

FORM

UPC



C6665932

INCLUDES 1 IN CHAMBER

MODEL 700 TM M24

5716

ORDER NO.

BARREL LENGTH

CAPACITY*

Arms Services Repair & Estimate System

File Add Repair Estimate Repair Expedite Repair Inquiry Repair Tools CSR Tools Reports Table Maintenance System Maintenance Help

Repair Inquiry

Repair Number: RE00133019

Serial: C6665932 Model M24 SWS Center Fire
Caliber: 7.62 NATO

Repairman:

Verify Repair

High Priority

Status:

Closed 8/22/2007 7:13:56 AM

Address Information

Customer:

Received From

Return To:

Received From

Name: TRANSPORTATION OFFICER

TRANSPORTATION OFFICER

Address 1: XR WOK8 USA ROCK ISL ARSENAL

XR WOK8 USA ROCK ISL ARSENAL

Address 2: BLDG 299 GILLESPIE AVE BECK PO Box:

BLDG 299 GILLESPIE AVE BECK PO Box:

City: ROCK ISLAND

ROCK ISLAND

State: IL

Zip Code: 61299

Country: US

State: IL

Zip Code: 61299

Country: US

FFL:

Contact / Condition

Problems

Estimate

History / Status

Shipping / Billing

Contact Information

Phone: NN

Fax:

Email:

Comments:

Received Condition

Fair

Condition
Notes:CSR
Notes:

Accessories Received

Code	Desc	Qty
A007	With Stud	3
A017	Scope Base	1
A057	Fit and Rear Sgt Base	1

Repair Search

Refresh

Close

naglej

8/22/2007

7:53 AM

CAPS

NUM

INS

SCRL



Inbox - Micr...

Calendar - M...

FW: Restrict...

Arms Service...

7:53 AM

Serial Number:

C6665932

Model: M24 SWS



RE00133019

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

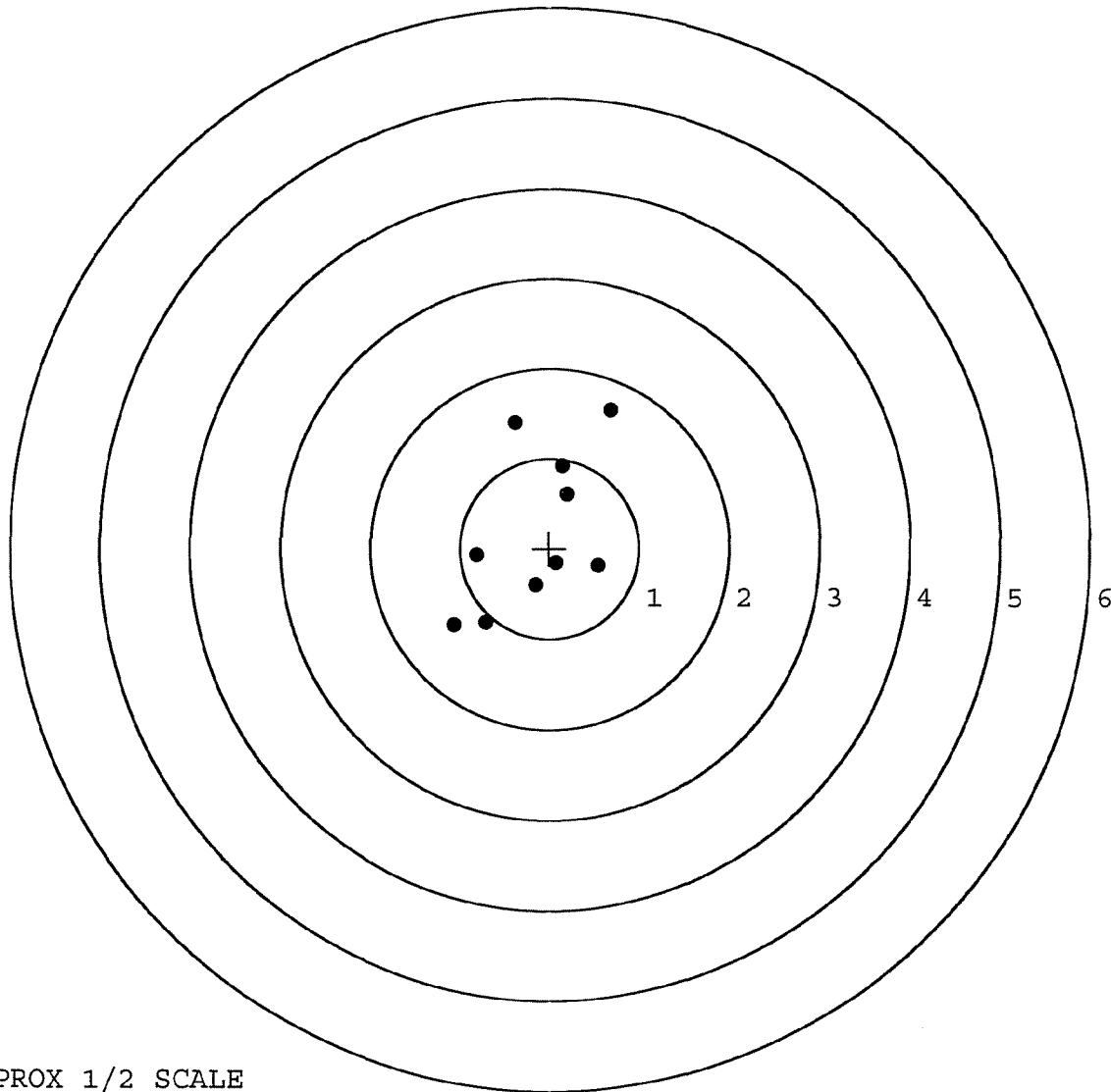
FIREARM SERIAL NUMBER / DATASET NAME: C6665932.__0
FILE DATE AND TIME: 09/21/2007 13:16

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	-0.049
The Average Y Centroid of the Five Target Set:	0.051
The Average Point of Impact of the Five Target Set:	0.071
The Average Mean Radius of the Five Target Set:	0.827
The Distance from POA to Centroid Target #1:	0.246
The Distance from Centroid Target #2 to Centroid Target #1:	0.171
The Distance from Centroid Target #3 to Centroid Target #1:	0.557
The Distance from Centroid Target #4 to Centroid Target #1:	0.145
The Distance from Centroid Target #5 to Centroid Target #1:	0.080

BARBER - M24 0104162

SERIAL NUMBER: C6665932. __0	POINT#	X	Y
TARGET NUMBER: 1	1:	-1.067	-0.849
FILE DATE: 09/21/2007	2:	-0.718	-0.823
FILE TIME: 13:16	3:	0.545	-0.198
	4:	0.076	-0.166
X CENTROID: -0.150	5:	-0.159	-0.411
Y CENTROID: 0.194	6:	-0.817	-0.076
POA TO CENTROID: 0.246	7:	-0.389	1.405
HORZ SPREAD: 1.748	8:	0.151	0.920
VERT SPREAD: 2.385	9:	0.197	0.606
GROUP SPREAD: 2.957	10:	0.681	1.536
MIN RADIUS: 0.425			
MAX RADIUS: 1.578			
MEAN RADIUS: 0.924			
# IN 1 IN DIAMETER: 1			
# IN 2 IN DIAMETER: 6			
# in 3 IN DIAMETER: 9			



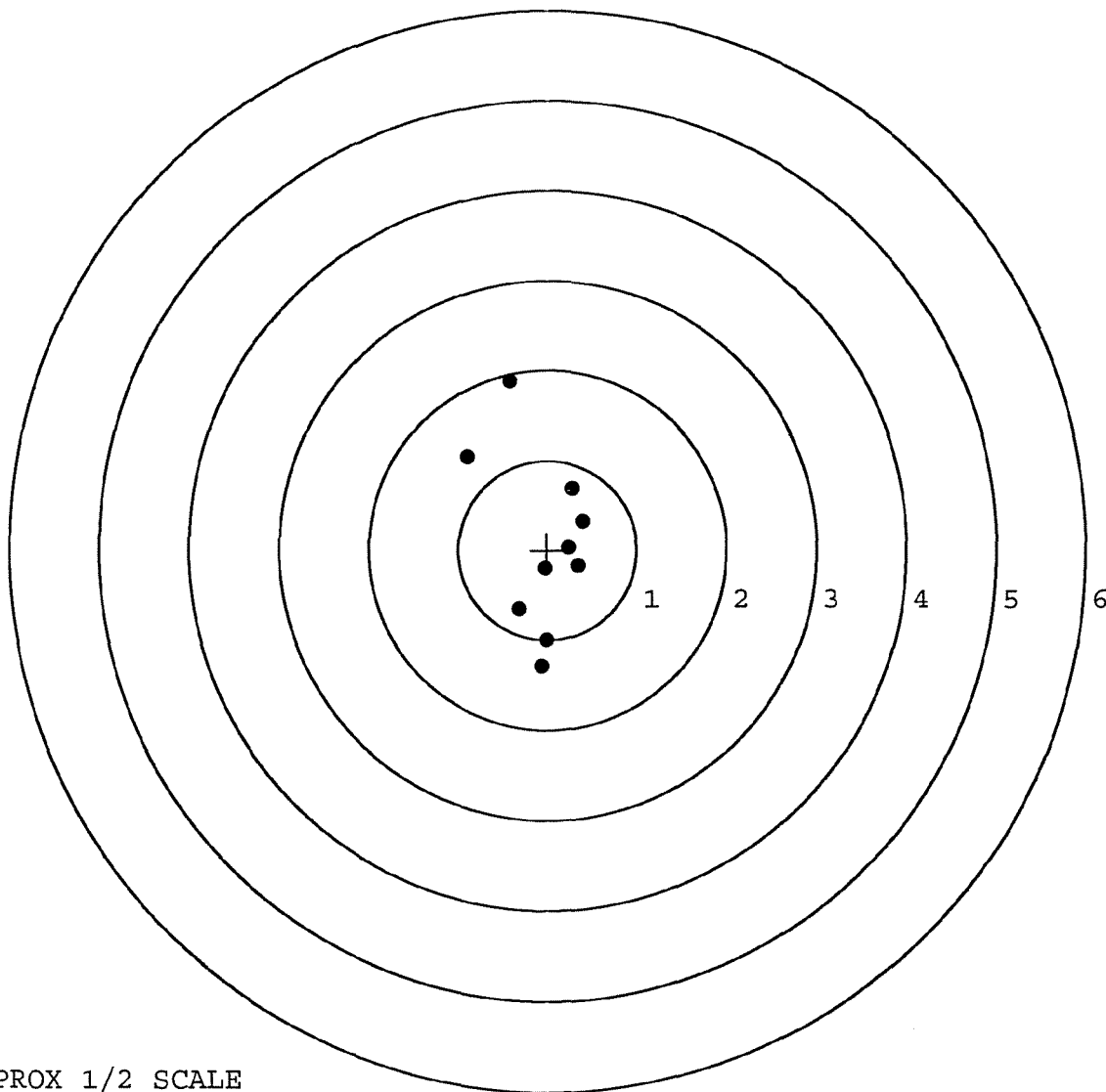
TARGET APPROX 1/2 SCALE

BARBER - M24 0104163

SERIAL NUMBER: C6665932. __0
 TARGET NUMBER: 2
 FILE DATE: 09/21/2007
 FILE TIME: 13:16

POINT#	X	Y
1:	-0.064	-1.300
2:	-0.009	-1.013
3:	-0.315	-0.662
4:	0.352	-0.178
5:	-0.021	-0.212
6:	0.245	0.029
7:	0.400	0.322
8:	0.282	0.688
9:	-0.899	1.043
10:	-0.425	1.875

