

FORM

UPC



0 47700 25716 7

C6649191

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

Remington



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

MODEL 700 TM M24

SERIAL NO.
C6649191

ORDER NO.
5716

20

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



5716 C6649191

ORDER **5716**
MODEL 700 TM M24
UPC

ORDER **5716**
MODEL 700 TM M24
UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649191

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 10 1991	KR
	Magnaflux Bolt		OCT 10 1991	KR
615	Rollmark Caliber		OCT 10 1991	GS
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/13/91	WB
620	Apply Coatings (Barrel Action)		11/2/91	PA
	Apply Coating (Bolt)		11/2/91	P
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		12/26/91	WB

op. #	BARBER MEM24 0066066	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3 $\frac{3}{4}$	4 $\frac{1}{2}$	4 $\frac{1}{2}$			12-26-91	DH
	G) Safety Off Force	2 $\frac{1}{4}$	2 $\frac{1}{4}$	2 $\frac{1}{4}$			12-26-91	DH
	H) Trigger Pull Test & Retainability						12/26/91	WB
	I) Firing Pin Indent	.021	.021	.020			12-26-91	DH
	J) Assemble Stock						12/27/91	RW
	K) Assemble Swivel Studs						12-31-91	AC
	L) Attach Front and Rear Sight Assemblies						12/27/91	RW
	M) Iron Sight Alignment						12/27/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/27/91	RW
	O) Attach Scope to Rifle						12/27/91	RW
	P) Detach & Attach Scope 20 Times						12/27/91	RW
640	Gallery Target & Test						12-31-91	AC
	A) Time						12-31-91	AC
	B) Malfunctions						12-31-91	AC
	C) Pierced Primers						12-31-91	AC
	D) Optical Clarity of Scope						12-31-91	AC
645	Inspect for Live Ammo						12-31-91	AC
655	Final Inspection						12-31-91	AC
	A) Headspace						12-31-91	AC
	B) Trigger Pull	2.55	2.52	2.45	2.48	2.40	12/21/91	WB
	C) Function						12-31-91	AC
660	Pack						2-25-92	VF

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

SERIAL NO. C6649191
DATE 12/26/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.34	2.51	2.35	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.39	2.47	2.52	
PULL #3	2.37	2.34	2.32	2.45	
PULL #4	2.36	2.27	2.35	2.48	
PULL #5	2.37	2.33	2.30	2.40	
TOTAL	11.83	11.67	11.95	12.40	
AVG.	2.37	2.33	2.39	2.48	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.23	3.28		
PULL #2	3.23	3.30		
PULL #3	3.24	3.21		
PULL #4	3.21	3.20		
PULL #5	3.14	3.21		
TOTAL	16.05	16.20		
AVG.	3.21	3.24		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.11	4.06		4.22
PULL #2	4.02	4.01		4.25
PULL #3	4.10	4.00		4.16
PULL #4	4.05	4.00		4.30
PULL #5	4.06	4.03		4.18
TOTAL	20.34	20.10		21.11
AVG.	4.07	4.02		4.22

CENTROIDAL DISTANCE CALCULATIONS
 FOR RIFLE # C6649191
 21 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.333366
1 TO 2	.170836
1 TO 3	.376175
1 TO 4	.719118
1 TO 5	.568401

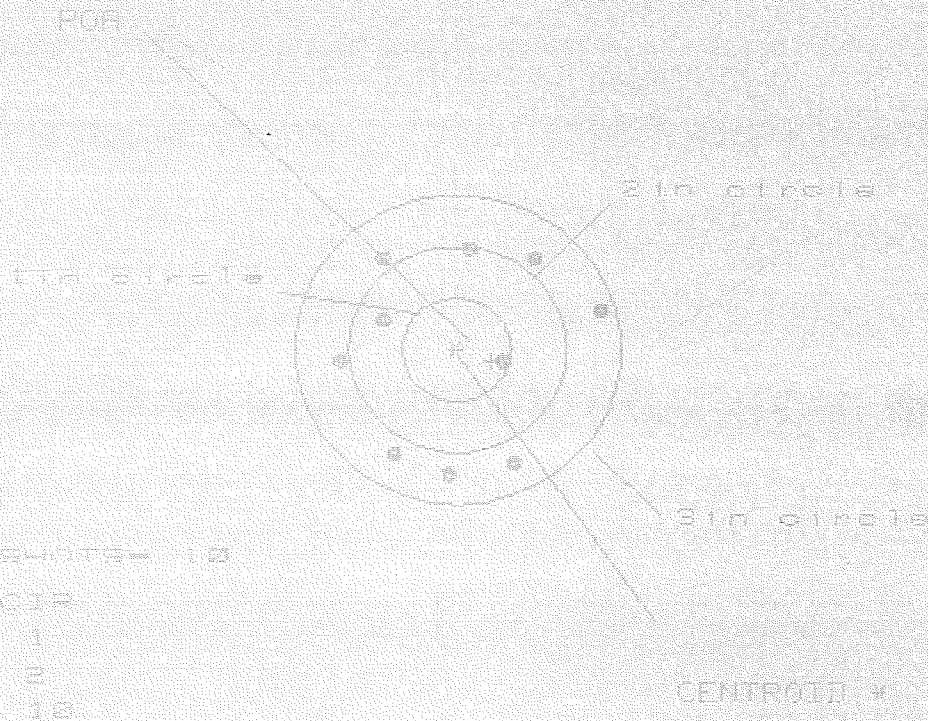
$\bar{x}_s$ $\bar{y}_s$ ——— POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.023
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1914
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .192777
 THE APR FOR THIS RIFLE IS: .4298

31 Feb 1991

FILES/PATTERNING/CENTERFIRE_PATT/06648191

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 2

3in = 7

MS = 2.400

VS = 2.194

GS = 2.444

PATTERN #	1	10	9	8
SHOTS (BEST OF)	1	10	9	8
MAXIMUM X	1.254	.853	.930	
MINIMUM X	-1.116	-.974	-.897	
MAXIMUM Y	1.026	1.067	.930	
MINIMUM Y	-1.168	-1.127	-1.264	
CENTROID X	-.320	-.462	-.539	
CENTROID Y	.113	.072	.209	
POA TO CENTROID (in)	.309	.463	.573	
MIN RADIUS	.443	.573	.492	
TEAR RADIUS	1.053	1.010	.964	
MAX RADIUS	1.038	1.292	1.275	
HORIZONTAL SPREAD	2.400	1.827	1.827	
VERTICAL SPREAD	2.194	2.194	2.194	
EXTREME SPREAD	2.444	2.339	2.639	
NUMBER IN ONE INCH CIRCLE =		1		
NUMBER IN TWO INCH CIRCLE =		2		
NUMBER IN THREE INCH CIRCLE =		7		

31 Oct 1991

FILE: PATTERNS/CENTERFIRE_PATT/06543191

CENTERFIRE PATTERNS

2

POA

2 in circle

1 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

CENTROID *

RCE = R = .466

VCE = R = .400

COE = R = .040

PATTERN #

3

SHOTS (BEST OF)	10	5	6
MAXIMUM	1.215	1.094	.915
MINIMUM	1.221	-1.342	-1.894
MAXIMUM	1.135	.936	1.027
MINIMUM	-1.206	-.681	-.650
CENTROID *	-.1284	-.163	.085
CENTROID *	.230	.423	.392
POA TO CENTROID	.309	.453	.392
MIN RADIUS	.482	.332	.463
MEAN RADIUS	.560	.858	.778
MAX RADIUS	1.586	1.384	1.175
HORIZONTAL SPREAD	2.436	2.436	2.920
VERTICAL SPREAD	2.425	1.677	1.677
EXTREME SPREAD	2.593	2.504	2.824
NUMBER IN ONE INCH CIRCLE	1	1	1
NUMBER IN TWO INCH CIRCLE	5	5	5
NUMBER IN THREE INCH CIRCLE	9	9	9

