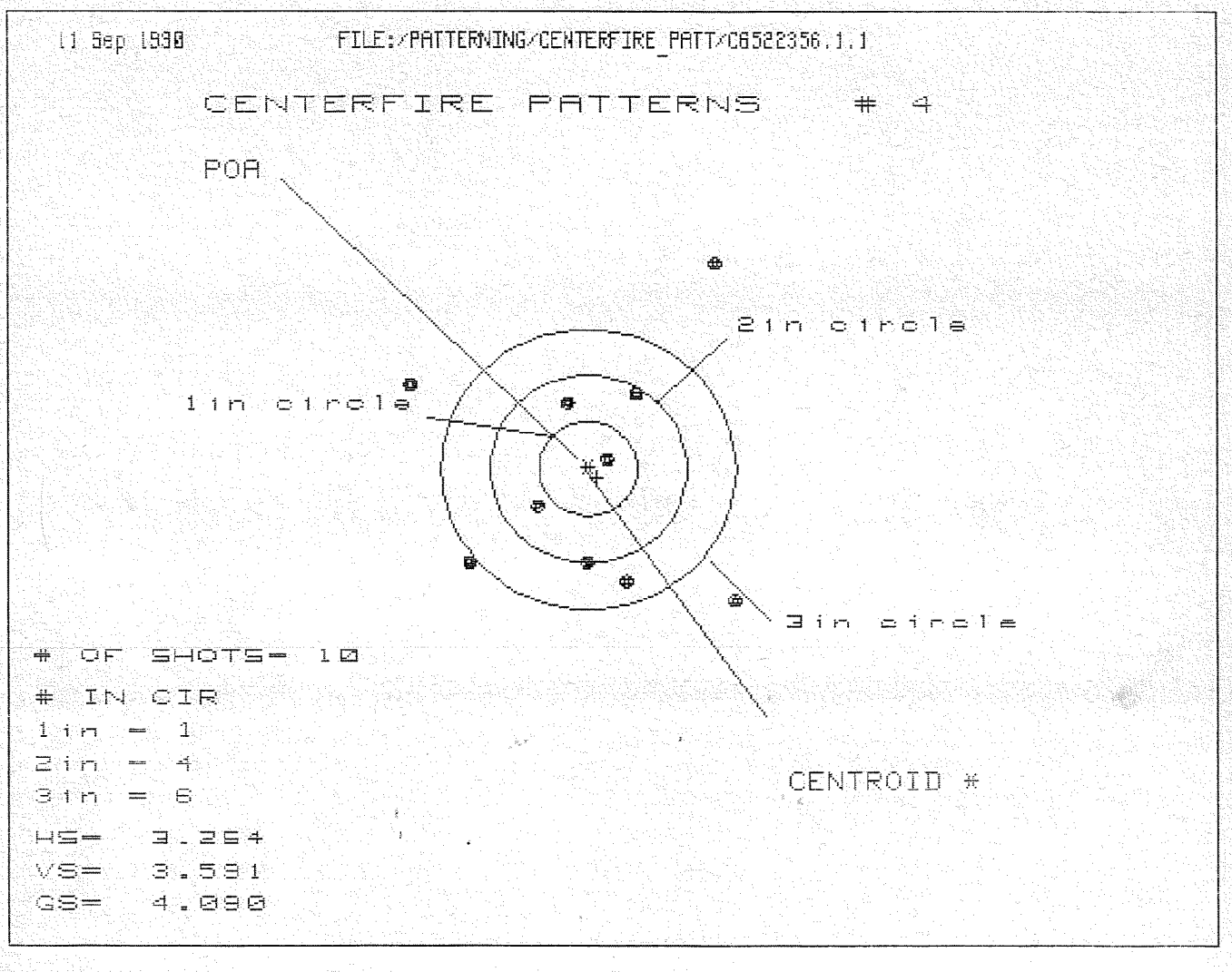


PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.314	1.065	1.027
MINIMUM X	:	-2.241	-1.530	-1.568
MAXIMUM Y	:	1.971	1.841	1.247
MINIMUM Y	:	-1.167	-1.140	-.910
CENTROID X	:	.353	.602	.640
CENTROID Y	:	-.211	-.081	-.311
POA TO CENTROID in.	:	.411	.608	.711
MIN RADIUS	:	.369	.200	.107
MEAN RADIUS	:	1.355	1.171	1.040
MAX RADIUS	:	2.527	1.865	1.656
HORIZONTAL SPREAD	:	3.555	2.595	2.595
VERTICAL SPREAD	:	3.138	2.981	2.157
EXTREME SPREAD	:	3.828	2.985	2.691
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		1	
NUMBER IN THREE INCH CIRCLE	=		8	

