

BARBER - M24 0067525

FORM

UPC



0 47700 25716 7

C6649303

*INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

BARBER - M24 0067525 M2400967564

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

MODEL 700 TM M24

RemingtonVERY IMPORTANT:
Instruction Book
enclosed to assure
safe use of this
firearm.**MODEL 700TM M24****SERIAL NO.**
C6649303**ORDER NO.**
5716

20

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



5716 C6649303

ORDER 5716
MODEL 700TM M24
UPC

0 47700 25716 7

ORDER 5716
MODEL 700TM M24
UPC

0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649303

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	70 1	91	RW
600	Proof	70 1	91	RW
607	Check Headspace	70 1	91	RW
610	Dis-assemble Gun	70 1		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		10/15/91	WB
620	Apply Coatings (Barrel Action)			
	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 0067529	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			12/26/91	WB
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			12/26/91	WB
	H) Trigger Pull Test & Retainability						12/26/91	WB
	I) Firing Pin Indent	.021	.0205	.021			12/26/91	WB
	J) Assemble Stock						12/26/91	RW
	K) Assemble Swivel Studs						12-31-91	A
	L) Attach Front and Rear Sight Assemblies						12/26/91	RW
	M) Iron Sight Alignment						12/26/91	RW
	N) Detach Front & Rear Sights & place in numbered container						12/26/91	RW
	O) Attach Scope to Rifle						12/26/91	RW
	P) Detach & Attach Scope 20 Times						12/26/91	RW
640	Gallery Target & Test						12-31-91	A
	A) Time						12-31-91	A
	B) Malfunctions						12-31-91	A
	C) Pierced Primers						12-31-91	A
	D) Optical Clarity of Scope						12-31-91	A
645	Inspect for Live Ammo						12-31-91	A
655	Final Inspection						12-31-91	A
	A) Headspace						12/31/91	WB
	B) Trigger Pull	2.33	2.14	2.47	2.25	2.30	12/31/91	WB
	C) Function						12-31-91	A
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. C6649303DATE 12/26/91TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.42	2.53	2.33	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.38	2.33	2.14	2.14	
PULL #3	2.40	2.36	2.61	2.47	
PULL #4	2.43	2.06	2.42	2.25	
PULL #5	2.34	2.37	2.14	2.30	
TOTAL	11.99	11.54	11.84	11.49	
AVG.	2.40	2.31	2.37	2.30	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.19	3.15		
PULL #2	3.19	3.22		
PULL #3	3.23	3.26		
PULL #4	3.23	3.34		
PULL #5	3.23	3.17		
TOTAL	16.07	16.14		
AVG.	3.21	3.23		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.18	4.28		4.11
PULL #2	4.09	4.18		4.17
PULL #3	3.95	4.18		4.12
PULL #4	4.14	4.28		4.22
PULL #5	4.11	4.19		3.90
TOTAL	20.47	21.11		20.52
AVG.	4.09	4.22		4.10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06649303
31 Dec 1991

CENTROIDAL DISTANCES

0 TO	1	.090377
1 TO	2	.227783
1 TO	3	.437001
1 TO	4	.533353
1 TO	5	.1449

*23 <----POA

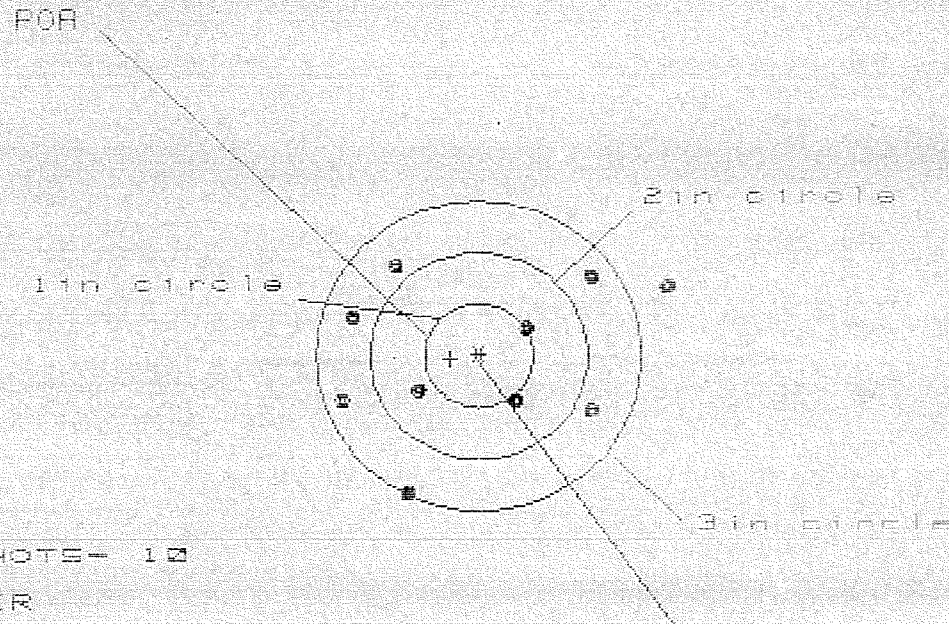
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2476
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0364
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .250261

THE AMR FOR THIS RIFLE IS: 1.004

31 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08649303

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1in = 1

2in = 3

3in = 9

HS= 2.928

VS= 2.215

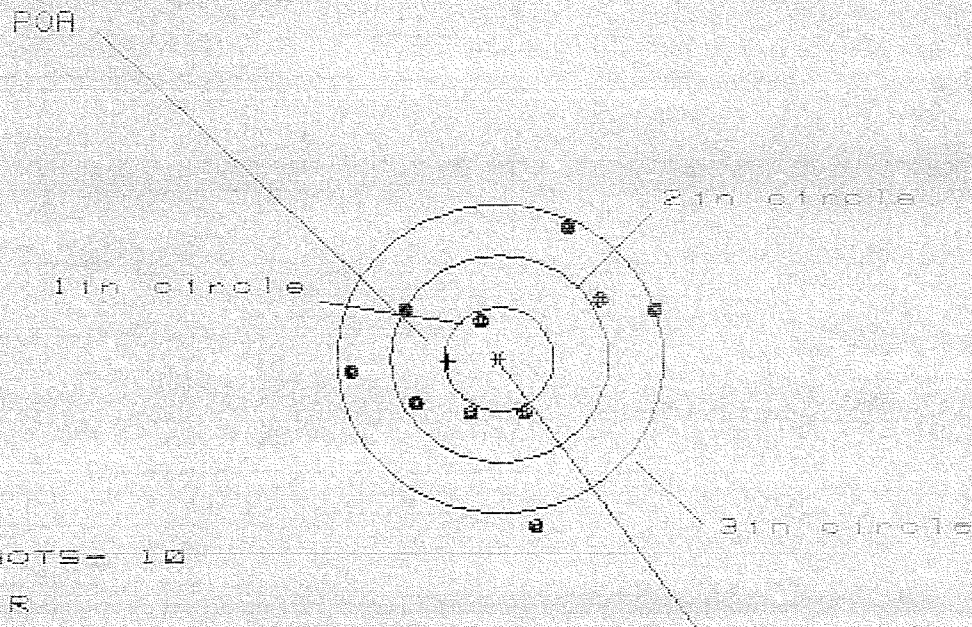
GS= 3.133

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.705	1.187	1.122
MINIMUM X	-1.223	-1.034	-1.099
MAXIMUM Y	.967	.982	.928
MINIMUM Y	-1.308	-1.233	-1.629
CENTROID X	.263	.074	.139
CENTROID Y	.031	-.044	.110
POA TO CENTROID in.	.265	.086	.177
MIN RADIUS	.507	.456	.584
MEAN RADIUS	1.123	1.030	.988
MAX RADIUS	1.835	1.476	1.335
HORIZONTAL SPREAD	2.928	2.221	2.221
VERTICAL SPREAD	2.215	2.215	1.457
EXTREME SPREAD	3.133	2.715	2.543
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		3	
NUMBER IN THREE INCH CIRCLE =		9	

31 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649303

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.781

VS = 2.843

CS = 2.860

CENTROID *

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.394
MINIMUM X	-1.387
MAXIMUM Y	1.231
MINIMUM Y	-1.612
CENTROID X	.471
CENTROID Y	.023
POA TO CENTROID in.	.472
MIN RADIUS	.441
MEAN RADIUS	1.039
MAX RADIUS	1.637
HORIZONTAL SPREAD	2.781
VERTICAL SPREAD	2.843
EXTREME SPREAD	2.860
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	9