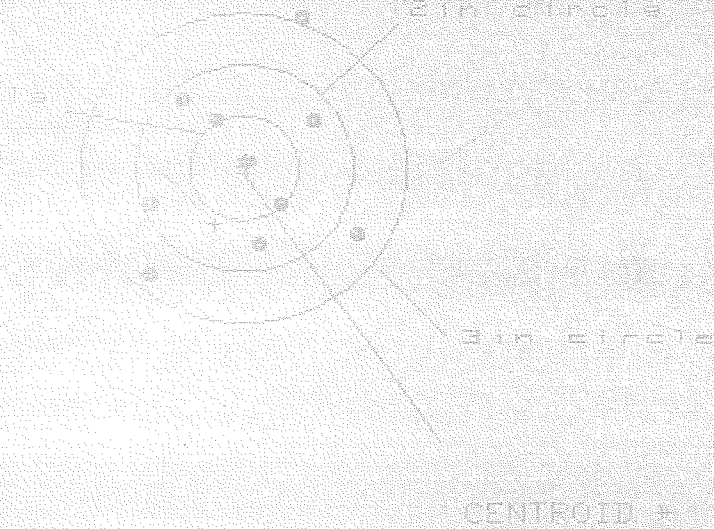
Dec 1961

FBI PATTERNS CENTER FIRE PATT/C6549101

CENTERFIRE PATTERNS

4

FOR



11

252
451
593
598
596
479
559
117
594
1,107
212
597
596

REC-131 CENTER FIRE PATT/C8849191

ENTERED PATTERNS # 5

2in circle

3in circle

CENTROID +

LOT. RAC 90J-001-010 ENDURANCE
M-24
GUN —

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C 4522292

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		6/27/90	KA
600	Proof		6/27/90	KA
607	Check Headspace		6/27/90	KA
610	Dis-assemble Gun		6/27/90	KA
612	Magnaflux Barrel Action		7/10/90	KR
	Magnaflux Bolt		7/10/90	KR
615	Rollmark Caliber		7/10/90	GL
617	Drill and Tap Sight Holes		7/11/90	EB
618	Polish Barrel RB		7/13/90	WB
620	Apply Coatings (Barrel Action)		7/23/90	TS
	Apply Coating (Bolt)			
625	Final Assembly		7/30/90	KA
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		7/30/90	KA
	C) Inspect Ejector Hole for Chamfer		7/31/90	KA
	D) Oil Firing Pin Ass'y		7/30/90	KA
	E) Adjust Trigger Pull to Min Setting and Stake		7/30/90	

8/17/90 JZC

op. #	OP. NAME	READINGS			DATE	INIT
625 cont.	F) Safety On Force	4	4	4	7/27/90	KL
	G) Safety Off Force	3	3	3	7/27/90	KL
	H) Trigger Pull Test & Retainability				8/17/90	KL
	I) Firing Pin Indent	.022	.022	.022	7/27/90	KL
	J) Assemble Stock				7/27/90	KL
	K) Assemble Swivel Studs					
	L) Attach Front and Rear Sight Assemblies				7/27/90	KL
	M) Iron Sight Alignment				7/27/90	KL
	N) Detach Front & Rear Sights & place in numbered container				7/27/90	KL
	O) Attach Scope to Rifle				7/27/90	KL
	P) Detach & Attach Scope 20 Times				7/27/90	KL
640	Gallery Target & Test				8-2-90	AC
	A) Time				8-2-90	AC
	B) Malfunctions				8-2-90	AC
	C) Pierced Primers				8-2-90	AC
	D) Optical Clarity of Scope				8-2-90	AC
645	Inspect for Live Ammo				8-2-90	AC
655	Final Inspection					
	A) Headspace					
	B) Trigger Pull					
	C) Function					
660	Pack					

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C65 22292DATE 8/17/90TESTER JU

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.25	2.29	2.30	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.46	2.28	2.27	2.29	
PULL #3	2.36	2.29	2.28	2.36	
PULL #4	2.30	2.30	2.29	2.34	
PULL #5	2.27	2.30	2.36	2.28	
TOTAL	11.64	11.46	11.60	11.61	
AVG.	2.328	2.292	2.3	2.322	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.33		
PULL #2	3.42	3.43		
PULL #3	3.41	3.41		
PULL #4	3.40	3.37		
PULL #5	3.34	3.33		
TOTAL	17.03	16.87		
AVG.	3.406	3.374		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.25	4.20		4.33
PULL #2	4.26	4.25		4.37
PULL #3	4.28	4.24		4.30
PULL #4	4.21	4.28		4.40
PULL #5	4.34	4.34		4.35
TOTAL	21.34	21.31		21.79
AVG.	4.268	4.262		4.358

SERIAL NO. 6523292 SHOOTER DA DATE 8-20-90

[illegible]

SWS ENDURANCE TEST REPORT

SERIAL NO. C65 22292 SHOOTER HK DATE 8-24-60

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
7.62	60	OK	FF	NONE
"	60	"	FF	"
"	60	"	FF	"
"	60	"	FF	"
"	60	"	FF	"
"	60	"	FF	"
360 Total				
2500 Magna 44				

2600 Total

SERIAL NO. C6522292 SHOOTER TK DATE 8-29-90

[illegible]

SERIAL NO CL522292 SHOOTER TF DATE 8-25-80

[illegible]

SWS ENDURANCE TEST REPORT

SERIAL NO. C6522292 SHOOTER TUE DATE 8-28-90

560	Total
-----	-------

ed t-540

Sheet 12 of 12

SWS ENDURANCE TEST REPORT

SERIAL NO. C6527792 SHOOTER EA DATE 7-4-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60 3	OK	NONE
		60 6	OK	NONE
		60 9	OK	NONE
		60 12	OK	NONE
		60 15	OK	NONE
		60 18	OK	NONE
		60 21	OK	NONE
		60 24	OK	NONE
		60 27	OK	NONE
		60 30	OK	NONE
		60 33	OK	NONE
		60 36	OK	NONE
		60 39	OK	NONE
		60 42	OK	NONE
		60 45	OK	NONE
		60 48	OK	NONE
		80 50	OK	NONE
		1000		
		5000		
		6000		

SWS ENDURANCE TEST REPORT

SERIAL NO. 0152292 SHOOTER EA DATE 9-5-90

[illegible]

SWS ENDURANCE TEST REPORT

SERIAL NO. CL522292 SHOOTER RS DATE 9-8-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
	7.62	30	OIL RS	NONE
		660		

SWS ENDURANCE TEST REPORT

SERIAL NO. CL522282 SHOOTER RH TF DATE 9-16-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	RH	NONE
7.62	60	OK	TF	NONE
7.62	60	OK	TF	NONE
	1000			
	8000			
	9000	Total		