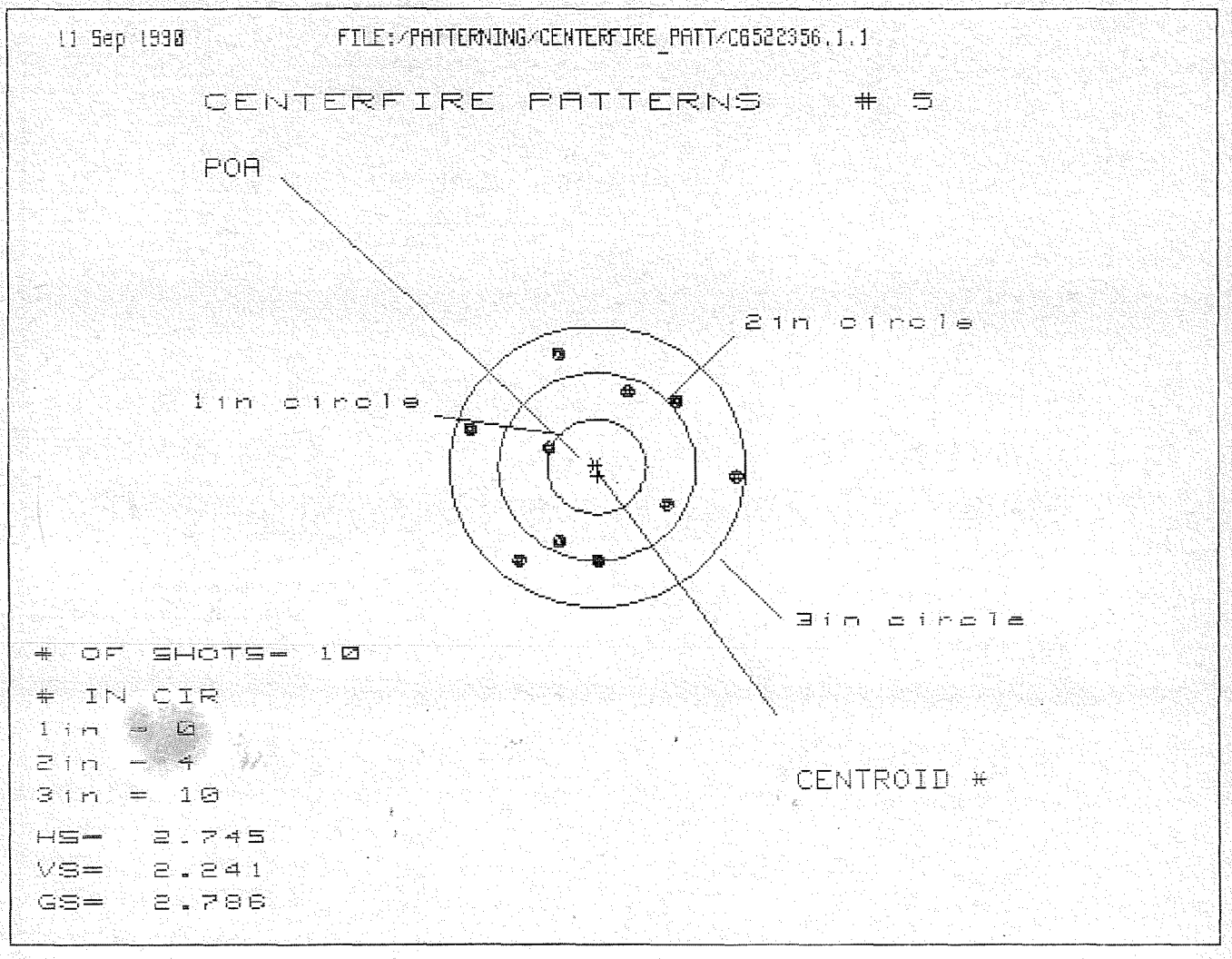


PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.825	1.838	1.558
MINIMUM X	:	-2.251	-2.238	-1.389
MAXIMUM Y	:	1.392	1.079	1.099
MINIMUM Y	:	-2.813	-1.747	-1.727
CENTROID X	:	-.296	-.309	-.029
CENTROID Y	:	-.241	.072	.052
POA TO CENTROID in.	:	.382	.317	.059
MIN RADIUS	:	.511	.420	.340
MEAN RADIUS	:	1.433	1.237	1.068
MAX RADIUS	:	2.816	2.244	1.730
HORIZONTAL SPREAD	:	4.076	4.076	2.947
VERTICAL SPREAD	:	4.205	2.826	2.826
EXTREME SPREAD	:	4.229	4.101	3.026

NUMBER IN ONE INCH CIRCLE = 0
NUMBER IN TWO INCH CIRCLE = 3
NUMBER IN THREE INCH CIRCLE = 7



PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.444	1.590	1.381
MINIMUM X	:	-1.820	-1.674	-1.295
MAXIMUM Y	:	2.236	1.202	1.250
MINIMUM Y	:	-1.355	-1.106	-.956
CENTROID X	:	-.087	-.233	-.024
CENTROID Y	:	.096	-.153	-.303
POA TO CENTROID in.	:	.130	.279	.304
MIN RADIUS	:	.247	.392	.566
MEAN RADIUS	:	1.303	1.141	1.020
MAX RADIUS	:	2.591	2.061	1.679
HORIZONTAL SPREAD	:	3.264	3.264	2.676
VERTICAL SPREAD	:	3.591	2.308	2.206
