

BARBER - M24 0066334

FORM

UPC



0 47700 25716 7

06649207

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0066334

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

BARBER - M24 0066336

Remington



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

MODEL 700 TM M24

SERIAL NO.

C6649207

ORDER NO.

5716

20

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



5716 C6649207

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 # C6649207

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	LS
617	Drill and Tap Sight Holes		OCT 10 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/2/91	WB
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		12/27/91	WB

op. #	BARBER M24 0066338	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	4			12-27-91	AC
	G) Safety Off Force	4	4	4			12-27-91	AC
	H) Trigger Pull Test & Retainability						12/27/91	WB
	I) Firing Pin Indent	.022	.022	.021			12-27-91	AC
	J) Assemble Stock							
	K) Assemble Swivel Studs						12-30-91	AC
	L) Attach Front and Rear Sight Assemblies							
	M) Iron Sight Alignment							
	N) Detach Front & Rear Sights & place in numbered container							
	O) Attach Scope to Rifle							
	P) Detach & Attach Scope 20 Times							
640	Gallery Target & Test						12-30-91	AC
	A) Time						12-30-91	AC
	B) Malfunctions						12-30-91	AC
	C) Pierced Primers						12-30-91	AC
	D) Optical Clarity of Scope						12-30-91	AC
645	Inspect for Live Ammo						12-30-91	AC
655	Final Inspection							
	A) Headspace						12-30-91	AC
	B) Trigger Pull	2.37	2.36	2.38	2.38	2.33	12/30/91	WB
	C) Function						12-30-91	AC
660	Pack						2-25-92	AC

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6649207

DATE 12/27/91

TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.41	2.30	2.37	2.37	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.37	2.31	2.26	2.36	
PULL #3	2.34	2.26	2.39	2.38	
PULL #4	2.35	2.29	2.42	2.38	
PULL #5	2.36	2.21	2.38	2.33	
TOTAL	11.83	11.37	11.82	11.82	
AVG.	2.37	2.27	2.36	2.36	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.08	2.90		
PULL #2	3.03	2.97		
PULL #3	3.00	2.99		
PULL #4	3.05	2.90		
PULL #5	3.05	3.03		
TOTAL	15.21	14.79		
AVG.	3.04	2.96		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.08	4.07		4.08
PULL #2	4.06	4.05		3.92
PULL #3	3.85	3.90		3.97
PULL #4	4.07	4.07		4.12
PULL #5	3.85	3.98		4.09
TOTAL	19.91	20.07		20.18
AVG.	3.98	4.01		4.03

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649207
30 Dec 1991

CENTROIDAL DISTANCES

0 TO 1	.534161
1 TO 2	.682003
1 TO 3	1.04652
1 TO 4	.901233
1 TO 5	.746813

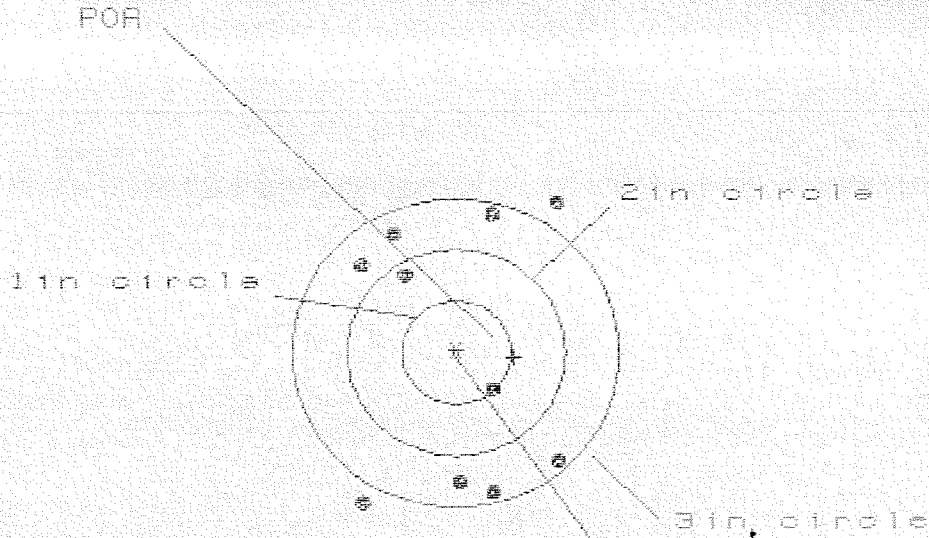
$\frac{2}{1.53}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1162
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1052
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .156747
THE AMR FOR THIS RIFLE IS: 1.07

38 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649207

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 2

3in = 8

HS= 1.768

VS= 2.846

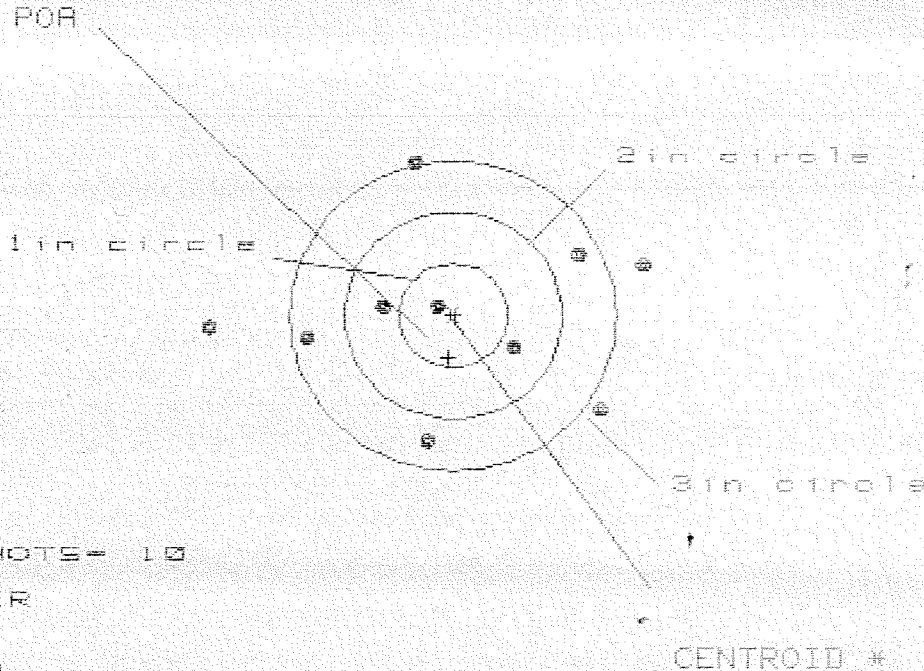
GS= 3.342

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.908	1.007	.912
MINIMUM X	-.860	-.761	-.835
MAXIMUM Y	1.415	1.514	1.355
MINIMUM Y	-1.431	-1.274	-1.381
CENTROID X	-.532	-.631	-.536
CENTROID Y	.048	-.109	.050
POA TO CENTROID in.	.534	.640	.538
MIN RADIUS	.417	.411	.422
MEAN RADIUS	1.255	1.200	1.151
MAX RADIUS	1.672	1.570	1.413
HORIZONTAL SPREAD	1.768	1.768	1.747
VERTICAL SPREAD	2.846	2.788	2.736
EXTREME SPREAD	3.342	3.026	2.736
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	8		