0-Rounds

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522292
2 Aug 1990

CENTROIDAL DISTANCES

0 TO	1	.679213
1 TO	2	.865491
1 TO	3	1.03489
1 TO	4	.733894
1 TO	5	1.07084

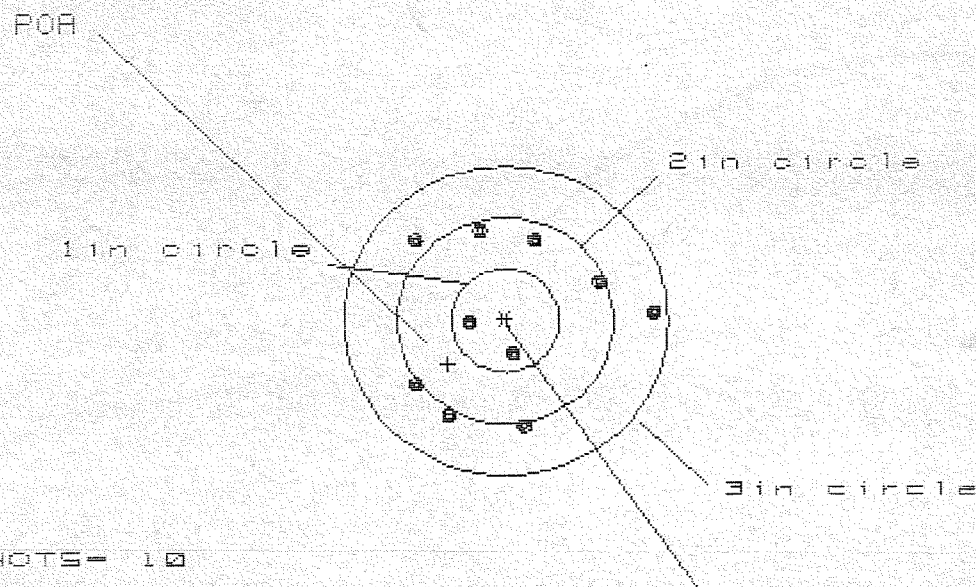
1
3/4 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0034
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0814
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .081471
THE AMP FOR THIS RIFLE IS: .799

2 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522292

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 10

HS= 2.224

VS= 1.954

GS= 2.315

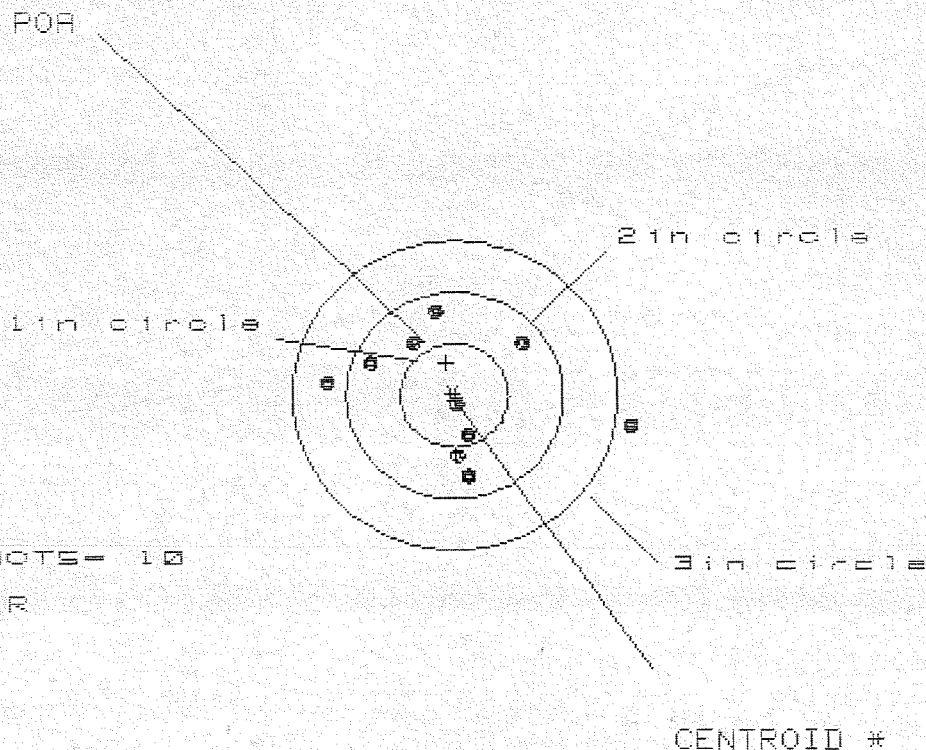
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.364	.982	.894
MINIMUM X	-.860	-.709	-.726
MAXIMUM Y	.897	.910	1.006
MINIMUM Y	-1.057	-1.044	-.948
CENTROID X	.533	.382	.471
CENTROID Y	.421	.408	.312
POA TO CENTROID in.	.679	.559	.565
MIN RADIUS	.325	.173	.250
MEAN RADIUS	.899	.825	.791
MAX RADIUS	1.368	1.098	1.039
HORIZONTAL SPREAD	2.224	1.691	1.619
VERTICAL SPREAD	1.954	1.954	1.954
EXTREME SPREAD	2.315	2.093	1.993
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

2 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522292

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 8

3 in = 9

HS= 2.776

VS= 1.634

GS= 2.799

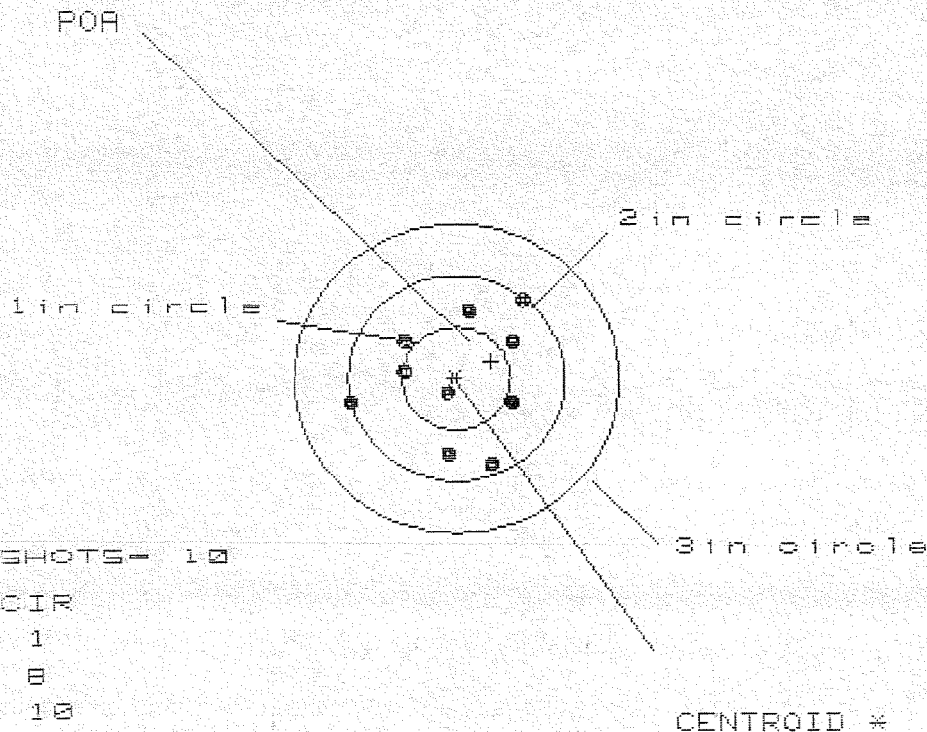
CENTROID #

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.587	.832	.706
MINIMUM X	-1.189	-1.013	-.700
MAXIMUM Y	.821	.790	.796
MINIMUM Y	-.813	-.844	-.838
CENTROID X	.076	-.100	.027
CENTROID Y	-.314	-.283	-.289
POA TO CENTROID in.	.323	.300	.290
MIN RADIUS	.093	.221	.131
MEAN RADIUS	.785	.691	.634
MAX RADIUS	1.611	1.014	.850
HORIZONTAL SPREAD	2.776	1.845	1.405
VERTICAL SPREAD	1.634	1.634	1.634
EXTREME SPREAD	2.799	1.892	1.660
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

