

FORM

UPC



0 47700 25716 7

C664919Z

MODEL 700 TM M24

ORDER NO. 5716

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.

C6649192

ORDER NO.

5716

20

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



5716 C6649192

ORDER 5716

MODEL 700 TM M24

UPC



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ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649192

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		GL
617	Drill and Tap Sight Holes	OCT 1 0 1991		LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/2-01	DA
	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		12/26/91	WB

Op. #	BARBER M24 0066122	READINGS						
625 cont.	F) Safety On Force	4	4	4	12-27-91	AC		
	G) Safety Off Force	3	3	4	12-27-91	AC		
	H) Trigger Pull Test & Retainability				12/26/91	WB		
	I) Firing Pin Indent	.021	.021	.020	12-27-91	AC		
	J) Assemble Stock				12/27/91	RW		
	K) Assemble Swivel Studs				12-30-91	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				12-30-91	A		
	A) Time				12-30-91	A		
	B) Malfunctions				12-30-91	A		
	C) Pierced Primers				12-30-91	A		
	D) Optical Clarity of Scope				12-30-91	A		
645	Inspect for Live Ammo				12-30-91	A		
655	Final Inspection							
	A) Headspace				12-30-91	AC		
	B) Trigger Pull	2.49	2.48	2.40	2.39	2.36	12/30/91	WB
	C) Function				12-30-91	A		
660	Pack				12-25-92	VF		

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649192
DATE 12/26/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.59	2.57	2.49	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.51	2.56	2.48	
PULL #3	2.43	2.51	2.56	2.40	
PULL #4	2.25	2.33	2.55	2.39	
PULL #5	2.45	2.53	2.57	2.36	
TOTAL	12.03	12.47	12.81	12.12	
AVG.	2.41	2.49	2.56	2.42	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.16	3.09		
PULL #2	3.15	3.24		
PULL #3	3.07	3.24		
PULL #4	3.19	3.25		
PULL #5	3.03	3.21		
TOTAL	15.60	16.03		
AVG.	3.12	3.21		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.12	4.11		4.11
PULL #2	4.00	4.05		4.09
PULL #3	4.00	4.11		4.08
PULL #4	4.10	4.12		4.15
PULL #5	4.08	4.10		4.09
TOTAL	20.30	20.49		20.52
AVG.	4.06	4.10		4.10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649192
30 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.1236
1 TO 2	.070406
1 TO 3	.578955
1 TO 4	.391944
1 TO 5	.497534

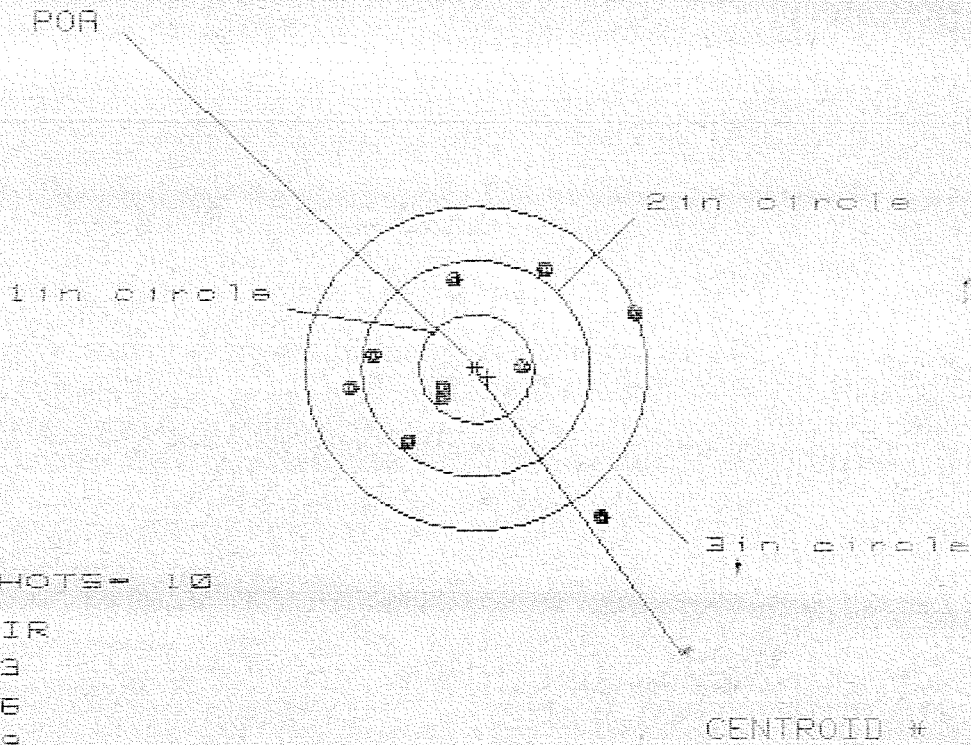
44 <----FOR
35

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1248
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0958
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .15733
THE AMR FOR THIS RIFLE IS: .9306

30 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649192

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 6

3in = 9

HS= 2.422

VS= 2.300

GS= 2.573

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.353	1.477	.872
MINIMUM X	-1.069	-.945	-.761
MAXIMUM Y	.954	.805	.852
MINIMUM Y	-1.346	-.793	-.746
CENTROID X	-.099	-.223	-.407
CENTROID Y	.074	.223	.176
POA TO CENTROID in.	.124	.315	.444
MIN RADIUS	.328	.332	.233
MEAN RADIUS	.929	.820	.693
MAX RADIUS	1.746	1.524	1.219
HORIZONTAL SPREAD	2.422	2.422	1.633
VERTICAL SPREAD	2.300	1.598	1.598
EXTREME SPREAD	2.573	2.531	2.006
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

30 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649192

CENTERFIRE PATTERNS # 2

POB

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 4

2in = 8

3in = 9

HS= 2.673

VS= 1.931

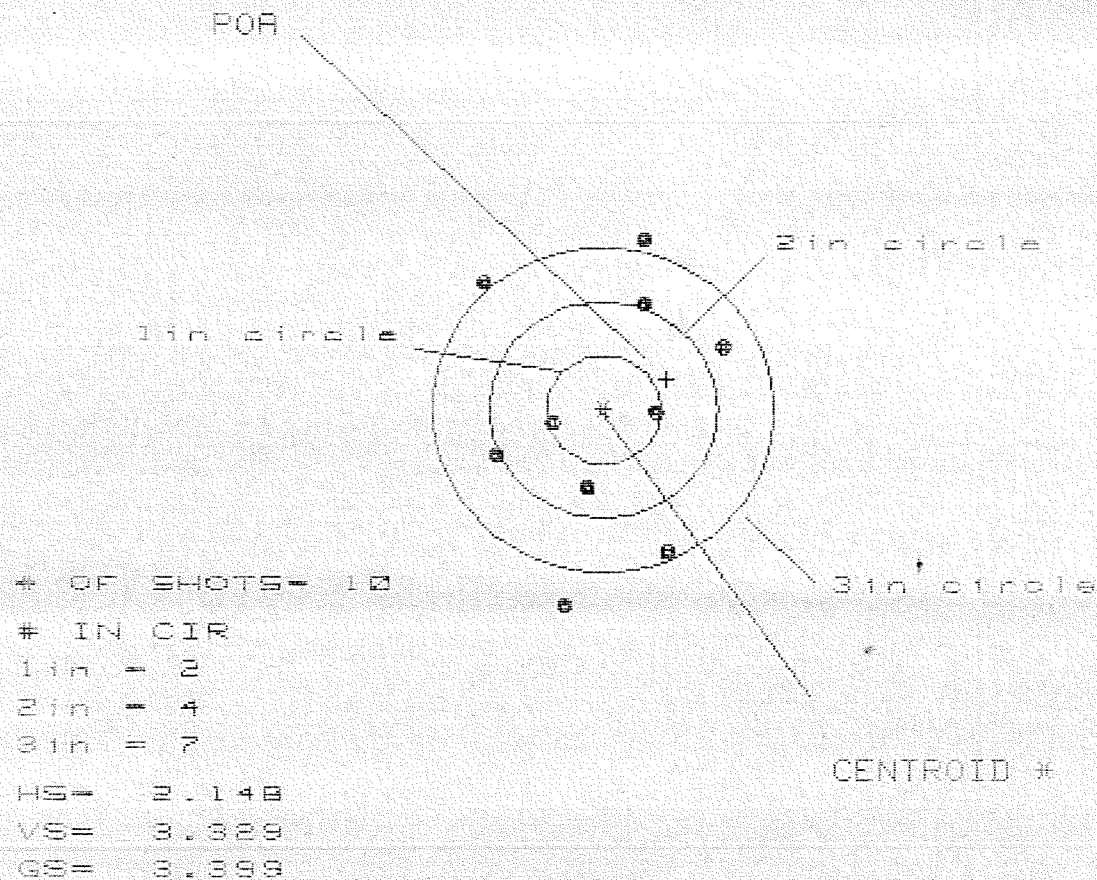
GS= 2.673

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.909	.713	.697
MINIMUM X	:	-1.764	-.454	-.470
MAXIMUM Y	:	.666	.685	.529
MINIMUM Y	:	-1.265	-1.246	-.401
CENTROID X	:	-.085	.111	.127
CENTROID Y	:	.143	.124	.280
POB TO CENTROID in.	:	.167	.167	.307
MIN RADIUS	:	.268	.260	.260
MEAN RADIUS	:	.740	.607	.514
MAX RADIUS	:	1.773	1.252	.698
HORIZONTAL SPREAD	:	2.673	1.167	1.167
VERTICAL SPREAD	:	1.931	1.931	.930
EXTREME SPREAD	:	2.673	1.953	1.221
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