X CENTROID: -0.045
 Y CENTROID: 0.059
 POA TO CENTROID: 0.075
 HORZ SPREAD: 1.299
 VERT SPREAD: 3.175
 GROUP SPREAD: 3.195
 MIN RADIUS: 0.272
 MAX RADIUS: 1.855
 MEAN RADIUS: 0.861
 # IN 1 IN DIAMETER: 3
 # IN 2 IN DIAMETER: 6
 # in 3 IN DIAMETER: 9



TARGET APPROX 1/2 SCALE

BARBER - M24 0104164

SERIAL NUMBER: C6665932. 0

TARGET NUMBER: 3

FILE DATE: 09/21/2007

FILE TIME: 13:16

POINT#	X	Y
1:	-0.634	0.738
2:	-0.267	0.482
3:	-0.765	0.164
4:	-0.763	-0.385
5:	0.183	-0.234
6:	0.303	-0.024
7:	0.697	-0.057
8:	1.102	-0.893
9:	0.743	-0.932
10:	0.032	-2.056

X CENTROID: 0.063

Y CENTROID: -0.320

POA TO CENTROID: 0.326

HORZ SPREAD: 1.867

VERT SPREAD: 2.794

GROUP SPREAD: 2.872

MIN RADIUS: 0.147

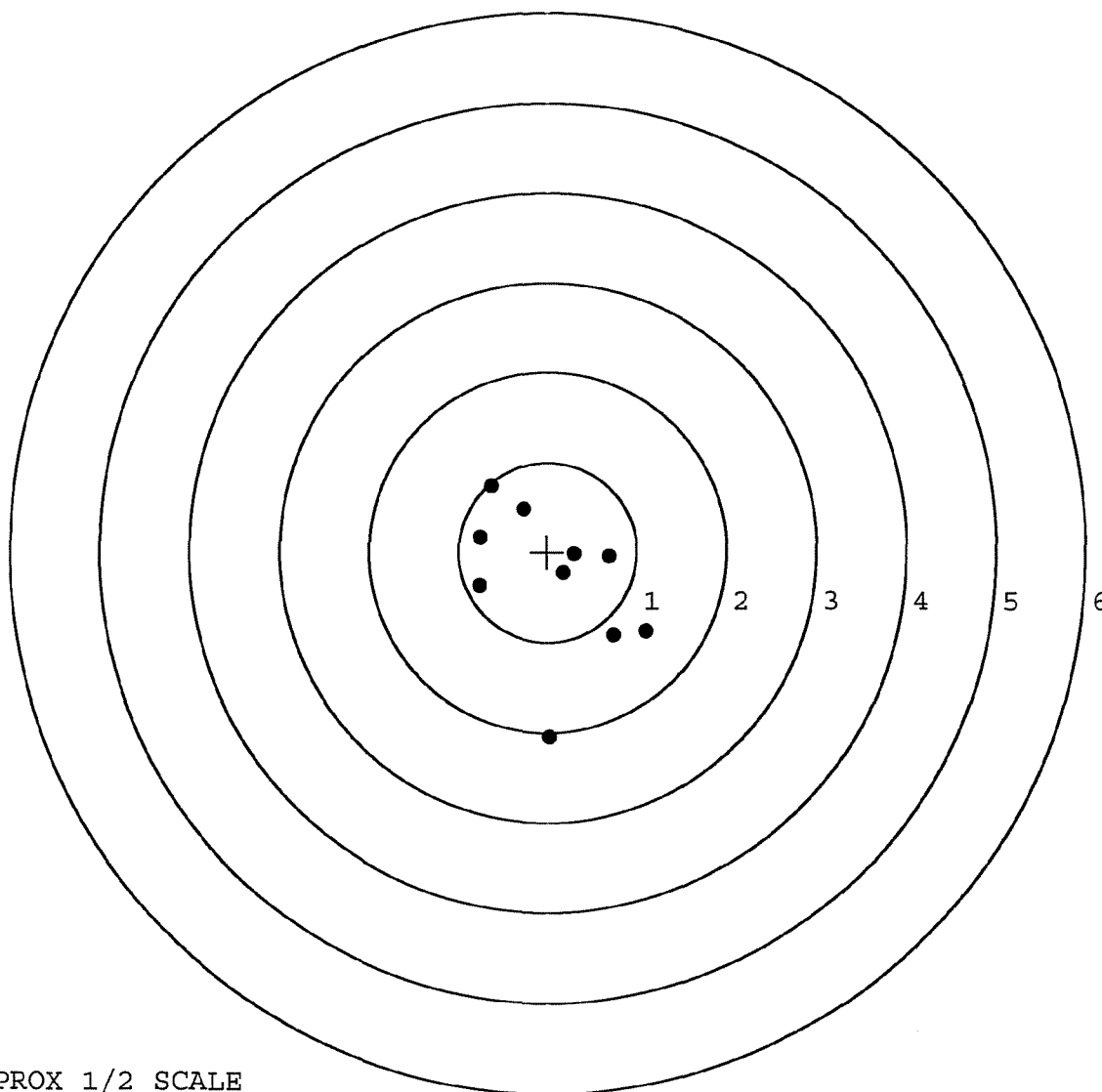
MAX RADIUS: 1.737

MEAN RADIUS: 0.897

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 9



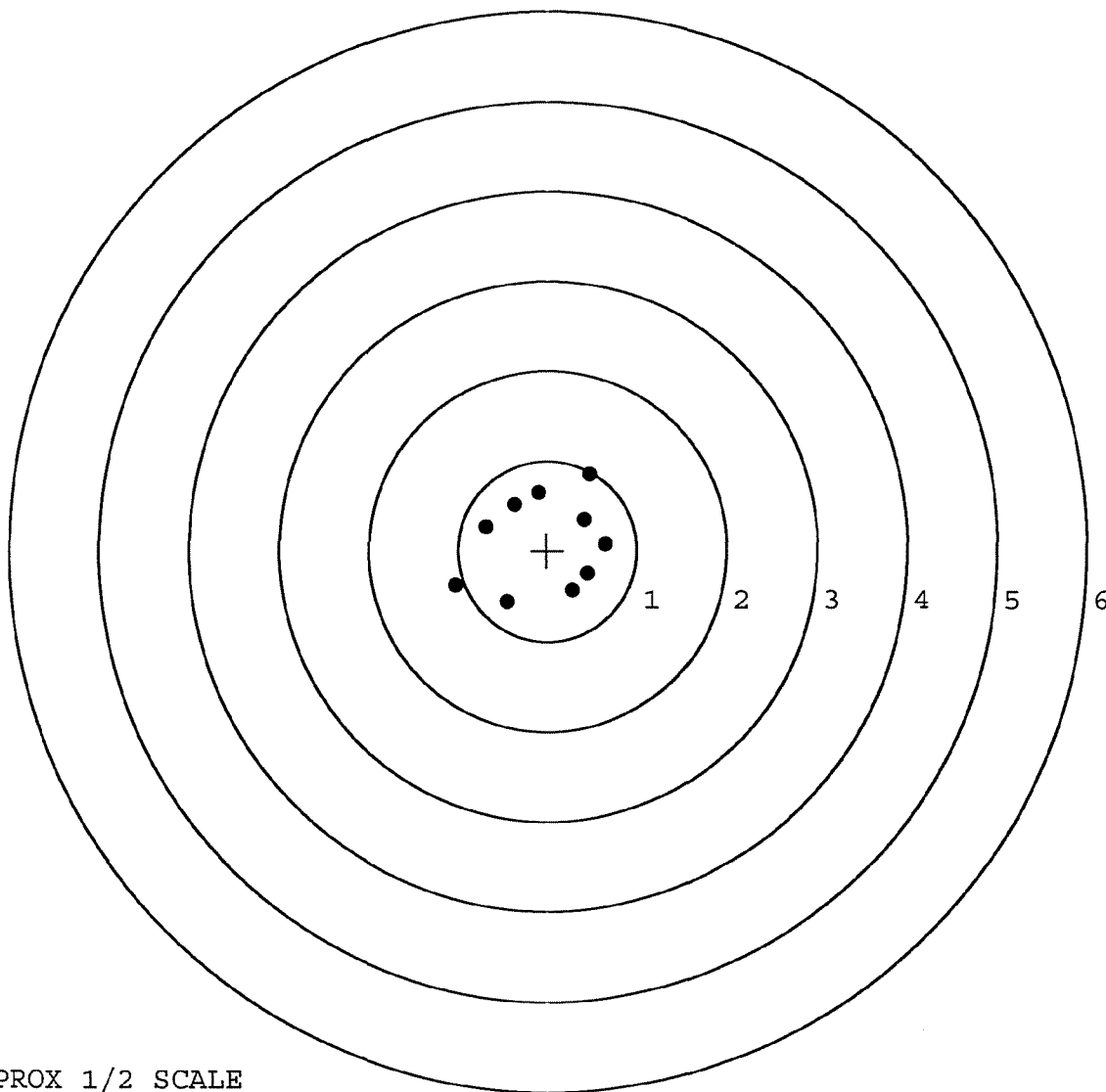
TARGET APPROX 1/2 SCALE

BARBER - M24 0104165

SERIAL NUMBER: C6665932. __0
 TARGET NUMBER: 4
 FILE DATE: 09/21/2007
 FILE TIME: 13:16

POINT#	X	Y
1:	-1.032	-0.389
2:	-0.455	-0.573
3:	-0.694	0.262
4:	-0.378	0.512
5:	-0.106	0.644
6:	0.479	0.849
7:	0.413	0.343
8:	0.648	0.071
9:	0.453	-0.256
10:	0.286	-0.446