38 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CGB49207

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 3.986

VS= 2.707

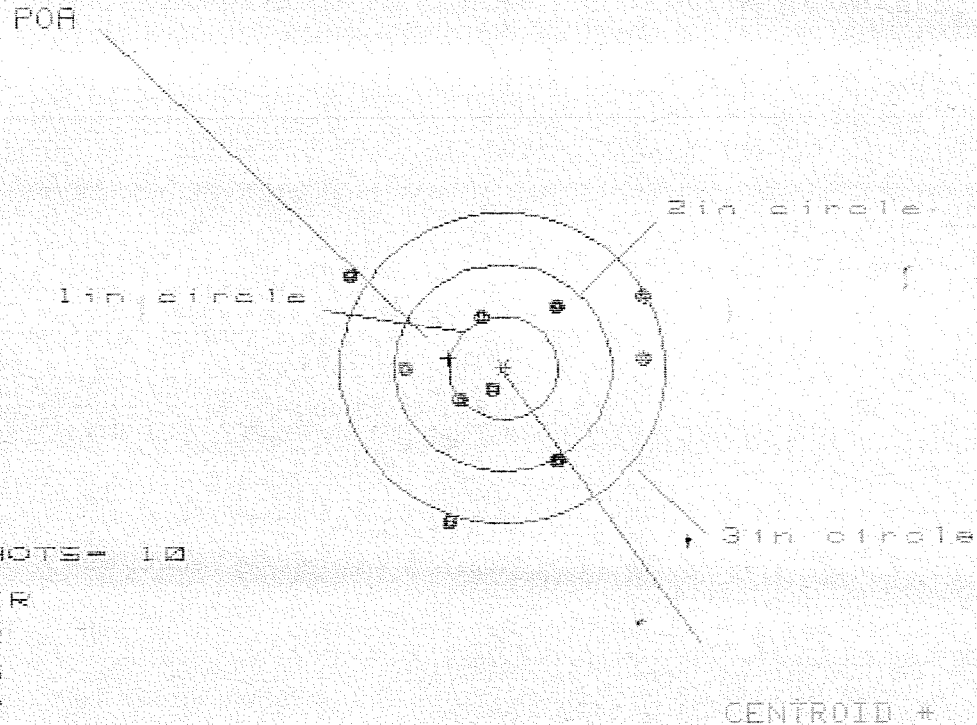
GS= 4.032

PATTERN #	2
SHOTS (BEST OF)	10
MAXIMUM X	1.743
MINIMUM X	-2.243
MAXIMUM Y	1.528
MINIMUM Y	-1.179
CENTROID X	.046
CENTROID Y	.410
POA TO CENTROID in.	.412
MIN RADIUS	.116
MEAN RADIUS	1.252
MAX RADIUS	2.247
HORIZONTAL SPREAD	3.986
VERTICAL SPREAD	2.707
EXTREME SPREAD	4.032
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	3
NUMBER IN THREE INCH CIRCLE =	6

38 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649207

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.722

VS= 2.367

GS= 2.902

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.333
MINIMUM X	-1.389
MAXIMUM Y	.874
MINIMUM Y	-1.493
CENTROID X	.504
CENTROID Y	-.100
POA TO CENTROID in.	.514
MIN RADIUS	.187
MEAN RADIUS	.992
MAX RADIUS	1.641
HORIZONTAL SPREAD	2.722
VERTICAL SPREAD	2.367
EXTREME SPREAD	2.902
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	7

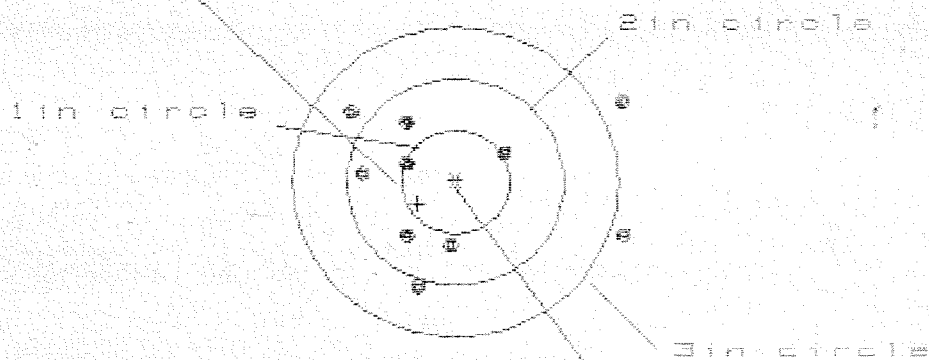
30 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8649207

CENTERFIRE PATTERNS

4

POR



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS = 2.513

VS = 1.836

GS = 2.775

CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.548	1.708	.861
MINIMUM X	-.965	-.793	-.579
MAXIMUM Y	.819	.821	.773
MINIMUM Y	-1.017	-.926	-.974
CENTROID X	.354	.182	-.032
CENTROID Y	.213	.122	.170
POR TO CENTROID in.	.413	.219	.173
MIN RADIUS	.457	.373	.238
MEAN RADIUS	.955	.825	.668
MAX RADIUS	1.751	1.750	.974
HORIZONTAL SPREAD	2.513	2.501	1.440
VERTICAL SPREAD	1.836	1.747	1.747
EXTREME SPREAD	2.775	2.775	1.848
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	8		

18 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/CG649207

CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 8

HS= 2.531

VS= 2.185

GS= 2.724

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.998
MINIMUM X	-1.533
MAXIMUM Y	1.025
MINIMUM Y	-1.160
CENTROID X	.209
CENTROID Y	-.045
POA TO CENTROID in.	.214
MIN RADIUS	.248
MEAN RADIUS	.897
MAX RADIUS	1.533
CENTRAL SPREAD	2.531
SPREAD	2.185
SPREAD	2.724
ONE INCH CIRCLE	3
TWO INCH CIRCLE	5
THREE INCH CIRCLE	8

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	1228	90	RW
600	Proof	1228	90	RW
607	Check Headspace	1228	90	RW
610	Dis-assemble Gun	1228	90	RW
612	Magnaflux Barrel Action		1-7-91	KR
	Magnaflux Bolt		11	KR
615	Rollmark Caliber		11	GL
617	Drill and Tap Sight Holes	1 10	91	Fib
618	Polish Barrel	1 10	91	WB
620	Apply Coatings (Barrel Action)		1-18-91	TJA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		1/19/91	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		1/19/91	RW
	C) Inspect Ejector Hole for Chamfer		1/19/91	RW
	D) Oil Firing Pin Ass'y		1/19/91	RW
	E) Adjust Trigger Pull to Min Setting and Stake		1-23-91	RI

op. #	BARBER - M24 0066347 OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4 1/2	4 1/2			1/23/91	WLB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			1/23/91	WLB
	H) Trigger Pull Test & Retainability						1-23-91	JH
	I) Firing Pin Indent	.020	.0205	.0205			1/23/91	WLB
	J) Assemble Stock						1/23/91	RW
	K) Assemble Swivel Studs							
	L) Attach Front and Rear Sight Assemblies						1/23/91	RW
	M) Iron Sight Alignment						1/23/91	RW
	N) Detach Front & Rear Sights & place in numbered container						1/23/91	RW
	O) Attach Scope to Rifle						1/23/91	RW
	P) Detach & Attach Scope 20 Times						1/23/91	RW
640	Gallery Target & Test						1/23/91	K2
	A) Time							K2
	B) Malfunctions							K2
	C) Pierced Primers							K2
	D) Optical Clarity of Scope							K2
645	Inspect for Live Ammo						1/23/91	WLB
655	Final Inspection							
	A) Headspace						1-28/91	JH
	B) Trigger Pull	2.54	2.51	2.51	2.50	2.52	1-28-91	JH
	C) Function						1-28-91	JH
660	Pack							