EXTREME SPREAD	:	4.090	3.998	2.704
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	



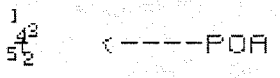
PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.441	1.021	.878
MINIMUM X	:	-1.304	-1.143	-.720
MAXIMUM Y	:	1.204	1.192	1.237
MINIMUM Y	:	-1.037	-1.049	-1.004
CENTROID X	:	-.012	-.173	-.030
CENTROID Y	:	.097	.109	.064
POA TO CENTROID in.	:	.097	.204	.071
MIN RADIUS	:	.529	.379	.527
MEAN RADIUS	:	1.061	1.004	.975
MAX RADIUS	:	1.445	1.249	1.305
HORIZONTAL SPREAD	:	2.745	2.164	1.598
VERTICAL SPREAD	:	2.241	2.241	2.241
EXTREME SPREAD	:	2.786	2.380	2.380
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

5000 ROUNDS

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522356
12 Sep 1990

CENTROIDAL DISTANCES

0	TO	1	.56657
1	TO	2	.852247
1	TO	3	.468834
1	TO	4	.416541
1	TO	5	.724462

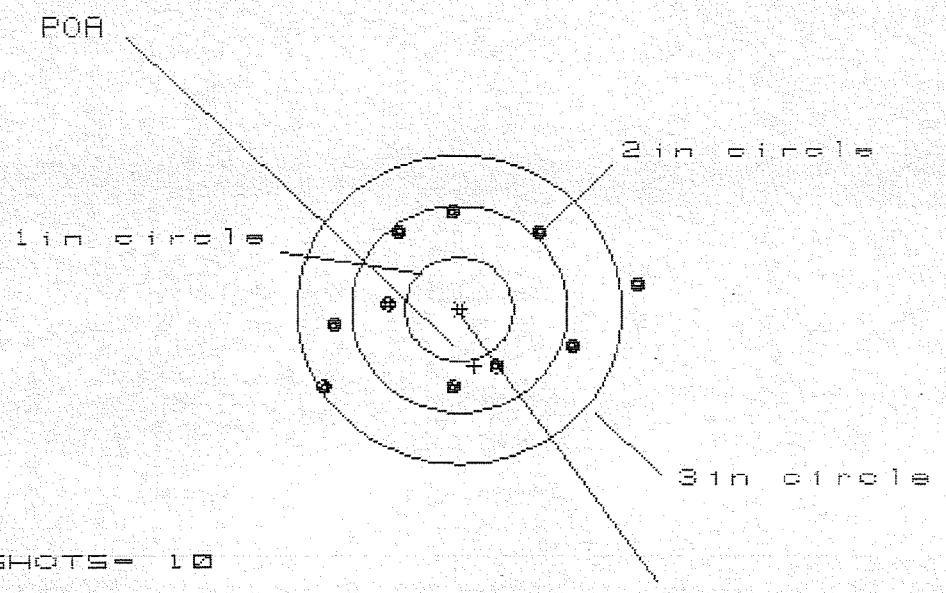


THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0106
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1074
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .107922