X CENTROID: -0.039
 Y CENTROID: 0.102
 POA TO CENTROID: 0.109
 HORZ SPREAD: 1.680
 VERT SPREAD: 1.422
 GROUP SPREAD: 1.953
 MIN RADIUS: 0.512
 MAX RADIUS: 1.108
 MEAN RADIUS: 0.701
 # IN 1 IN DIAMETER: 0
 # IN 2 IN DIAMETER: 9
 # in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

BARBER - M24 0104166

SERIAL NUMBER: C6665932. __0

TARGET NUMBER: 5

FILE DATE: 09/21/2007

FILE TIME: 13:16

POINT#	X	Y
1:	-0.140	-0.712
2:	-0.503	-0.421
3:	-0.121	-0.149
4:	0.515	-0.470
5:	0.327	-0.132
6:	0.038	0.447
7:	-0.310	0.472
8:	-0.955	0.745
9:	0.746	0.914
10:	-0.343	1.515

X CENTROID: -0.075

Y CENTROID: 0.221

POA TO CENTROID: 0.233

HORZ SPREAD: 1.701

VERT SPREAD: 2.227

GROUP SPREAD: 2.236

MIN RADIUS: 0.253

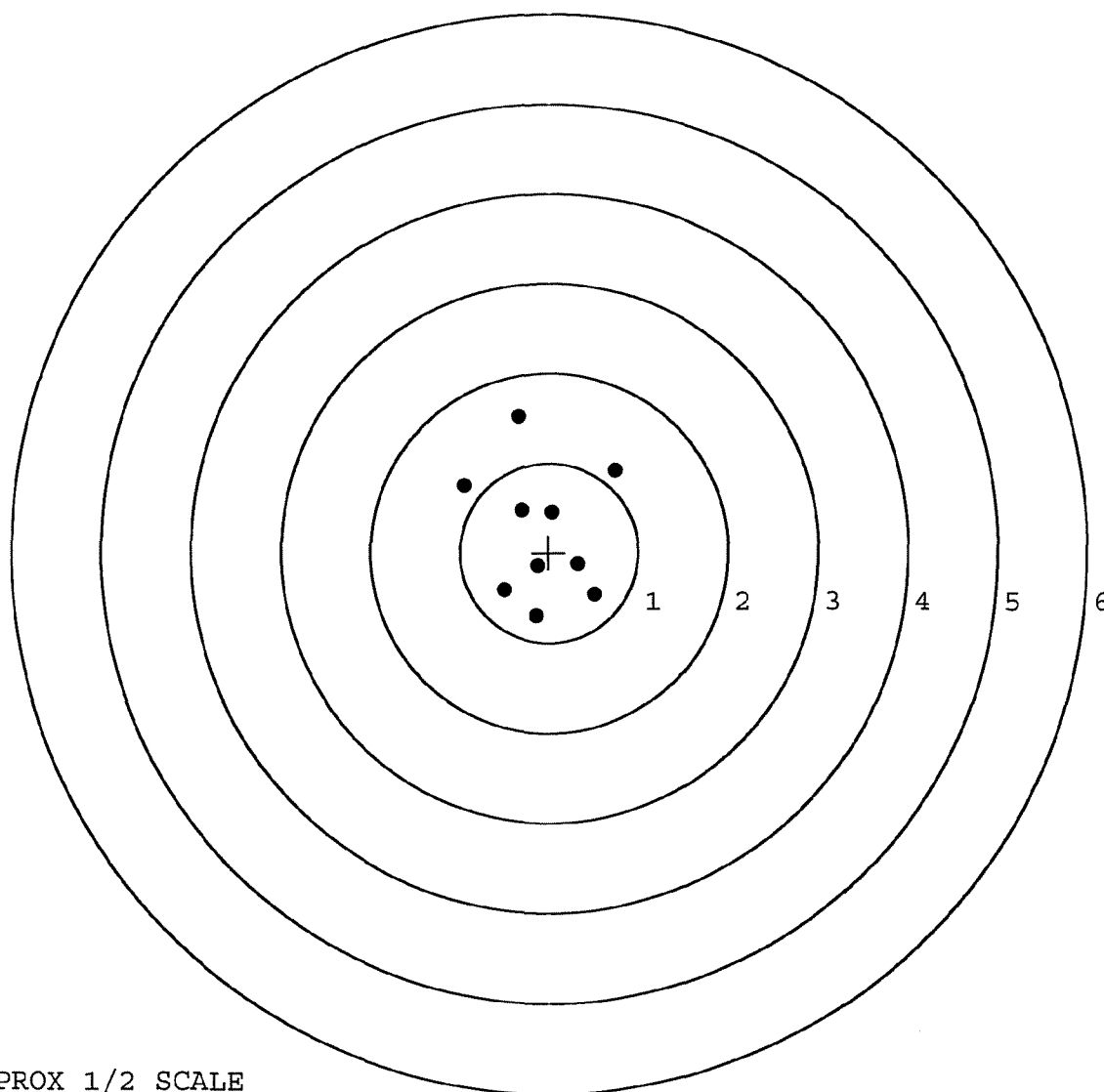
MAX RADIUS: 1.322

MEAN RADIUS: 0.754

IN 1 IN DIAMETER: 3

IN 2 IN DIAMETER: 7

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

R & E NUMBER

133019

SERIAL NUMBER

C6665932

LOG-IN DATE

8-22-07

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	9-10-07	RTZ
505	RE-BARREL	9-11-07	RTZ
560	ASSEMBLE	9-11-07	RTZ
600	PROOF	9-12-07	TRW
605	CHECK HEADSPACE	9-12-07	TRW
610	DIS-ASSEMBLE GUN	9-12-07	RTZ
612	MAGNAFLUX	9-13-07	JB
510	DRILL AND TAP	9-12-07	FM
615	ROLLMARK CALIBER	9-12-07	CW
618	ROTO-BLAST	9-12-07	LS
620	APPLY COATINGS	9/14/07	RB
625	FINAL ASSEMBLY	9-20-07	RTZ
640	FUNCTION TEST AND	PASS FAIL 9-21-07	TRW
650	TARGET	PASS FAIL 9-21-07	TRW
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	9-21-07	FM
	A) HEADSPACE	PASS FAIL 9/21/07	mm
	B) TRIGGER PULL	2.91 2.90 2.83 2.95 2.96 9/21/07	DA
680	F) SAFETY ON FORCE	4.0 4.0 4.0 9/21/07	DA
	G) SAFETY OFF FORCE	2.5 2.5 2.5 9/21/07	DA
	I) FIRING PIN INDENT	.0225 .023 .0225 9/21/07	DA
690	PACK	9-24-07	RTA

Remington



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

MODEL 700™ M24

SERIAL NO.
C6665932

ORDER NO.
5716

20

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



5716 C6665932

ORDER 5716
MODEL 700™ M24
UPC

ORDER 5716
MODEL 700™ M24
UPC



0 47700 25716 7



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6665932

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 8 1991	KR
	Magnaflux Bolt		OCT 8 1991	KR
615	Rollmark Caliber		OCT 8 1991	LS
617	Drill and Tap Sight Holes		OCT 8 1991	LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/2/91	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		11/14/91	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		12/27/91	WB

op. #	BARBER - M24 0104170	READINGS					DATE	INIT
625 cont.	F) Safety On Force	3	3	3			12-27-91	AC
	G) Safety Off Force	3	3	3			12-27-91	AC
	H) Trigger Pull Test & Retainability						12/27/91	WB
	I) Firing Pin Indent	.021	.020	.020			12-27-91	AC
	J) Assemble Stock						1/2/92	RW
	K) Assemble Swivel Studs						1-3-92	JU
	L) Attach Front and Rear Sight Assemblies						1/2/92	RW
	M) Iron Sight Alignment						1/2/92	RW
	N) Detach Front & Rear Sights & place in numbered container						1/2/92	RW
	O) Attach Scope to Rifle						1/2/92	RW
	P) Detach & Attach Scope 20 Times						1/2/92	RW
640	Gallery Target & Test						1-3-92	AC
	A) Time						1-3-92	AC
	B) Malfunctions						1-3-92	AC
	C) Pierced Primers						1-3-92	AC
	D) Optical Clarity of Scope						1-3-92	AC
645	Inspect for Live Ammo						1-3-92	AC
655	Final Inspection							
	A) Headspace						1-3-92	JU
	B) Trigger Pull	217	218	218	217	219	1-3-92	DH
	C) Function						1-3-92	JU
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. C6665932
DATE 12/27/91
TESTER WB

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.42	2.31	2.34	2.17	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.43	2.51	2.38	2.18	
PULL #3	2.51	2.49	2.36	2.18	
PULL #4	2.51	2.46	2.26	2.17	
PULL #5	2.47	2.44	2.26	2.19	
TOTAL	12.34	12.41	11.60		
AVG.	2.47	2.48	2.32		

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.24	3.24		
PULL #2	3.10	3.31		
PULL #3	3.15	3.25		
PULL #4	3.17	3.29		
PULL #5	3.19	3.26		
TOTAL	15.85	16.35		
AVG.	3.17	3.27		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.10	4.18		3.82
PULL #2	4.16	4.22		3.76
PULL #3	3.95	4.19		3.77
PULL #4	4.07	4.20		3.81
PULL #5	4.13	4.19		3.80
TOTAL	20.41	20.98		18.96
AVG.	4.08	4.20		3.79

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06665932
3 Jan 1992

CENTROIDAL DISTANCES

0 TO	1	.373225
1 TO	2	.166532
1 TO	3	.536795
1 TO	4	.367723
1 TO	5	.351814

FE1 <----POA
3

AVERAGE X-COORDINATE FOR THIS RIFLE IS: .2278
AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0306
AVERAGE AVERAGE POI RADIUS FOR THIS RIFLE IS: .22984-
R THIS RIFLE IS: 1.182