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6594488

DATE 1-23-91

TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.39	2.45	2.41	2.54	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.31	2.39	2.37	2.51	
PULL #3	2.39	2.39	2.29	2.51	
PULL #4	2.36	2.37	2.38	2.50	
PULL #5	2.41	2.38	2.30	2.52	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.27		
PULL #2	3.22	3.12		
PULL #3	3.33	3.27		
PULL #4	3.33	3.30		
PULL #5	3.39	3.41		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.36	4.43		4.21
PULL #2	4.27	4.47		4.16
PULL #3	4.26	4.60		4.33
PULL #4	4.28	4.46		4.30
PULL #5	4.22	4.54		4.37
TOTAL				
AVG.				

SWS ENDURANCE TEST REPORT

SERIAL NO. C6594489 SHOOTER AW DATE 2/4/91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	120	OK	NONE
		2920	TOTAL 2/4/91	
	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	40	OK	NONE
		3320	TOTAL 2-4-91	KB
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	120	OK	NONE
		3740	TOTAL 2/5/91 AW	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6594488 SHOOTER R. Bailey DATE 2/5/91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
LC 865136002	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	40	OK	NONE
		4140	TOTAL 2/5/91	R.B.
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	60	OK	NONE
		4500	TOTAL 2/6/91	AW
Test + Target 2/6/91				NF
		60	TEST & TGT	
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	80	OK	NONE
		4940	TOTAL 2/7/91	AW
Test + Target 60 Rds 2/7/91				NF
		5000	RDS 2-8-91	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6594488 SHOOTER AW DATE 2/13

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
		7900	TOTAL 2/13/91	AW
	7.62	100	OK	NONE
		8000	TOTAL 2/14/91	AW
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	60	OK	NONE
		8660	TOTAL 2/14/91	AW
	7.62	200	OK	NONE
	7.62	140	OK	NONE
		9000	TOTAL 2/15/91	AW

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06594488
24 Jan 1991

0 Rounds

CENTROIDAL DISTANCES

0 TO	1	.442159
1 TO	2	.64405
1 TO	3	.57
1 TO	4	.300328
1 TO	5	.400151

1
32

-----POA

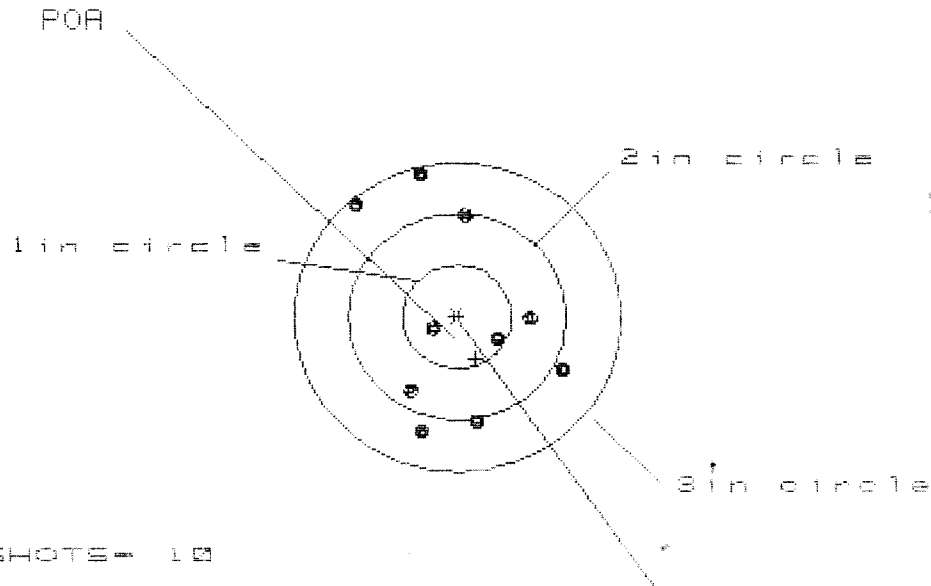
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0886
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0428
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0983961

THE AMR FOR THIS RIFLE IS: .8898

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06534488

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS = 1.897

VS = 2.581

GS = 2.582

CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.958	.918	.795
MINIMUM X	-.939	-.979	-.564
MAXIMUM Y	1.437	1.283	1.356
MINIMUM Y	-1.144	-.985	-.824
CENTROID X	-.168	-.128	-.085
CENTROID Y	.409	.250	.089
POA TO CENTROID in.	.442	.280	.089
MIN RADIUS	.241	.261	.227
MEAN RADIUS	.932	.839	.710
MAX RADIUS	1.482	1.614	1.359
HORIZONTAL SPREAD	1.897	1.897	1.359
VERTICAL SPREAD	2.581	2.268	2.180
EXTREME SPREAD	2.582	2.512	2.212
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C85944B8