THE AMR FOR THIS RIFLE IS: .9946

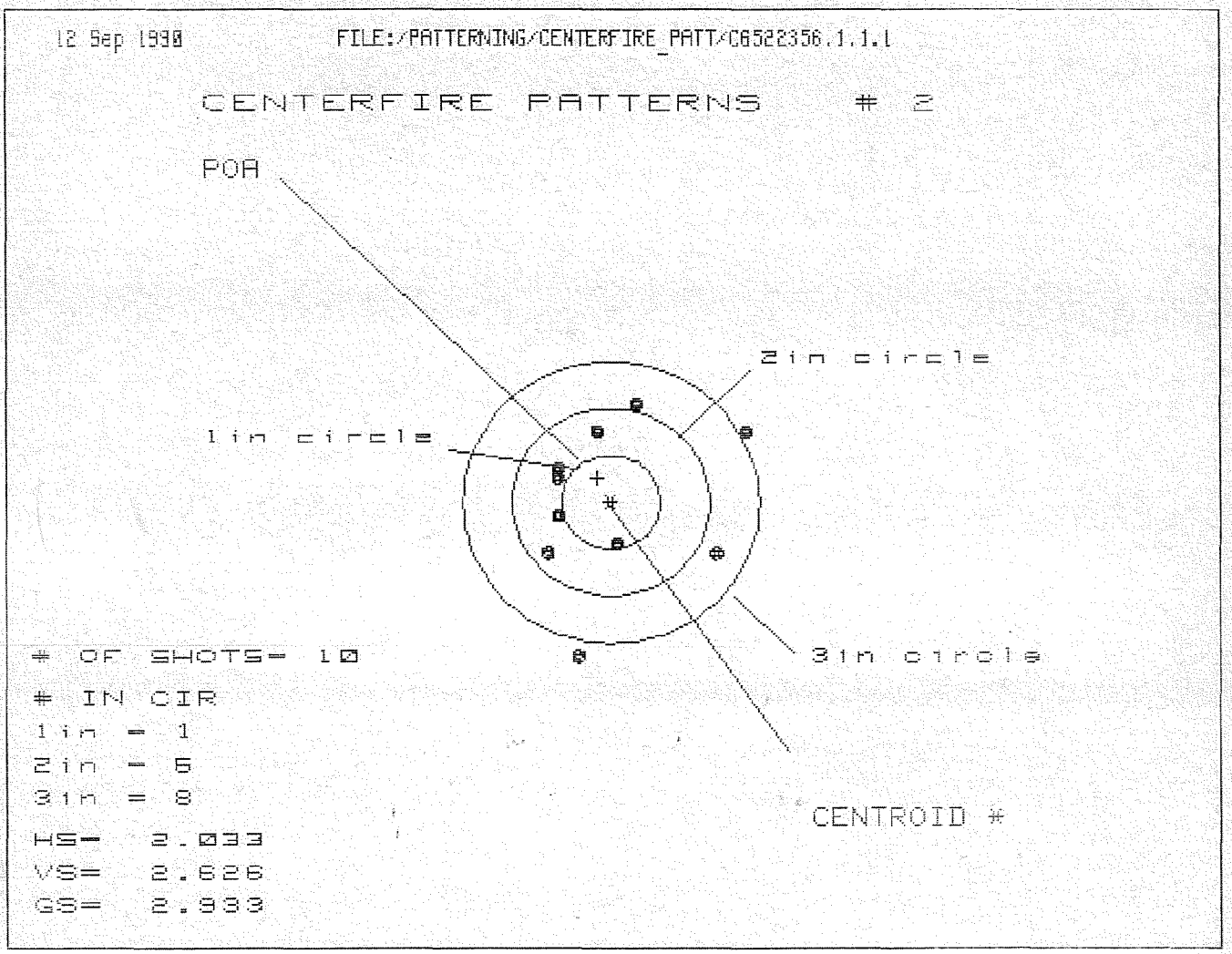
12 Sep 1990 FILE:/PATTERNING/CENTERFIRE_PATT/C0522356.1.1.1