31 Dec 1991

FILE: \PATTERNING\CENTERFIRE_PATT\06648303

CENTERFIRE PATTERNS

4

FOR

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 1.837

VS= 3.172

ES= 3.311

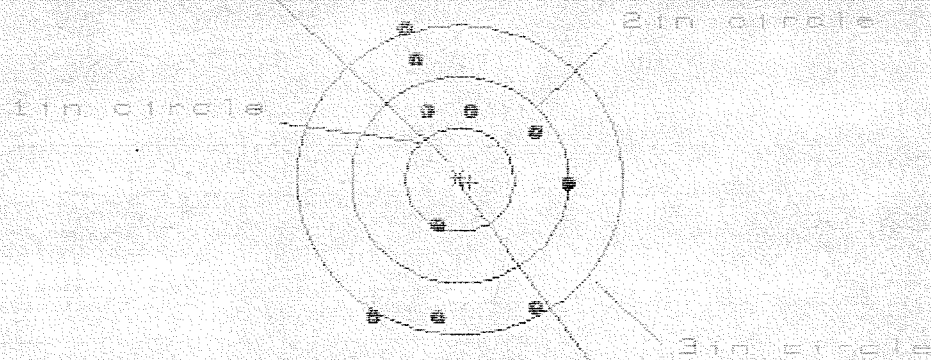
PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.040	.984	.902
MINIMUM X	-.597	-.653	-.727
MAXIMUM Y	1.959	1.113	.989
MINIMUM Y	-1.213	-.995	-.987
CENTROID X	.567	.623	.705
CENTROID Y	.014	-.204	-.079
FOR TO CENTROID IN.	.567	.656	.709
MIN RADIUS	.322	.110	.199
MEAN RADIUS	.929	.755	.714
MAX RADIUS	2.023	1.286	1.227
HORIZONTAL SPREAD	1.637	1.637	1.629
VERTICAL SPREAD	3.172	2.108	1.976
EXTREME SPREAD	3.311	2.421	2.421
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		9	

31 Dec 1991

FILE: PATTERNING/CENTERFIRE_PATT/CBB49383

CENTERFIRE PATTERNS # 5

POB



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 1.837

VS= 2.846

CS= 3.005

CENTROID #

PATTERN #	1	5	9	8
SHOTS (BEST OF)	10	9	9	8
MAXIMUM X	1.004	.911	.911	.833
MINIMUM X	-.833	-.622	-.622	-.581
MAXIMUM Y	1.481	1.329	1.329	1.217
MINIMUM Y	-1.365	-1.480	-1.480	-1.314
CENTROID X	-.098	-.005	-.005	.073
CENTROID Y	.032	.184	.184	.018
POB TO CENTROID IN.	.103	.184	.184	.075
MIN RADIUS	.493	.471	.471	.584
MEAN RADIUS	1.098	1.015	1.015	.963
MAX RADIUS	1.599	1.538	1.538	1.361
HORIZONTAL SPREAD	1.837	1.533	1.533	1.414
VERTICAL SPREAD	2.846	2.809	2.809	2.531
EXTREME SPREAD	3.005	3.005	3.005	2.702
NUMBER IN ONE INCH CIRCLE =		1		
NUMBER IN TWO INCH CIRCLE =		4		
NUMBER IN THREE INCH CIRCLE =		8		

CONTRACT # DAAA21-87-C-0086

ENDURANCE GUN

GUN SERIAL # C6349189

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	3 31	90	RW
600	Proof	3 31	90	RW
607	Check Headspace	3 31	90	RW
610	Dis-assemble Gun	3 31	90	RW
612	Magnaflux Barrel Action	4-2-90		KCR
	Magnaflux Bolt	4-2-90		KCR
615	Rollmark Caliber	4-2-90		GL
617	Drill and Tap Sight Holes		4/4/90	FB
618	Polish Barrel RWB		4/3/90	WB
620	Apply Coatings (Barrel Action)		4-9-90	TA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		4/18/90	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		4/18/90	RW
	C) Inspect Ejector Hole for Chamfer		4/18/90	RW
	D) Oil Firing Pin Ass'y		4/18/90	RW
	E) Adjust Trigger Pull to Min Setting and Stake		4/24/90	RM

BARBER - M24 0067538		READINGS					DATE	INIT
op. #	OP. NAME							
625 cont.	F) Safety On Force	5	5	5			4/25/90	RL
	G) Safety Off Force	3	3	3			4/25/90	RL
	H) Trigger Pull Test & Retainability						4/24/90	RL
	I) Firing Pin Indent	.020	.020	.020			4/25/90	RL
	J) Assemble Stock						4/25/90	RW
	K) Assemble Swivel Studs						5/8/90	WB
	L) Attach Front and Rear Sight Assemblies						4/25/90	RW
	M) Iron Sight Alignment						4/25/90	RW
	N) Detach Front & Rear Sights & place in numbered container						4/25/90	RW
	O) Attach Scope to Rifle						4/25/90	WB
	P) Detach & Attach Scope 20 Times						4/25/90	WB
640	Gallery Target & Test						4-26-90	AC
	A) Time						4-26-90	AC
	B) Malfunctions						4-26-90	AC
	C) Pierced Primers						4-26-90	AC
	D) Optical Clarity of Scope						4-26-90	AC
645	Inspect for Live Ammo						4-26-90	AC
655	Final Inspection						5/8/90	WB
	A) Headspace							
	B) Trigger Pull	2.50	2.56	2.49	2.61	2.59	5/9/90	WB
	C) Function						5/8/90	WB
660	Pack							

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

SERIAL NO. C6349189DATE 4/24/90TESTER JL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.36	2.41	2.54	2.50	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.41	2.44	2.49	2.56	
PULL #3	2.37	2.42	2.58	2.49	
PULL #4	2.38	2.45	2.56	2.61	
PULL #5	2.43	2.46	2.56	2.59	
TOTAL	11.95	12.18	12.73		
AVG.	2.39	2.436	2.546		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.47	3.31		
PULL #2	3.46	3.32		
PULL #3	3.53	3.34		
PULL #4	3.57	3.36		
PULL #5	3.26	3.34		
TOTAL	17.29	16.67		
AVG.	3.458	3.334		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.50	4.26		4.23
PULL #2	4.22	4.20		4.43
PULL #3	4.25	4.23		4.34
PULL #4	4.22	4.28		4.37
PULL #5	4.14	4.18		4.14
TOTAL	21.33	21.15		21.51
AVG.	4.266	4.23		4.302

*ACCURACY
ORIGINAL*CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349189
26 Apr 1990

CENTROIDAL DISTANCES

0 TO	1	.443979
1 TO	2	.333209
1 TO	3	.600853
1 TO	4	.569577
1 TO	5	.455703

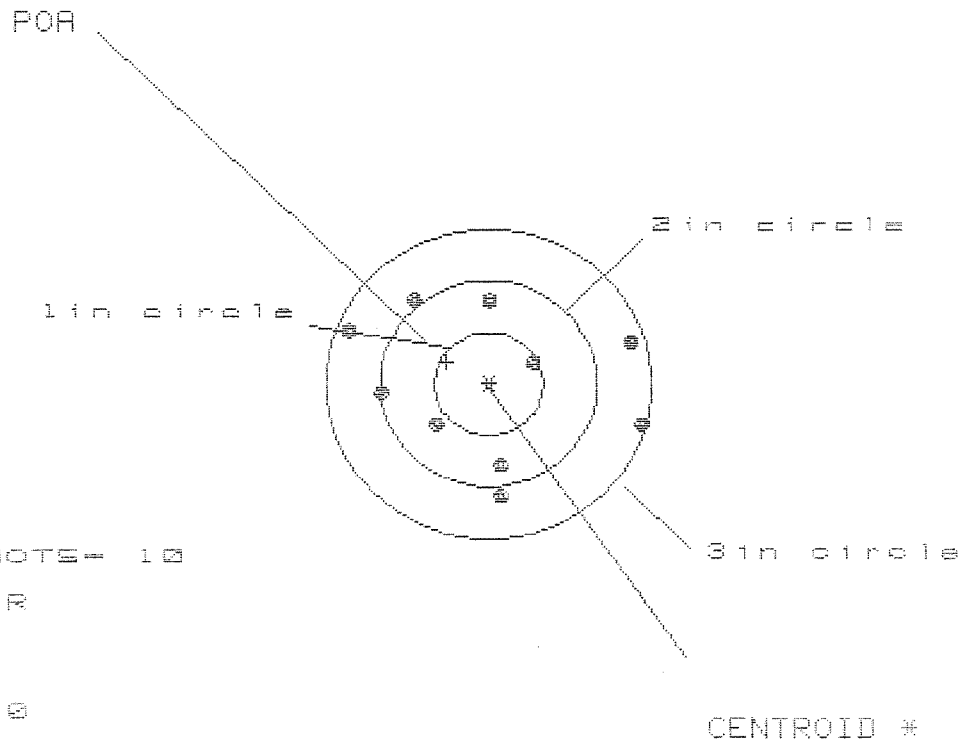
 $\frac{1}{2} \frac{1}{2}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0694
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1194
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .138104
THE AMR FOR THIS RIFLE IS: .9472

26 Apr 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C63491B3

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.514

VS= 1.875

GS= 2.772

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.369	1.489	.740
MINIMUM X	-1.245	-1.093	-.906
MAXIMUM Y	.800	.755	.797
MINIMUM Y	-1.075	-1.120	-1.078
CENTROID X	.389	.237	.050
CENTROID Y	-.214	-.169	-.211
POA TO CENTROID in.	.444	.290	.217
MIN RADIUS	.474	.541	.409
MEAN RADIUS	.998	.937	.842
MAX RADIUS	1.429	1.528	1.180
HORIZONTAL SPREAD	2.614	2.582	1.646
VERTICAL SPREAD	1.875	1.875	1.875
EXTREME SPREAD	2.772	2.585	2.111
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	10		