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 8

HS = 1.141

VS = 4.086

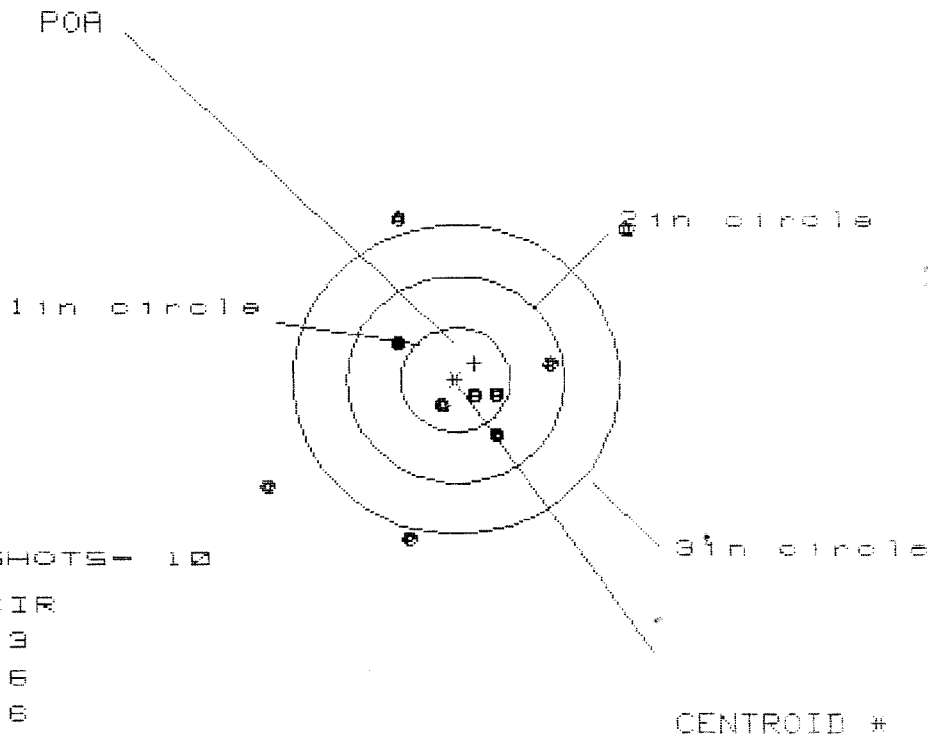
GS = 4.143

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.439	.478	.449
MINIMUM X	:	-.703	-.663	-.692
MAXIMUM Y	:	2.417	1.258	1.082
MINIMUM Y	:	-1.679	-1.411	-1.217
CENTROID X	:	.112	.072	.101
CENTROID Y	:	-.171	-.439	-.263
POA TO CENTROID in.	:	.204	.445	.282
MIN RADIUS	:	.112	.272	.128
MEAN RADIUS	:	.946	.765	.660
MAX RADIUS	:	2.442	1.430	1.400
HORIZONTAL SPREAD	:	1.141	1.141	1.141
VERTICAL SPREAD	:	4.086	2.669	2.299
EXTREME SPREAD	:	4.143	2.691	2.427
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C65944B8

CENTERFIRE PATTERNS # 3

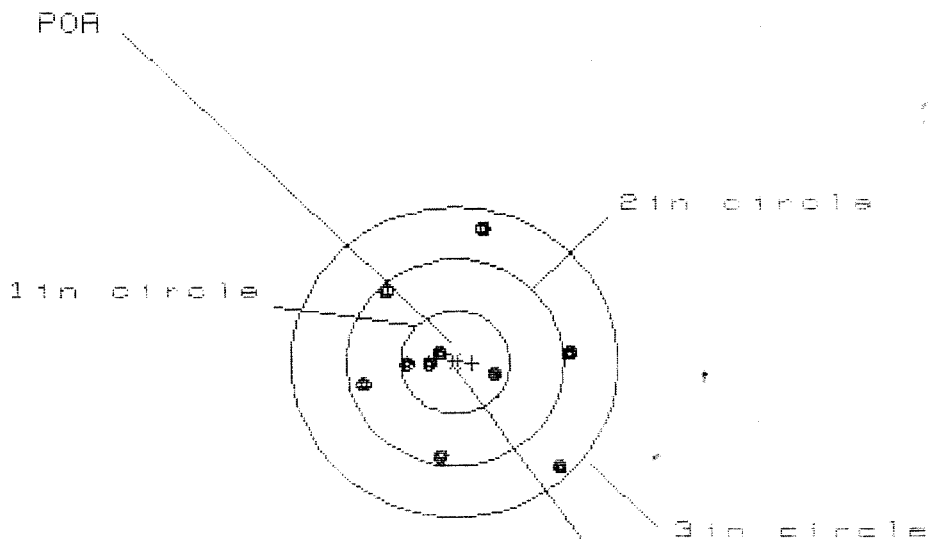


PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.545	1.044	.848
MINIMUM X	-1.733	-1.561	-1.561
MAXIMUM Y	1.548	1.710	1.607
MINIMUM Y	-1.520	-1.358	-1.461
CENTROID X	-.168	-.340	-.144
CENTROID Y	-.161	-.323	-.220
POA TO CENTROID in.	.232	.469	.263
MIN RADIUS	.236	.104	.176
MEAN RADIUS	1.032	.913	.758
MAX RADIUS	2.125	1.767	1.702
HORIZONTAL SPREAD	3.278	2.605	1.409
VERTICAL SPREAD	3.068	3.068	3.068
EXTREME SPREAD	4.092	3.070	3.070
NUMBER IN ONE INCH CIRCLE	= 3		
NUMBER IN TWO INCH CIRCLE	= 6		
NUMBER IN THREE INCH CIRCLE	= 6		

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594488

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 1.881

VS = 2.333

GS = 2.441

CENTROID *

PATTERN #	5	5	5
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.046	1.150	1.190
MINIMUM X	-.835	-.731	-.691
MAXIMUM Y	1.333	1.222	.721
MINIMUM Y	-1.000	-.979	-.826
CENTROID X	-.157	-.261	-.301
CENTROID Y	.009	.120	-.033
POA TO CENTROID in.	.158	.287	.303
MIN RADIUS	.165	.055	.118
MEAN RADIUS	.774	.681	.590
MAX RADIUS	1.368	1.263	1.196
HORIZONTAL SPREAD	1.881	1.881	1.881
VERTICAL SPREAD	2.333	2.201	1.547
EXTREME SPREAD	2.441	2.228	1.908
NUMBER IN ONE INCH CIRCLE =	4		
NUMBER IN TWO INCH CIRCLE =	7		

NUMBER IN THREE INCH CIRCLE = 10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594488
29 Jan 1991

500 ROUNDS

CENTROIDAL DISTANCES

0 TO	1	.163783
1 TO	2	.278539
1 TO	3	.30536
1 TO	4	.26703
1 TO	5	.294878

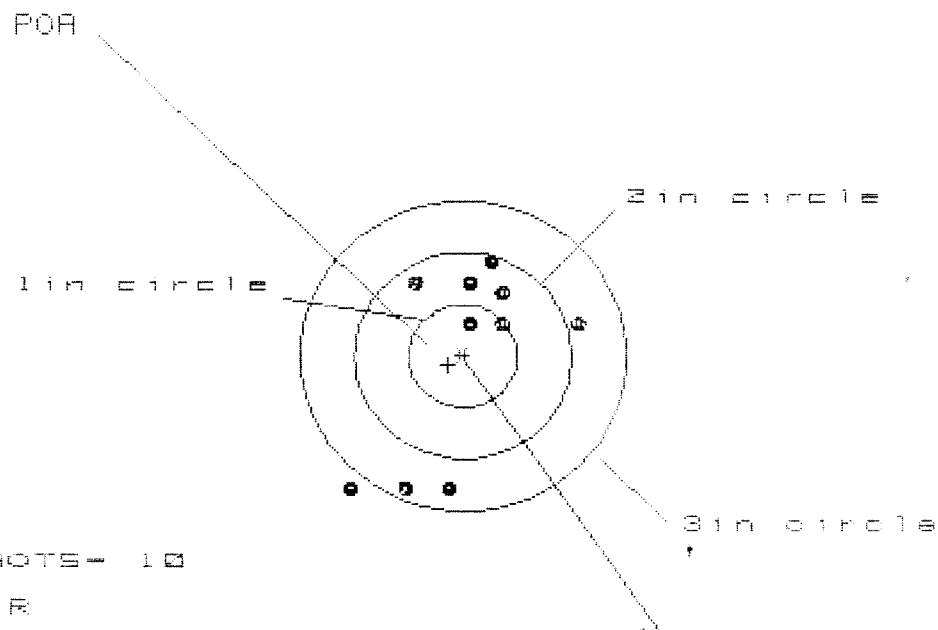
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0156
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0464
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0489522
THE AMR FOR THIS RIFLE IS: .96