CENTERFIRE PATTERNS # 1



# OF SHOTS= 10
# IN CIR
1in = 0
2in = 5
3in = 9
HS= 2.842
VS= 1.692
GS= 3.005

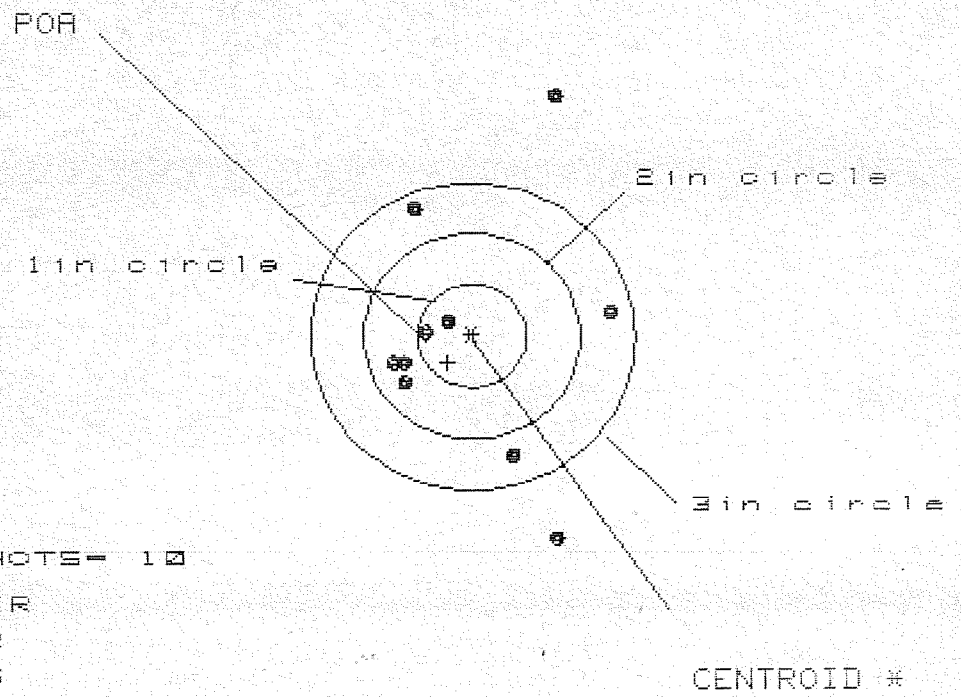
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.620	1.247	1.117
MINIMUM X	:	-1.222	-1.043	-1.107
MAXIMUM Y	:	.918	.940	.847
MINIMUM Y	:	-.774	-.752	-.810
CENTROID X	:	-.140	-.320	-.190
CENTROID Y	:	.549	.527	.620
POA TO CENTROID in.	:	.567	.616	.649
MIN RADIUS	:	.656	.477	.608
MEAN RADIUS	:	1.038	.951	.909
MAX RADIUS	:	1.632	1.293	1.199
HORIZONTAL SPREAD	:	2.842	2.290	2.224
VERTICAL SPREAD	:	1.692	1.692	1.657
EXTREME SPREAD	:	3.005	2.483	2.233
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	



PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.376	1.338	1.230
MINIMUM X	:	-.657	-.695	-.527
MAXIMUM Y	:	1.017	.838	.913
MINIMUM Y	:	-1.609	-.730	-.655
CENTROID X	:	.134	.172	.004
CENTROID Y	:	-.258	-.079	-.154
POA TO CENTROID in.	:	.291	.189	.154
MIN RADIUS	:	.410	.589	.452
MEAN RADIUS	:	.935	.852	.727
MAX RADIUS	:	1.644	1.465	1.393
HORIZONTAL SPREAD	:	2.033	2.033	1.757
VERTICAL SPREAD	:	2.626	1.568	1.568
EXTREME SPREAD	:	2.933	2.401	1.890
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522356.1.1.L