2 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8522292

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS = 1.619

VS = 1.579

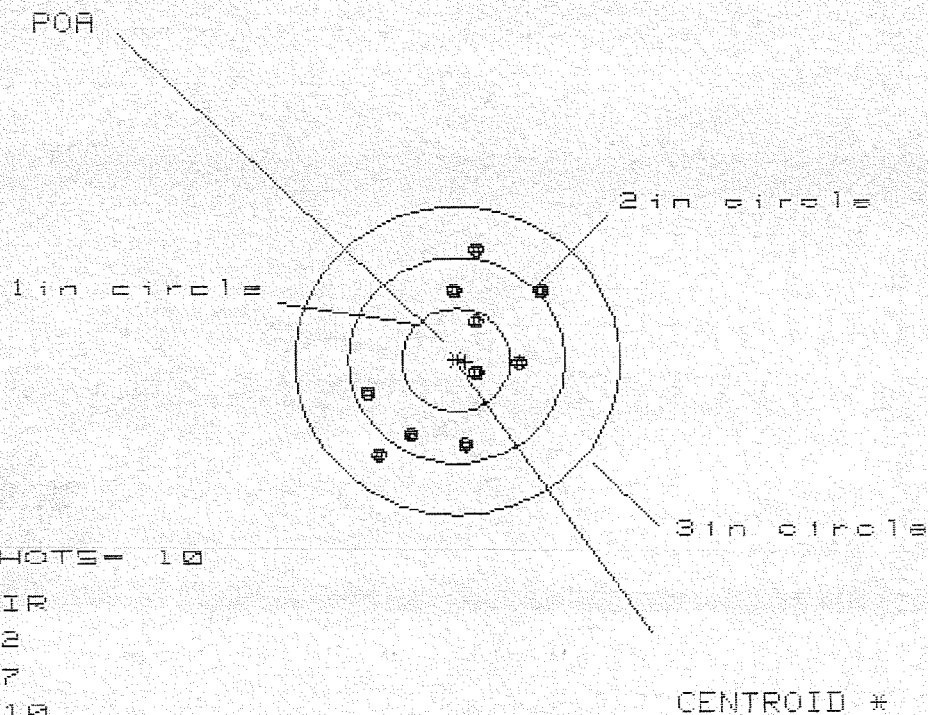
GS = 1.931

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.655	.615	.504
MINIMUM X	-.964	-.892	-.564
MAXIMUM Y	.776	.739	.716
MINIMUM Y	-.803	-.717	-.740
CENTROID X	-.320	-.392	-.281
CENTROID Y	-.165	-.251	-.228
POA TO CENTROID in.	.360	.466	.361
MIN RADIUS	.167	.074	.134
MEAN RADIUS	.684	.633	.597
MAX RADIUS	1.015	.912	.802
HORIZONTAL SPREAD	1.619	1.507	1.068
VERTICAL SPREAD	1.579	1.456	1.456
EXTREME SPREAD	1.931	1.626	1.475
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	10	

2 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/08522292

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.591

VS= 1.982

GS= 2.212

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.777	.692	.764
MINIMUM X	:	-.814	-.899	-.887
MAXIMUM Y	:	1.091	.992	.743
MINIMUM Y	:	-.891	-.948	-.824
CENTROID X	:	-.081	.005	-.007
CENTROID Y	:	.019	.118	-.006
POA TO CENTROID in.	:	.083	.118	.009
MIN RADIUS	:	.222	.229	.146
MEAN RADIUS	:	.784	.720	.681
MAX RADIUS	:	1.176	.996	1.005
HORIZONTAL SPREAD	:	1.591	1.591	1.591
VERTICAL SPREAD	:	1.982	1.940	1.567
EXTREME SPREAD	:	2.212	1.941	1.889
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			10	

2 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522292

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS = 2.408

VS = 1.348

GS = 2.475

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.211	1.087	.922
MINIMUM X	:	-1.197	-1.321	-1.071
MAXIMUM Y	:	.682	.514	.471
MINIMUM Y	:	-.666	-.590	-.633
CENTROID X	:	-.191	-.067	.098
CENTROID Y	:	-.368	-.444	-.401
POA TO CENTROID in.	:	.415	.449	.412
MIN RADIUS	:	.272	.134	.066
MEAN RADIUS	:	.843	.768	.673
MAX RADIUS	:	1.305	1.366	1.130
HORIZONTAL SPREAD	:	2.408	2.408	1.993
VERTICAL SPREAD	:	1.348	1.104	1.104
EXTREME SPREAD	:	2.475	2.475	2.001
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522292 2TARGET
21 Aug 1990

500 Rounds

CENTROIDAL DISTANCES

Ø TO	1	.929174
1 TO	2	.178443
1 TO	3	.324347
1 TO	4	1.19464
1 TO	5	.66188

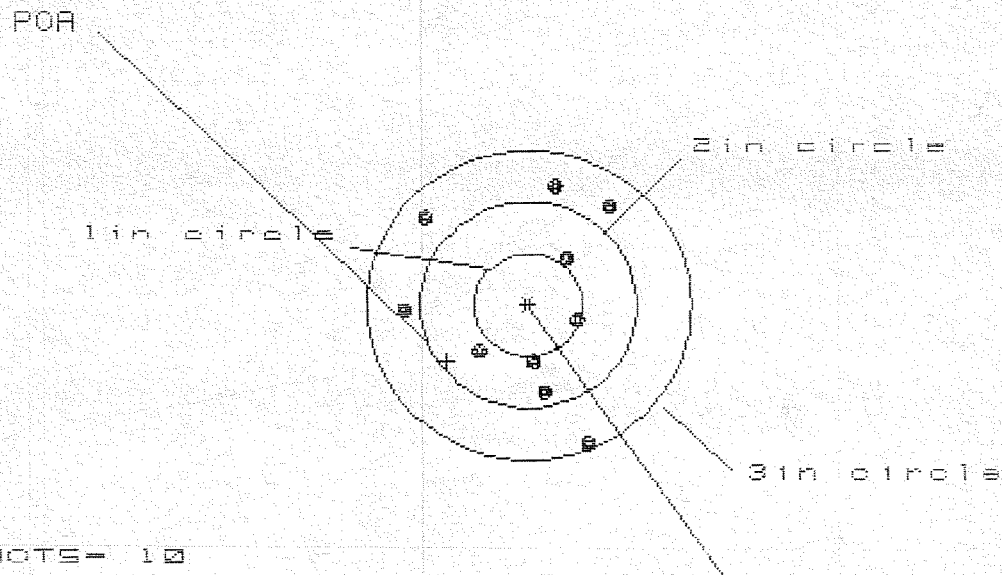
8
5
4
+
4
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .5294
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2328
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .578325
THE AMR FOR THIS RIFLE IS: .8662

21 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522292.1

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 1.937

VS = 2.496

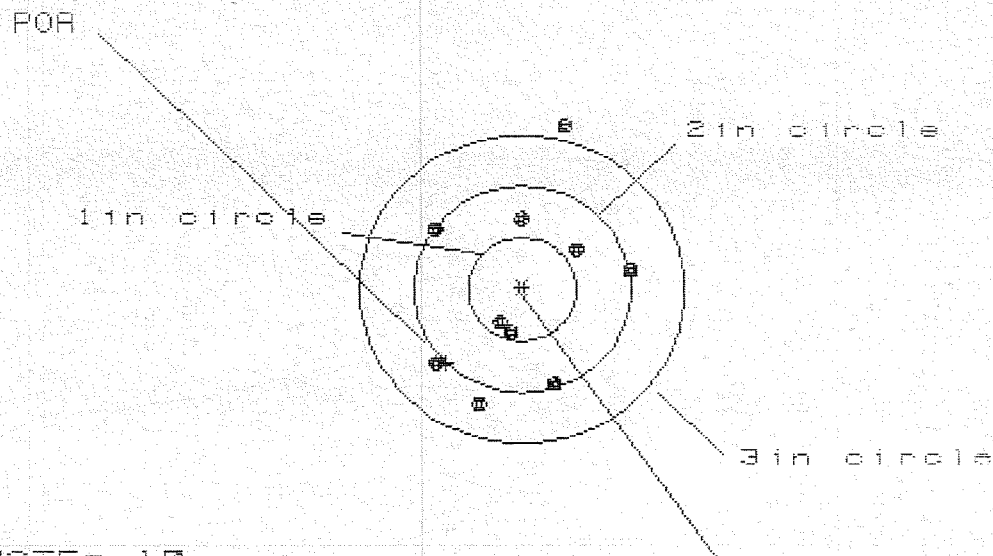
GS = 2.656

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.771	.836	.730
MINIMUM X	-1.166	-1.101	-1.207
MAXIMUM Y	1.170	1.022	1.112
MINIMUM Y	-1.327	-.984	-.894
CENTROID X	.754	.689	.795
CENTROID Y	.543	.691	.601
POA TO CENTROID in.	.929	.976	.997
MIN RADIUS	.480	.455	.441
MEAN RADIUS	.927	.877	.821
MAX RADIUS	1.450	1.142	1.214
HORIZONTAL SPREAD	1.937	1.937	1.937
VERTICAL SPREAD	2.496	2.006	2.006
EXTREME SPREAD	2.656	2.177	2.177
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