26 Apr 1990

FILE:/PATTERNING/CENTERFIRE_PATT/063491B9

CENTERFIRE PATTERNS # 2

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HE = 0.429

VS = 0.142

GS = 0.662

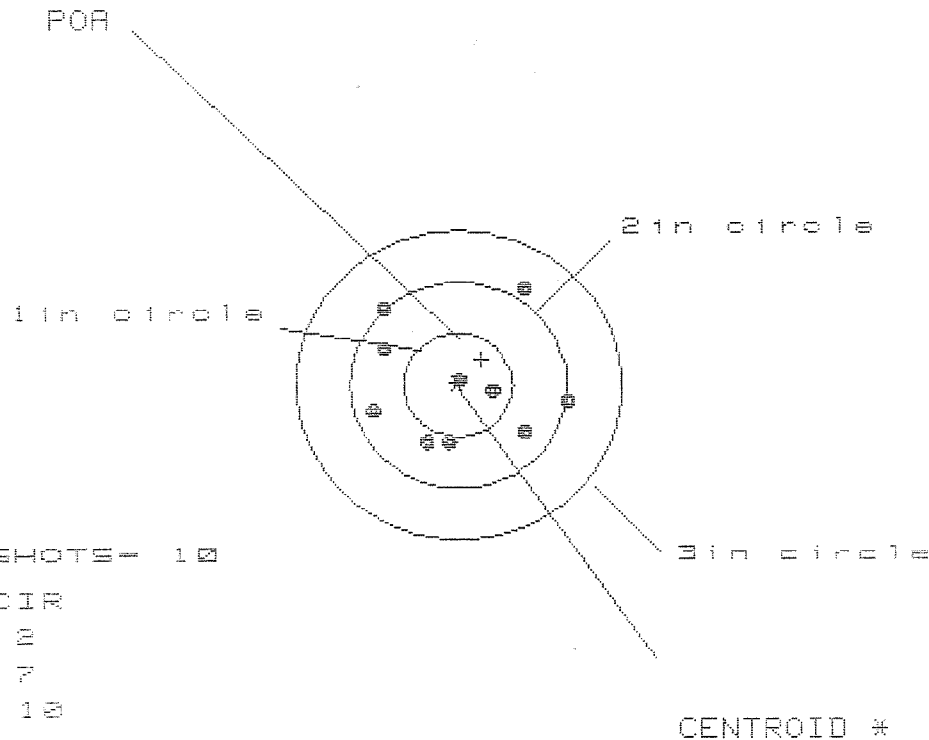
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.122	.977	.768
MINIMUM X	-1.305	-1.315	-1.192
MAXIMUM Y	1.066	.949	1.036
MINIMUM Y	-1.077	-1.193	-1.106
CENTROID X	.121	.266	.143
CENTROID Y	-.412	-.295	-.382
POA TO CENTROID in.	.429	.397	.408
MIN RADIUS	.244	.372	.257
MEAN RADIUS	1.071	1.006	.959
MAX RADIUS	1.675	1.415	1.346
HORIZONTAL SPREAD	2.427	2.292	1.960
VERTICAL SPREAD	2.142	2.142	2.142
EXTREME SPREAD	3.062	2.590	2.530
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	3		
NUMBER IN THREE INCH CIRCLE =	6		

26 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C8349189

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 7

3 in = 10

HS= 1.845

VS= 1.562

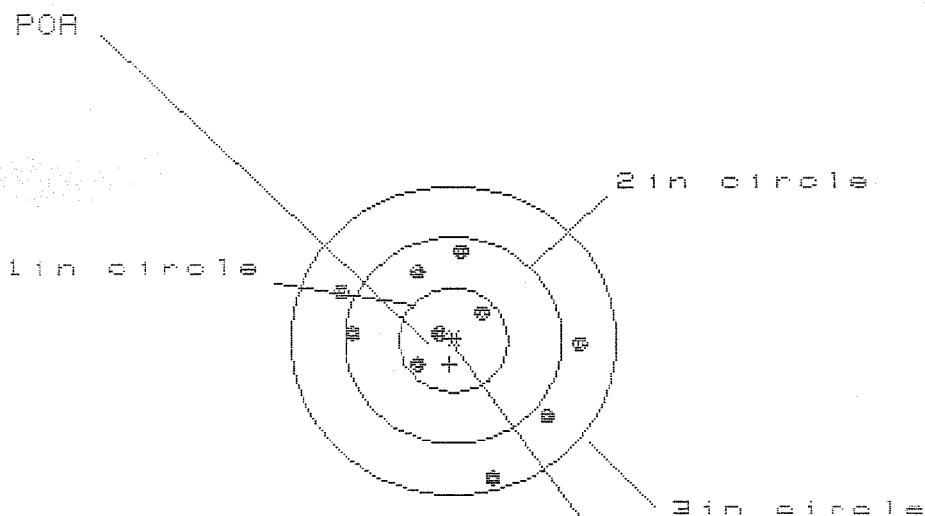
GS= 2.032

PATTERN #	1	3	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.052	1.119	.781
MINIMUM X	-.793	-.726	-.586
MAXIMUM Y	.967	.895	.884
MINIMUM Y	-.595	-.488	-.499
CENTROID X	-.211	-.278	-.418
CENTROID Y	-.246	-.353	-.342
POA TO CENTROID in.	.324	.450	.540
MIN RADIUS	.029	.134	.218
MEAN RADIUS	.718	.663	.608
MAX RADIUS	1.140	1.123	1.025
HORIZONTAL SPREAD	1.845	1.845	1.367
VERTICAL SPREAD	1.562	1.383	1.383
EXTREME SPREAD	2.032	2.032	1.783
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		10	

26 Apr 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C83491B3

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 10

HS= 2.217

VS= 2.248

GS= 2.286

CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.195	1.236	1.034
MINIMUM X	-1.022	-.981	-.826
MAXIMUM Y	.914	.766	.738
MINIMUM Y	-1.334	-.855	-.883
CENTROID X	.036	-.005	-.160
CENTROID Y	.233	.382	.410
POA TO CENTROID in.	.236	.382	.440
MIN RADIUS	.146	.099	.120
MEAN RADIUS	.823	.735	.654
MAX RADIUS	1.384	1.257	1.360
HORIZONTAL SPREAD	2.217	2.217	1.860
VERTICAL SPREAD	2.248	1.621	1.621
EXTREME SPREAD	2.286	2.286	2.204
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

26 Apr 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349189

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS = 10

IN CIR

1 in = 0

2 in = 4

3 in = 8

HS = 2.912

VS = 1.465

GS = 3.012

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.542	1.629	1.479
MINIMUM X	-1.371	-1.199	-1.174
MAXIMUM Y	.794	.804	.722
MINIMUM Y	-.671	-.661	-.680
CENTROID X	.012	-.159	-.009
CENTROID Y	.042	.032	.114
POA TO CENTROID in.	.044	.162	.114
MIN RADIUS	.609	.633	.683
MEAN RADIUS	1.126	1.057	1.020
MAX RADIUS	1.545	1.636	1.498
HORIZONTAL SPREAD	2.912	2.828	2.653
VERTICAL SPREAD	1.465	1.465	1.402
EXTREME SPREAD	3.012	2.873	2.761
NUMBER IN ONE INCH CIRCLE	=	0	
NUMBER IN TWO INCH CIRCLE	=	4	
NUMBER IN THREE INCH CIRCLE	=	8	

~~SECRET~~

Accuracy 500 RDS

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349189
29 May 1990

CENTROIDAL DISTANCES

0 TO	1	.924091
1 TO	2	.551153
1 TO	3	.487682
1 TO	4	.655886
1 TO	5	.534333

+ 5) <----FOR
4

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .5562
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2012
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .591473

THE AMR FOR THIS RIFLE IS: .8974

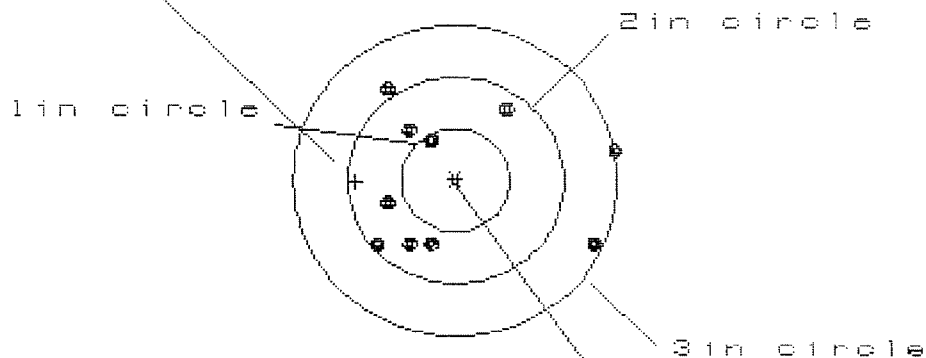
29 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349189.1