30 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649192

CENTERFIRE PATTERNS # 3

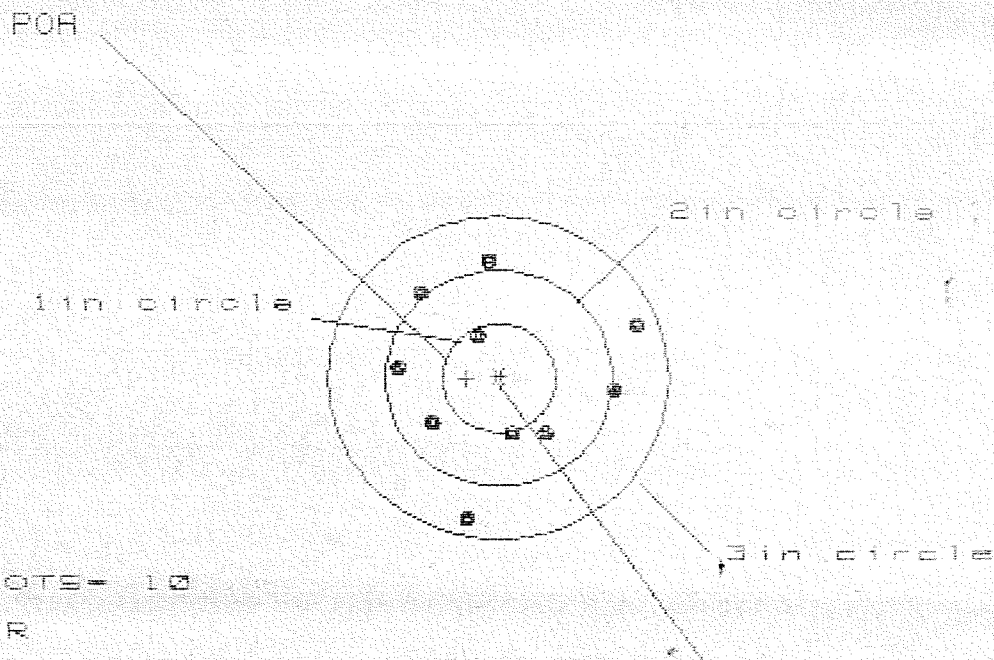


PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.084	1.051	1.095
MINIMUM X	:	-1.064	-1.097	-1.053
MAXIMUM Y	:	1.555	1.358	1.163
MINIMUM Y	:	-1.774	-1.518	-1.349
CENTROID X	:	-.554	-.521	-.566
CENTROID Y	:	-.284	-.087	-.257
POA TO CENTROID in.	:	.623	.528	.621
MIN RADIUS	:	.431	.494	.427
MEAN RADIUS	:	1.141	1.067	1.002
MAX RADIUS	:	1.799	1.605	1.568
HORIZONTAL SPREAD	:	2.148	2.148	2.148
VERTICAL SPREAD	:	3.329	2.876	2.511
EXTREME SPREAD	:	3.399	2.988	2.988
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

10 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649192

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 10

HS= 2.085

VS= 2.445

GS= 2.447

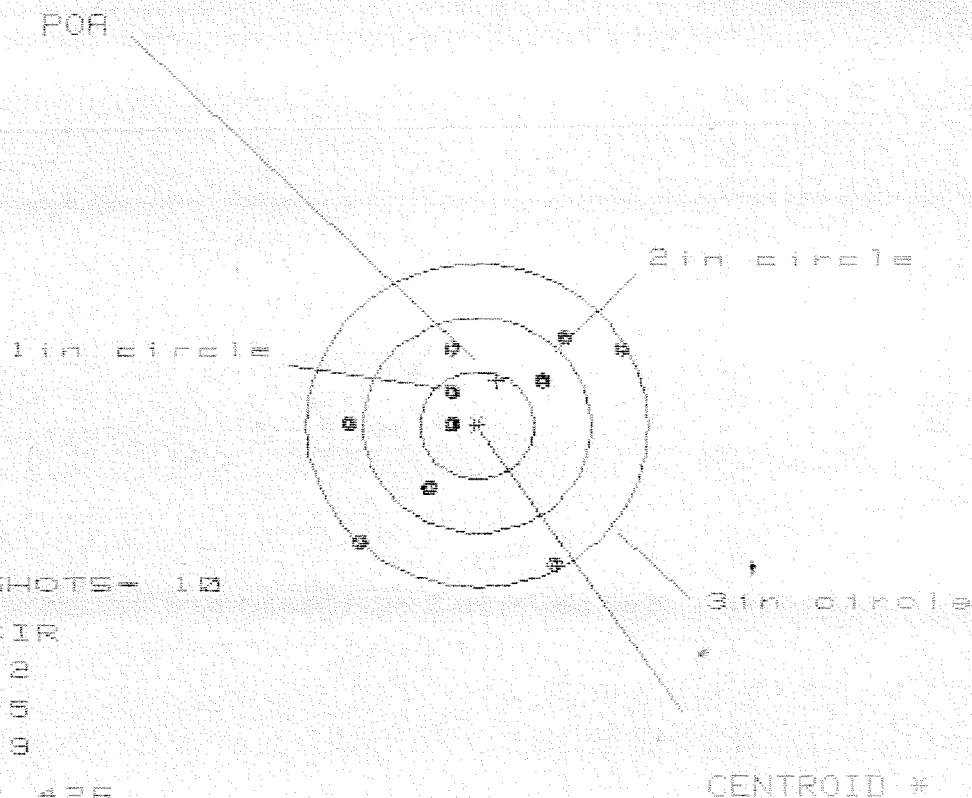
CENTROID *

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.216	1.189	1.157
MINIMUM X	:	-.869	-.896	-.747
MAXIMUM Y	:	1.119	.972	1.017
MINIMUM Y	:	-1.326	-.663	-.618
CENTROID X	:	.287	.314	.165
CENTROID Y	:	.006	.153	.108
POA TO CENTROID in.	:	.287	.349	.197
MIN RADIUS	:	.398	.296	.259
MEAN RADIUS	:	.906	.855	.782
MAX RADIUS	:	1.348	1.244	1.180
HORIZONTAL SPREAD	:	2.085	2.085	1.904
VERTICAL SPREAD	:	2.445	1.635	1.635
EXTREME SPREAD	:	2.447	2.126	1.996
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

30 Dec 1991

FILE: /PATTERNING/CENTERFIRE_PATT/C8649192

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 3

HS = 2.426

VS = 2.149

GS = 2.919

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.281	1.169	.763
MINIMUM X	-1.145	-1.257	-1.111
MAXIMUM Y	.861	.736	.806
MINIMUM Y	-1.288	-1.413	-1.343
CENTROID X	-.173	-.061	-.207
CENTROID Y	-.418	-.293	-.363
POA TO CENTROID in.	.453	.299	.418
MIN RADIUS	.198	.307	.154
MEAN RADIUS	.937	.863	.784
MAX RADIUS	1.511	1.514	1.510
HORIZONTAL SPREAD	2.426	2.426	1.874
VERTICAL SPREAD	2.149	2.149	2.149
EXTREME SPREAD	2.919	2.522	2.212
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

GUN SERIAL # C6611766

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 25	91	RW
600	Proof	3 25	91	RW
607	Check Headspace	3 25	91	RW
610	Dis-assemble Gun	3 25	91	RW
612	Magnaflux Barrel Action	3 28	91	KR
	Magnaflux Bolt	3 28	91	u
615	Rollmark Caliber	3 28	91	JS
617	Drill and Tap Sight Holes	APR 3	1991	LB
618	Polish Barrel	APR 3	1991	WB
620	Apply Coatings (Barrel Action)		4-11-91	TS
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		5/10/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		5/10/91	RW
	C) Inspect Ejector Hole for Chamfer		5/10/91	RW
	D) Oil Firing Pin Ass'y		5/10/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		5-30-91	DH

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	6	6	6			5-21-91	DH
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			5-21-91	DH
	H) Trigger Pull Test & Retainability						5-20-91	DH
	I) Firing Pin Indent	.020	.020	.020			5-21-91	DH
	J) Assemble Stock						5/24/91	Rev
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						5/24/91	Rev
	M) Iron Sight Alignment						5/24/91	Rev
	N) Detach Front & Rear Sights & place in numbered container						5/24/91	Rev
	O) Attach Scope to Rifle						5/24/91	Rev
	P) Detach & Attach Scope 20 Times						5/24/91	Rev
640	Gallery Target & Test						5-29-91	DH
	A) Time						5-29-91	DH
	B) Malfunctions						5-29-91	DH
	C) Pierced Primers						5-29-91	DH
	D) Optical Clarity of Scope						5-29-91	DH
645	Inspect for Live Ammo						5-29-91	DH
655	Final Inspection							
	A) Headspace						5/30/91	JD
	B) Trigger Pull	2.58	2.52	2.54	2.58	2.39	5/30/91	JD
	C) Function						5/30/91	JD
660	Pack							

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6611766

DATE 5-20-91

TESTER DH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.58	2.73	2.60	2.58	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.55	2.66	2.80	2.52	
PULL #3	2.59	2.69	2.81	2.54	
PULL #4	2.55	2.63	2.73	2.58	
PULL #5	2.54	2.69	2.93	2.39	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.01	3.39		
PULL #2	3.25	3.22		
PULL #3	3.52	3.21		
PULL #4	3.36	3.15		
PULL #5	3.43	3.23		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.22	4.32		4.10
PULL #2	4.07	4.35		4.13
PULL #3	4.07	3.92		3.98
PULL #4	3.87	4.33		4.18
PULL #5	4.04	4.32		4.44
TOTAL				
AVG.				

SWS ENDURANCE TEST REPORT

SERIAL NO. C6611766 SHOOTER _____ DATE 5-30-91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
60	7.62	60	TARGET TEST OK	OK
90	7.62	30	OK S-31 P.C.	NONE TEST
120	7.62	30	OK	NONE TEST
150	7.62	30	OK	NONE TEST
180	7.62	30	OK	NONE TEST
210	7.62	30	OK	NONE TEST
240	7.62	30	OK	NONE TEST
270	7.62	30	OK	NONE TEST
300	7.62	30	OK	NONE TEST
330	7.62	30	OK	NONE TEST
360	7.62	30	OK	NONE TEST
390	7.62	30	OK	NONE TEST
420	7.62	30	OK	NONE TEST
440	7.62	20	OK	NONE TEST
		440	TOTAL	
540	7.62	60	OK	5/31/91
		500	Total	
560	7.62	60	OK 6-1-91 KB	NONE TEST
620	7.62	60	OK	NONE TEST
680	7.62	60	OK	NONE TEST
740	7.62	60	OK	NONE TEST
800	7.62	60	OK	NONE TEST
		800	TOTAL	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6611766 SHOOTER _____ DATE 6-3

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
830	7.62	30	OK ⁶⁻³ _{P.C.}	NONE TEST
860	7.62	30	OK	NONE TEST
890	7.62	30	OK	NONE TEST
920	7.62	30	OK	NONE TEST
950	7.62	30	OK	NONE TEST
980	7.62	30	OK	NONE TEST
1010	7.62	30	OK	NONE TEST
1020	7.62	10	OK	NONE TEST
		1020	TOTAL	
1080	7.62	60	OK ⁶⁻³ _{KB}	NONE TEST
1140	7.62	60	OK	NONE TEST
1200	7.62	60	OK	NONE TEST
1260	7.62	60	OK	NONE TEST
1320	7.62	60	OK	NONE TEST
1380	7.62	60	OK	NONE TEST
1440	7.62	60	OK	NONE TEST
1500	7.62	60	OK	NONE TEST
1520	7.62	20	OK	NONE TEST
		1520	TOTAL	
1550	7.62	30	OK ⁶⁻⁴ _{P.C.}	NONE TEST
1580	7.62	30	OK	NONE TEST
1610	7.62	30	OK	NONE TEST
		1610	TOTAL	