29 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08594488.1

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1in = 1

2in = 6

3in = 9

HS = 2.126

VS = 2.231

GS = 2.640

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.081	.965	.882
MINIMUM X	-1.044	-.669	-.595
MAXIMUM Y	.917	.774	.592
MINIMUM Y	-1.314	-1.457	-1.604
CENTROID X	.140	.257	.340
CENTROID Y	.085	.228	.410
POA TO CENTROID in.	.164	.343	.533
MIN RADIUS	.359	.205	.108
MEAN RADIUS	.940	.795	.601
MAX RADIUS	1.658	1.603	1.635
HORIZONTAL SPREAD	2.126	1.634	1.477
VERTICAL SPREAD	2.231	2.231	2.196
EXTREME SPREAD	2.640	2.362	2.222
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

29 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/09394488.1

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

CENTROID *

HS = 2.165

VS = 2.318

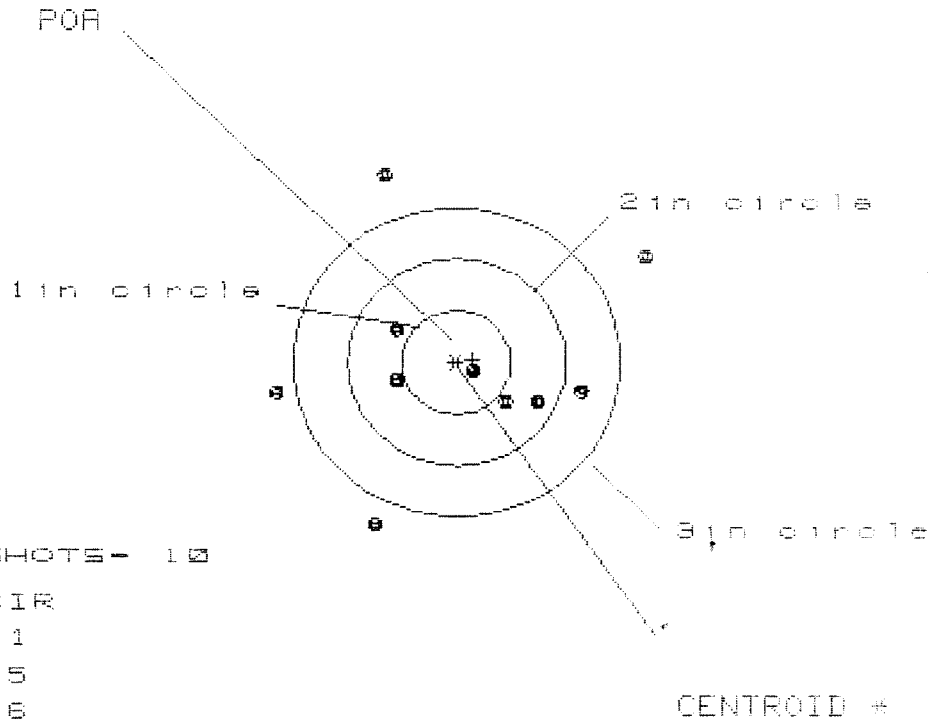
GS = 2.877

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.236	1.182	.855
MINIMUM X	-.929	-.983	-.835
MAXIMUM Y	.815	.648	.727
MINIMUM Y	-1.503	-.731	-.652
CENTROID X	-.888	-.834	-.182
CENTROID Y	-.075	.092	.013
POA TO CENTROID in.	.116	.098	.182
MIN RADIUS	.139	.265	.113
MEAN RADIUS	.796	.725	.601
MAX RADIUS	1.580	1.341	1.122
HORIZONTAL SPREAD	2.165	2.165	1.690
VERTICAL SPREAD	2.318	1.379	1.379
EXTREME SPREAD	2.877	2.286	1.848
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

29 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06534488.1

CENTERFIRE PATTERNS # 3



PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.738
MINIMUM X	-1.659
MAXIMUM Y	1.856
MINIMUM Y	-1.599
CENTROID X	-0.146
CENTROID Y	-0.022
POR TO CENTROID in.	0.147
MIN RADIUS	0.145
MEAN RADIUS	1.137
MAX RADIUS	1.995
HORIZONTAL SPREAD	3.396
VERTICAL SPREAD	3.455
EXTREME SPREAD	3.632
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	5
NUMBER IN THREE INCH CIRCLE =	6

25 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C65944B8.1

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS - 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS = 3.039

VS = 2.167

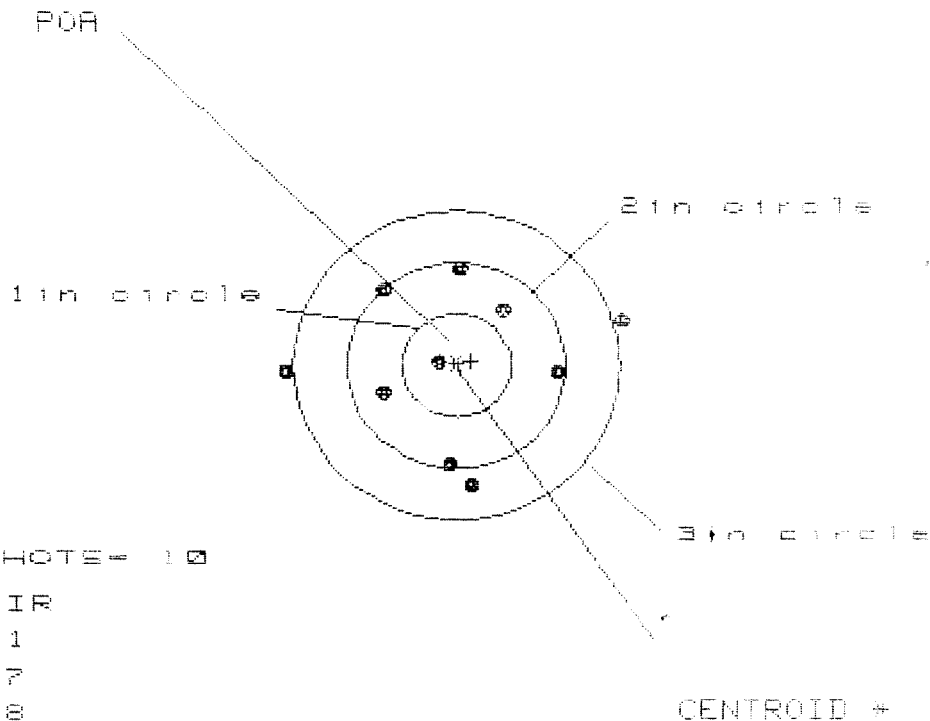
GS = 3.389

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.239	1.039	.821
MINIMUM X	:	-1.800	-.740	-.610
MAXIMUM Y	:	.978	.846	.868
MINIMUM Y	:	-1.189	-1.216	-1.194
CENTROID X	:	.144	.344	.214
CENTROID Y	:	-.182	-.050	-.072
POA TO CENTROID in.	:	.232	.348	.226
MIN RADIUS	:	.347	.126	.256
MEAN RADIUS	:	.937	.745	.716
MAX RADIUS	:	2.158	1.407	1.327
HORIZONTAL SPREAD	:	3.039	1.779	1.431
VERTICAL SPREAD	:	2.167	2.062	2.062
EXTREME SPREAD	:	3.389	2.236	2.112
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