21 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522292.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 9

HS = 1.891

VS = 2.619

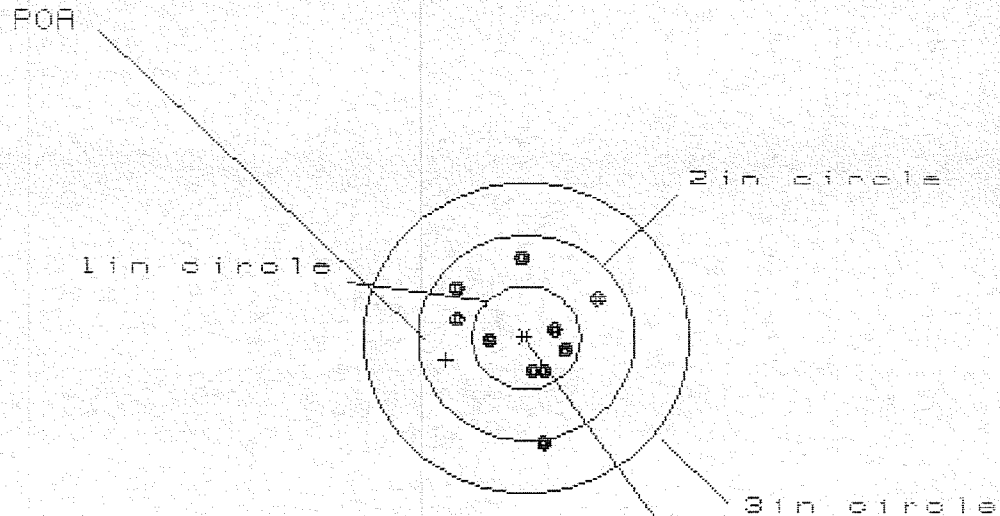
GS = 2.745

PATTERN #	:	2	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.043	1.092	1.050
MINIMUM X	:	-.848	-.799	-.841
MAXIMUM Y	:	1.545	.868	.755
MINIMUM Y	:	-1.074	-.902	-.874
CENTROID X	:	.703	.654	.696
CENTROID Y	:	.714	.542	.655
POA TO CENTROID in.	:	1.002	.849	.955
MIN RADIUS	:	.310	.144	.256
MEAN RADIUS	:	.888	.772	.759
MAX RADIUS	:	1.607	1.144	1.075
HORIZONTAL SPREAD	:	1.891	1.891	1.891
VERTICAL SPREAD	:	2.619	1.770	1.629
EXTREME SPREAD	:	2.745	2.072	2.072
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	6		
NUMBER IN THREE INCH CIRCLE =	:	9		

21 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522292.1

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 5

2 in = 9

3 in = 10

HS = 1.291

VS = 1.828

CS = 1.839

CENTROID #

PATTERN #	3	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.651	.668	.590
MINIMUM X	-.640	-.623	-.684
MAXIMUM Y	.763	.644	.689
MINIMUM Y	-1.065	-.427	-.382
CENTROID X	.739	.722	.800
CENTROID Y	.219	.338	.293
POA TO CENTROID in.	.770	.797	.852
MIN RADIUS	.250	.232	.163
MEAN RADIUS	.565	.514	.469
MAX RADIUS	1.076	.719	.699
HORIZONTAL SPREAD	1.291	1.291	1.274
VERTICAL SPREAD	1.828	1.071	1.071
EXTREME SPREAD	1.839	1.299	1.284
NUMBER IN ONE INCH CIRCLE =		5	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

21 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522292.1

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.262

VS= 3.058

GS= 3.066

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.044	1.010	.996
MINIMUM X	-1.218	-1.252	-1.266
MAXIMUM Y	1.261	1.062	1.028
MINIMUM Y	-1.797	-.726	-.593
CENTROID X	.288	.322	.336
CENTROID Y	-.557	-.358	-.491
POA TO CENTROID in.	.628	.481	.595
MIN RADIUS	.347	.546	.415
MEAN RADIUS	.980	.883	.843
MAX RADIUS	1.822	1.328	1.303
HORIZONTAL SPREAD	2.262	2.262	2.262
VERTICAL SPREAD	3.058	1.788	1.621
EXTREME SPREAD	3.066	2.336	2.336
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

21 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522292.1

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

OF SHOTS = 10

IN CIR

1in = 0

2in = 7

3in = 9

HS = 2.511

VS = 2.279

GS = 2.596

CENTROID #

PATTERN #	:	5	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.464	.991	1.050
MINIMUM X	:	-1.047	-.884	-.825
MAXIMUM Y	:	.817	.776	.589
MINIMUM Y	:	-1.462	-1.503	-1.047
CENTROID X	:	.163	.000	-.060
CENTROID Y	:	.245	.286	.473
POA TO CENTROID in.	:	.295	.286	.477
MIN RADIUS	:	.569	.403	.375
MEAN RADIUS	:	.971	.881	.753
MAX RADIUS	:	1.508	1.577	1.071
HORIZONTAL SPREAD	:	2.511	1.875	1.875
VERTICAL SPREAD	:	2.279	2.279	1.636
EXTREME SPREAD	:	2.596	2.413	1.880
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522292
30 Aug 1990

4500 Rounds

CENTROIDAL DISTANCES

0 TO	1	.587804
1 TO	2	.31197
1 TO	3	.345303
1 TO	4	.415909
1 TO	5	.426058

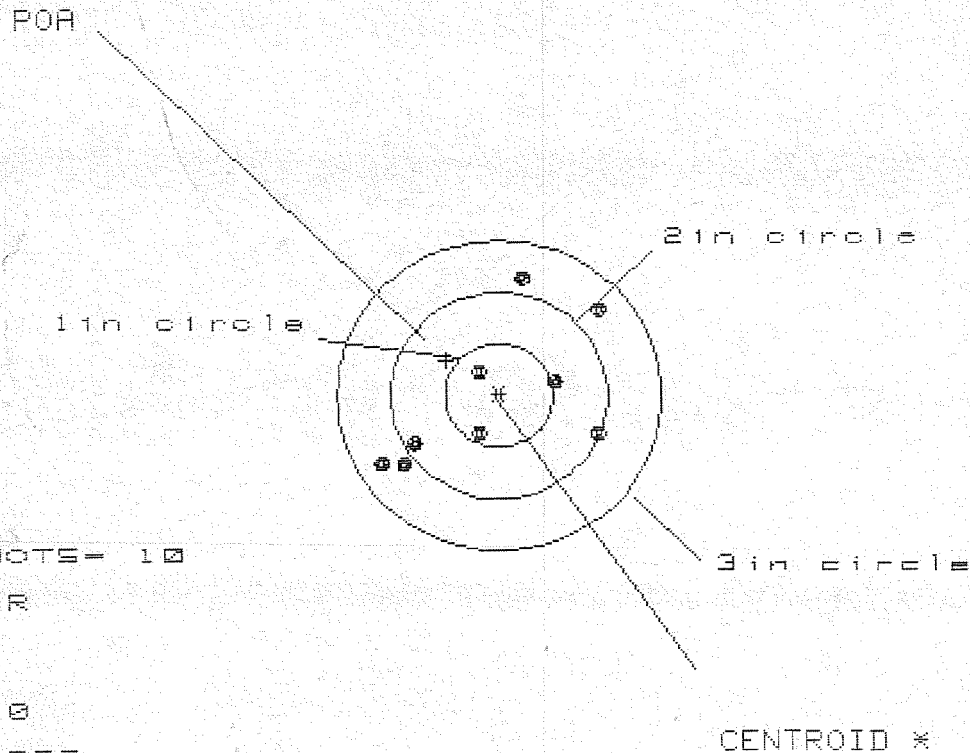
+ $\frac{5}{34}$ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .7308
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.3068
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .792587
THE AMR FOR THIS RIFLE IS: .6546