CENTERFIRE PATTERNS

1

POA



OF SHOTS - 10

IN CIR

1in = 1

2in = 7

3in = 10

HS = 2.161

VS = 1.511

GS = 2.486

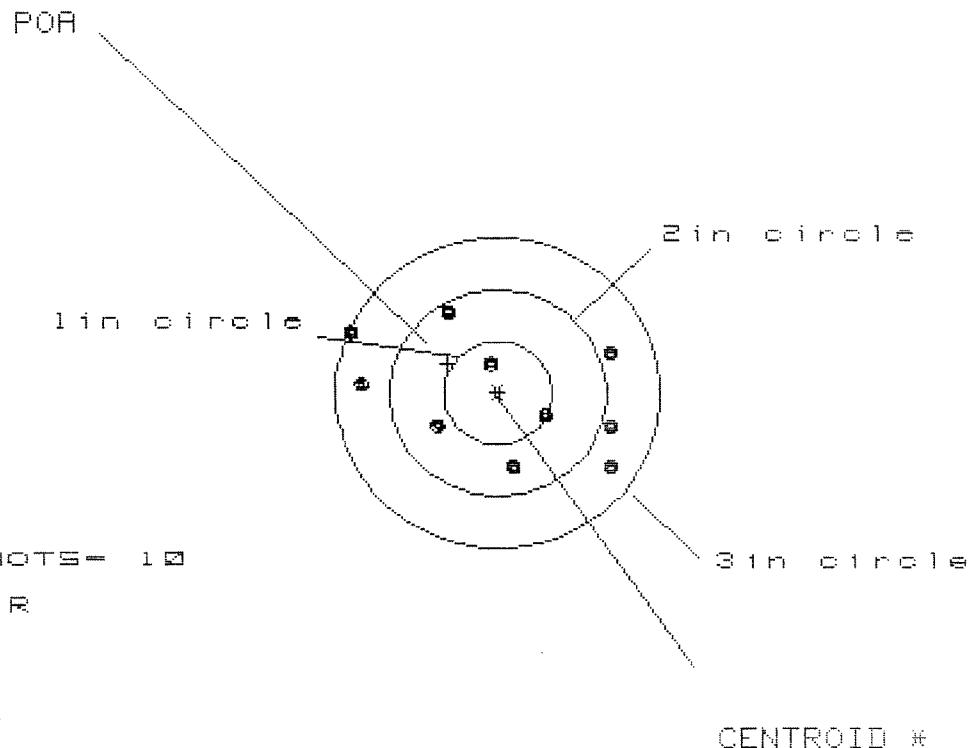
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.459	1.473	.830
MINIMUM X	-.702	-.540	-.356
MAXIMUM Y	.851	.888	.810
MINIMUM Y	-.660	-.623	-.663
CENTROID X	.924	.762	.578
CENTROID Y	.013	-.024	.054
POA TO CENTROID in.	.924	.763	.581
MIN RADIUS	.446	.426	.363
MEAN RADIUS	.897	.791	.653
MAX RADIUS	1.497	1.599	1.034
HORIZONTAL SPREAD	2.161	2.013	1.186
VERTICAL SPREAD	1.511	1.511	1.473
EXTREME SPREAD	2.486	2.486	1.744
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

29 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C83491B9.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1in = 2

2in = 5

3in = 8

HS = 2.451

VS = 1.556

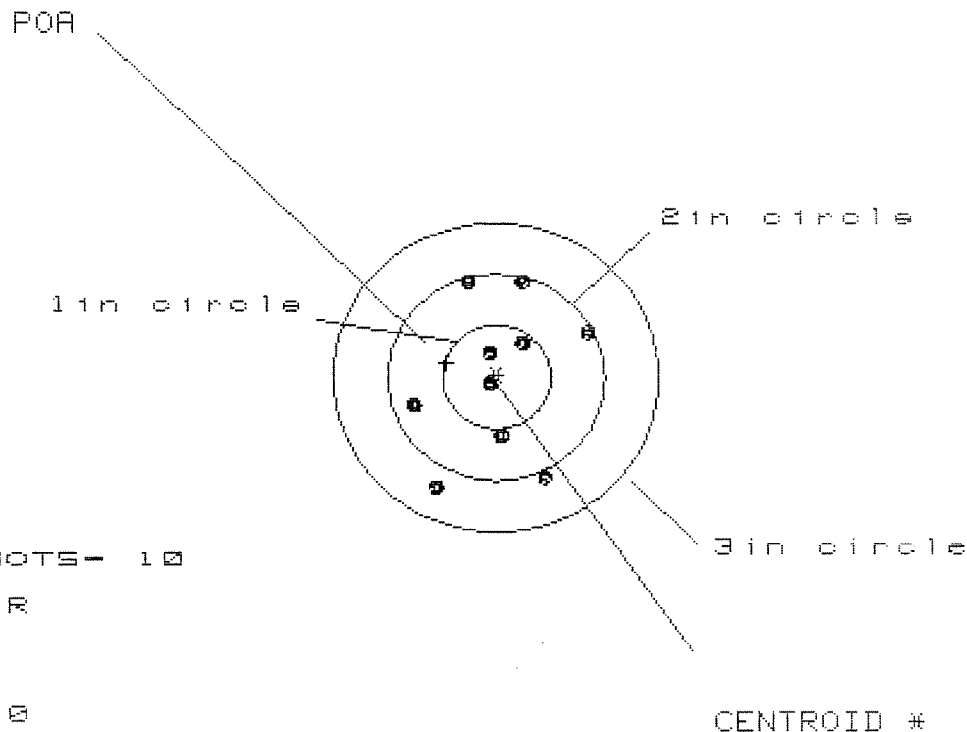
GS = 2.734

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.063	.909	1.015
MINIMUM X	:	-1.388	-1.391	-1.285
MAXIMUM Y	:	.821	.885	.802
MINIMUM Y	:	-.735	-.671	-.710
CENTROID X	:	.461	.615	.509
CENTROID Y	:	-.286	-.350	-.267
POA TO CENTROID in.	:	.543	.708	.574
MIN RADIUS	:	.264	.299	.262
MEAN RADIUS	:	.926	.844	.811
MAX RADIUS	:	1.505	1.400	1.287
HORIZONTAL SPREAD	:	2.451	2.300	2.300
VERTICAL SPREAD	:	1.556	1.556	1.511
EXTREME SPREAD	:	2.734	2.391	2.332
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

29 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349189.1

CENTERFIRE PATTERNS # 3



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS = 1.558

VS = 2.041

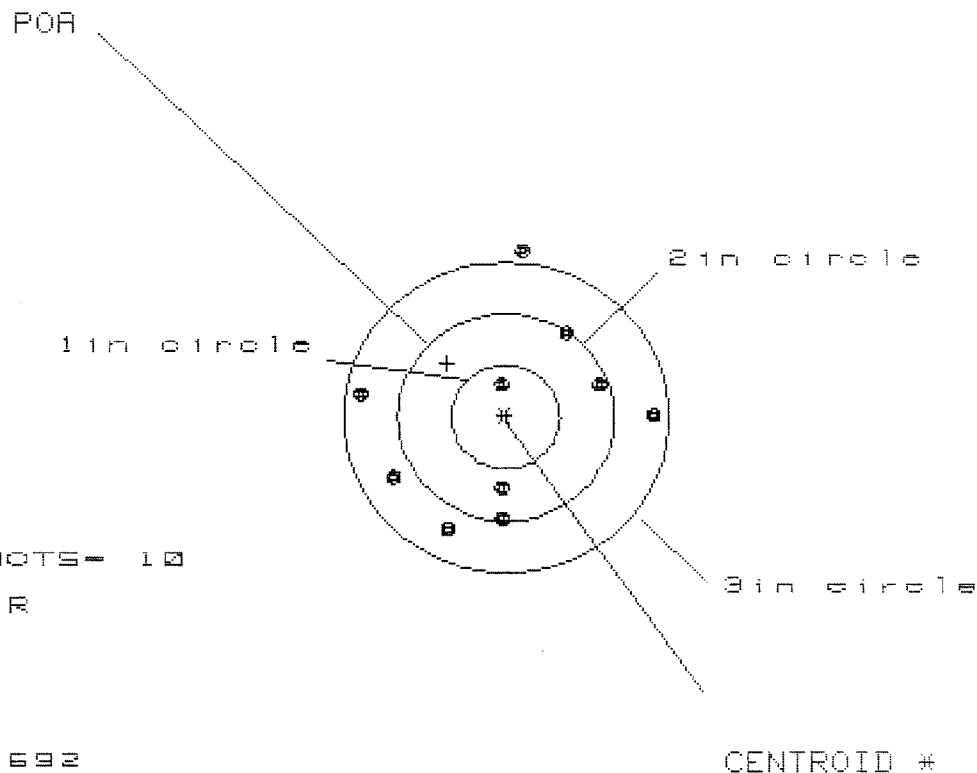
GS = 2.102

PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.801	.743	.786
MINIMUM X	-.757	-.815	-.772
MAXIMUM Y	.967	.848	.712
MINIMUM Y	-1.073	-1.093	-.813
CENTROID X	.459	.517	.474
CENTROID Y	-.134	-.015	.121
POA TO CENTROID in.	.478	.517	.489
MIN RADIUS	.053	.113	.081
MEAN RADIUS	.712	.648	.574
MAX RADIUS	1.195	1.146	.917
HORIZONTAL SPREAD	1.558	1.558	1.558
VERTICAL SPREAD	2.041	1.941	1.525
EXTREME SPREAD	2.102	2.054	1.697
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	10		