CENTERFIRE PATTERNS # 3

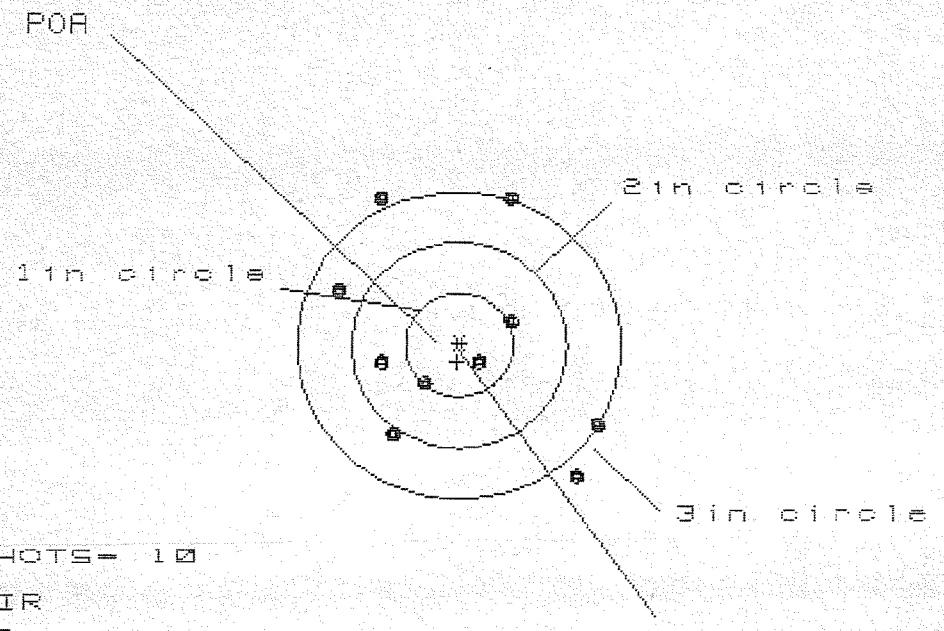


# OF SHOTS= 10
# IN CIR
1in = 2
2in = 5
3in = 8
HS= 1.995
VS= 4.282
GS= 4.282

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.296	1.382	1.487
MINIMUM X	:	-.699	-.613	-.508
MAXIMUM Y	:	2.337	1.537	1.327
MINIMUM Y	:	-1.944	-1.685	-1.074
CENTROID X	:	.226	.140	.035
CENTROID Y	:	.256	-.003	.207
POA TO CENTROID in.	:	.342	.140	.210
MIN RADIUS	:	.281	.434	.217
MEAN RADIUS	:	1.135	.952	.775
MAX RADIUS	:	2.462	1.881	1.510
HORIZONTAL SPREAD	:	1.995	1.995	1.995
VERTICAL SPREAD	:	4.282	3.222	2.401
EXTREME SPREAD	:	4.282	3.482	2.574
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

12 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6528356.1.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