SWS ENDURANCE TEST REPORT

SERIAL NO. 06611766 SHOOTER _____ DATE 6-4

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
1640	7.62	30	OK 6-4 PC.	NONE TEST
1670	7.62	30	OK	NONE TEST
1700	7.62	30	OK	NONE TEST
1730	7.62	30	OK	NONE TEST
1760	7.62	30	OK	NONE TEST
1790	7.62	30	OK	NONE TEST
1800	7.62	10	OK	NONE TEST
		<u>1800</u>	<u>TOTAL</u>	
1860	7.62	60	OK 6-4 KB	NONE TEST
1920	7.62	60	OK	NONE TEST
1980	7.62	60	OK	NONE TEST
2040	7.62	60	OK	NONE TEST
2100	7.62	60	OK	NONE TEST
2160	7.62	60	OK	NONE TEST
2220	7.62	60	OK	NONE TEST
2280	7.62	60	OK	NONE TEST
2300	7.62	60	OK	NONE TEST
		<u>2300</u>	<u>TOTAL</u>	
2330	7.62	30	OK 6-5 PC.	NONE TEST
2360	7.62	30	OK	NONE TEST
2390	7.62	30	OK	NONE TEST
2420	7.62	30	OK	NONE TEST
		<u>2420</u>	<u>TOTAL</u>	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6611766 SHOOTER _____ DATE 6-5

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
2450	7.62	30	OK 6-5 PC	NONE TEST
2480	7.62	30	OK	NONE TEST
2500	7.62	20	OK	NONE TEST
		2500	TOTAL	MAGNAFLUX
2560	7.62	60	OK 6-5 KB	NONE TEST
2620	7.62	60	OK	NONE TEST
2680	7.62	60	OK	NONE TEST
2740	7.62	60	OK	NONE TEST
2800	7.62	60	OK	NONE TEST
2860	7.62	60	OK	NONE TEST
2920	7.62	60	OK	NONE TEST
2980	7.62	60	OK	NONE TEST
3000	7.62	20	OK	NONE TEST
		3000	TOTAL	
3030	7.62	30	OK 6-8 PC	NONE TEST
3060	7.62	30	OK	NONE TEST
3090	7.62	30	OK	NONE TEST
3120	7.62	30	OK	NONE TEST
3150	7.62	30	OK	NONE TEST
3180	7.62	30	OK	NONE TEST
3210	7.62	30	OK	NONE TEST
3240	7.62	30	OK	NONE TEST
		3240	TOTAL	

SWS ENDURANCE TEST REPORT

 SERIAL NO. C6611766 SHOOTER _____ DATE 6-6

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
3270	7.62	30	OK ⁶⁰ PC	NONE TEST
3300	7.62	30	OK	NONE TEST
3330	7.62	30	OK	NONE TEST
3360	7.62	30	OK	NONE TEST
3390	7.62	30	OK	NONE TEST
3400	7.62	10	OK	NONE TEST
		3400	TOTAL	
3460	7.62	60	OK ⁶⁻⁶ KB	NONE TEST
3520	7.62	60	OK	NONE TEST
3580	7.62	60	OK	NONE TEST
3640	7.62	60	OK	NONE TEST
3700	7.62	60	OK	NONE TEST
3760	7.62	60	OK	NONE TEST
3820	7.62	60	OK	NONE TEST
3880	7.62	60	OK	NONE TEST
3900	7.62	20	OK	NONE TEST
		3900	TOTAL	
3930	7.62	30	OK ⁶⁻² PC	NONE TEST
3960	7.62	30	OK	NONE TEST
3990	7.62	30	OK	NONE TEST
4020	7.62	30	OK	NONE TEST
		4020	TOTAL	

SWS ENDURANCE TEST REPORT

 SERIAL NO. C6611766 SHOOTER _____ DATE 6-7

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
4050	7.62	30	OK	NONE TEST
4080	7.62	30	OK	NONE TEST
		4080	TOTAL	
4140	7.62	60	OK ^{KB} ₆₋₃	NONE TEST
4200	7.62	60	OK 6-3	NONE TEST
4260	7.62	60	OK	NONE TEST
4320	7.62	60	OK	NONE TEST
4380	7.62	60	OK	NONE TEST
4440	7.62	60	OK	NONE TEST
4500	7.62	60	OK	NONE TEST
		4500	TOTAL	
		60	TARGET + ACC.	6-8-91 DIT
4560		4560		
4620	7.62	60	OK ⁶⁻⁸ _{KB}	NONE TEST
4680	7.62	60	OK	NONE TEST
4740	7.62	60	OK	NONE TEST
4800	7.62	60	OK	NONE TEST
4860	7.62	60	OK	NONE TEST
		4860	TOTAL	
4890	7.62	30	OK ⁶⁻⁸ _{P.C.}	NONE TEST
4920	7.62	30	OK	NONE TEST
4940	7.62	20	OK	NONE TEST
		4940	TOTAL	

SWS ENDURANCE TEST REPORT

 SERIAL NO. C6611766 SHOOTER _____ DATE 6-10

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
5000	7.62	60	OK A.C.	TARGET + ACCURACY
		5000	TOTAL	MAGNAFLUX
5060	7.62	60	OK G.P.E.	NONE TEST
5120	7.62	60	OK	NONE TEST
5180	7.62	60	OK	NONE TEST
5240	7.62	60	OK	NONE TEST
5300	7.62	60	OK	NONE TEST
5360	7.62	60	OK	NONE TEST
5420	7.62	60	OK	NONE TEST
5440	7.62	20	OK	NONE TEST
		5440	TOTAL	
5500	7.62	60	OK 6-10 KB	NONE TEST
5560	7.62	60	OK	NONE TEST
5620	7.62	60	OK	NONE TEST
5680	7.62	60	OK	NONE TEST
5740	7.62	60	OK	NONE TEST
5800	7.62	60	OK	NONE TEST
5860	7.62	60	OK	NONE TEST
5920	7.62	60	OK	NONE TEST
5980	7.62	60	OK	NONE TEST
6000	7.62	60	OK	NONE TEST
		6000	TOTAL	MAGNAFLUX

SWS ENDURANCE TEST REPORT

SERIAL NO. C 6611766 SHOOTER _____ DATE 6-11

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
6060	7.62	60	OK 6-11 KB	NONE TEST
6120	7.62	60	OK	NONE TEST
6180	7.62	60	OK	NONE TEST
6240	7.62	60	OK	NONE TEST
6300	7.62	60	OK	NONE TEST
6360	7.62	60	OK	NONE TEST
6420	7.62	60	OK	NONE TEST
6480	7.62	60	OK	NONE TEST
6540	7.62	60	OK	NONE TEST
6600	7.62	60	OK	NONE TEST
6660	7.62	60	OK	NONE TEST
6720	7.62	60	OK	NONE TEST
6780	7.62	60	OK	NONE TEST
6840	7.62	60	OK	NONE TEST
6900	7.62	60	OK	NONE TEST
6960	7.62	60	OK	NONE TEST
7000	7.62	<u>40</u>	OK	NONE TEST
		7000	TOTAL	MAGNAFLUX
7060	7.62	60	OK 6-12 P.C.	NONE TEST
7120	7.62	60	OK	NONE TEST
7180	7.62	60	OK	NONE TEST
7200	7.62	<u>20</u>	OK	NONE TEST
		7200	TOTAL	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6611766 SHOOTER _____ DATE 6-12

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
7260	7.62	60	OK ⁶⁻¹²⁻⁹¹ KB	NONE TEST NONE TEST
7320	7.62	60	OK	NONE TEST
7380	7.62	60	OK	NONE TEST
7440	7.62	60	OK	NONE TEST
7500	7.62	60	OK	NONE TEST
7560	7.62	60	OK	NONE TEST
7620	7.62	60	OK	NONE TEST
7680	7.62	60	OK	NONE TEST
7740	7.62	60	OK	NONE TEST
7800	7.62	60	OK	NONE TEST
7860	7.62	60	OK	NONE TEST
7920	7.62	60	OK	NONE TEST
7980	7.62	60	OK	NONE TEST
8000	7.62	20	OK	NONE TEST
		8000	TOTAL	MAGNAFLUX
8060	7.62	60	OK ⁶⁻¹³ KB	NONE TEST
8120	7.62	60	OK	NONE TEST
8180	7.62	60	OK	NONE TEST
8240	7.62	60	OK	NONE TEST
8300	7.62	60	OK	NONE TEST
8360	7.62	60	OK	NONE TEST
8420	7.62	60	OK	NONE TEST
		8420	TOTAL	

SWS ENDURANCE TEST REPORT

SERIAL NO. C66117.66 SHOOTER _____ DATE 6-13-91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
8480	7.62	60	OK ⁶⁻¹³	NONE TEST
8540	7.62	60	OK	NONE TEST
8600	7.62	60	OK	NONE TEST
8660	7.62	60	OK	NONE TEST
8720	7.62	60	OK	NONE TEST
8780	7.62	60	OK	NONE TEST
8840	7.62	60	OK	NONE TEST
8900	7.62	60	OK	NONE TEST
8960	7.62	60	OK	NONE TEST
9000	7.62	60	OK	NONE TEST
		9000	TOTAL	MAGNAFLUX
9060	7.62	60	OK	NONE TEST
9120	7.62	60	OK	NONE TEST
9180	7.62	60	OK	NONE TEST
9240	7.62	60	OK	NONE TEST
9300	7.62	60	OK	NONE TEST
9360	7.62	60	OK	NONE TEST
9420	7.62	60	OK	NONE TEST
9480	7.62	60	OK	NONE TEST
9540	7.62	60	OK	NONE TEST
9600	7.62	60	OK	NONE TEST
9660	7.62	60	OK	NONE TEST
		9660	TOTAL	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611766
29 May 1991

0 ROUNDS

CENTROIDAL DISTANCES

0 TO	1	.51266
1 TO	2	.503612
1 TO	3	.221461
1 TO	4	.161895
1 TO	5	.414664

+

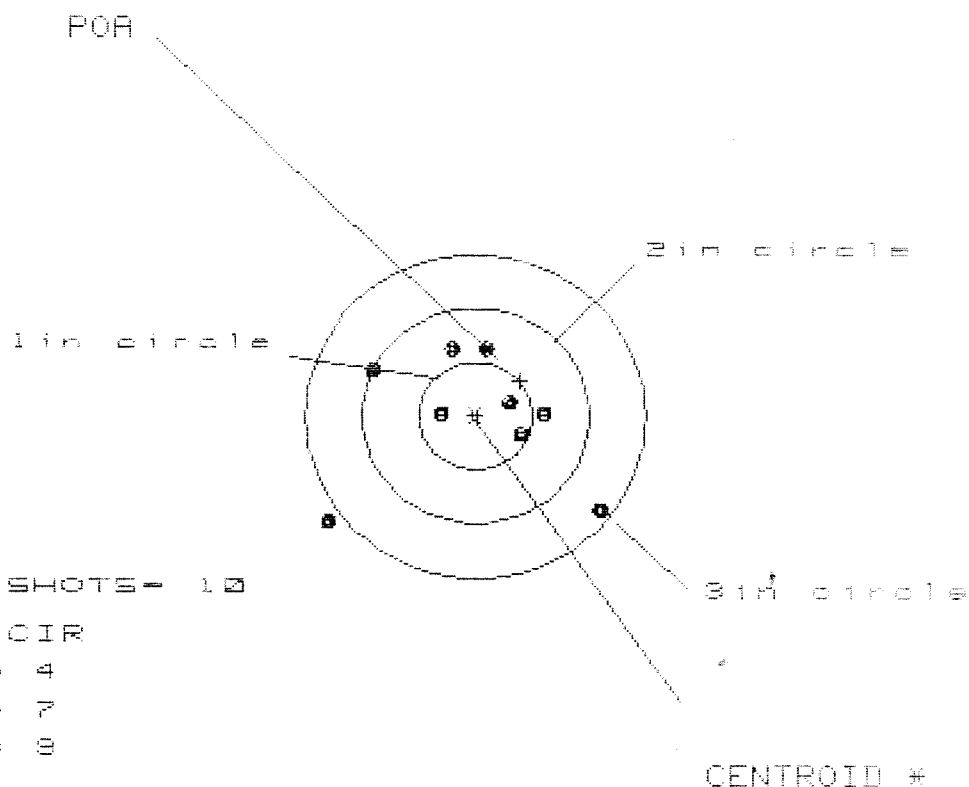
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.3024
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1004
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .318631
THE AMR FOR THIS RIFLE IS: .8902