30 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522292.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 10

HS= 1.987

VS= 1.794

GS= 2.511

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.920	.802	.855
MINIMUM X	-1.067	-1.042	-.942
MAXIMUM Y	1.108	1.031	1.128
MINIMUM Y	-.686	-.731	-.634
CENTROID X	.483	.602	.502
CENTROID Y	-.335	-.258	-.355
POA TO CENTROID in.	.588	.655	.615
MIN RADIUS	.330	.373	.351
MEAN RADIUS	.850	.790	.747
MAX RADIUS	1.268	1.273	1.142
HORIZONTAL SPREAD	1.987	1.844	1.797
VERTICAL SPREAD	1.794	1.762	1.762
EXTREME SPREAD	2.511	2.379	2.087
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

30 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522292.1.1

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 8

2 in = 10

3 in = 10

HS= 1.013

VS= 1.043

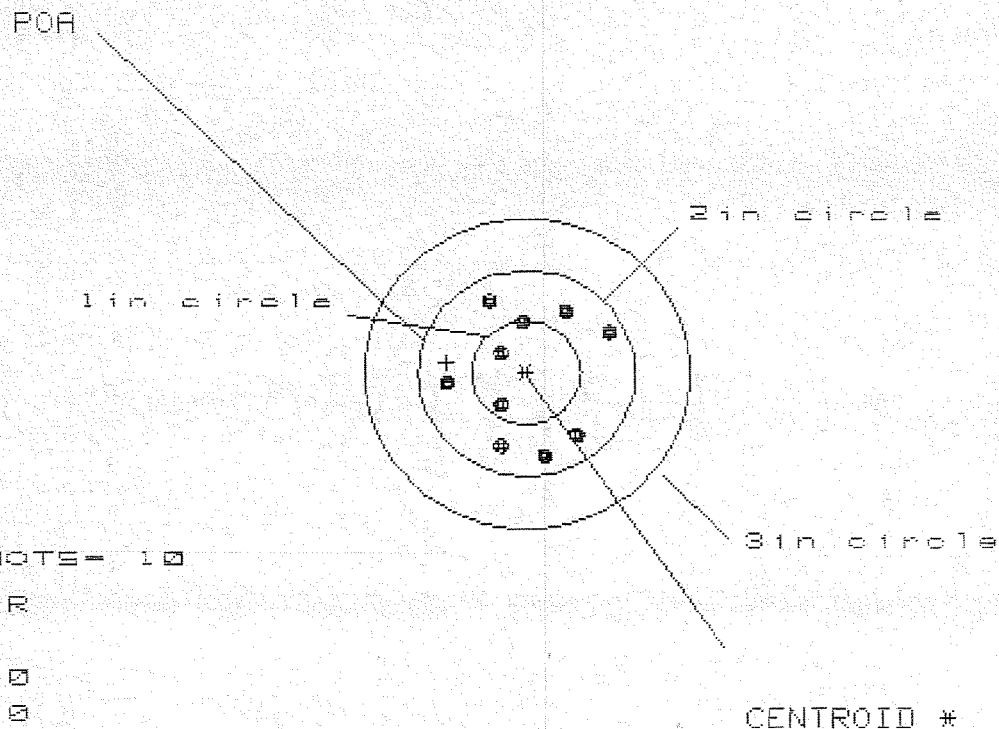
CS= 1.265

PATTERN #	:	2
SHOTS (BEST OF)	:	10
MAXIMUM X	:	.508
MINIMUM X	:	-.505
MAXIMUM Y	:	.388
MINIMUM Y	:	-.655
CENTROID X	:	.752
CENTROID Y	:	-.493
POA TO CENTROID in.	:	.899
MIN RADIUS	:	.075
MEAN RADIUS	:	.386
MAX RADIUS	:	.827
HORIZONTAL SPREAD	:	1.013
VERTICAL SPREAD	:	1.043
EXTREME SPREAD	:	1.265
NUMBER IN ONE INCH CIRCLE	=	8
NUMBER IN TWO INCH CIRCLE	=	10
NUMBER IN THREE INCH CIRCLE	=	10

30 Aug 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6522292.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 10

3 in = 10

HS= 1.432

VS= 1.503

CS= 1.574

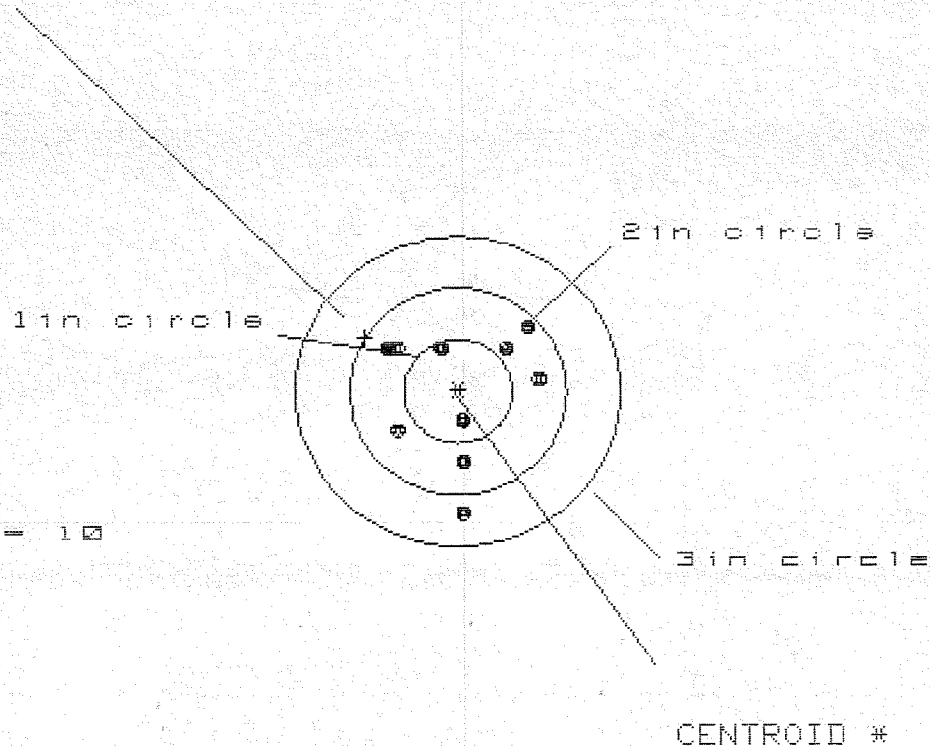
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.734	.557	.587
MINIMUM X	:	-.698	-.617	-.587
MAXIMUM Y	:	.725	.774	.683
MINIMUM Y	:	-.778	-.729	-.718
CENTROID X	:	.736	.655	.625
CENTROID Y	:	-.100	-.149	-.058
POA TO CENTROID in.	:	.743	.671	.628
MIN RADIUS	:	.316	.283	.209
MEAN RADIUS	:	.644	.608	.576
MAX RADIUS	:	.857	.808	.860
HORIZONTAL SPREAD	:	1.432	1.174	1.174
VERTICAL SPREAD	:	1.503	1.503	1.401
EXTREME SPREAD	:	1.574	1.574	1.530
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			10	
NUMBER IN THREE INCH CIRCLE =			10	