25 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349189.1

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS = 2.692

VS = 2.665

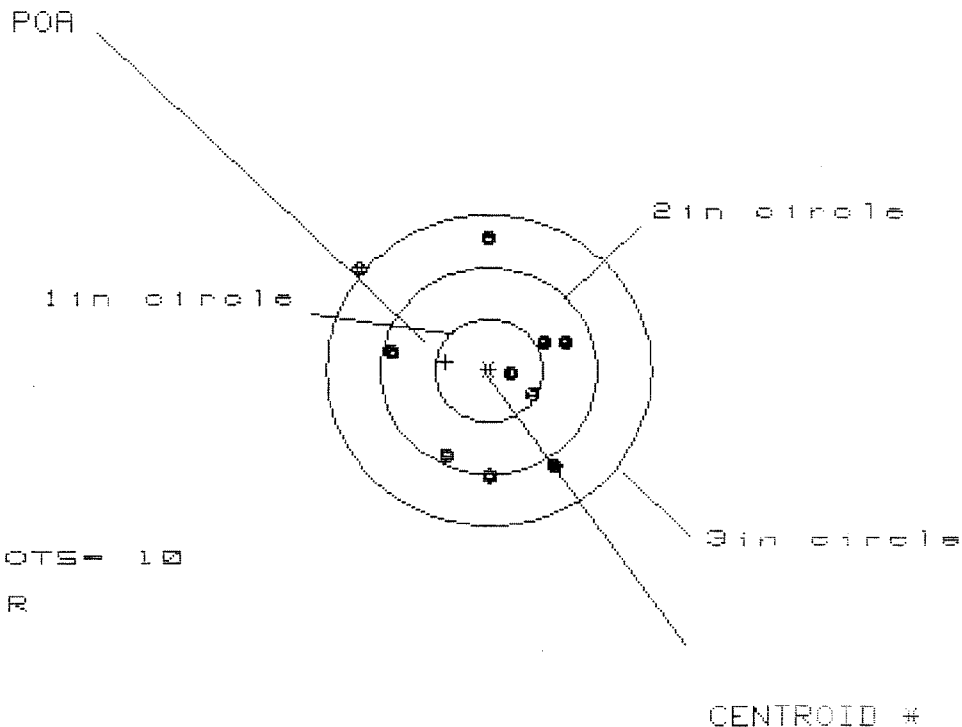
GS = 2.756

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	1.360
MINIMUM X	-1.332
MAXIMUM Y	1.591
MINIMUM Y	-1.074
CENTROID X	.539
CENTROID Y	-.518
POA TO CENTROID in.	.747
MIN RADIUS	.367
MEAN RADIUS	1.070
MAX RADIUS	1.595
HORIZONTAL SPREAD	2.692
VERTICAL SPREAD	2.665
EXTREME SPREAD	2.756
NUMBER IN ONE INCH CIRCLE =	1
NUMBER IN TWO INCH CIRCLE =	4
NUMBER IN THREE INCH CIRCLE =	9

29 May 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C63491B9.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.942

VS= 2.294

GS= 2.652

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.697	.559	.542
MINIMUM X	-1.245	-1.036	-1.053
MAXIMUM Y	1.269	1.378	.549
MINIMUM Y	-1.025	-.916	-.744
CENTROID X	.398	.536	.553
CENTROID Y	-.081	-.190	-.362
POA TO CENTROID in.	.406	.569	.661
MIN RADIUS	.222	.142	.286
MEAN RADIUS	.882	.761	.681
MAX RADIUS	1.583	1.384	1.149
HORIZONTAL SPREAD	1.942	1.595	1.595
VERTICAL SPREAD	2.294	2.294	1.293
EXTREME SPREAD	2.652	2.294	1.869
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06349189
7 Jun 1990

Accuracy
4500 RDS

CENTROIDAL DISTANCES

0 TO	1	.204941
1 TO	2	.389899
1 TO	3	.182822
1 TO	4	.231741
1 TO	5	.357066

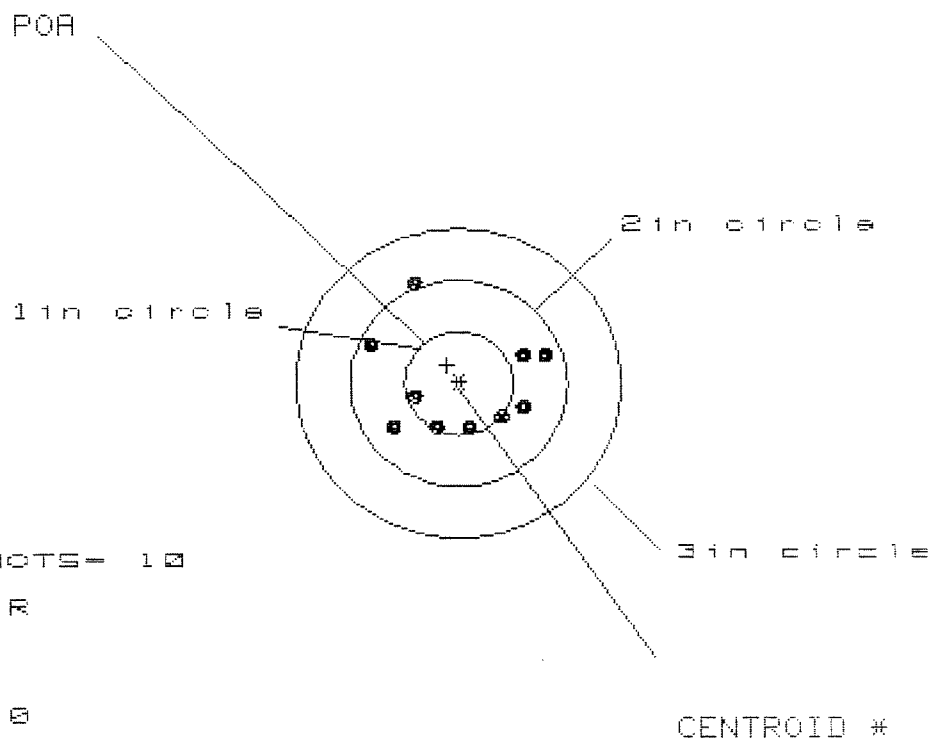
 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0728
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1644
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .179798
THE AMR FOR THIS RIFLE IS: .7696

7 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349189.1.1^

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 9

3in = 10

HS= 1.611

VS= 1.388

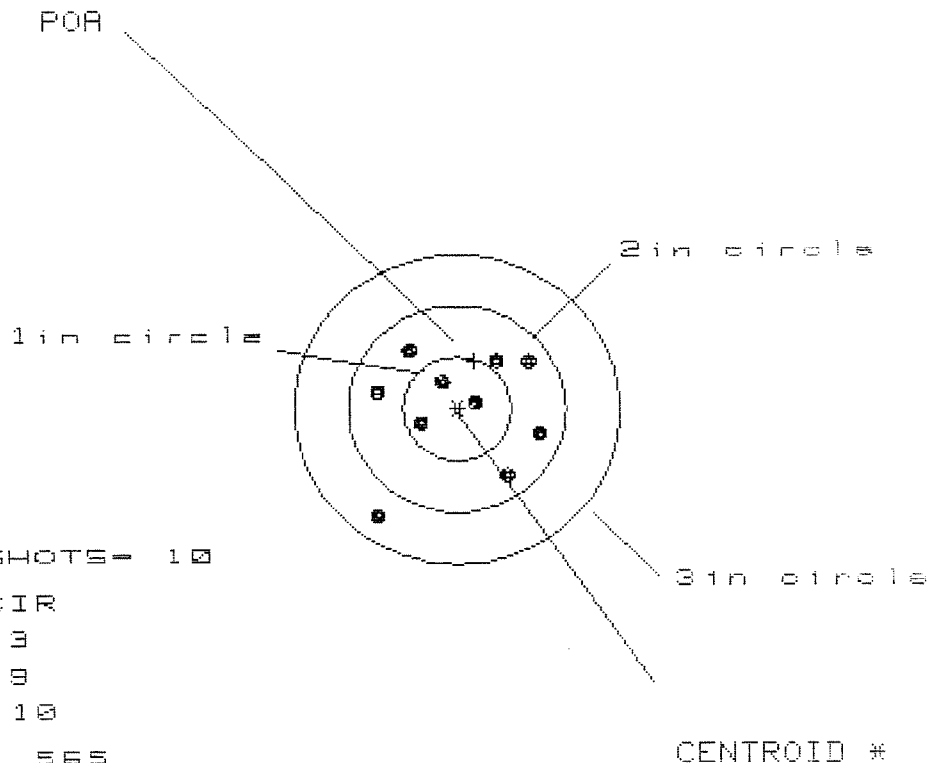
GS= 1.615

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.781	.733	.623
MINIMUM X	-.830	-.878	-.807
MAXIMUM Y	.971	.471	.417
MINIMUM Y	-.417	-.310	-.251
CENTROID X	.105	.153	.263
CENTROID Y	-.176	-.284	-.343
POA TO CENTROID in.	.205	.323	.432
MIN RADIUS	.408	.292	.236
MEAN RADIUS	.660	.589	.517
MAX RADIUS	1.062	.997	.845
HORIZONTAL SPREAD	1.611	1.611	1.430
VERTICAL SPREAD	1.388	.781	.668
EXTREME SPREAD	1.615	1.615	1.578
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

7 Jun 1990

FILE:/PATTERNING/CENTERFIRE_PATT/C63491B3.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.565

VS= 1.600

GS= 2.010

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.805	.720	.630
MINIMUM X	:	-.760	-.826	-.736
MAXIMUM Y	:	.566	.452	.412
MINIMUM Y	:	-1.034	-.704	-.744
CENTROID X	:	-.160	-.075	-.165
CENTROID Y	:	-.462	-.348	-.308
POA TO CENTROID in.	:	.489	.356	.349
MIN RADIUS	:	.170	.105	.202
MEAN RADIUS	:	.649	.557	.522
MAX RADIUS	:	1.283	.828	.878
HORIZONTAL SPREAD	:	1.565	1.546	1.366
VERTICAL SPREAD	:	1.600	1.156	1.156
EXTREME SPREAD	:	2.010	1.592	1.452
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349189.1.1