28 Jan 1981

FILE:/PATTERNING/CENTERFIRE_PATT/08534488.1

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS = 3.084

VS = 2.100

GS = 3.142

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	1.540
MINIMUM X	-1.554
MAXIMUM Y	.890
MINIMUM Y	-1.210
CENTROID X	-.128
CENTROID Y	-.038
POA TO CENTROID in.	.134
MIN RADIUS	.203
MEAN RADIUS	.982
MAX RADIUS	1.609
HORIZONTAL SPREAD	3.094
VERTICAL SPREAD	2.100
EXTREME SPREAD	3.142
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	8

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06594488
7 Feb 1991

4500 RDS

CENTROIDAL DISTANCES

0 TO	1	.212659
1 TO	2	.344398
1 TO	3	.261222
1 TO	4	.105005
1 TO	5	.26011

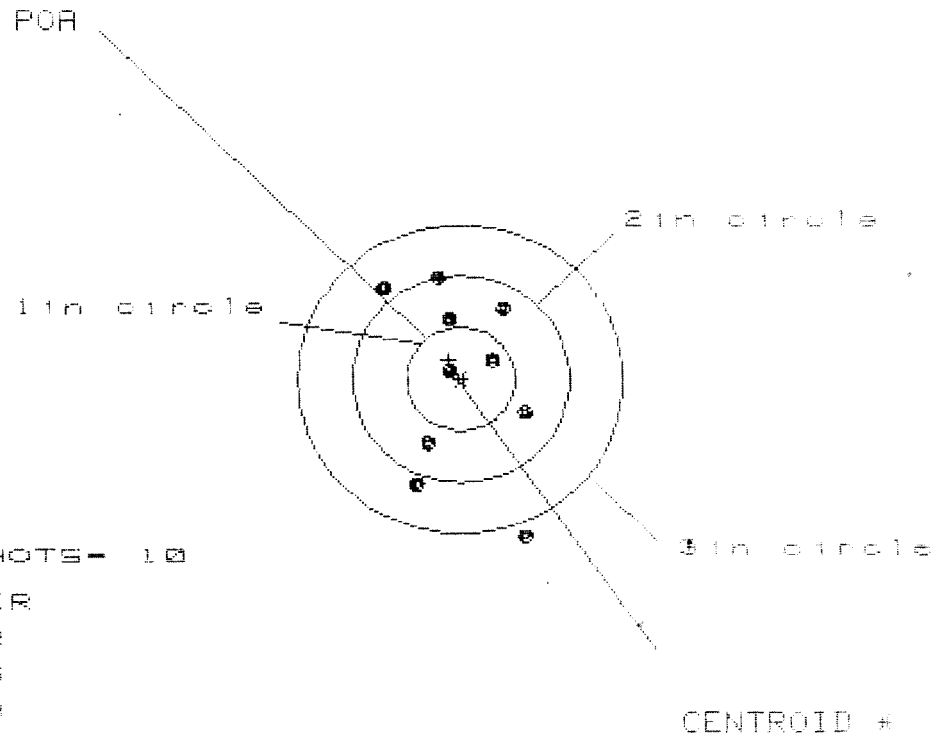
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0038
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0458
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0459574
THE AMR FOR THIS RIFLE IS: 1.006

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594488.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.363

VS= 2.481

GS= 2.724

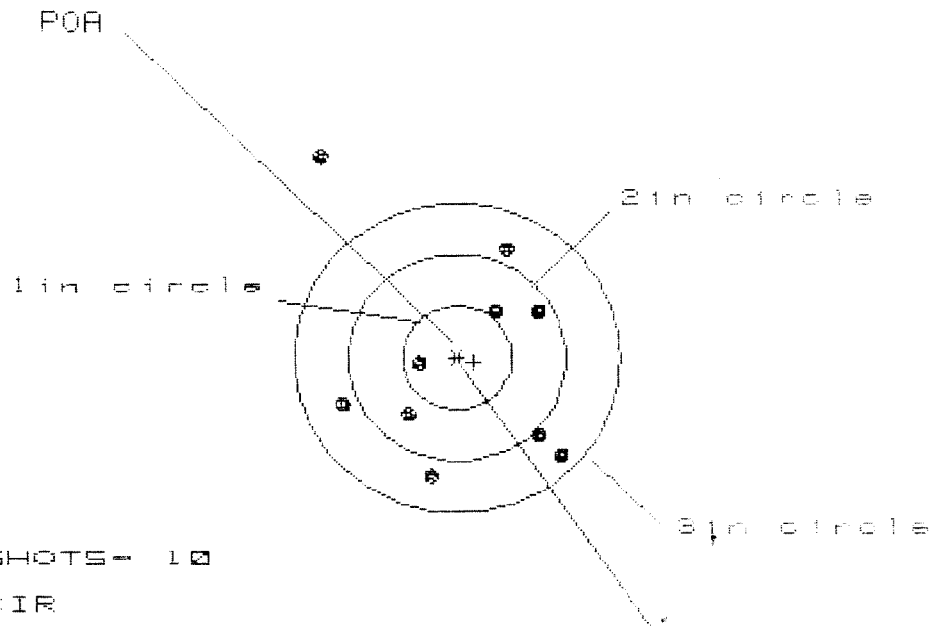
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.611	.672	.587
MINIMUM X	-.752	-.684	-.382
MAXIMUM Y	1.013	.850	.941
MINIMUM Y	-1.468	-1.217	-1.127
CENTROID X	.110	.042	.127
CENTROID Y	-.182	-.019	-.110
POA TO CENTROID in.	.212	.046	.168
MIN RADIUS	.144	.084	.130
MEAN RADIUS	.801	.687	.645
MAX RADIUS	1.590	1.253	1.190
HORIZONTAL SPREAD	1.363	1.356	.969
VERTICAL SPREAD	2.481	2.067	2.067
EXTREME SPREAD	2.724	2.071	2.071
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	9		

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594488.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.131

VS= 3.186

GS= 3.662

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.910	.774	.750
MINIMUM X	:	-1.221	-1.160	-1.063
MAXIMUM Y	:	1.997	1.270	1.175
MINIMUM Y	:	-1.189	-.967	-1.062
CENTROID X	:	-.149	-.013	-.110
CENTROID Y	:	.045	-.177	-.082
POA TO CENTROID in.	:	.155	.178	.137
MIN RADIUS	:	.390	.571	.448
MEAN RADIUS	:	1.083	.927	.892
MAX RADIUS	:	2.341	1.318	1.258
HORIZONTAL SPREAD	:	2.131	1.934	1.813
VERTICAL SPREAD	:	3.186	2.237	2.237
EXTREME SPREAD	:	3.662	2.363	2.363
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	4		
NUMBER IN THREE INCH CIRCLE	=	9		

7 Feb 1981

FILE:/PATTERNING/CENTERFIRE_PATT/06534488.1.1

CENTERFIRE PATTERNS # 3

POR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 10

HS= 2.156

VS= 2.427

GS= 2.487

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.108	1.089	.956
MINIMUM X	:	-1.048	-1.067	-.863
MAXIMUM Y	:	1.030	.875	.753
MINIMUM Y	:	-1.397	-.972	-1.016
CENTROID X	:	.076	.095	.228
CENTROID Y	:	.077	.232	.354
POR TO CENTROID in.	:	.108	.251	.421
MIN RADIUS	:	.339	.495	.341
MEAN RADIUS	:	.982	.927	.840
MAX RADIUS	:	1.407	1.443	1.145
HORIZONTAL SPREAD	:	2.156	2.156	1.819
VERTICAL SPREAD	:	2.427	1.847	1.769
EXTREME SPREAD	:	2.487	2.453	2.176
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Feb 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C65944B8.1.1

CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS - 10

IN CIR

1in = 1

2in = 5

3in = 9

HS = 2.274

VS = 2.216

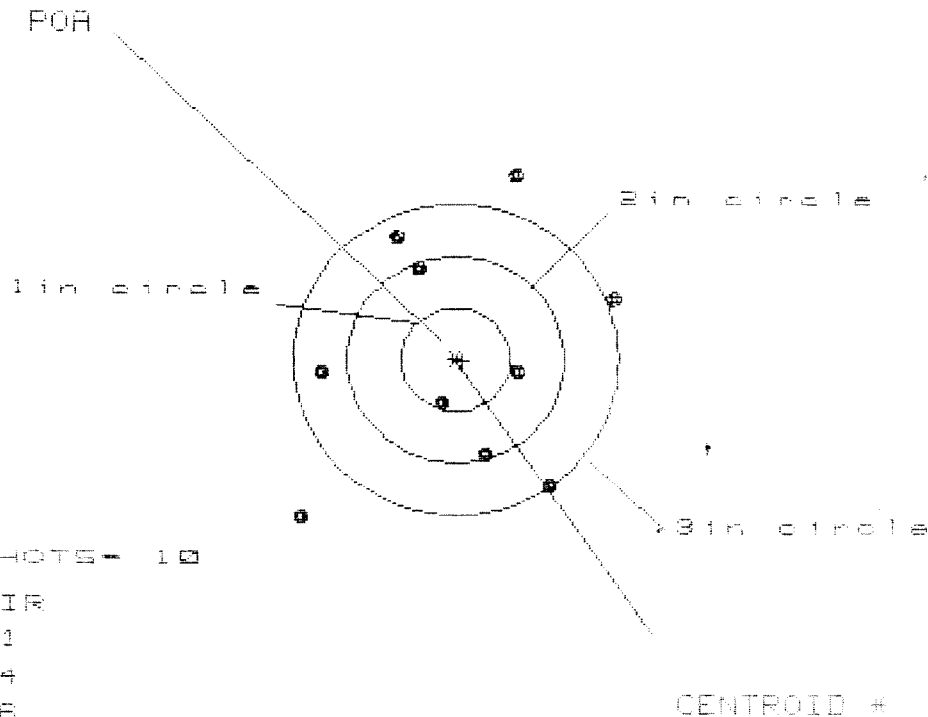
GS = 2.274

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.128	1.107	.961
MINIMUM X	:	-1.146	-1.167	-1.181
MAXIMUM Y	:	.653	.479	.451
MINIMUM Y	:	-1.563	-1.502	-1.530
CENTROID X	:	.005	.026	.172
CENTROID Y	:	-.183	-.009	.019
POA TO CENTROID in.	:	.183	.027	.173
MIN RADIUS	:	.264	.135	.264
MEAN RADIUS	:	.914	.799	.744
MAX RADIUS	:	1.574	1.188	1.294
HORIZONTAL SPREAD	:	2.274	2.274	2.142
VERTICAL SPREAD	:	2.216	.981	.981
EXTREME SPREAD	:	2.274	2.274	2.165
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/085944B8.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 5

HS = 2.971

VS = 3.326

GS = 3.921

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.486	1.321	1.374
MINIMUM X	-1.485	-1.354	-1.301
MAXIMUM Y	1.772	1.599	1.179
MINIMUM Y	-1.554	-1.413	-1.213
CENTROID X	-.061	.104	.051
CENTROID Y	.014	.187	-.013
POA TO CENTROID in.	.062	.214	.053
MIN RADIUS	.436	.454	.416
MEAN RADIUS	1.249	1.148	1.052
MAX RADIUS	2.150	1.655	1.515
HORIZONTAL SPREAD	2.971	2.675	2.675
VERTICAL SPREAD	3.326	3.012	2.392
EXTREME SPREAD	3.921	3.028	2.869
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	5		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594488
8 Feb 1991

5000 RDS

CENTROIDAL DISTANCES

0 TO	1	.0594054
1 TO	2	.00948683
1 TO	3	.103368
1 TO	4	.132401
1 TO	5	.267

5
4
3
2
1
0
←----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0568
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0642
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0857198

THE AMR FOR THIS RIFLE IS: .7922

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08534488.1.1.1

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

CENTROID #

OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.146

VS= 2.173

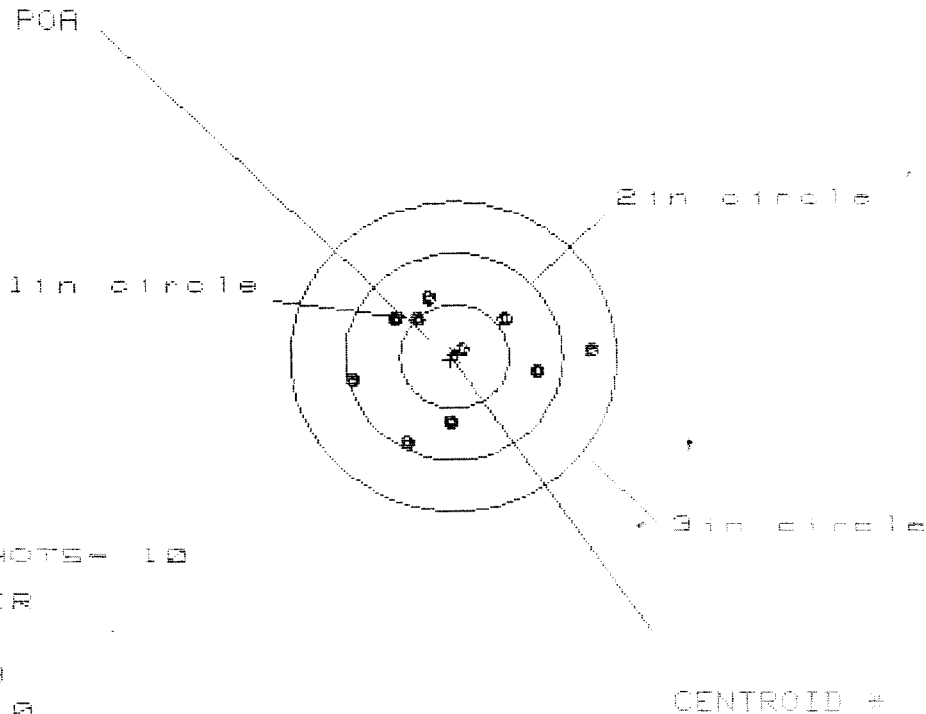
GS= 2.588

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.423	.805	.735
MINIMUM X	-.723	-.565	-.497
MAXIMUM Y	.987	1.015	.870
MINIMUM Y	-1.186	-1.158	-.890
CENTROID X	.048	-.110	-.040
CENTROID Y	.035	.007	.152
POA TO CENTROID in.	.059	.111	.157
MIN RADIUS	.048	.113	.125
MEAN RADIUS	.767	.682	.611
MAX RADIUS	1.445	1.289	.910
HORIZONTAL SPREAD	2.146	1.370	1.232
VERTICAL SPREAD	2.173	2.173	1.760
EXTREME SPREAD	2.588	2.283	1.778
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6534480.1.1.1