30 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/G6522292.1.1

CENTERFIRE PATTERNS # 4

POB



OF SHOTS= 10

IN CIR

1in = 2

2in = 9

3in = 10

HS= 1.406

VS= 1.857

GS= 1.930

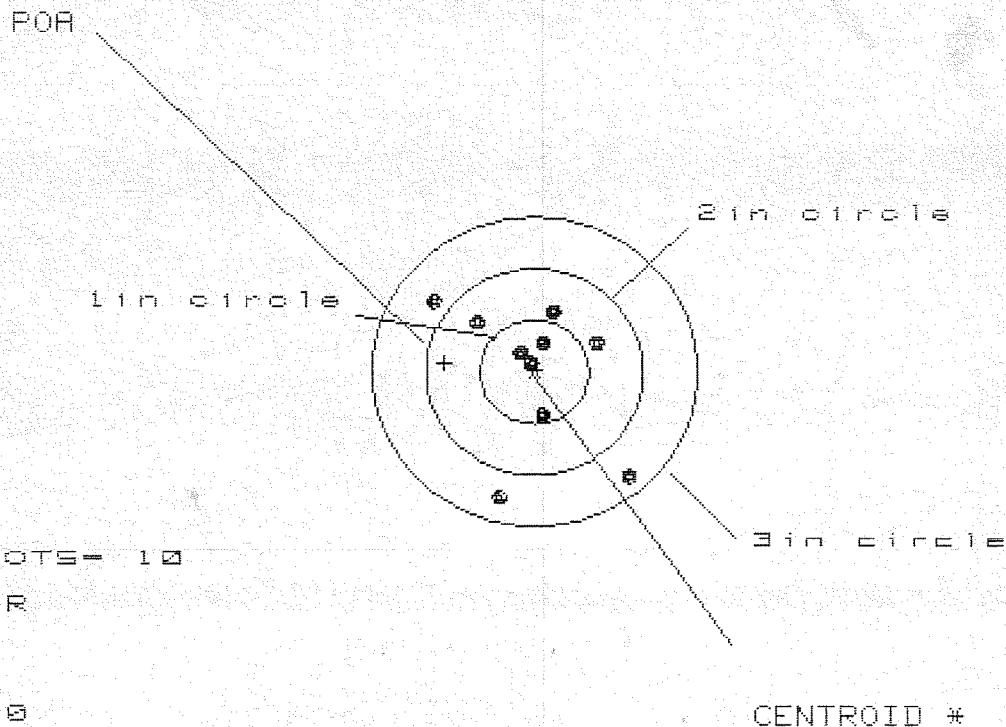
CENTROID *

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.720	.730	.809
MINIMUM X	-.686	-.676	-.597
MAXIMUM Y	.641	.506	.382
MINIMUM Y	-1.216	-.783	-.720
CENTROID X	.855	.845	.766
CENTROID Y	-.521	-.386	-.449
POB TO CENTROID in.	1.001	.929	.888
MIN RADIUS	.282	.366	.382
MEAN RADIUS	.715	.648	.622
MAX RADIUS	1.220	.808	.813
HORIZONTAL SPREAD	1.406	1.406	1.406
VERTICAL SPREAD	1.857	1.289	1.102
EXTREME SPREAD	1.930	1.613	1.438
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

30 Aug 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8522292.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS = 1.878

VS = 1.871

GS = 2.548

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.920	.722	.698
MINIMUM X	-.958	-.856	-.880
MAXIMUM Y	.699	.585	.424
MINIMUM Y	-1.172	-1.286	-.678
CENTROID X	.828	.726	.750
CENTROID Y	-.085	.029	.190
POA TO CENTROID in.	.833	.727	.774
MIN RADIUS	.116	.044	.119
MEAN RADIUS	.678	.570	.468
MAX RADIUS	1.376	1.301	.977
HORIZONTAL SPREAD	1.878	1.578	1.578
VERTICAL SPREAD	1.871	1.871	1.102
EXTREME SPREAD	2.548	1.985	1.623
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

5000 Rounds

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6522292
1 Sep 1990

CENTROIDAL DISTANCES

0 TO 1	1.0094
1 TO 2	.816863
1 TO 3	.592041
1 TO 4	.915551
1 TO 5	.486576

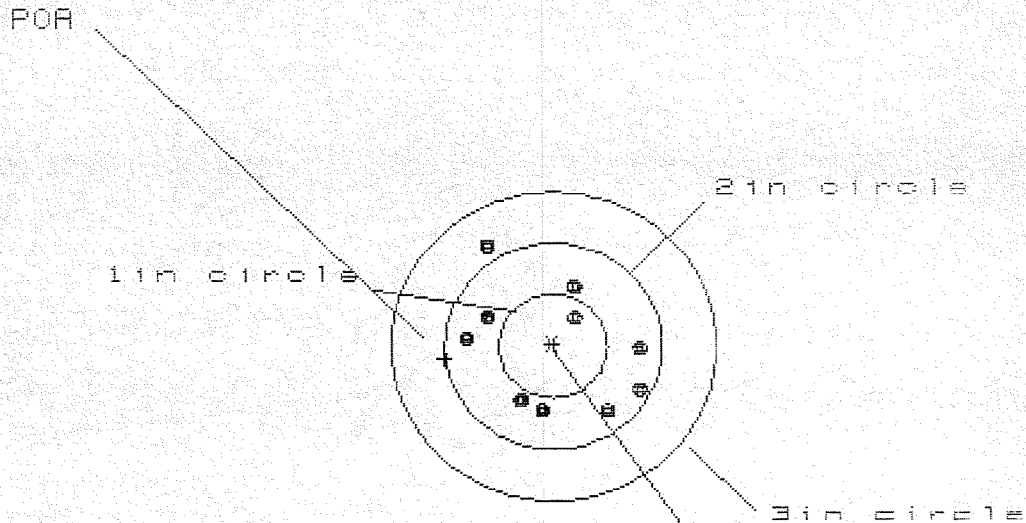
+^F_E L <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .4848
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0112
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .484929
THE AMR FOR THIS RIFLE IS: .8236

1 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C8522282.1.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 1.609