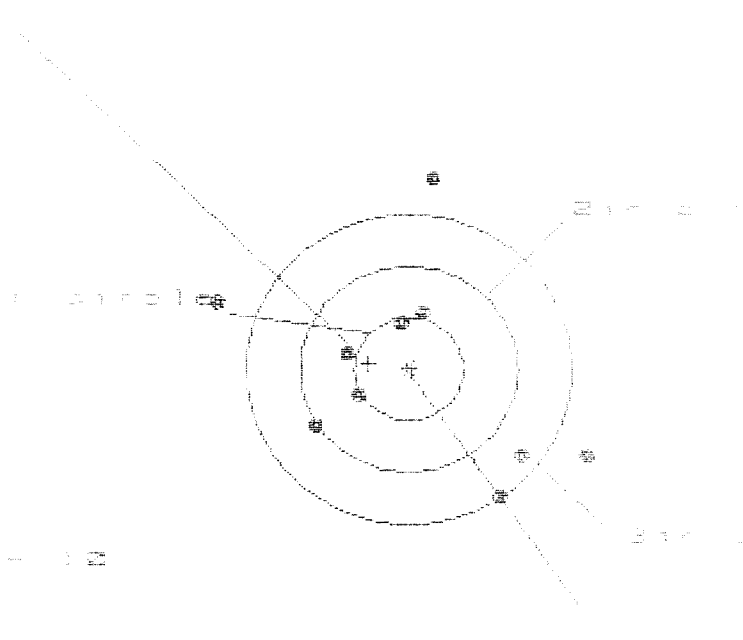
11/25/1992

FILE:/PATTERNING/CENTERFIRE_PATT/08665822

CENTERFIRE PATTERNS

1

FOR



1.000

CENTER

PATTERN #

:

1

PATTERN (BEST OF)

:

10

9

0

PATTERN X

:

1.850

1.454

1.000

PATTERN X

:

-1.780

-1.107

-1.025

PATTERN Y

:

1.810

1.886

1.780

PATTERN Y

:

-1.205

-1.137

-1.234

PATTERN X

:

.369

.565

.080

PATTERN X

:

-1.056

-1.124

-1.027

PATTERN X

:

.373

.578

.084

PATTERN X

:

.507

.641

.482

PATTERN X

:

1.166

1.109

.992

PATTERN X

:

1.863

1.886

1.797

PATTERN X

:

3.410

2.561

1.924

PATTERN X

:

3.023

3.023

3.023

PATTERN X

:

3.797

3.097

3.097

PATTERN X

:

3.797

3.097

3.097

PATTERN X

:

3.797

3.097

3.097

PATTERN X

:

3.797

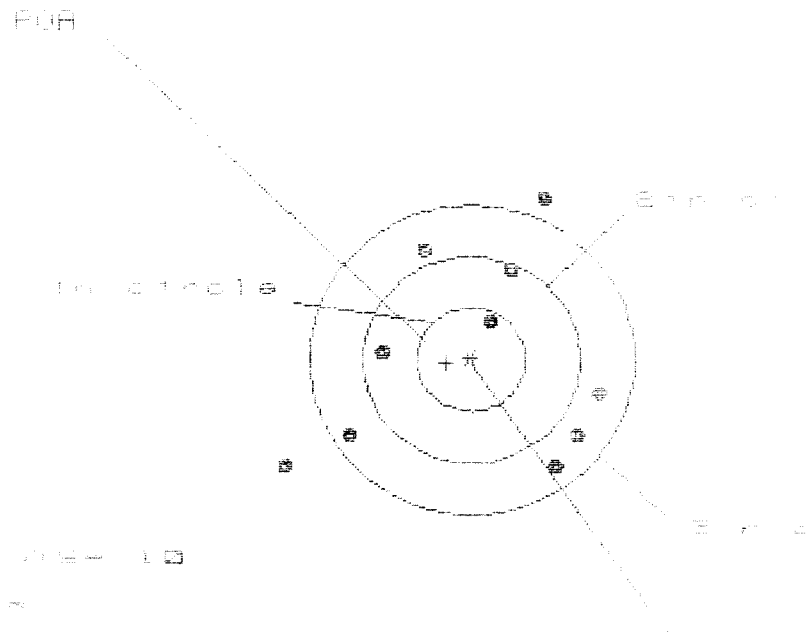
3.097

3.097

Jan 1992

FILE:/PATTERNING/CENTERFIRE_PATT/C8865932

CENTERFIRE PATTERNS # 2



FOA TO CENTER = 1.0

FOA TO 1 INCH = 1.7

FOA TO 2 INCH = 3.1

FOA TO 3 INCH = 5.0

FOA TO 4 INCH = 6.8

FOA TO 5 INCH = 8.6

FOA TO 6 INCH = 10.4

FOA TO 7 INCH = 12.2

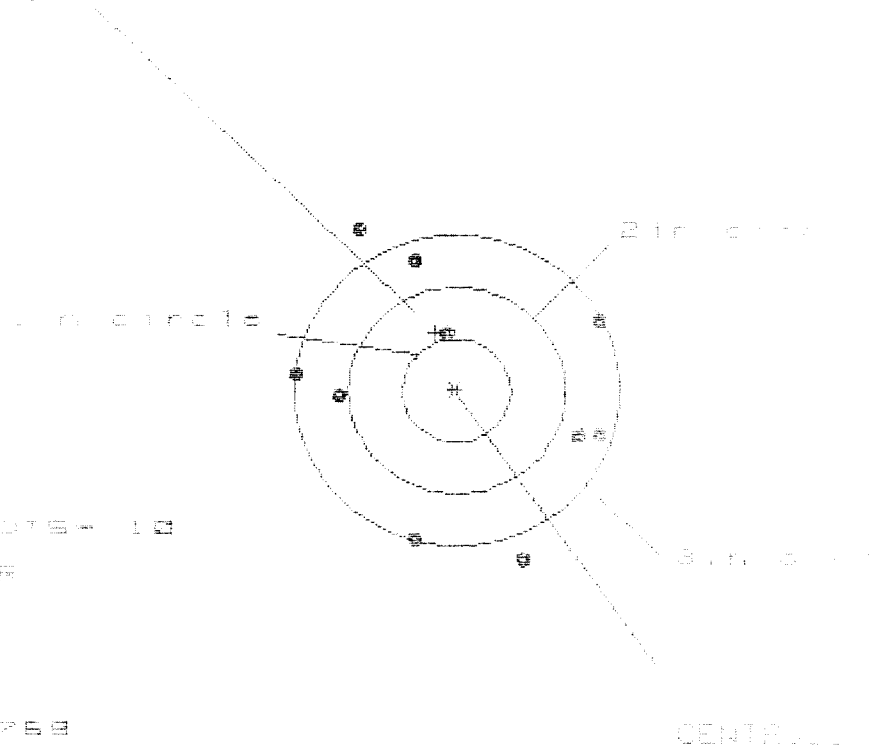
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MINIMUM X	1.161	.967	1.038
MINIMUM Y	-1.738	-1.304	-1.242
MAXIMUM X	1.575	1.468	1.183
MAXIMUM Y	-1.033	-1.119	-1.936
ENVELOPE X	.227	.426	.357
ENVELOPE Y	.031	.146	-.037
FOA TO CENTROID (in)	.229	.444	.359
1 INCH RADIUS	.352	.209	.387
2 INCH RADIUS	1.199	1.075	1.027
3 INCH RADIUS	2.022	1.545	1.408
4 INCH RADIUS	2.899	2.271	2.271
5 INCH RADIUS	2.608	2.579	2.119
6 INCH RADIUS	3.564	2.913	2.699
FOA TO 1 INCH CIRCLE	=	1	
FOA TO 2 INCH CIRCLE	=	3	
FOA TO 3 INCH CIRCLE	=	8	

2 Jan 1932

FILE:/PATTERNING/CENTERFIRE_PATT/06685036

CENTERFIRE PATTERNS # 3

FOR



* 10 SHOTS - 10

1 - 015

1 - 0

1 - 1

1 - 2

15 = 3.753

16 = 3.193

17 = 3.523

CENTRAL

PATTERN #	3		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.315	1.383	1.294
MINIMUM X	-1.453	-1.385	-1.484
MAXIMUM Y	1.522	1.336	1.294
MINIMUM Y	-1.676	-1.648	-1.481
CENTROID X	.187	.119	.218
CENTROID Y	-.561	-.375	-.542
FOR TO CENTROID in.	.591	.393	.584
1 in. RADIUS	.553	.364	.538
2 in. RADIUS	1.363	1.287	1.261
3 in. RADIUS	1.786	1.686	1.549
HORIZONTAL SPREAD	2.768	2.768	2.768
VERTICAL SPREAD	3.193	2.984	2.765
CIRCLE SPREAD	3.523	3.016	2.839
CORRECTION ONE INCH CIRCLE	=	0	
CORRECTION TWO INCH CIRCLE	=	1	
CORRECTION THREE INCH CIRCLE	=	7	

Jan 1982

FILE:/PATTERNING/CENTERFIRE_PATT/C866593C

CENTERFIRE PATTERNS

4

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

4 INCH CIB

X = 1

Y = 4

Z = 9

MS = 1.717

MS = 2.379

MS = 3.468

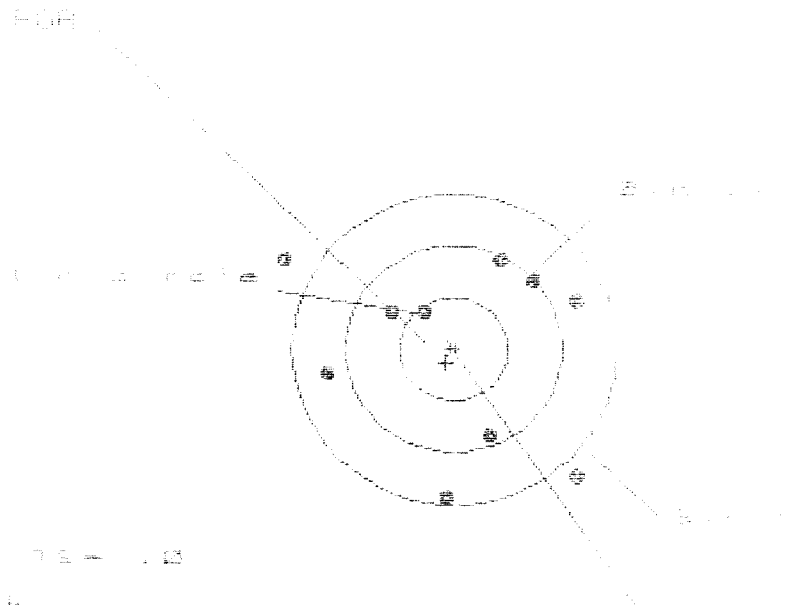
CEN = 1.0

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.947	.998	.988
MINIMUM X	:	-1.771	-1.727	-1.739
MAXIMUM Y	:	1.593	1.394	1.194
MINIMUM Y	:	-1.786	-1.348	-1.173
CENTROID X	:	.285	.241	.248
CENTROID Y	:	.302	.501	.327
POA TO CENTROID in.	:	.415	.556	.407
1IN RADIUS	:	.381	.469	.420
2IN RADIUS	:	1.052	.953	.887
3IN RADIUS	:	1.828	1.444	1.283
HORIZONTAL SPREAD	:	1.717	1.717	1.717
VERTICAL SPREAD	:	3.379	2.742	2.367
DIAGN SPREAD	:	3.468	2.788	2.398
CORNER IN ONE INCH CIRCLE	=	1		
CORNER IN TWO INCH CIRCLE	=	4		
CORNER IN THREE INCH CIRCLE	=	8		