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS= 2.295

VS= 2.108

GS= 2.525

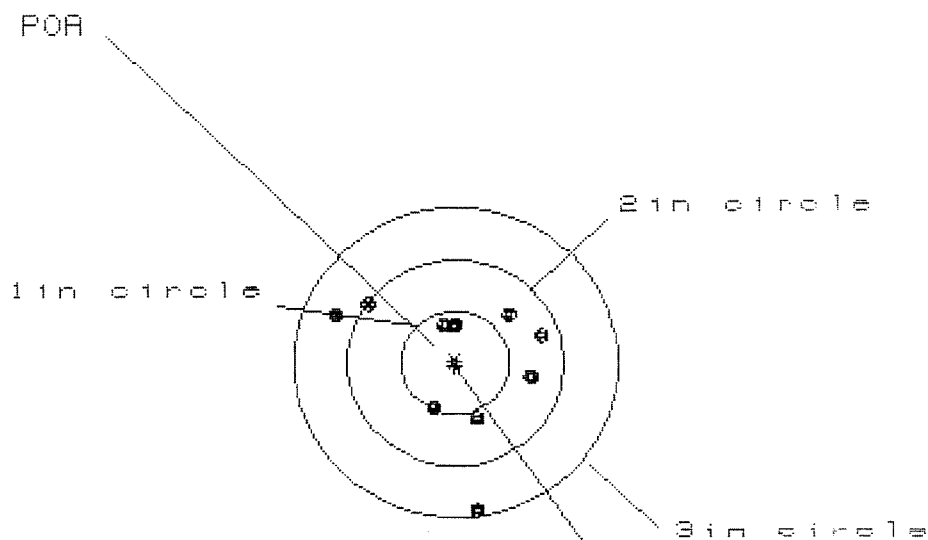
CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.516	.733	.625
MINIMUM X	:	-.778	-.610	-.518
MAXIMUM Y	:	1.091	1.156	1.036
MINIMUM Y	:	-1.017	-.952	-.858
CENTROID X	:	.137	-.031	-.123
CENTROID Y	:	-.356	-.421	-.301
POA TO CENTROID in.	:	.381	.422	.325
MIN RADIUS	:	.300	.141	.078
MEAN RADIUS	:	.887	.764	.679
MAX RADIUS	:	1.625	1.202	1.061
HORIZONTAL SPREAD	:	2.295	1.343	1.143
VERTICAL SPREAD	:	2.108	2.108	1.894
EXTREME SPREAD	:	2.525	2.198	1.940
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C83491B9.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 10

HS = 1.929

VS = 2.001

GS = 2.264

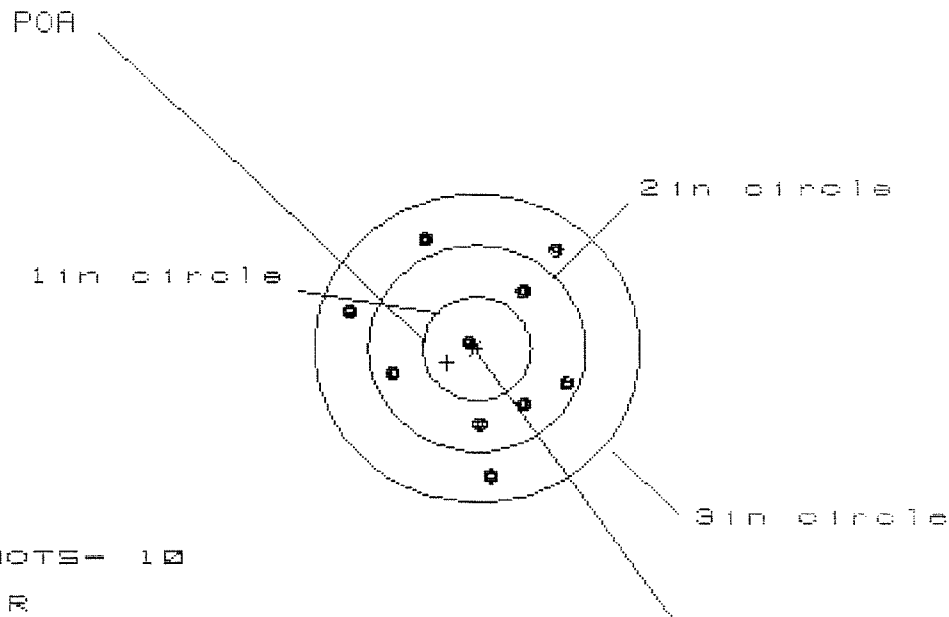
CENTROID *

PATTERN #	4
SHOTS (BEST OF)	10
MAXIMUM X	.794
MINIMUM X	-1.135
MAXIMUM Y	.612
MINIMUM Y	-1.389
CENTROID X	.007
CENTROID Y	.034
POA TO CENTROID in.	.034
MIN RADIUS	.346
MEAN RADIUS	.764
MAX RADIUS	1.404
HORIZONTAL SPREAD	1.929
VERTICAL SPREAD	2.001
EXTREME SPREAD	2.264
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	10

7 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349189.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HS= 1.962

VS= 2.361

GS= 2.442

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.795	.810	.666
MINIMUM X	-1.167	-1.152	-.924
MAXIMUM Y	1.097	.957	.988
MINIMUM Y	-1.264	-.908	-.877
CENTROID X	.275	.260	.404
CENTROID Y	.138	.278	.247
POA TO CENTROID in.	.307	.381	.474
MIN RADIUS	.129	.085	.217
MEAN RADIUS	.888	.839	.791
MAX RADIUS	1.270	1.179	1.167
HORIZONTAL SPREAD	1.962	1.962	1.590
VERTICAL SPREAD	2.361	1.865	1.865
EXTREME SPREAD	2.442	2.079	1.932
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6349189
9 Jun 1990

Accuracy
5000 RDS

CENTROIDAL DISTANCES

0 TO	1	.781655
1 TO	2	.866274
1 TO	3	1.05229
1 TO	4	.477335
1 TO	5	1.0162

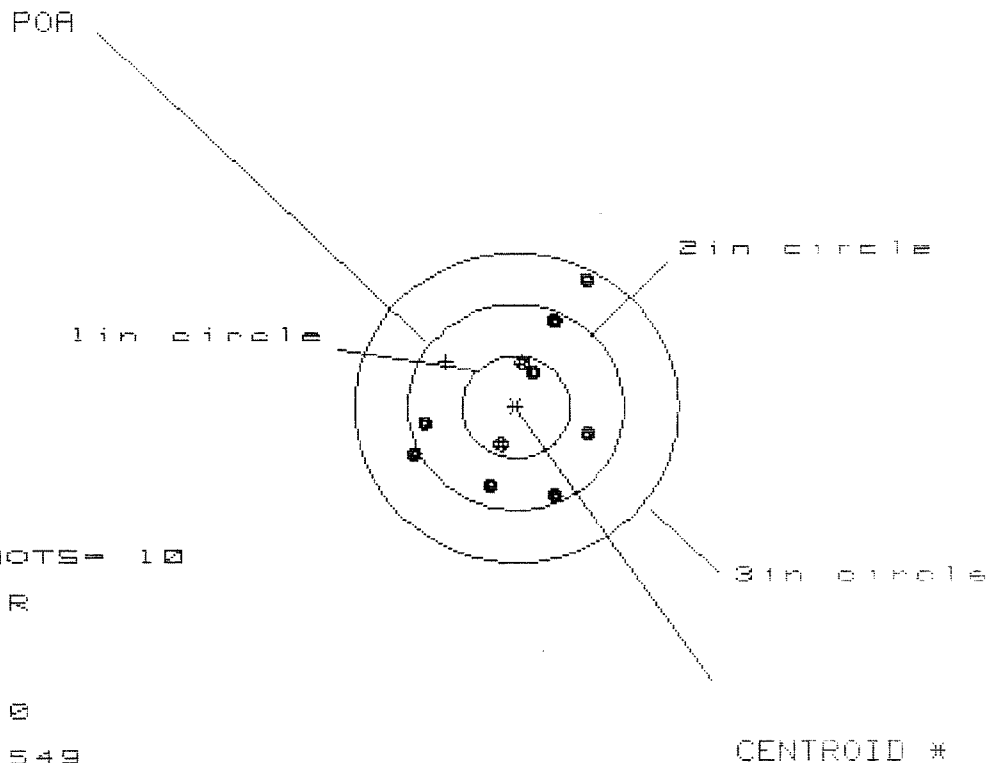
$\frac{5^2}{4^2}$ <----POA
1

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .3742
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1246
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .394399
THE AMR FOR THIS RIFLE IS: .7598

9 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/063491B9.1.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 1.549