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611786

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 9

HS= 2.419

VS= 1.655

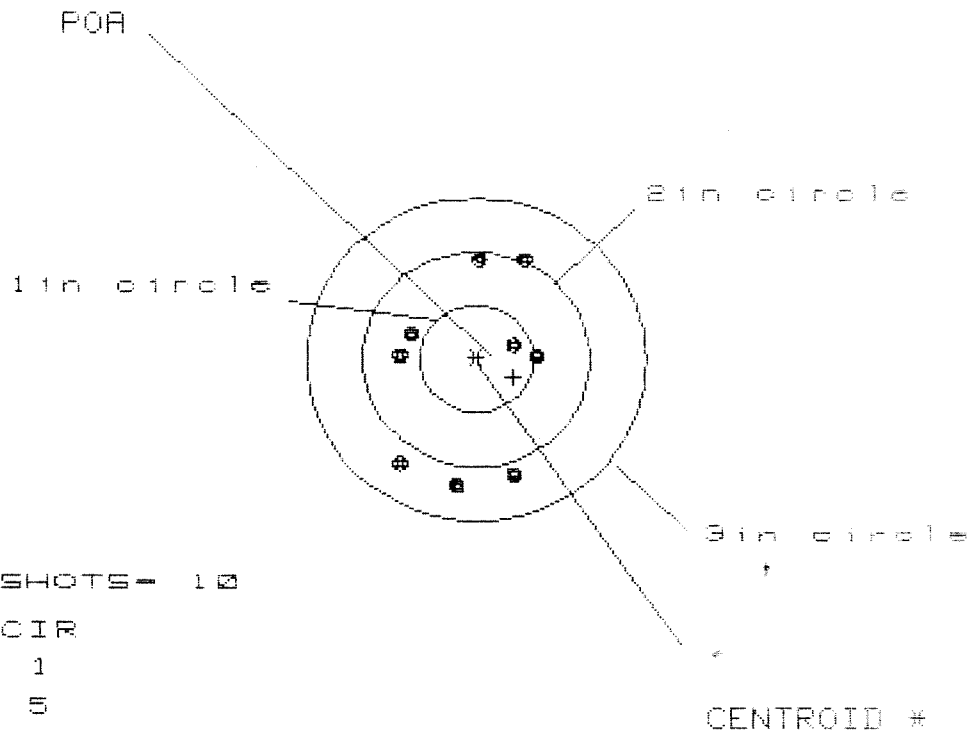
GS= 2.423

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.078	.929	.602
MINIMUM X	:	-1.341	-1.053	-.937
MAXIMUM Y	:	.635	.522	.397
MINIMUM Y	:	-1.020	-.995	-.419
CENTROID X	:	-.394	-.245	-.361
CENTROID Y	:	-.328	-.215	-.090
POA TO CENTROID in.	:	.513	.326	.373
MIN RADIUS	:	.302	.117	.240
MEAN RADIUS	:	.742	.580	.493
MAX RADIUS	:	1.685	1.362	.965
HORIZONTAL SPREAD	:	2.419	1.982	1.539
VERTICAL SPREAD	:	1.655	1.517	.816
EXTREME SPREAD	:	2.423	2.400	1.599
NUMBER IN ONE INCH CIRCLE	=	4		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611766

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 10

HS = 1.272

VS = 2.129

GS = 2.191

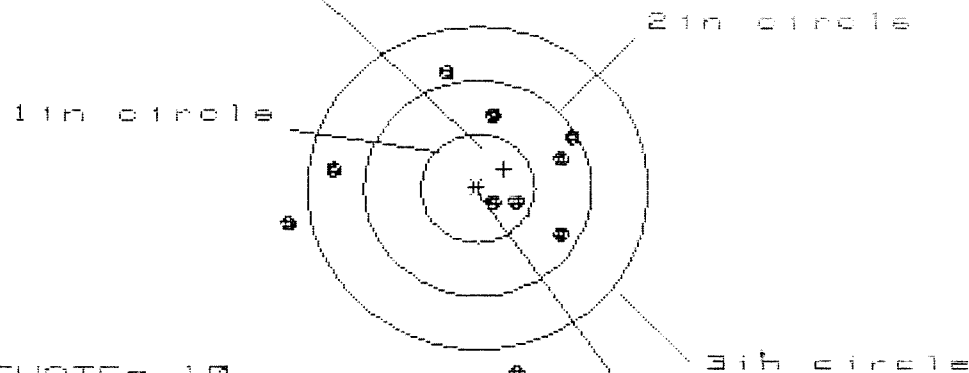
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.572	.496	.469
MINIMUM X	:	-.700	-.776	-.803
MAXIMUM Y	:	.960	.853	.694
MINIMUM Y	:	-1.169	-1.276	-1.355
CENTROID X	:	-.326	-.250	-.223
CENTROID Y	:	.171	.278	.438
POA TO CENTROID in.	:	.368	.374	.491
MIN RADIUS	:	.334	.233	.246
MEAN RADIUS	:	.876	.819	.733
MAX RADIUS	:	1.182	1.294	1.381
HORIZONTAL SPREAD	:	1.272	1.272	1.272
VERTICAL SPREAD	:	2.129	2.129	2.048
EXTREME SPREAD	:	2.191	2.170	2.074
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

25 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C86117B6

CENTERFIRE PATTERNS # 3

POR



OF SHOTS - 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 2.585

VS= 2.777

GS= 2.842

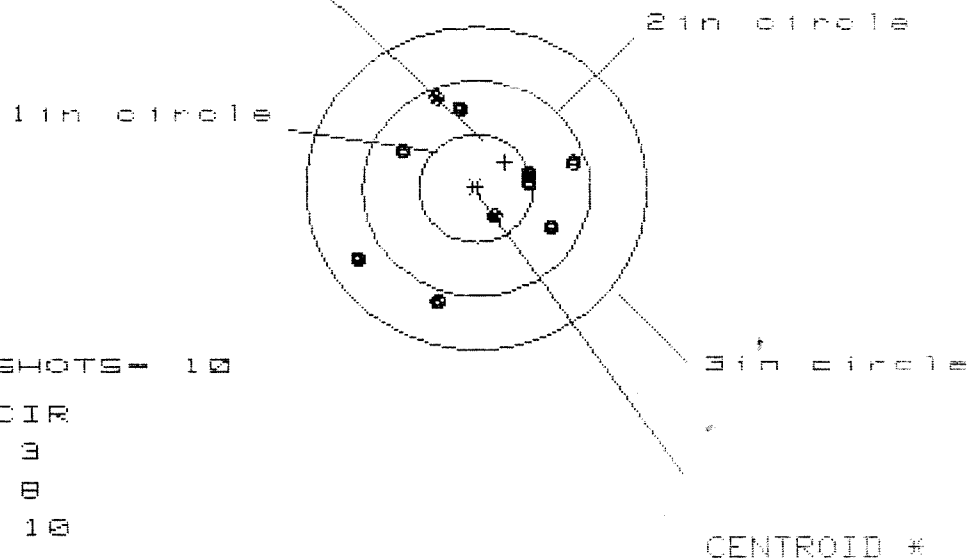
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.879	.917	.789
MINIMUM X	:	-1.706	-1.668	-1.428
MAXIMUM Y	:	1.075	.886	.823
MINIMUM Y	:	-1.702	-.628	-.691
CENTROID X	:	-.232	-.270	-.062
CENTROID Y	:	-.177	.012	.075
POR TO CENTROID in.	:	.292	.271	.097
MIN RADIUS	:	.121	.297	.337
MEAN RADIUS	:	.963	.875	.715
MAX RADIUS	:	1.736	1.741	1.429
HORIZONTAL SPREAD	:	2.585	2.585	2.137
VERTICAL SPREAD	:	2.777	1.514	1.514
EXTREME SPREAD	:	2.842	2.707	2.155
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611766

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.889

VS= 1.935

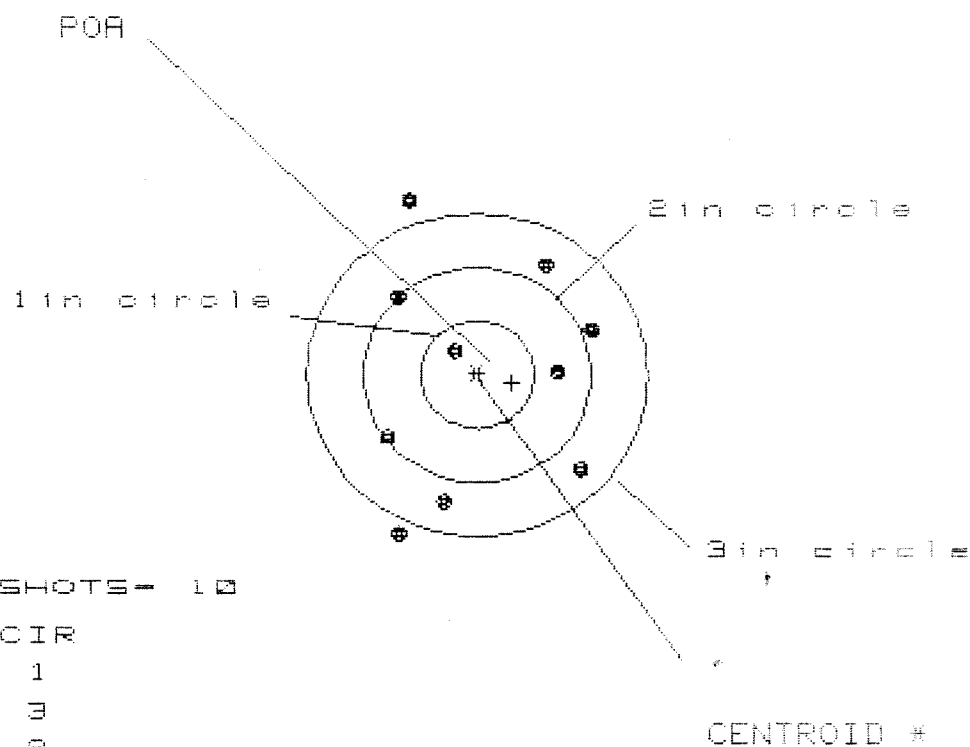
GS= 2.104

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.810	.691	.637
MINIMUM X	:	-1.079	-.772	-.826
MAXIMUM Y	:	.875	.797	.655
MINIMUM Y	:	-1.060	-1.138	-.603
CENTROID X	:	-.255	-.136	-.082
CENTROID Y	:	-.245	-.168	-.026
POA TO CENTROID in.	:	.354	.216	.086
MIN RADIUS	:	.293	.303	.309
MEAN RADIUS	:	.762	.673	.595
MAX RADIUS	:	1.284	1.217	.840
HORIZONTAL SPREAD	:	1.889	1.463	1.463
VERTICAL SPREAD	:	1.935	1.935	1.258
EXTREME SPREAD	:	2.104	1.935	1.561
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