11

FILE \PATTERNING\CENTERFIRE_PAT\08585832

CENTERFIRE PATTERNING



+ 1.121 1.946 1.1040

+ 1.501 -1.352 -1.038

+ 1.892 1.989 1.801

+ 1.435 -1.338 -1.475

+ 1.071 1.246 1.132

+ 1.131 1.034 1.131

+ 1.149 1.249 1.215

+ 1.462 1.642 1.417

+ 1.129 1.056 1.075

+ 1.807 1.436 1.140

+ 2.703 2.298 2.193

+ 2.327 2.327 2.327

+ 2.389 2.474 2.100

+ 1.121 1.946 1.1040

+ 1.501 -1.352 -1.038

+ 1.892 1.989 1.801

+ 1.435 -1.338 -1.475

+ 1.071 1.246 1.132

+ 1.131 1.034 1.131

+ 1.149 1.249 1.215

+ 1.462 1.642 1.417

+ 1.129 1.056 1.075

+ 1.807 1.436 1.140

+ 2.703 2.298 2.193

+ 2.327 2.327 2.327

+ 2.389 2.474 2.100

RIFLE #

:

5

RIFLE BEST OF 5

:

10

A

C

MINIMUM X

:

1.121

1.946

1.1040

MINIMUM Y

:

-1.501

-1.352

-1.038

MINIMUM X

:

1.892

1.989

1.801

MINIMUM Y

:

-1.435

-1.338

-1.475

CENTROID X

:

1.071

1.246

1.132

CENTROID Y

:

1.131

1.034

1.131

RIFLE CENTROID INCH

:

1.149

1.249

1.215

RIFLE RADIUS

:

1.462

1.642

1.417

RIFLE RADIUS

:

1.129

1.056

1.075

RIFLE RADIUS

:

1.807

1.436

1.140

RIFLE RADIUS

:

2.703

2.298

2.193

RIFLE RADIUS

:

2.327

2.327

2.327

RIFLE RADIUS

:

2.389

2.474

2.100

RIFLE RADIUS

:

1

5

8

RIFLE RADIUS

:

5

8

8

RIFLE RADIUS

:

8

8

8

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348947

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	9 14	89	RW
600	Proof	9 14	89	RW
607	Check Headspace	9 14	89	RW
610	Dis-assemble Gun	9 14	89	RW
612	Magnaflux Barrel Action	9-14-89		KCR
	Magnaflux Bolt	9-14-89		KCR
615	Rollmark Caliber		9/15/89	GS
7	Drill and Tap Sight Holes	9 15	89	40
618	Polish Barrel	9 15	89	BT
620	Apply Coatings (Barrel Action)		9-25-89	THA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		9/26/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		9/26/89	RW
	C) Inspect Ejector Hole for Chamfer		9/26/89	RW
	D) Oil Firing Pin Ass'y		9/26/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		11/6/89	9-18

BARBER - M24 0104179

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4	4	4			10/12/89	gcl
	G) Safety Off Force	4	4	4			10/12/89	gcl
	H) Trigger Pull Test & Retainability						11/6/89	gcl
	I) Firing Pin Indent	.0215	.0205	.0205			10/12/89	gcl
	J) Assemble Stock						10/12/89	RW
	K) Assemble Swivel Studs						13/6/89	gcl
	L) Attach Front and Rear Sight Assemblies						10/12/89	RW
	M) Iron Sight Alignment						10/12/89	RW
	N) Detach Front & Rear Sights & place in numbered container						10/12/89	RW
	O) Attach Scope to Rifle						10/12/89	gcl
	P) Detach & Attach Scope 20 Times						10/12/89	gcl
640	Gallery Target & Test						10-12-89	AC
	A) Time						10-12-89	AC
	B) Malfunctions						10-12-89	AC
	C) Pierced Primers						10-12-89	AC
	D) Optical Clarity of Scope						10-12-89	AC
645	Inspect for Live Ammo						10-12-89	AC
655	Final Inspection							
	A) Headspace						13/6/89	gcl
	B) Trigger Pull	272	273	273	240	250	13/6/89	gcl
	C) Function						13/6/89	gcl
660	Pack							

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6348947DATE 11 Oct 89TESTER GIS

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.38	2.13	2.46	2.77	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.35	2.04	2.23	2.73	
PULL #3	2.54	2.18	2.77	2.73	
PULL #4	2.60	2.36	2.52	2.40	
PULL #5	2.52	2.23	2.35	2.50	
TOTAL	12.39	10.94	12.33	13.08	
AVG.	2.478	2.188	2.466	2.616	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.46	3.48		
PULL #2	3.60	3.17		
PULL #3	3.49	3.17		
PULL #4	3.37	3.48		
PULL #5	3.20	3.64		
TOTAL	17.12	16.94		
AVG.	3.424	3.388		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.27	4.38		4.53
PULL #2	4.05	4.04		3.99
PULL #3	3.99	4.50		4.09
PULL #4	3.99	3.87		3.74
PULL #5	4.12	4.04		3.95
TOTAL	20.43	20.83		20.30
AVG.	4.086	4.166		4.06

0 Rounds

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348947
12 Oct 1989

CENTROIDAL DISTANCES

0 TO	1	.344205
1 TO	2	.341001
1 TO	3	.69317
1 TO	4	.972587
1 TO	5	.486585

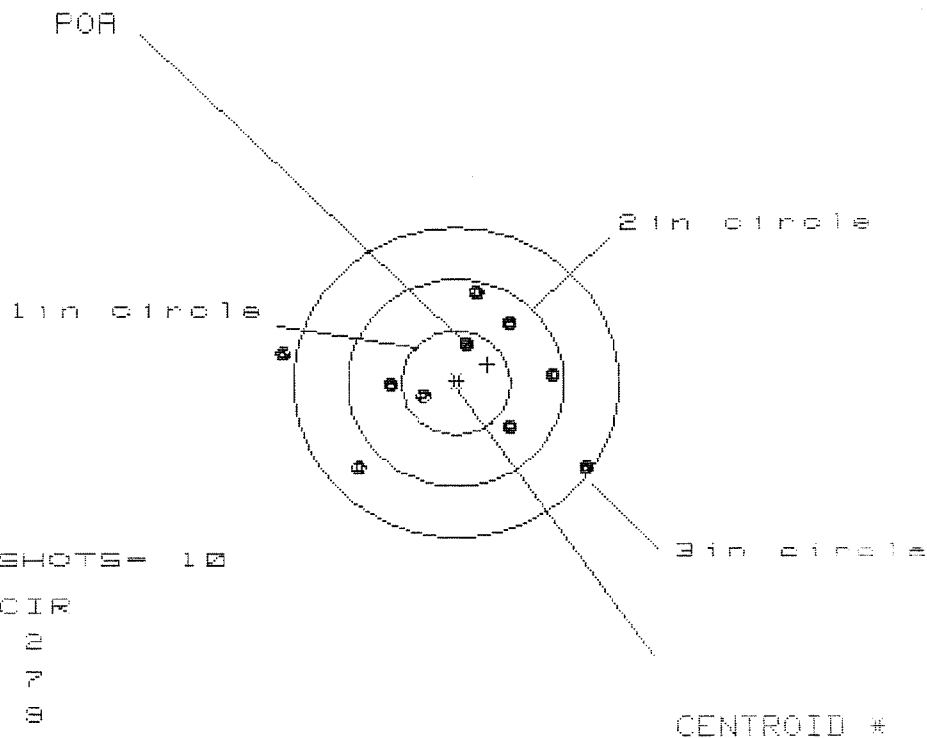
$$\frac{x_1 + x_2 + x_3 + x_4 + x_5}{5} \text{ ---- FOR}$$

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0496
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1286
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .137834
THE AMR FOR THIS RIFLE IS: .9992

12 Oct 1985

FILE:/PATTERNING/CENTERFIRE_PATT/08346347

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 7

3 in = 9

HS= 2.779

VS= 1.728

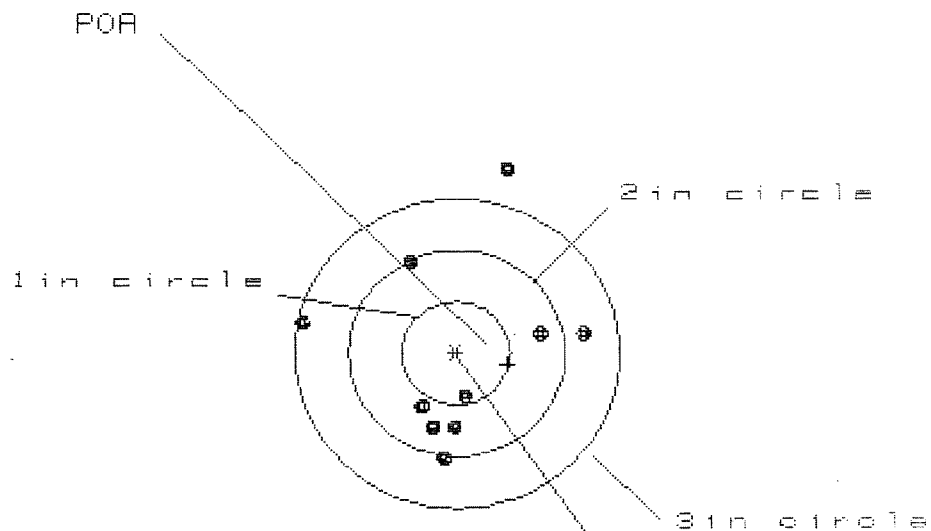
GS= 2.985

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.214	1.040	.687
MINIMUM X	:	-1.565	-1.068	-.938
MAXIMUM Y	:	.874	.900	.796
MINIMUM Y	:	-.854	-.828	-.872
CENTROID X	:	-.294	-.120	-.250
CENTROID Y	:	-.179	-.285	-.101
POA TO CENTROID in.	:	.344	.237	.270
MIN RADIUS	:	.352	.421	.316
MEAN RADIUS	:	.881	.797	.708
MAX RADIUS	:	1.583	1.329	1.281
HORIZONTAL SPREAD	:	2.779	2.108	1.825
VERTICAL SPREAD	:	1.728	1.728	1.668
EXTREME SPREAD	:	2.985	2.109	2.013
NUMBER IN ONE INCH CIRCLE	=	2		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	9		