VS= 2.176

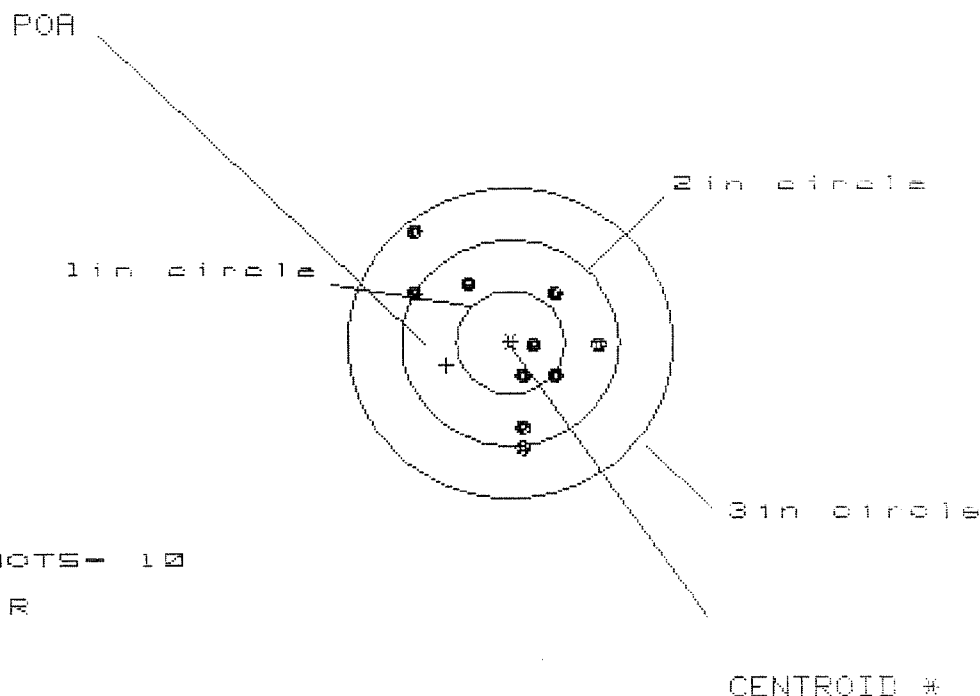
GS= 2.355

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.653	.682	.579
MINIMUM X	-.896	-.823	-.901
MAXIMUM Y	1.290	.986	.943
MINIMUM Y	-.886	-.742	-.785
CENTROID X	.644	.571	.674
CENTROID Y	-.443	-.587	-.544
POA TO CENTROID in.	.782	.819	.866
MIN RADIUS	.339	.199	.276
MEAN RADIUS	.785	.697	.658
MAX RADIUS	1.446	1.064	.989
HORIZONTAL SPREAD	1.549	1.505	1.480
VERTICAL SPREAD	2.176	1.728	1.728
EXTREME SPREAD	2.355	1.804	1.728
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

9 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6349183.1.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS= 1.676

VS= 2.119

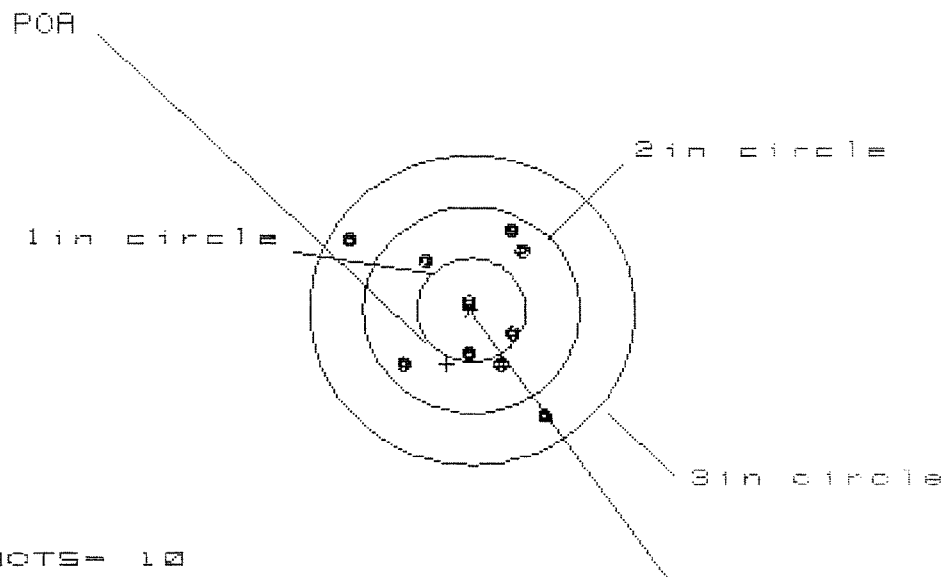
GS= 2.341

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.783	.686	.689
MINIMUM X	:	-.893	-.990	-.987
MAXIMUM Y	:	1.086	.721	.607
MINIMUM Y	:	-1.033	-.912	-.811
CENTROID X	:	.589	.686	.683
CENTROID Y	:	.221	.100	.214
POA TO CENTROID in.	:	.629	.693	.716
MIN RADIUS	:	.206	.120	.115
MEAN RADIUS	:	.743	.628	.598
MAX RADIUS	:	1.395	1.137	1.083
HORIZONTAL SPREAD	:	1.676	1.676	1.676
VERTICAL SPREAD	:	2.119	1.633	1.418
EXTREME SPREAD	:	2.341	1.785	1.743
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			8	
NUMBER IN THREE INCH CIRCLE =			10	

9 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C63491B9.1.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 1.822

VS = 1.792

GS = 2.472

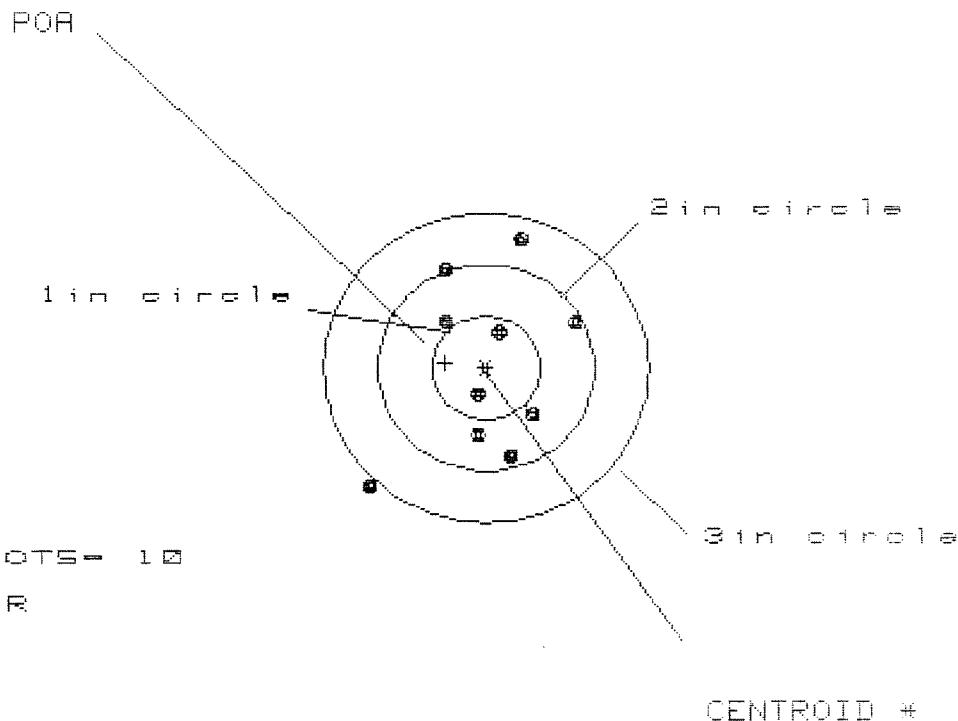
CENTROID #

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	.691
MINIMUM X	-1.131
MAXIMUM Y	.818
MINIMUM Y	-.974
CENTROID X	.229
CENTROID Y	.524
POA TO CENTROID in.	.572
MIN RADIUS	.113
MEAN RADIUS	.730
MAX RADIUS	1.329
HORIZONTAL SPREAD	1.822
VERTICAL SPREAD	1.792
EXTREME SPREAD	2.472
NUMBER IN ONE INCH CIRCLE =	3
NUMBER IN TWO INCH CIRCLE =	8
NUMBER IN THREE INCH CIRCLE =	10

9 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C63491B3.1.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 2

2in = 8

3in = 9

HS= 1.885

VS= 2.329

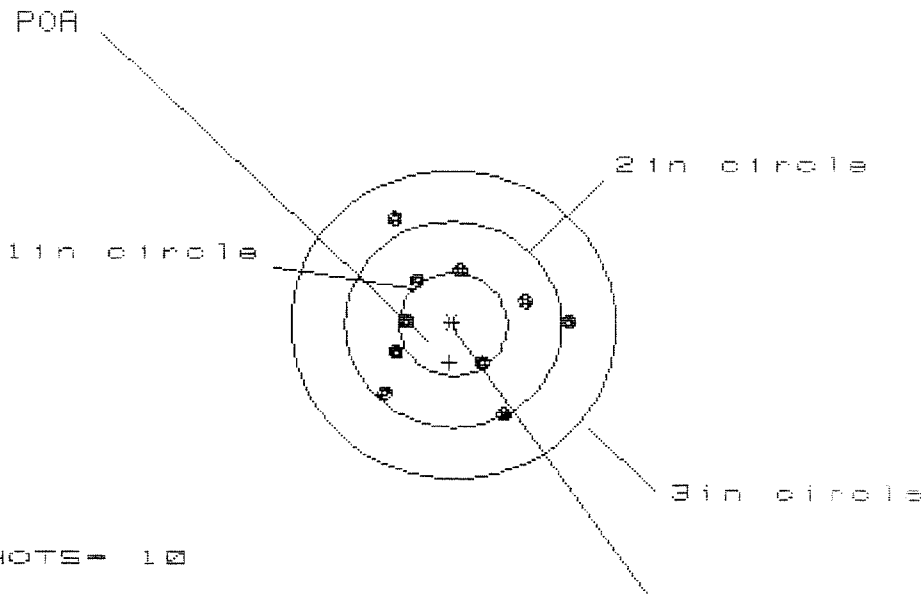
GS= 2.716

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.787	.665	.687
MINIMUM X	:	-1.098	-.488	-.466
MAXIMUM Y	:	1.218	1.095	.932
MINIMUM Y	:	-1.111	-.993	-.856
CENTROID X	:	.376	.498	.476
CENTROID Y	:	-.048	.075	-.062
POA TO CENTROID in.	:	.379	.504	.480
MIN RADIUS	:	.270	.176	.292
MEAN RADIUS	:	.807	.713	.651
MAX RADIUS	:	1.562	1.109	1.029
HORIZONTAL SPREAD	:	1.885	1.153	1.153
VERTICAL SPREAD	:	2.329	2.088	1.788
EXTREME SPREAD	:	2.716	2.089	1.880
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