29 May 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611766

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 8

HS= 1.725

VS= 3.136

GS= 3.137

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.975	.909	.814
MINIMUM X	:	-.750	-.816	-.911
MAXIMUM Y	:	1.664	1.219	1.058
MINIMUM Y	:	-1.472	-1.287	-1.112
CENTROID X	:	-.305	-.239	-.144
CENTROID Y	:	.077	-.108	.053
POA TO CENTROID in.	:	.315	.262	.154
MIN RADIUS	:	.316	.509	.444
MEAN RADIUS	:	1.108	1.034	.952
MAX RADIUS	:	1.769	1.492	1.197
HORIZONTAL SPREAD	:	1.725	1.725	1.725
VERTICAL SPREAD	:	3.136	2.506	2.170
EXTREME SPREAD	:	3.137	2.800	2.327
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611766
1 Jun 1991

500 RDS

CENTROIDAL DISTANCES

0 TO	1	.0620967
1 TO	2	.251334
1 TO	3	.233238
1 TO	4	1.01243
1 TO	5	.408336

$\bar{x}_j$ (----POA
4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.2514
 THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1406
 THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .208046
 THE AMR FOR THIS RIFLE IS: .9184

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611766.1

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 5

2in = 9

3in = 9

HS= 2.002

VS= 1.850

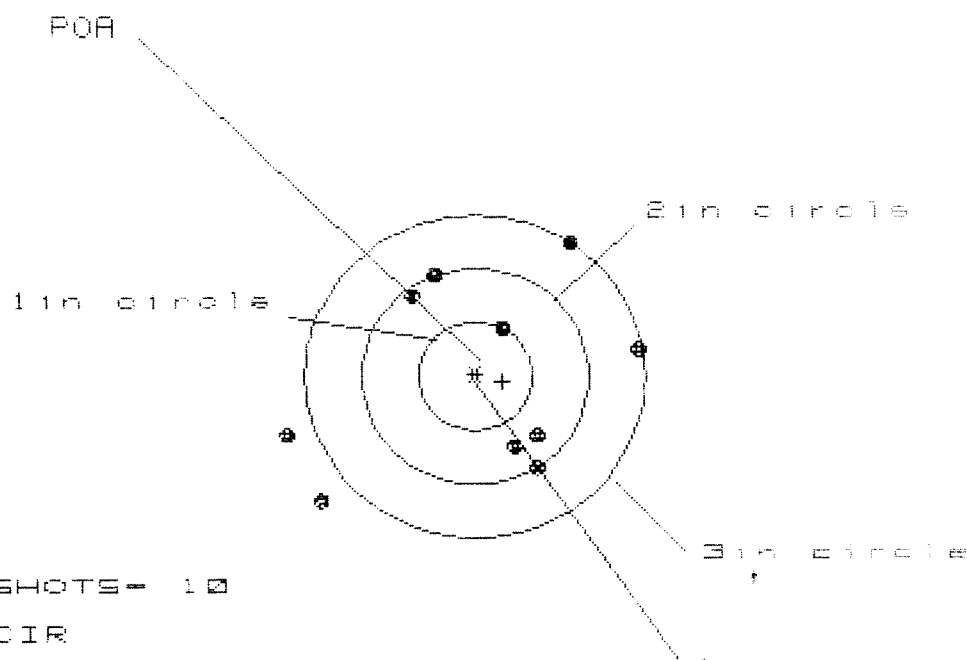
GS= 2.359

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.720	.577	.571
MINIMUM X	-1.282	-.673	-.679
MAXIMUM Y	.801	.685	.425
MINIMUM Y	-1.049	-.546	-.461
CENTROID X	-.016	.127	.133
CENTROID Y	-.060	.056	-.029
POA TO CENTROID in.	.062	.139	.137
MIN RADIUS	.100	.133	.071
MEAN RADIUS	.593	.432	.392
MAX RADIUS	1.657	.867	.821
HORIZONTAL SPREAD	2.002	1.250	1.250
VERTICAL SPREAD	1.850	1.231	.886
EXTREME SPREAD	2.359	1.385	1.385
NUMBER IN ONE INCH CIRCLE =	5		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	9		

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611766.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS= 3.147

VS= 2.400

GS= 3.250

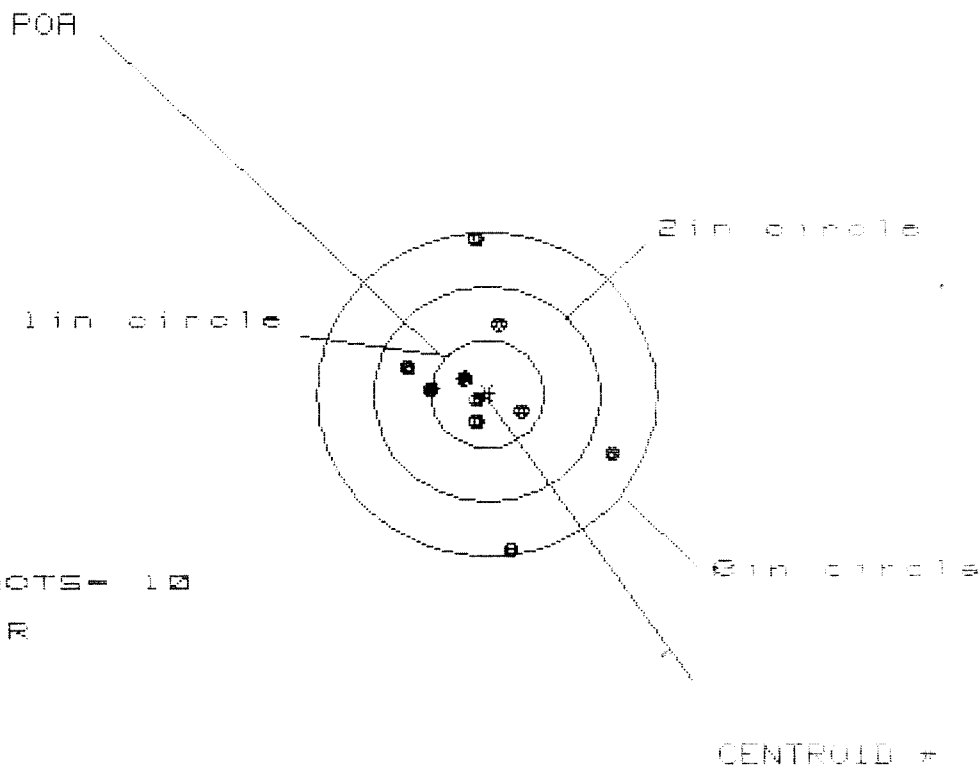
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.444	1.254	1.061
MINIMUM X	:	-1.703	-1.546	-.918
MAXIMUM Y	:	1.238	1.177	1.025
MINIMUM Y	:	-1.162	-1.223	-1.063
CENTROID X	:	-.241	-.051	.142
CENTROID Y	:	.052	.113	.265
POA TO CENTROID in.	:	.246	.124	.301
MIN RADIUS	:	.527	.415	.302
MEAN RADIUS	:	1.152	1.050	.911
MAX RADIUS	:	1.789	1.971	1.120
HORIZONTAL SPREAD	:	3.147	2.800	1.979
VERTICAL SPREAD	:	2.400	2.400	2.087
EXTREME SPREAD	:	3.250	3.250	2.108
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611766.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 5