VS= 1.621

GS= 1.944

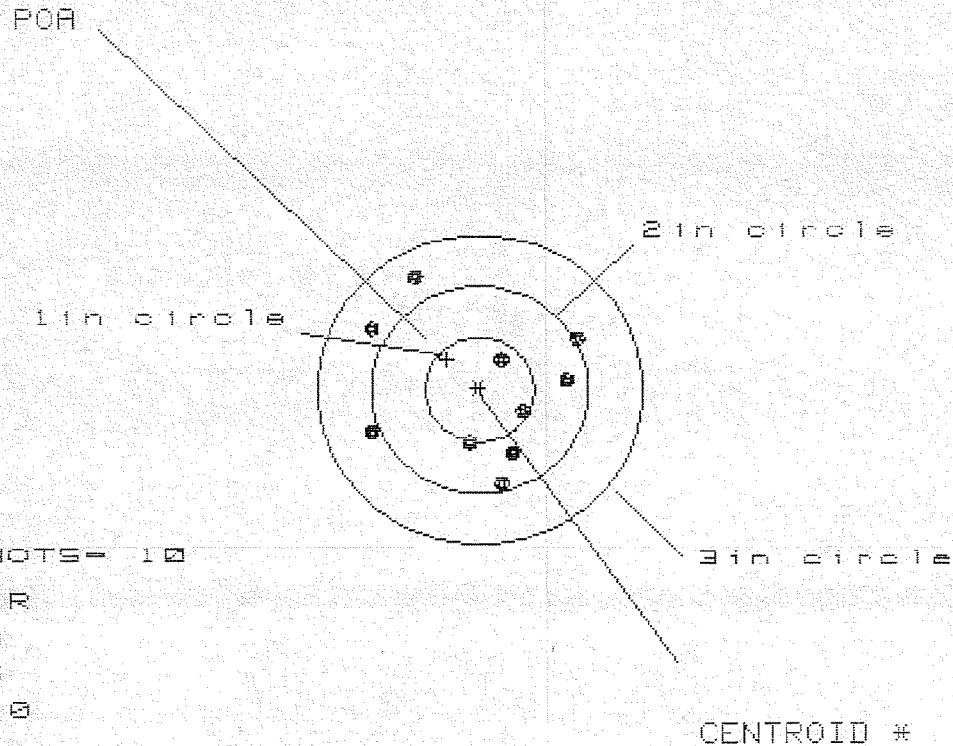
CENTROID #

PATTERN #	1	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.791	.719	.805
MINIMUM X	-.818	-.890	-.804
MAXIMUM Y	.954	.661	.626
MINIMUM Y	-.667	-.561	-.596
CENTROID X	1.002	1.074	.988
CENTROID Y	.122	.016	.051
POA TO CENTROID in.	1.009	1.074	.990
MIN RADIUS	.360	.435	.430
MEAN RADIUS	.730	.674	.661
MAX RADIUS	1.155	.912	.821
HORIZONTAL SPREAD	1.609	1.609	1.609
VERTICAL SPREAD	1.621	1.222	1.222
EXTREME SPREAD	1.944	1.647	1.613
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

1 Sep 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C6522292.1.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 1.930

VS= 1.947

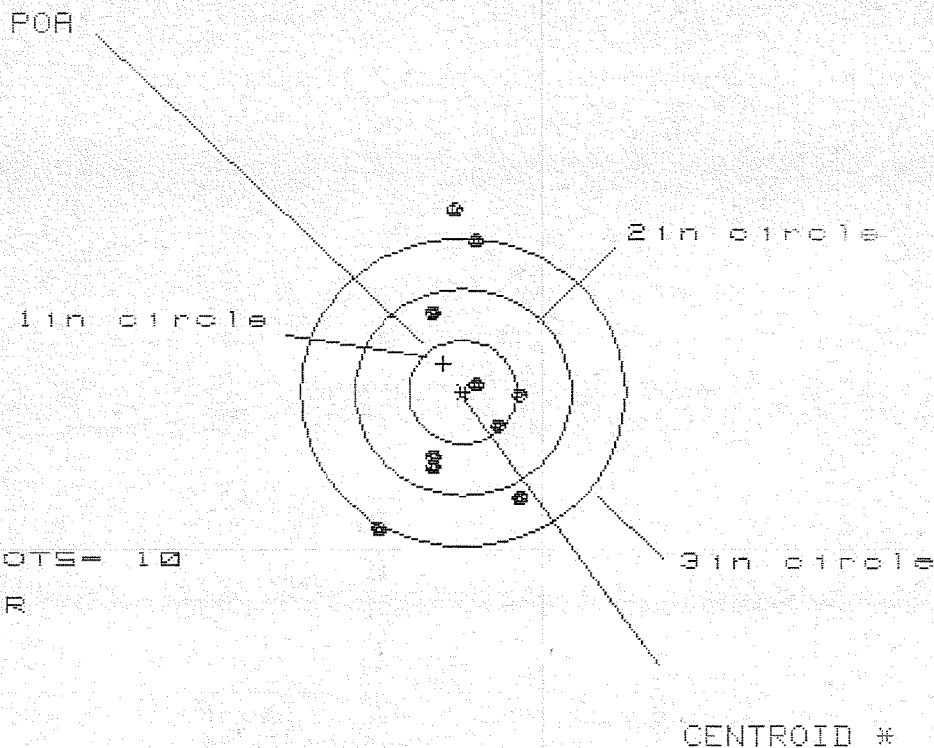
GS= 2.152

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.885	.822	.689
MINIMUM X	:	-1.045	-1.108	-1.241
MAXIMUM Y	:	1.061	.709	.705
MINIMUM Y	:	-.886	-.768	-.680
CENTROID X	:	.299	.362	.495
CENTROID Y	:	-.294	-.412	-.500
POA TO CENTROID in.	:	.419	.549	.704
MIN RADIUS	:	.358	.310	.166
MEAN RADIUS	:	.810	.737	.630
MAX RADIUS	:	1.205	1.273	1.265
HORIZONTAL SPREAD	:	1.930	1.930	1.930
VERTICAL SPREAD	:	1.947	1.477	1.385
EXTREME SPREAD	:	2.152	2.152	2.152
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

1 Sep 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8522292.1 1.1

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 6

3 in = 8

HS = 1.250

VS = 3.124

GS = 3.183

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.522
MINIMUM X	-.728
MAXIMUM Y	1.760
MINIMUM Y	-1.364
CENTROID X	.177
CENTROID Y	-.275
POA TO CENTROID in.	.326
MIN RADIUS	.201
MEAN RADIUS	.949
MAX RADIUS	1.764
HORIZONTAL SPREAD	1.250
VERTICAL SPREAD	3.124
EXTREME SPREAD	3.183
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	8

1 Sep 1938

FILE:/PATTERNING/CENTERFIRE_PATT/C3522292.1.1.1

CENTERFIRE PATTERNS # 5

POB

1in circle

2in circle

3in circle

OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.338

VS= 1.812

GS= 2.708

CENTROID *

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.209
MINIMUM X	-1.129
MAXIMUM Y	.995
MINIMUM Y	-.817
CENTROID X	.536
CENTROID Y	.262
POB TO CENTROID in.	.597
MIN RADIUS	.355
MEAN RADIUS	.843
MAX RADIUS	1.367
HORIZONTAL SPREAD	2.338
VERTICAL SPREAD	1.812
EXTREME SPREAD	2.708
NUMBER IN ONE INCH CIRCLE	3
NUMBER IN TWO INCH CIRCLE	6
NUMBER IN THREE INCH CIRCLE	10

QP 0041

8/24/90

Endurance B/A # B-6522292

MAGNETIC PARTICLE INSPECTION

PART NUMBER _____

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

OPERATION NUMBER 615

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

NON-FLUORESCENT
CONTINUOUS WET

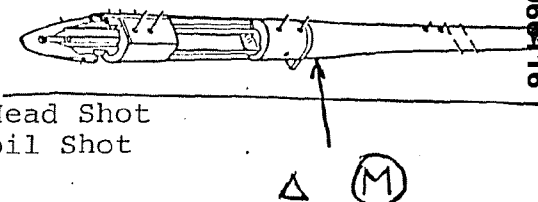
FLUORESCENT
CONTINUOUS WET Yes Yes (2 Overlapping)

NON-FLUORESCENT
RESIDUAL WET

FLUORESCENT
RESIDUAL WET

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

SKETCH AND/OR REMARKS



APPROVAL:

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

ACCEPTANCE STANDARD

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

OTHER Location-right side near Receiver.

PROCEDURE:

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

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

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

ALL BLOCKS MUST BE PROPERLY FILLED IN.

LEV III. _____
INSP. _____

QP 0041

Rounds

MEG.

DATE	ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS ACCEPTED	REJECTED
8-24-90	2,500	OK		1	
9-4-90	5,000	OK		1	
9-5-90	6,000	OK		1	
9-6-90	7,000	OK		1	
9-10-90	8,000	OK		1	
9-12-90	9,000	OK		1	
9-13-90	10,000	OK		1	