9 Jun 1998

FILE:/PATTERNING/CENTERFIRE_PATT/C6345189.1.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1in = 2

2in = 8

3in = 10

HS= 1.652

VS= 1.810

QS= 2.075

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.037	.972	.707
MINIMUM X	:	-.615	-.680	-.558
MAXIMUM Y	:	.991	.592	.608
MINIMUM Y	:	-.819	-.709	-.693
CENTROID X	:	.033	.098	-.024
CENTROID Y	:	.369	.259	.243
POA TO CENTROID in.	:	.371	.277	.244
MIN RADIUS	:	.449	.377	.429
MEAN RADIUS	:	.734	.686	.636
MAX RADIUS	:	1.148	.981	.850
HORIZONTAL SPREAD	:	1.652	1.652	1.265
VERTICAL SPREAD	:	1.810	1.301	1.301
EXTREME SPREAD	:	2.075	1.806	1.600
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6349189 SHOOTER K.F. DATE 5-25-90

5-29-90 →

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
①	7.62	30	OK	None
	7.62	30	OK	None
②	7.62	30	OK	None
	7.62	30	OK	None
③	7.62	30	OK	None
	7.62	30	OK	None
④	7.62	30	OK	None
	7.62	30	OK	None
⑤	7.62	30	OK	None
	7.62	30	OK	None
⑥	7.62	30	OK	None
	7.62	30	OK	None
⑦	7.62	30	OK	None
	7.62	30	OK	None
⑧	7.62	30	OK	None
	7.62	31	OK	None
⑨	7.62	30	OK	None

SWS ENDURANCE TEST REPORT

SERIAL NO. C6349189 SHOOTER Jim Seymour DATE 5-30-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None

SWS ENDURANCE TEST REPORT

SERIAL NO. C6349189 SHOOTER Ken Symon DATE 5/31/90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None (1700)
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None
	7.62	30	OK	None (2000 RDS)
	7.62	30	OK	None
	7.62	30	OK	None
200	7.62	38	OK	None
100	7.62	30	OK	None (2100)

SWS ENDURANCE TEST REPORT

SERIAL NO. C6349189 SHOOTER DH DATE 6-1-90
6-4-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	762	60	OK	NONE
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	20	"	"
	TOTAL	380		
		2120		
	TOTAL	(2500)	6-4-90	
	762	60	OK 6-4-90	NONE
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	420	"	"
		(2920)		

SWS ENDURANCE TEST REPORT

SERIAL NO. C 6349189 SHOOTER R. Heyman DATE 6-5-90
6-6-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	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	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
		(3520)		
				6-6-90
	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	60	OK	None
	7.62	60	OK	None
	7.62	60	OK	None
		4120		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6349189 SHOOTER DH DATE 6-12-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	NONE
	11	60	11	11
	11	60	11	11
	11	60	11	11
	11	60	11	11
	11	60	11	11
	11	60	11	11
	11	60	11	11
	11	60	11	11
	11	60 *	11	11
	11	60	11	11
	11	60	11	11
	11	60	11	11
	11	60	11	11
	11	60	11	11
	11	60	11	11
	11	40	11	11
		1000	6-12-90	
		6000		
		(7000)		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6349189 SHOOTER K. J. DATE 6-13-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	40	OK	None
	"	60	OK	None
			(8000)	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6349189 SHOOTER K. J.DATE 6-14-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	60	OK	None
	"	40	OK	None
			9000	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6349189 SHOOTER KH DATE 6-15-90

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	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	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	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
			10000	

QP 0041

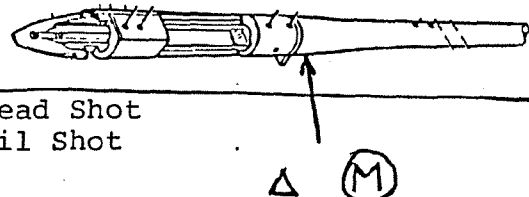
6-4-90 Endurance Bbl & Bolt
C-6349189

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			SKETCH AND/OR REMARKS
	HEAD SHOT	CENTRAL	CONDUCTOR	HEAD SHOT	CENTRAL	COIL SHOT	
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: _____

STEEL STAMP ON. Triangular stamp Δ 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.

ACCEPTANCE STANDARD

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. Karl C Rice
INSP. 2158-8096

Endurance 138P & Bolt

QP 0041

HC-6349189

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS	
				ACCEPTED	REJECTED
-4-90		2,500 Rds		OK	
-11-90		5,000 Rds		OK	
12-90		6,000 Rds		OK	
13-90		7,000 Rds		OK	
14-90		8,000 Rds		OK	
15-90		9,000 Rds		OK	
18-90		10,000 Rds		OK	

QP 0041

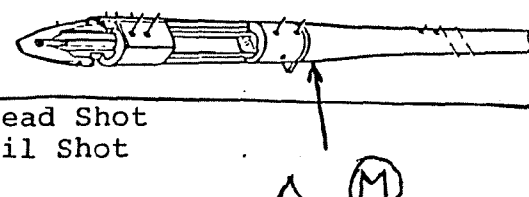
6-4-90 Endurance Bbl & Bolt
C-6349189

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			SKETCH AND/OR REMARKS
	HEAD SHOT	CENTRAL	CONDUCTOR	HEAD SHOT	CENTRAL	CONDUCTOR	
NON-FLUORESCENT CONTINUOUS WET							
FLUORESCENT CONTINUOUS WET	Yes			Yes (2 Overlapping)			
NON-FLUORESCENT RESIDUAL WET							

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

APPROVAL:

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

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. Karl C. Rice
INSP. 258-8096

Endurance 138P & Bolt

QP 0041

HC-6349189

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS	
				ACCEPTED	REJECTED
5-4-90		2,500 Rds		OK.	
-11-90		5,000 Rds		OK	
12-90		6,000 Rds		OK	
13-90		7,000 Rds		OK	
14-90		8,000 Rds		OK	
15-90		9,000 Rds		OK	
18-90		10,000 Rds		OK	

QP 0041

6-4-90 Endurance Bbl & Bolt
C-6349189

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-FLUORESCENT
CONTINUOUS WET

FLUORESCENT
CONTINUOUS WET Yes

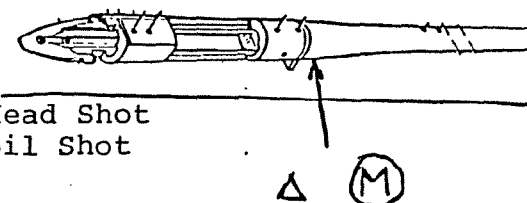
Yes (2 Overlapping)

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

NON-FLUORESCENT
RESIDUAL WET

FLUORESCENT
RESIDUAL WET

SKETCH AND/OR REMARKS



APPROVAL:

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

STEEL STAMP ON. Triangular stamp Δ 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.

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

ALL BLOCKS MUST BE PROPERLY FILLED IN.

ACCEPTANCE STANDARD

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

LEV III. Karl C. Rice
INSP. 2158-8096

Endurance 138P & Bolt

QP 0041

HC-6349189

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS	
				ACCEPTED	REJECTED
-4-90		2,500 Rds		OK	
-11-90		5,000 Rds		OK	
12-90		6,000 Rds		OK	
13-90		7,000 Rds		OK	
14-90		8,000 Rds		OK	
15-90		9,000 Rds		OK	
18-90		10,000 Rds		OK	

QP 0041

6-4-90 Endurance Bbl & Bolt
C-6349189

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

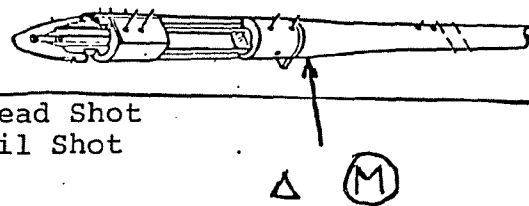
NON-FLUORESCENT
CONTINUOUS WET

FLUORESCENT
CONTINUOUS WET Yes Yes (2 Overlapping)

NON-FLUORESCENT
RESIDUAL WET

FLUORESCENT
RESIDUAL WET

SKETCH AND/OR REMARKS



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

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

- 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. Karl C Rice
INSP. 2158-8096

Endurance 138P & Bolt

QP 0041

HC-6349189

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS	
				ACCEPTED	REJECTED
5-4-90		2,500 Rds		OK.	
-11-90		5,000 Rds		OK	
12-90		6,000 Rds		OK	
13-90		7,000 Rds		OK	
14-90		8,000 Rds		OK	
15-90		9,000 Rds		OK	
18-90		10,000 Rds		OK	