2in = 7

3in = 9

HS= 1.745

VS= 2.946

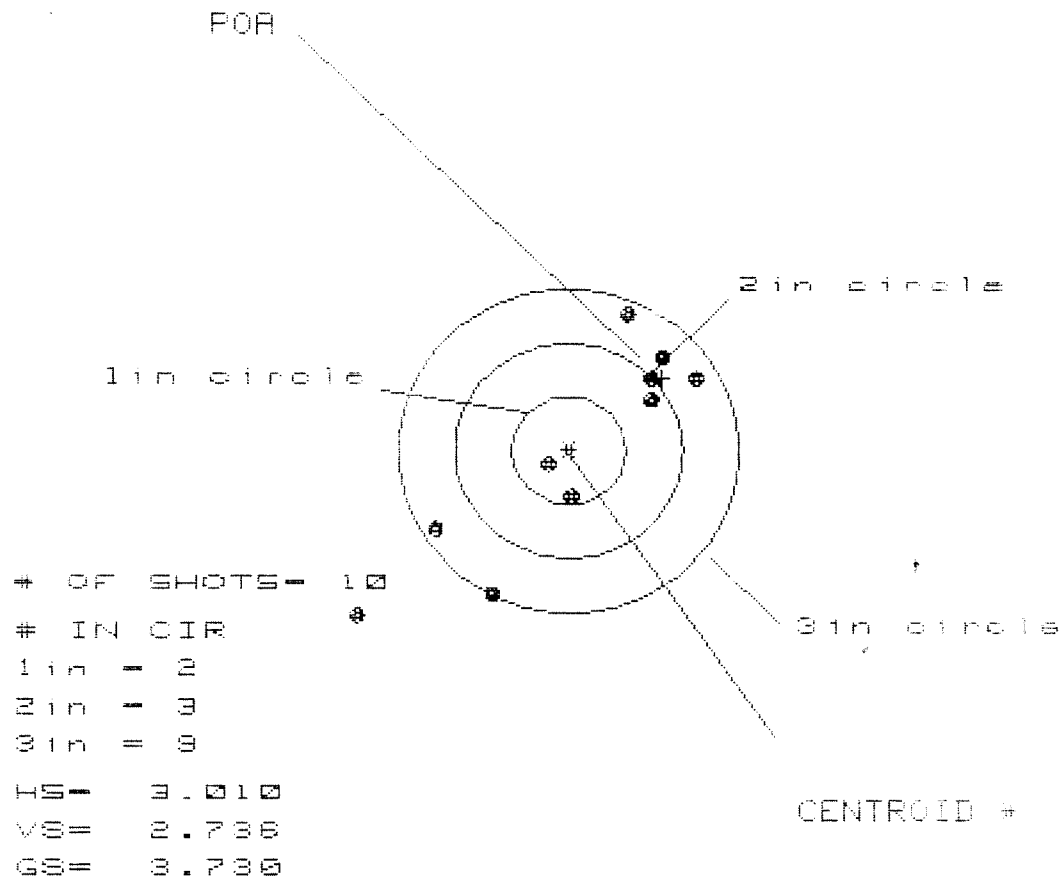
GS= 2.956

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.068	1.086	1.078
MINIMUM X	:	-.677	-.659	-.667
MAXIMUM Y	:	1.451	1.285	.650
MINIMUM Y	:	-1.495	-.759	-.598
CENTROID X	:	.200	.182	.190
CENTROID Y	:	-.143	.018	-.143
POA TO CENTROID in.	:	.249	.183	.238
MIN RADIUS	:	.132	.218	.126
MEAN RADIUS	:	.712	.627	.519
MAX RADIUS	:	1.503	1.325	1.233
HORIZONTAL SPREAD	:	1.745	1.745	1.745
VERTICAL SPREAD	:	2.946	2.044	1.248
EXTREME SPREAD	:	2.956	2.346	1.920
NUMBER IN ONE INCH CIRCLE	=		5	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06611788.1

CENTERFIRE PATTERNS # 4

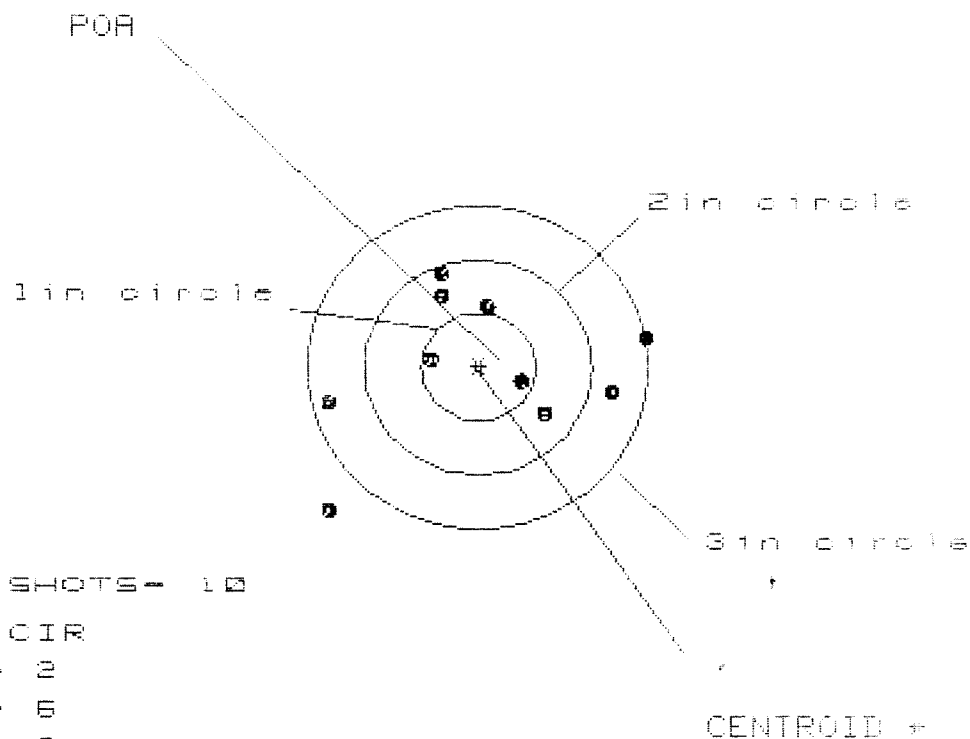


PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.100	.888	.782
MINIMUM X	:	-1.910	-1.365	-1.471
MAXIMUM Y	:	1.241	1.075	.893
MINIMUM Y	:	-1.495	-1.456	-1.050
CENTROID X	:	-.821	-.609	-.503
CENTROID Y	:	-.674	-.508	-.326
POA TO CENTROID in.	:	1.063	.793	.599
MIN RADIUS	:	.262	.532	.429
MEAN RADIUS	:	1.161	.986	.851
MAX RADIUS	:	2.425	1.686	1.807
HORIZONTAL SPREAD	:	3.010	2.253	2.253
VERTICAL SPREAD	:	2.736	2.531	1.943
EXTREME SPREAD	:	3.730	2.788	2.658
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

1 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611756.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.797

VS= 2.163

GS= 3.150

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.454	1.310	1.245
MINIMUM X	-1.343	-1.487	-1.323
MAXIMUM Y	.870	.726	.738
MINIMUM Y	-1.293	-.605	-.593
CENTROID X	-.379	-.235	-.399
CENTROID Y	.127	.271	.259
POA TO CENTROID in.	.400	.359	.476
MIN RADIUS	.438	.373	.424
MEAN RADIUS	.974	.852	.782
MAX RADIUS	1.832	1.551	1.391
HORIZONTAL SPREAD	2.797	2.797	2.568
VERTICAL SPREAD	2.163	1.331	1.331
EXTREME SPREAD	3.150	2.848	2.569
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611766
8 Jun 1991

4500 RDS

CENTROIDAL DISTANCES

0 TO	1	.101074
1 TO	2	.286782
1 TO	3	.148165
1 TO	4	.201556
1 TO	5	.418814

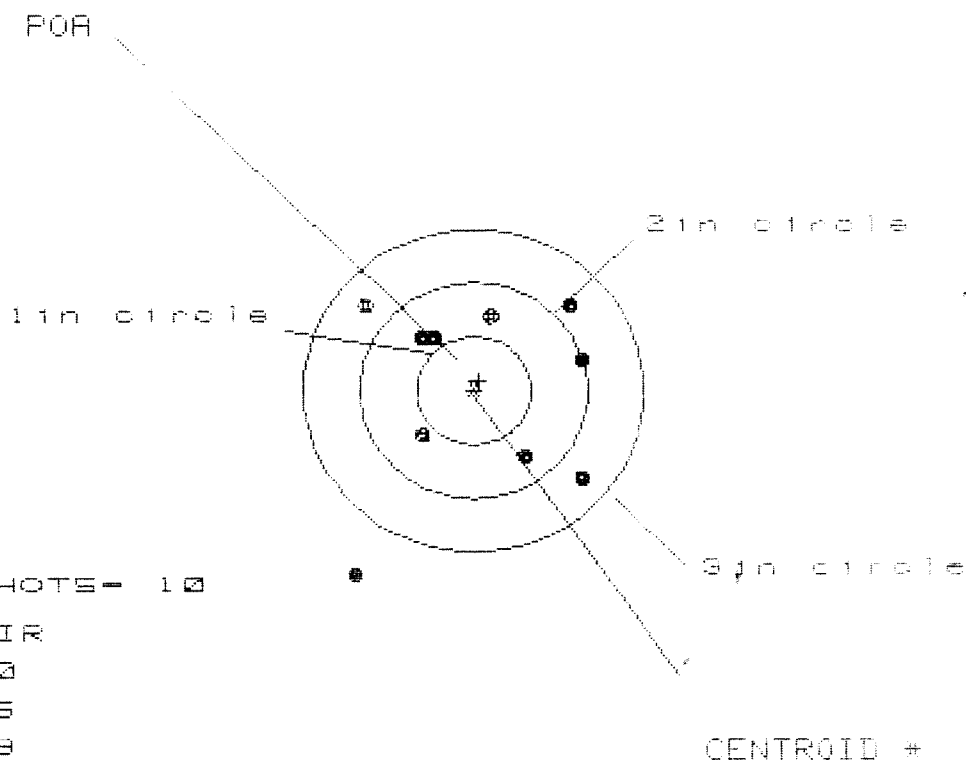
45 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1242
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0908
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .153851
THE AMR FOR THIS RIFLE IS: .9946

8 Jun 1981

FILE://PATTERNING/CENTERFIRE_PATT/C8611756.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 8

HS= 2.067

VS= 2.441

GS= 3.124

CENTROID *

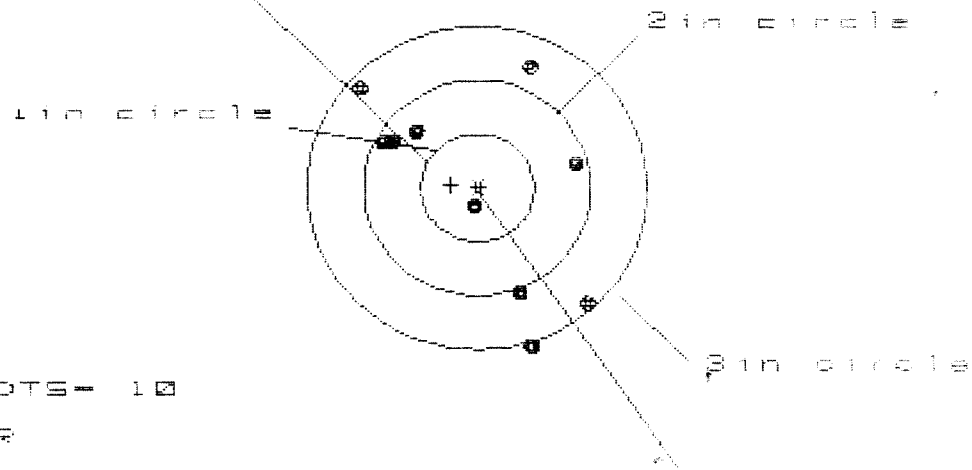
PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.968	.846	.927
MINIMUM X	:	-1.099	-1.090	-.984
MAXIMUM Y	:	.772	.586	.464
MINIMUM Y	:	-1.669	-.977	-.982
CENTROID X	:	-.046	.076	-.030
CENTROID Y	:	-.090	.096	.218
POA TO CENTROID in.	:	.101	.122	.220
MIN RADIUS	:	.613	.532	.424
MEAN RADIUS	:	.999	.860	.776
MAX RADIUS	:	1.998	1.292	1.088
HORIZONTAL SPREAD	:	2.067	1.936	1.911
VERTICAL SPREAD	:	2.441	1.563	1.366
EXTREME SPREAD	:	3.124	2.488	1.969
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611756.1.1