CENTERFIRE PATTERNS # 2



HS= 2.242

VS= 1.406

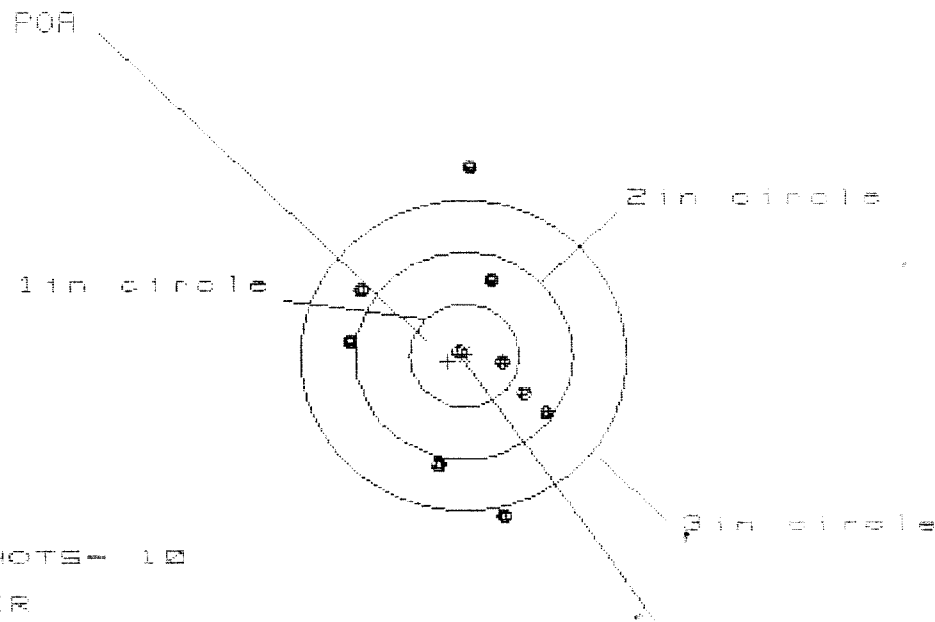
GS= 2.256

PATTERN #	2		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.254	.940	.834
MINIMUM X	-.988	-.848	-.515
MAXIMUM Y	.550	.557	.536
MINIMUM Y	-.856	-.849	-.870
CENTROID X	.039	-.101	.005
CENTROID Y	.032	.025	.046
POA TO CENTROID in.	.050	.104	.047
MIN RADIUS	.158	.275	.173
MEAN RADIUS	.714	.650	.608
MAX RADIUS	1.256	.943	.975
HORIZONTAL SPREAD	2.242	1.788	1.349
VERTICAL SPREAD	1.406	1.406	1.406
EXTREME SPREAD	2.256	1.791	1.491
NUMBER IN ONE INCH CIRCLE	=	1	
NUMBER IN TWO INCH CIRCLE	=	8	
NUMBER IN THREE INCH CIRCLE	=	10	

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/085344B0.1.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 1.859

VS= 3.362

GS= 3.371

CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.765
MINIMUM X	-1.094
MAXIMUM Y	1.849
MINIMUM Y	-1.513
CENTROID X	.149
CENTROID Y	.057
POA TO CENTROID in.	.160
MIN RADIUS	.063
MEAN RADIUS	.952
MAX RADIUS	1.851
HORIZONTAL SPREAD	1.859
VERTICAL SPREAD	3.362
EXTREME SPREAD	3.371
NUMBER IN ONE INCH CIRCLE	2
NUMBER IN TWO INCH CIRCLE	5
NUMBER IN THREE INCH CIRCLE	8

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PAT/08594488.1.1.1

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 5

2 in = 5

3 in = 8

LS = 2.114

VS = 2.843

GS = 2.852

PATTERN #

4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.091	1.081	1.042
MINIMUM X	:	-1.023	-1.033	-1.072
MAXIMUM Y	:	1.607	1.604	1.472
MINIMUM Y	:	-1.236	-1.057	-0.917
CENTROID X	:	.117	.127	.166
CENTROID Y	:	-.078	-.257	-.125
POA TO CENTROID in.	:	.141	.286	.208
MIN RADIUS	:	.113	.171	.177
MEAN RADIUS	:	.773	.699	.621
MAX RADIUS	:	1.609	1.196	1.172
HORIZONTAL SPREAD	:	2.114	2.114	2.114
VERTICAL SPREAD	:	2.843	1.661	1.389
EXTREME SPREAD	:	2.852	2.253	2.253
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=		9	

7 Feb 1961

FILE: PATTERNING/CENTERFIRE_PATT/C6594468.1.1.1

CENTERFIRE PATTERNS # 5

POR

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CTR

1 in = 5

2 in = 7

3 in = 10

ME = 1.966

MS = 2.663

CS = 2.543

CENTR 11

PATTERN #

5

SHOTS	FEET OF	10	3	2
MAXIMUM X	:	1.657	1.512	1.496
MINIMUM X	:	-1.308	-1.512	-1.520
MAXIMUM Y	:	1.471	1.393	1.047
MINIMUM Y	:	-1.762	-1.840	-1.504
CENTROID X	:	-1.059	1.076	1.032
CENTROID Y	:	1.275	1.353	1.178
POR TO CENTROID (in)	:	1.284	1.361	1.201
MIN RADIUS	:	1.171	1.336	1.511
MEAN RADIUS	:	1.755	1.681	1.552
MAX RADIUS	:	1.482	1.399	1.064
HORIZONTAL SPREAD	:	1.966	1.924	1.024
VERTICAL SPREAD	:	2.233	2.233	1.713
EXTREME SPREAD	:	2.543	2.236	1.726
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

QP 0041

Endurance B/A - M-24 SWS
#C-6594488

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	COIL SHOT	HEAD SHOT	CENTRAL CONDUCTOR	COIL SHOT IN BASKET AMPERES

NON-FLUORSECENT
CONTINUOUS WET

FLUORESCENT :
CONTINUOUS WET Yes Yes (2 Overlapping)

NON-FLUORESCENT
RESIDUAL WET

FLUORESCENT
RESIDUAL WET



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

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

ACCEPTANCE STANDARD

STEEL STAMP ON. Triangular stamp Δ and letter "M" circled
OTHER Location-right side near Receiver.

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. Karl C. Rice
INSP. 8158-3096

FORM QP-0041-1

"B" Stamp

BARBER - M24 0066384

Endurance B/A- M-24 SWS

QP 0041 #C 659 44 88

Rounds

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS ACCEPTED	REJECTED
2-4-91	3,500	1	OK	1	0
2-8-91	5,000	1	OK	1	0
2-11-91	6,000	1	OK	1	0
2-12-91	7,000	1	OK	1	0
2-14-91	8,000	1	OK	1	0
2-15-91	9,000	1	OK	1	0
2-19-91	10,000	1	OK	1	0