12 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348347

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.675

VS= 2.754

GS= 2.820

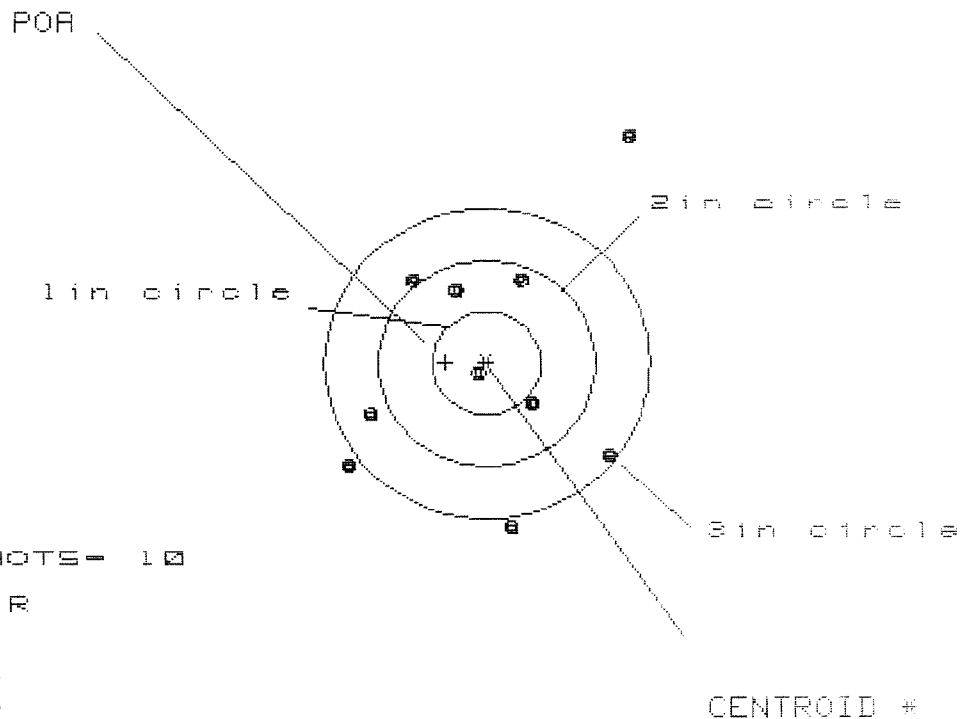
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.224	1.279	1.105
MINIMUM X	:	-1.452	-1.396	-1.552
MAXIMUM Y	:	1.784	1.115	1.175
MINIMUM Y	:	-.970	-.772	-.712
CENTROID X	:	-.475	-.531	-.357
CENTROID Y	:	.110	-.088	-.148
POA TO CENTROID in.	:	.488	.538	.386
MIN RADIUS	:	.377	.199	.144
MEAN RADIUS	:	.979	.815	.711
MAX RADIUS	:	1.853	1.477	1.299
HORIZONTAL SPREAD	:	2.675	2.675	1.657
VERTICAL SPREAD	:	2.754	1.887	1.887
EXTREME SPREAD	:	2.820	2.678	1.916
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

12 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/0634B947

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 7

HS= 2.570

VS= 3.728

GS= 4.093

CENTROID +

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.327	1.235	1.098
MINIMUM X	:	-1.243	-1.096	-1.098
MAXIMUM Y	:	2.182	1.065	.970
MINIMUM Y	:	-1.546	-1.303	-1.398
CENTROID X	:	.378	.231	.368
CENTROID Y	:	-.009	-.252	-.157
POA TO CENTROID in.	:	.379	.342	.400
MIN RADIUS	:	.153	.133	.055
MEAN RADIUS	:	1.176	1.009	.941
MAX RADIUS	:	2.554	1.397	1.419
HORIZONTAL SPREAD	:	2.570	2.331	2.196
VERTICAL SPREAD	:	3.728	2.368	2.368
EXTREME SPREAD	:	4.093	2.529	2.529
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

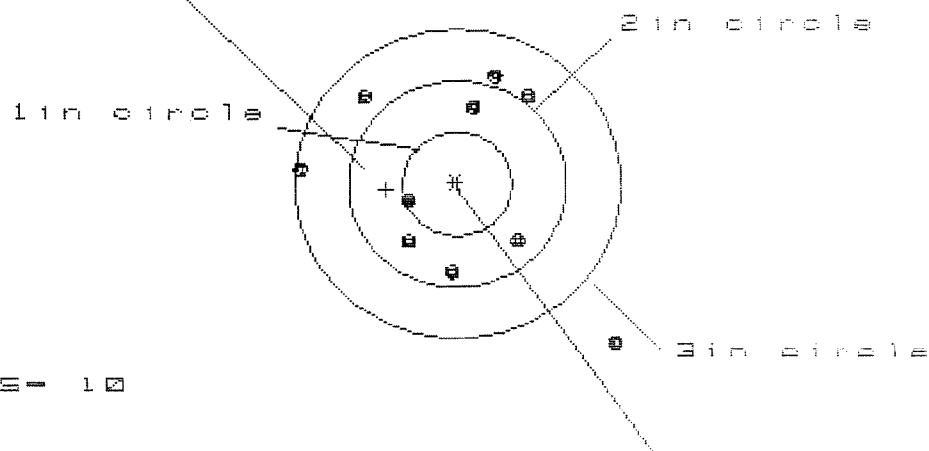
12 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B947

CENTERFIRE PATTERNS

4

POA



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 5

3 in = 9

HS= 2.926

VS= 2.524

GS= 3.377

CENTROID *

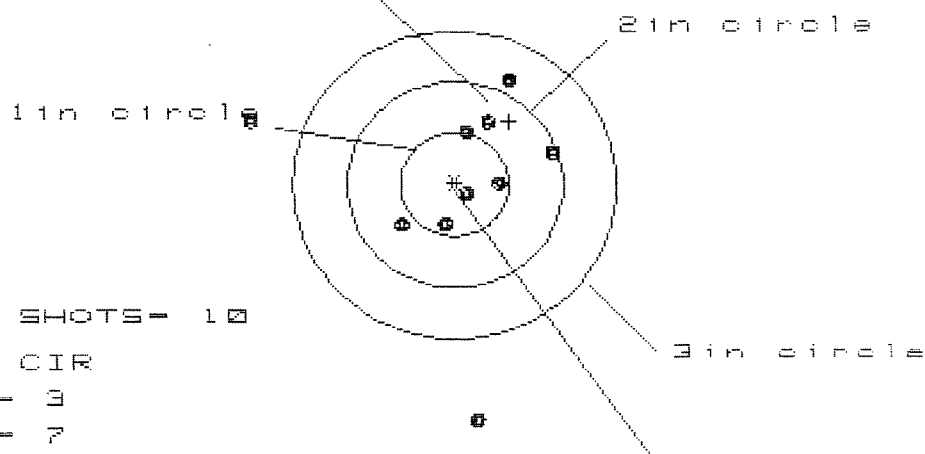
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.482	.766	.606
MINIMUM X	:	-1.444	-1.279	-.888
MAXIMUM Y	:	1.009	.841	.841
MINIMUM Y	:	-1.515	-1.015	-1.015
CENTROID X	:	.651	.486	.646
CENTROID Y	:	.051	.219	.219
POA TO CENTROID in.	:	.653	.533	.632
MIN RADIUS	:	.444	.413	.525
MEAN RADIUS	:	1.050	.912	.859
MAX RADIUS	:	2.119	1.279	1.050
HORIZONTAL SPREAD	:	2.926	2.045	1.414
VERTICAL SPREAD	:	2.524	1.856	1.856
EXTREME SPREAD	:	3.377	2.168	1.991
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			9	

12 Oct 1989

FILE:/PATTERNING/CENTERFIRE_PATT/0634B947

CENTERFIRE PATTERNS # 5

POA



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 2.751

VS= 3.239

GS= 3.481

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.878	.897	.665
MINIMUM X	:	-1.873	-1.854	-.746
MAXIMUM Y	:	.996	.746	.787
MINIMUM Y	:	-2.243	-.654	-.613
CENTROID X	:	-.508	-.527	-.295
CENTROID Y	:	-.616	-.366	-.407
POA TO CENTROID in.	:	.798	.642	.503
MIN RADIUS	:	.132	.274	.268
MEAN RADIUS	:	.910	.750	.554
MAX RADIUS	:	2.250	1.882	.966
HORIZONTAL SPREAD	:	2.751	2.751	1.411
VERTICAL SPREAD	:	3.239	1.400	1.400
EXTREME SPREAD	:	3.481	2.765	1.742
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

500 Rds

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348947
16 Nov 1989

CENTROIDAL DISTANCES

0 TO	1	.360946
1 TO	2	.454863
1 TO	3	.264327
1 TO	4	.612847
1 TO	5	.586931

531 <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0878
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1886
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .208036