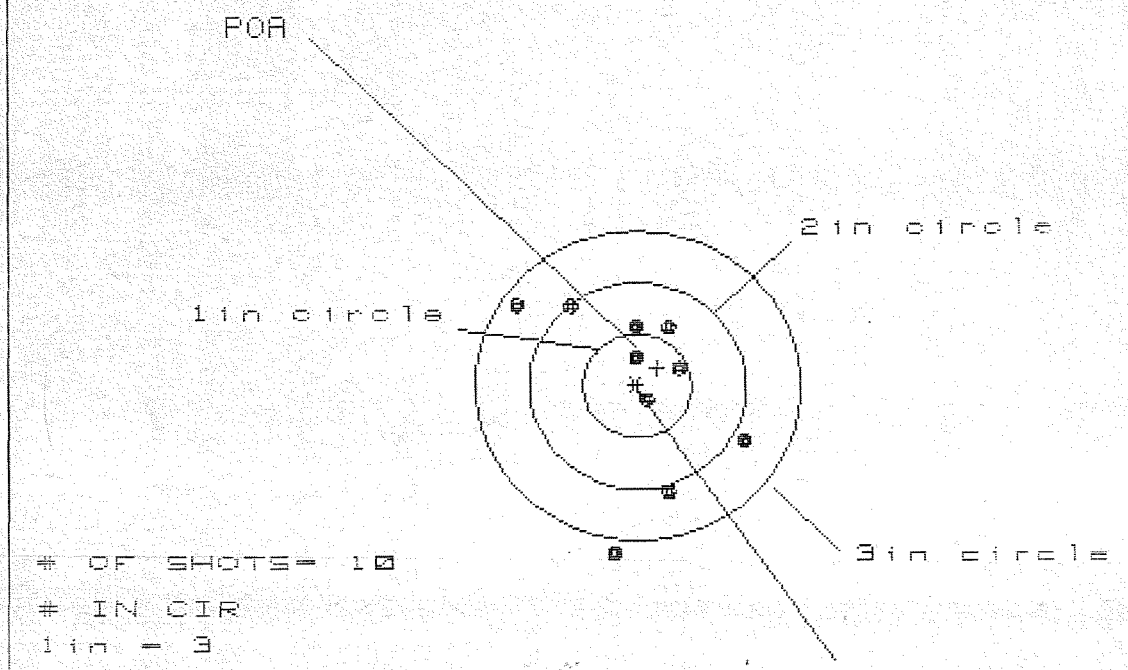
# IN CIR
1in = 2
2in = 4
3in = 8

HS= 2.347
VS= 2.702
GS= 3.289

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.239	1.364	1.286
MINIMUM X	:	-1.108	-.983	-1.061
MAXIMUM Y	:	1.397	1.252	1.398
MINIMUM Y	:	-1.305	-1.035	-.879
CENTROID X	:	.019	-.106	-.028
CENTROID Y	:	.164	.309	.153
POA TO CENTROID in.	:	.165	.327	.155
MIN RADIUS	:	.266	.457	.295
MEAN RADIUS	:	1.047	.977	.892
MAX RADIUS	:	1.723	1.660	1.509
HORIZONTAL SPREAD	:	2.347	2.347	2.347
VERTICAL SPREAD	:	2.702	2.287	2.277
EXTREME SPREAD	:	3.289	2.965	2.720
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	8		

12 Sep 1998 FILE:/PATTERNING/CENTERFIRE_PATT/C6522356.1.1.1

CENTERFIRE PATTERNS # 5



# OF SHOTS= 10
# IN CIR
1in = 3
2in = 5
3in = 9
HS= 2.071
VS= 2.478
GS= 2.625

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.956	.929	.786
MINIMUM X	:	-1.115	-1.142	-.787
MAXIMUM Y	:	.819	.635	.691
MINIMUM Y	:	-1.659	-1.174	-1.095
CENTROID X	:	-.186	-.159	-.016
CENTROID Y	:	-.174	.010	-.069
POA TO CENTROID in.	:	.255	.159	.071
MIN RADIUS	:	.116	.059	.198
MEAN RADIUS	:	.818	.678	.595
MAX RADIUS	:	1.678	1.307	1.100
HORIZONTAL SPREAD	:	2.071	2.071	1.573
VERTICAL SPREAD	:	2.478	1.809	1.786
EXTREME SPREAD	:	2.625	2.443	2.024
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

Endurance B/A & Bolt
#C-6522356

QP 0041

9-7-90

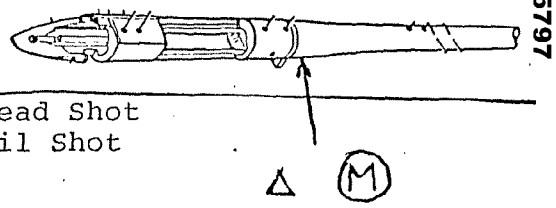
PART NUMBER

MAGNETIC PARTICLE INSPECTION

PART NAME Final Bbl.Assem. MATERIAL Bbl. Rem.Spec.#155-Rec.Spec.4137M OPERATION NUMBER 615

METHOD	SINGLE PARTS HEAD SHOT	SINGLE PARTS HEAD SHOT CENTRAL CONDUCTOR	SINGLE PARTS COIL SHOT	MULTIPLE PARTS HEAD SHOT CENTRAL CONDUCTOR	MULTIPLE PARTS COIL SHOT IN BASKET	MULTIPLE PARTS AMPERES
NON-FLUORSECENT 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: _____

STAMPING

STEEL STAMP ON: Triangular stamp (△) and letter "M" circled

OTHER: Location-right side near Receiver.

ACCEPTANCE STANDARD

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 satisfactorally 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 8" Bolt

QP 0041

#C-65222356

DATE	~~MFG.~~ Rounds Fired ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS ACCEPTED	REJECTED
9-7-90	2,500	1	OK	1	
9-12-90	5,000	1	OK	1	
9-13-90	6,000	1	OK	1	
9-14-90	7,000	1	OK	1	
9-17-90	8,000	1	OK	1	
9-17-90	9,000	1	OK	1	
9-18-90	10,000	1	OK	1	