CENTERFIRE PATTERNS # 2

FOR



OF SHOTS= 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.004

VS= 2.581

GS= 2.816

CENTROID +

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.002	1.050	1.020
MINIMUM X	:	-1.002	-.954	-.822
MAXIMUM Y	:	1.145	.986	.834
MINIMUM Y	:	-1.436	-1.213	-1.267
CENTROID X	:	.234	.186	.054
CENTROID Y	:	-.028	.131	.283
FOR TO CENTROID in.	:	.236	.227	.288
MIN RADIUS	:	.176	.340	.407
MEAN RADIUS	:	1.017	.950	.834
MAX RADIUS	:	1.501	1.605	1.399
HORIZONTAL SPREAD	:	2.004	2.004	1.842
VERTICAL SPREAD	:	2.581	2.199	2.101
EXTREME SPREAD	:	2.816	2.816	2.354
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8611766.1.1

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 10

HS = 2.646

VS = 1.537

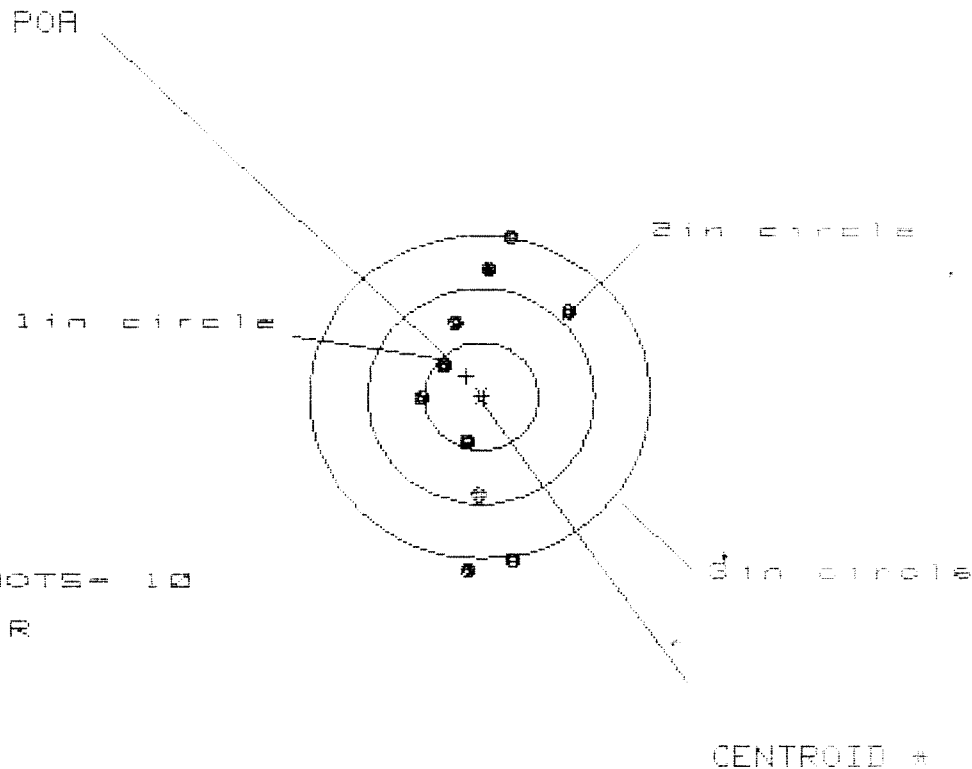
GS = 2.845

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.341	1.195	.927
MINIMUM X	:	-1.306	-1.288	-1.138
MAXIMUM Y	:	.733	.656	.691
MINIMUM Y	:	-.804	-.881	-.846
CENTROID X	:	-.053	.093	-.057
CENTROID Y	:	.058	.135	.100
POA TO CENTROID in.	:	.078	.164	.115
MIN RADIUS	:	.130	.289	.137
MEAN RADIUS	:	.940	.876	.815
MAX RADIUS	:	1.477	1.413	1.295
HORIZONTAL SPREAD	:	2.646	2.483	2.065
VERTICAL SPREAD	:	1.537	1.537	1.537
EXTREME SPREAD	:	2.845	2.502	2.258
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611786.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS = 1.302

VS = 3.055

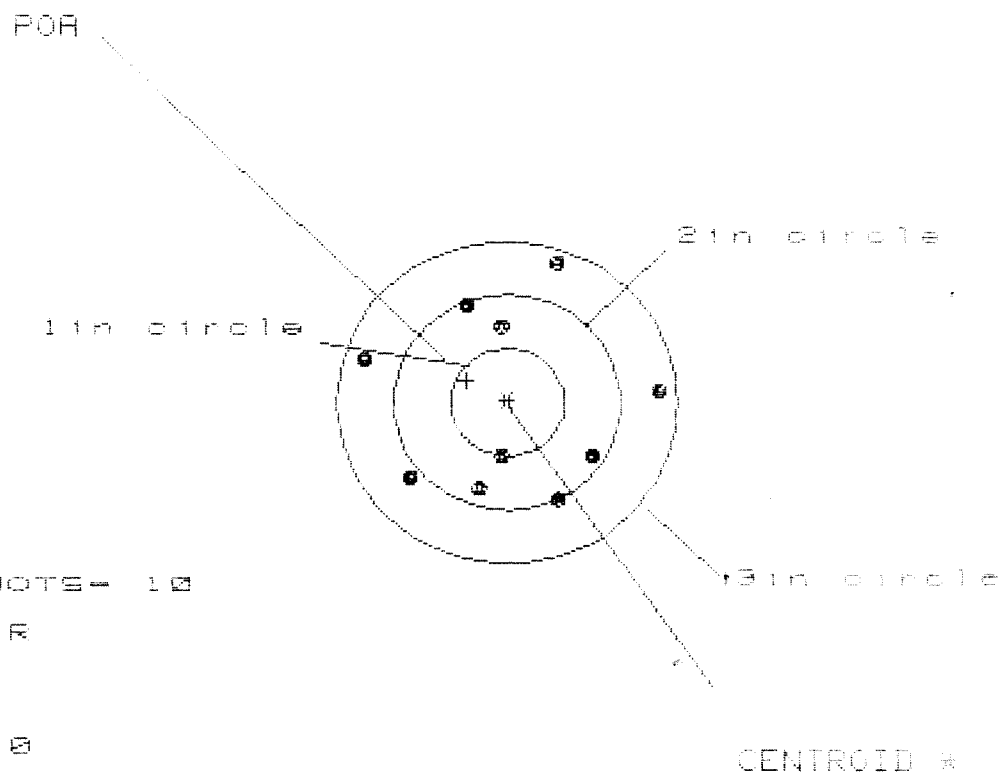
GS = 3.079

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.771	.760	.797
MINIMUM X	:	-.531	-.542	-.505
MAXIMUM Y	:	1.448	1.269	1.056
MINIMUM Y	:	-1.607	-1.705	-1.272
CENTROID X	:	.129	.140	.103
CENTROID Y	:	-.190	-.011	.202
POA TO CENTROID in.	:	.229	.141	.227
MIN RADIUS	:	.402	.375	.339
MEAN RADIUS	:	.998	.915	.783
MAX RADIUS	:	1.610	1.731	1.272
HORIZONTAL SPREAD	:	1.302	1.302	1.302
VERTICAL SPREAD	:	3.055	2.974	2.328
EXTREME SPREAD	:	3.079	2.974	2.351
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611788.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS= 2.651

VS= 2.192

GS= 2.672

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.355	1.407	.970
MINIMUM X	:	-1.296	-1.244	-1.068
MAXIMUM Y	:	1.287	1.043	1.068
MINIMUM Y	:	-.905	-.762	-.737
CENTROID X	:	.357	.305	.129
CENTROID Y	:	-.204	-.347	-.372
POA TO CENTROID in.	:	.411	.462	.394
MIN RADIUS	:	.496	.346	.342
MEAN RADIUS	:	1.019	.954	.881
MAX RADIUS	:	1.370	1.421	1.205
HORIZONTAL SPREAD	:	2.651	2.651	2.038
VERTICAL SPREAD	:	2.192	1.805	1.805
EXTREME SPREAD	:	2.672	2.672	2.236
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611766
10 Jun 1991

5000 RDS

CENTROIDAL DISTANCES

0 TO	1	.535703
1 TO	2	.40192
1 TO	3	.401659
1 TO	4	.0627694
1 TO	5	.192375

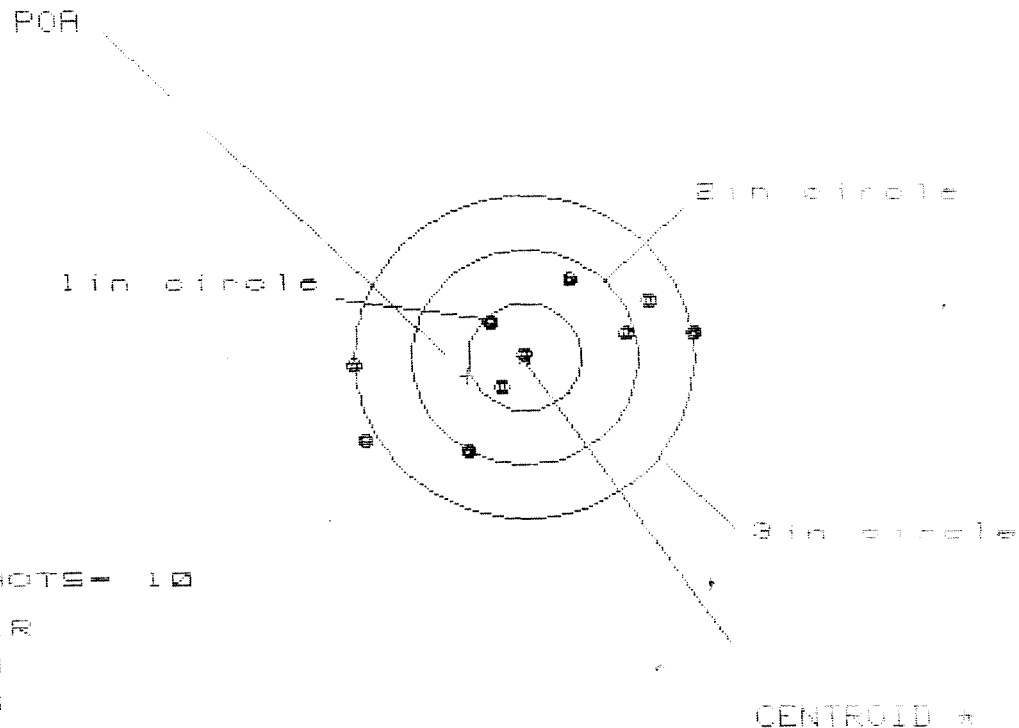
³
23 (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3708
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1456
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .398362
THE AMR FOR THIS RIFLE IS: .9948

18 Jun 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11766.1.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS= 3.007