THE AMR FOR THIS RIFLE IS: .8104

18 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B347.1

CENTERFIRE PATTERNS

1

POA

1in circle

2in circle

3in circle

OF SHOTS - 10

IN CIR

1in = 3

2in = 9

3in = 10

HS = 1.992

VS = 1.399

GS = 1.998

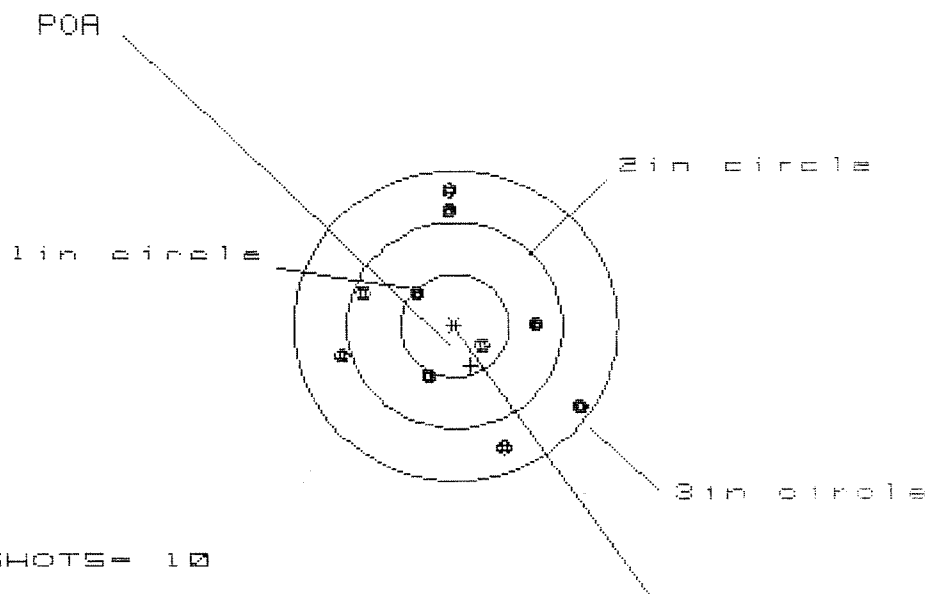
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.928	.810	.382
MINIMUM X	-1.064	-.326	-.225
MAXIMUM Y	.829	.837	.830
MINIMUM Y	-.570	-.562	-.570
CENTROID X	.279	.397	.296
CENTROID Y	.229	.221	.229
POA TO CENTROID in.	.361	.454	.374
MIN RADIUS	.283	.374	.296
MEAN RADIUS	.643	.595	.555
MAX RADIUS	1.067	.847	.860
HORIZONTAL SPREAD	1.992	1.136	.527
VERTICAL SPREAD	1.399	1.399	1.399
EXTREME SPREAD	1.998	1.453	1.453
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	9		
NUMBER IN THREE INCH CIRCLE =	10		

16 May 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348347.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 2.159

VS= 2.492

GS= 2.544

CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.152	.903	.972
MINIMUM X	:	-1.007	-.879	-.810
MAXIMUM Y	:	1.274	1.183	1.019
MINIMUM Y	:	-1.218	-1.309	-.779
CENTROID X	:	-.149	-.277	-.346
CENTROID Y	:	.383	.474	.638
POA TO CENTROID in.	:	.411	.549	.726
MIN RADIUS	:	.273	.342	.182
MEAN RADIUS	:	.917	.850	.760
MAX RADIUS	:	1.416	1.423	1.025
HORIZONTAL SPREAD	:	2.159	1.782	1.782
VERTICAL SPREAD	:	2.492	2.492	1.798
EXTREME SPREAD	:	2.544	2.544	1.848
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B947.1

CENTERFIRE PATTERNS # 3

POA

1 in circle

2 in circle

3 in circle

OF SHOTS = 10

IN CIR

1 in = 3

2 in = 8

3 in = 10

HS = 2.170

VS = 1.739

GS = 2.399

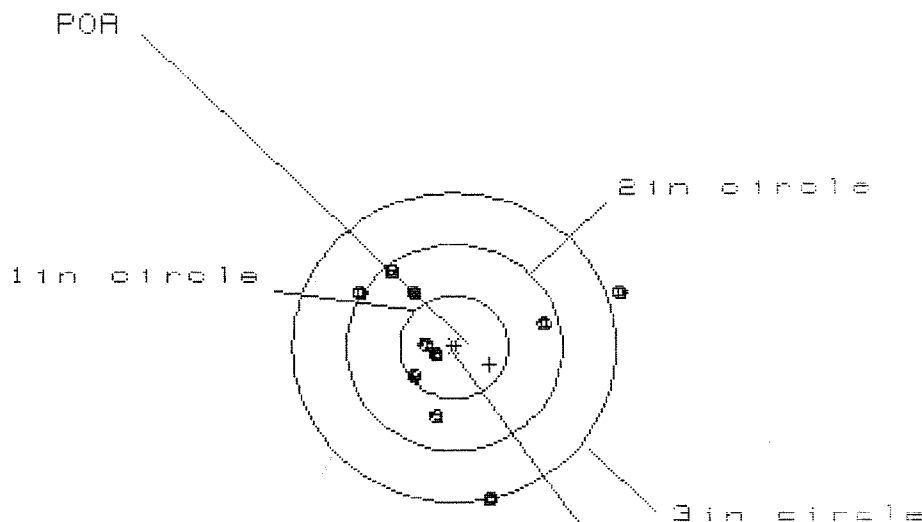
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.898	.757	.415
MINIMUM X	:	-1.272	-1.039	-.945
MAXIMUM Y	:	.866	.891	.794
MINIMUM Y	:	-.873	-.848	-.945
CENTROID X	:	.041	.182	.087
CENTROID Y	:	.114	.089	.186
POA TO CENTROID in.	:	.121	.203	.205
MIN RADIUS	:	.265	.282	.192
MEAN RADIUS	:	.796	.714	.676
MAX RADIUS	:	1.292	1.115	.994
HORIZONTAL SPREAD	:	2.170	1.796	1.360
VERTICAL SPREAD	:	1.739	1.739	1.739
EXTREME SPREAD	:	2.399	2.148	1.841
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

16 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348947.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1in = 3

2in = 8

3in = 8

HS= 2.352

VS= 2.180

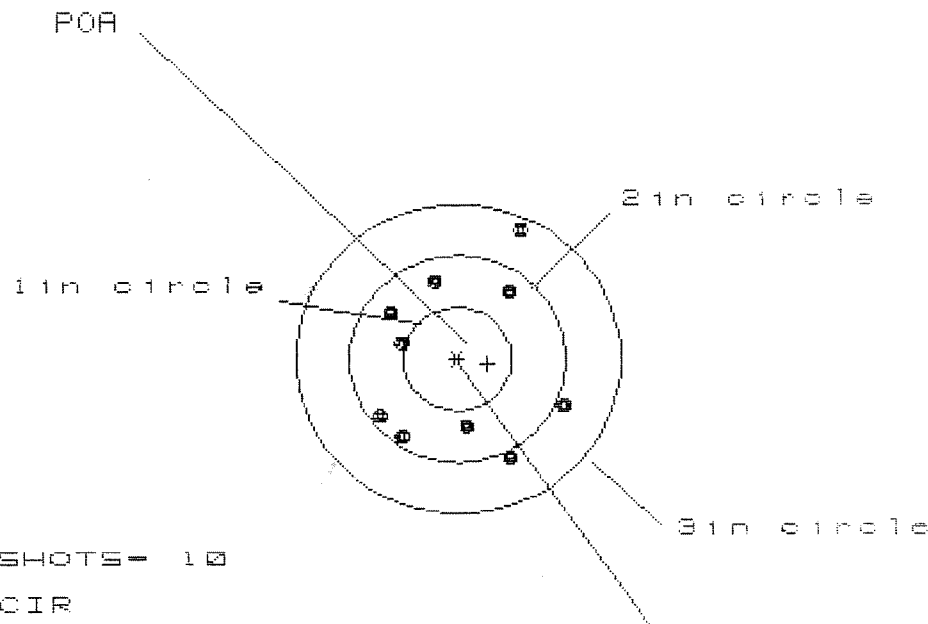
GS= 2.367

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.510	1.005	1.073
MINIMUM X	:	-.842	-.674	-.606
MAXIMUM Y	:	.711	.764	.587
MINIMUM Y	:	-1.469	-1.416	-.839
CENTROID X	:	-.331	-.499	-.567
CENTROID Y	:	.170	.117	.294
POA TO CENTROID in.	:	.373	.513	.639
MIN RADIUS	:	.194	.020	.066
MEAN RADIUS	:	.812	.667	.546
MAX RADIUS	:	1.585	1.517	1.080
HORIZONTAL SPREAD	:	2.352	1.679	1.679
VERTICAL SPREAD	:	2.180	2.180	1.426
EXTREME SPREAD	:	2.367	2.367	1.696
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

16 Nov 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348947.1

CENTERFIRE PATTERNS # 5



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 7

3 in = 10

HS = 1.666

VS = 2.139

GS = 2.284

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.941	1.009	.723
MINIMUM X	:	-.725	-.657	-.531
MAXIMUM Y	:	1.225	.871	.829
MINIMUM Y	:	-.914	-.778	-.820
CENTROID X	:	-.279	-.348	-.474
CENTROID Y	:	.047	-.089	-.047
POA TO CENTROID in.	:	.283	.359	.476
MIN RADIUS	:	.562	.499	.441
MEAN RADIUS	:	.884	.812	.761
MAX RADIUS	:	1.371	1.062	1.051
HORIZONTAL SPREAD	:	1.666	1.666	1.254
VERTICAL SPREAD	:	2.139	1.649	1.649
EXTREME SPREAD	:	2.284	1.817	1.783
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348947
7 Dec 1989

CENTROIDAL DISTANCES

0 TO	1	.405487
1 TO	2	.421521
1 TO	3	.216372
1 TO	4	.737055
1 TO	5	.471296

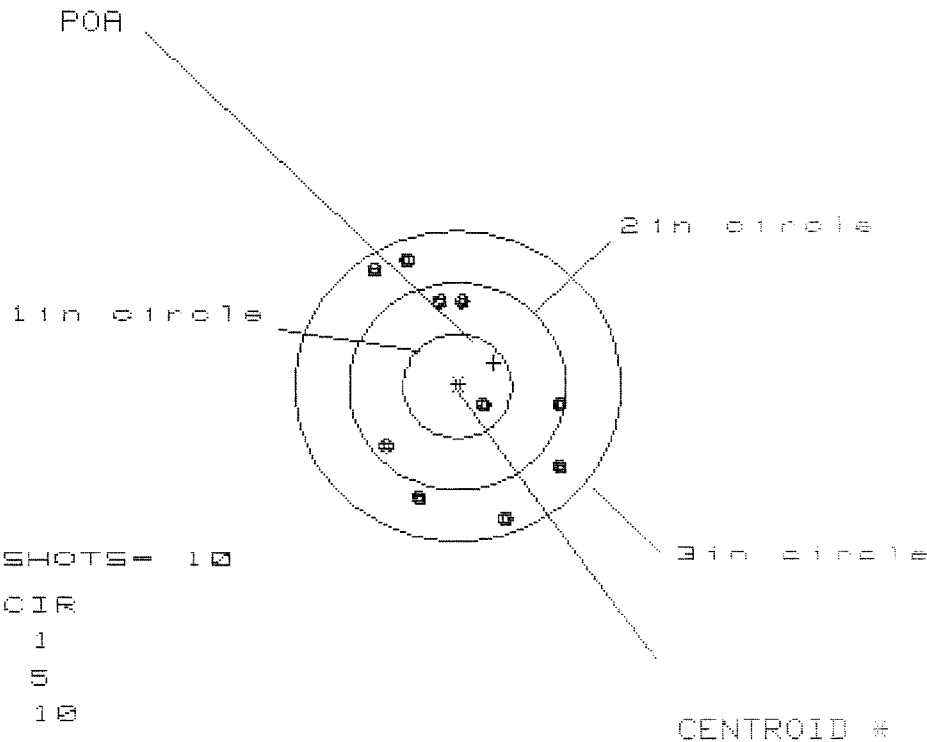
$\frac{2}{3}b^4$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1286
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0152
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .129495
THE AMR FOR THIS RIFLE IS: .9004