VS= 1.602

GS= 3.072

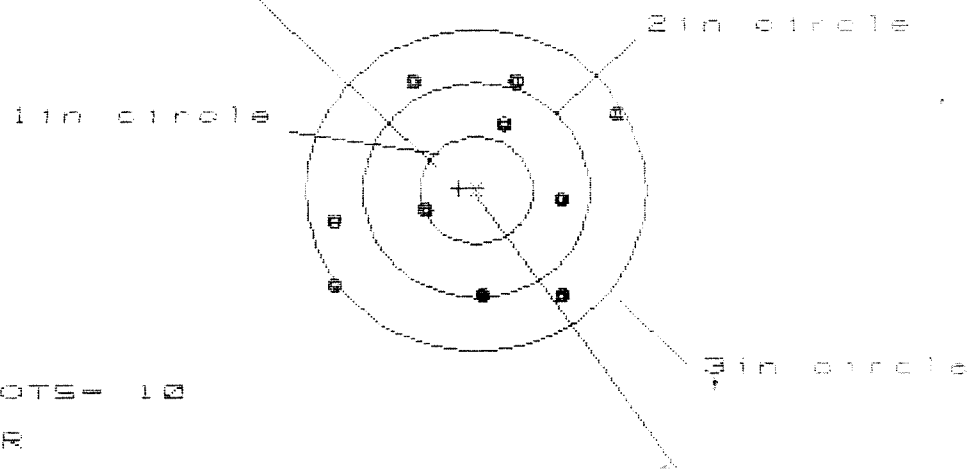
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.506	1.353	1.096
MINIMUM X	-1.501	-1.654	-1.484
MAXIMUM Y	.687	.597	.616
MINIMUM Y	-.915	-1.005	-.986
CENTROID X	.507	.660	.490
CENTROID Y	.173	.263	.244
POR TO CENTROID in.	.535	.710	.548
MIN RADIUS	.030	.153	.053
MEAN RADIUS	.943	.870	.786
MAX RADIUS	1.599	1.661	1.491
HORIZONTAL SPREAD	3.007	3.007	2.580
VERTICAL SPREAD	1.602	1.602	1.602
EXTREME SPREAD	3.072	3.024	2.657
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	7		

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611756.1.1.1

CENTERFIRE PATTERNS # 2

POR



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 6

HS= 2.562

VS= 2.082

GS= 2.987

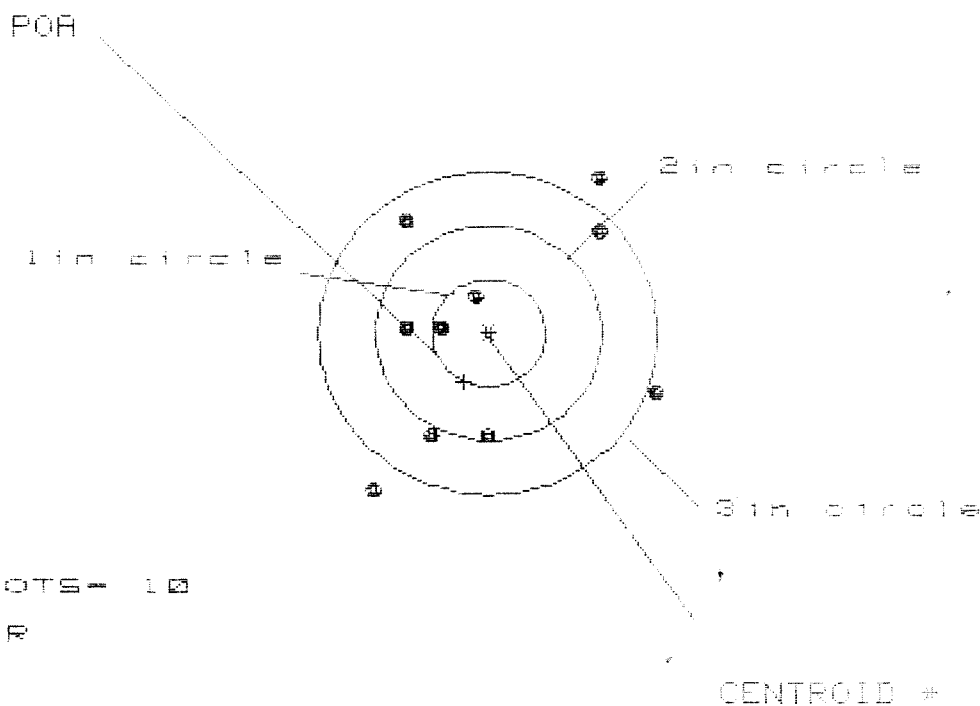
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.288	1.150	.796
MINIMUM X	:	-1.274	-1.412	-1.268
MAXIMUM Y	:	1.062	.962	1.036
MINIMUM Y	:	-1.020	-1.120	-1.046
CENTROID X	:	.155	.293	.149
CENTROID Y	:	-.021	.079	.005
POR TO CENTROID in.	:	.157	.303	.149
MIN RADIUS	:	.477	.550	.480
MEAN RADIUS	:	1.074	1.008	.967
MAX RADIUS	:	1.531	1.457	1.300
HORIZONTAL SPREAD	:	2.562	2.562	2.064
VERTICAL SPREAD	:	2.082	2.082	2.082
EXTREME SPREAD	:	2.987	2.735	2.340
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		9	

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6B11766.1.1.1

CENTERFIRE PATTERNS # 3



PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.474	1.586	1.473
MINIMUM X	:	-1.018	-.906	-.688
MAXIMUM Y	:	1.455	1.188	1.030
MINIMUM Y	:	-1.426	-1.264	-.969
CENTROID X	:	.220	.108	.221
CENTROID Y	:	.454	.292	.450
POA TO CENTROID in.	:	.504	.311	.501
MIN RADIUS	:	.379	.377	.383
MEAN RADIUS	:	1.129	1.035	.971
MAX RADIUS	:	1.772	1.629	1.565
HORIZONTAL SPREAD	:	2.492	2.492	2.161
VERTICAL SPREAD	:	2.881	2.452	1.999
EXTREME SPREAD	:	3.524	3.129	2.653
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8811756.1.1.1

CENTERFIRE PATTERNS # 4

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 7

3in = 7

HS= 3.060

VS= 2.121

GS= 3.663

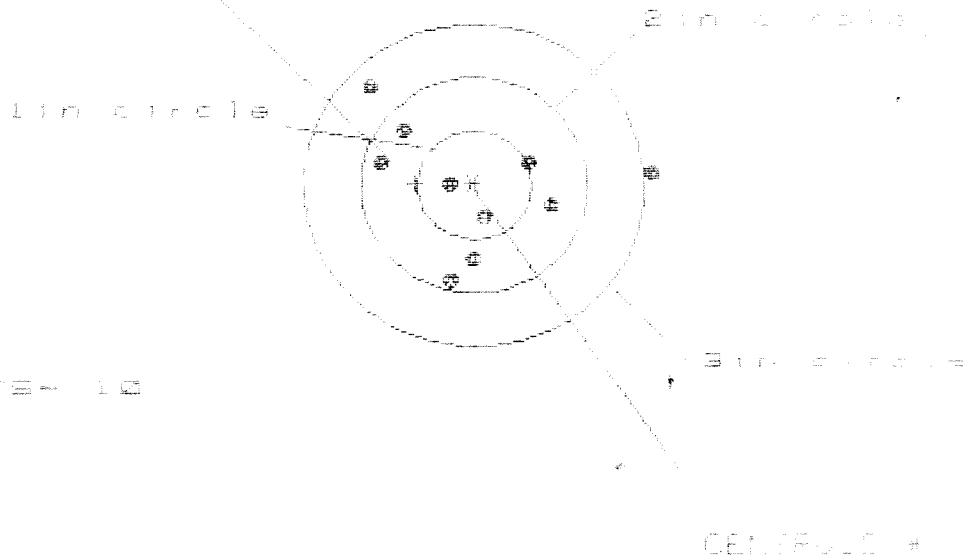
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.997	.977	.881
MINIMUM X	:	-1.063	-.841	-.937
MAXIMUM Y	:	.742	.731	.569
MINIMUM Y	:	-1.379	-1.296	-1.179
CENTROID X	:	.453	.231	.327
CENTROID Y	:	.141	.058	.221
POR TO CENTROID in.	:	.475	.239	.395
MIN RADIUS	:	.317	.467	.445
MEAN RADIUS	:	1.021	.901	.787
MAX RADIUS	:	2.130	1.507	1.507
HORIZONTAL SPREAD	:	3.060	1.818	1.818
VERTICAL SPREAD	:	2.121	2.027	1.748
EXTREME SPREAD	:	3.663	2.512	2.364
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		7	

18 Jun 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08611788.1.1.1

CENTERFIRE PATTERNS # 5

POR



OF SHOTS= 10

1 IN CIR

1 = 2

2 IN = 8

3 IN = 9

HS= 2.582

VS= 1.859

GS= 2.711

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.629	1.901	1.805
MINIMUM X	-1.951	-1.770	1.749
MAXIMUM Y	1.940	1.952	1.614
MINIMUM Y	-1.919	-1.907	-1.768
CENTROID X	1.519	1.338	1.484
CENTROID Y	-1.019	-1.031	-1.150
POR TO CENTROID in.	1.519	1.339	1.459
MIN RADIUS	1.190	1.035	1.185
MEAN RADIUS	1.807	1.695	1.618
MAX RADIUS	1.633	1.224	1.048
HORIZONTAL SPREAD	2.580	1.671	1.554
VERTICAL SPREAD	1.859	1.859	1.481
EXTREME SPREAD	2.711	2.011	1.000
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		9	

QP 0041

Endurance B/A & Bolt

C-6611766

MAGNETIC PARTICLE INSPECTION

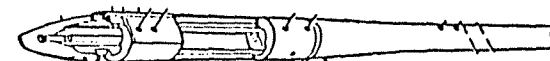
PART NUMBER _____

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

OPERATION NUMBER 615

METHOD	S I N G L E P A R T S			M U L T I P L E P A R T S		
	HEAD SHOT	CENTRAL	CONDUCTOR	HEAD SHOT	COIL SHOT	IN BASKET
NON-FLUORSECENT						
CONTINUOUS WET						
FLUORESCENT						
CONTINUOUS WET	Yes			Yes (2 Overlapping)		

SKETCH AND/OR REMARKS


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

Δ (M)

NON-FLUORSECENT
CONTINUOUS WETFLUORESCENT
CONTINUOUS WET Yes

Yes (2 Overlapping)

NON-FLUORESCENT
RESIDUAL WETFLUORESCENT
RESIDUAL WET

APPROVAL:

INSP. _____ LEV III _____

DATE: _____ DATE: _____

STAMPING

STEEL STAMP ON. Triangular stamp Δ 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 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.

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

BARBER - M24 M24008866207

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

Endurance B/A + Bolt

QP 0041 H C-66 11766

Rds. fired

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS	
				ACCEPTED	REJECTED
5-91	2,500	1	7741	1	0
6-10-91	5,000			1	0
11-91	6,000	1		1	0
12-91	7,000	1		1	0
13-91	8,000	1		1	0
14-91	9,000	1		1	0
17-91	10,000	1		1	0

OK
[Signature]