7 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B947.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 5

3 in = 10

HS = 1.724

VS = 2.436

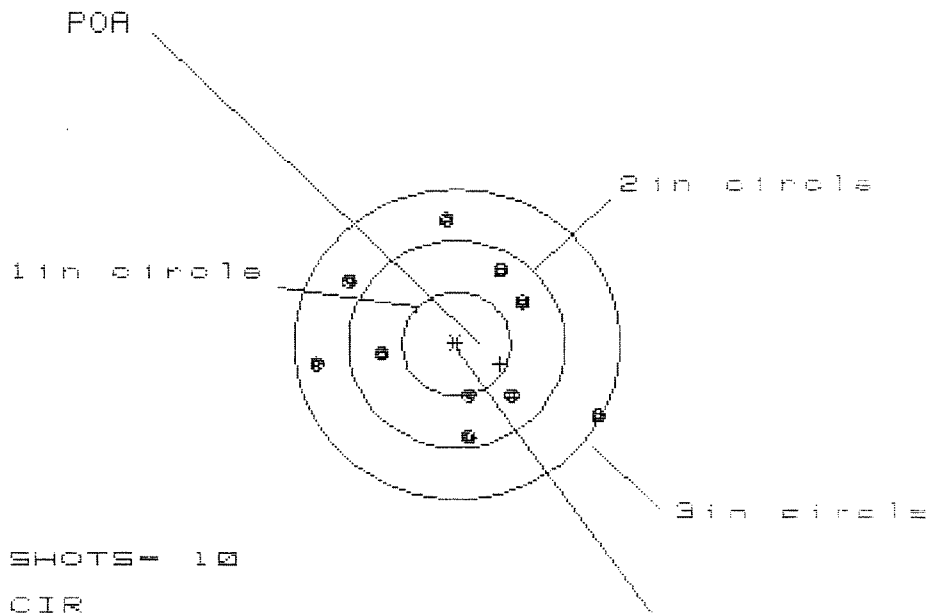
GS = 2.656

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.921	.831	.870
MINIMUM X	:	-.803	-.778	-.739
MAXIMUM Y	:	1.194	1.319	1.180
MINIMUM Y	:	-1.242	-1.117	-1.119
CENTROID X	:	-.338	-.248	-.287
CENTROID Y	:	-.224	-.349	-.210
POA TO CENTROID in.	:	.405	.429	.356
MIN RADIUS	:	.310	.183	.276
MEAN RADIUS	:	1.012	.950	.924
MAX RADIUS	:	1.383	1.446	1.303
HORIZONTAL SPREAD	:	1.724	1.609	1.609
VERTICAL SPREAD	:	2.436	2.436	2.299
EXTREME SPREAD	:	2.656	2.598	2.396
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	10		

7 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348947.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 6

3 in = 10

HS = 2.629

VS = 2.155

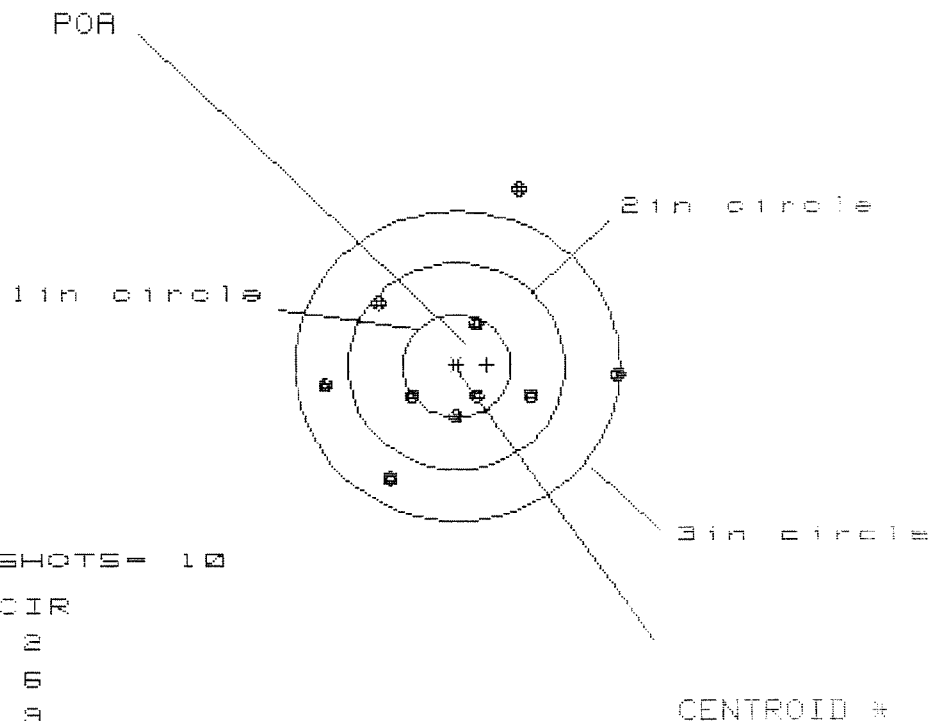
GS = 2.674

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.324	.767	.623
MINIMUM X	:	-1.305	-1.158	-.953
MAXIMUM Y	:	1.236	1.159	1.124
MINIMUM Y	:	-.919	-.996	-1.031
CENTROID X	:	-.406	-.553	-.409
CENTROID Y	:	.192	.269	.304
POA TO CENTROID in.	:	.449	.615	.509
MIN RADIUS	:	.508	.577	.617
MEAN RADIUS	:	.958	.898	.847
MAX RADIUS	:	1.494	1.191	1.127
HORIZONTAL SPREAD	:	2.629	1.925	1.586
VERTICAL SPREAD	:	2.155	2.155	2.155
EXTREME SPREAD	:	2.674	2.168	2.168
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348947.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 6

3in = 9

HS= 2.688

VS= 2.835

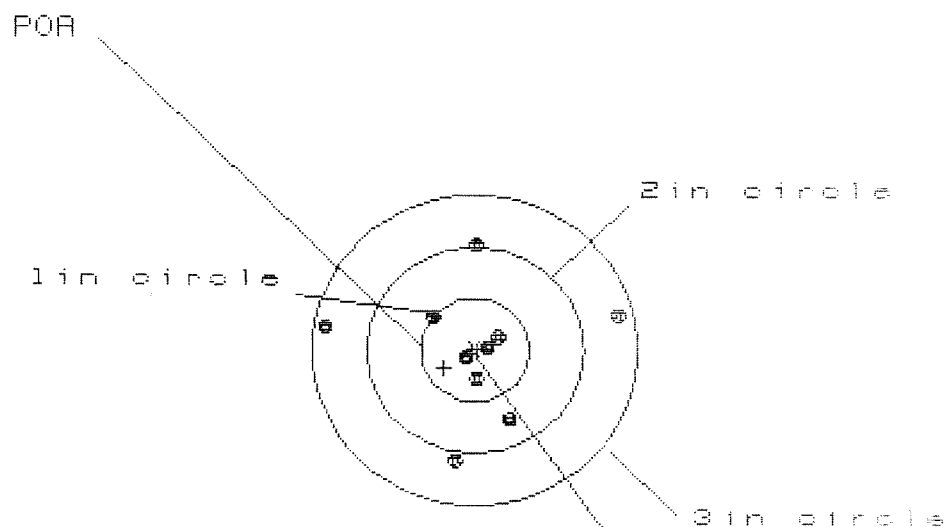
GS= 3.077

PATTERN #	3
SHOTS (BEST OF)	10
MAXIMUM X	1.479
MINIMUM X	-1.209
MAXIMUM Y	1.709
MINIMUM Y	-1.126
CENTROID X	-.282
CENTROID Y	-.015
FOR TO CENTROID in.	.282
MIN RADIUS	.330
MEAN RADIUS	.915
MAX RADIUS	1.805
HORIZONTAL SPREAD	2.688
VERTICAL SPREAD	2.835
EXTREME SPREAD	3.077
NUMBER IN ONE INCH CIRCLE =	2
NUMBER IN TWO INCH CIRCLE =	6
NUMBER IN THREE INCH CIRCLE =	9

7 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B947.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 4

2in = 6

3in = 10

HS= 2.684

VS= 2.147

GS= 2.685

CENTROID *

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.312	1.160	.283
MINIMUM X	-1.372	-.518	-.373
MAXIMUM Y	1.056	1.079	1.118
MINIMUM Y	-1.091	-1.068	-1.029
CENTROID X	.283	.435	.290
CENTROID Y	.173	.150	.111
POA TO CENTROID in.	.332	.461	.311
MIN RADIUS	.044	.084	.054
MEAN RADIUS	.683	.602	.512
MAX RADIUS	1.388	1.202	1.118
HORIZONTAL SPREAD	2.684	1.678	.656
VERTICAL SPREAD	2.147	2.147	2.147
EXTREME SPREAD	2.685	2.162	2.162
NUMBER IN ONE INCH CIRCLE =		4	
NUMBER IN TWO INCH CIRCLE =		6	
NUMBER IN THREE INCH CIRCLE =		10	

7 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C8348947.1.1

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

HS= 1.170

VS= 3.530

GS= 3.554

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.481	.451	.361
MINIMUM X	:	-.689	-.719	-.632
MAXIMUM Y	:	1.316	1.070	1.120
MINIMUM Y	:	-2.214	-1.589	-1.455
CENTROID X	:	.100	.130	.220
CENTROID Y	:	-.050	.196	.062
POA TO CENTROID in.	:	.112	.235	.229
MIN RADIUS	:	.123	.144	.057
MEAN RADIUS	:	.934	.768	.674
MAX RADIUS	:	2.231	1.646	1.494
HORIZONTAL SPREAD	:	1.170	1.170	.993
VERTICAL SPREAD	:	3.530	2.659	2.575
EXTREME SPREAD	:	3.554	2.897	2.590
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348947
8 Dec 1989

CENTROIDAL DISTANCES

0 TO	1	.214756
1 TO	2	.322523
1 TO	3	.506952
1 TO	4	.401688
1 TO	5	.480951

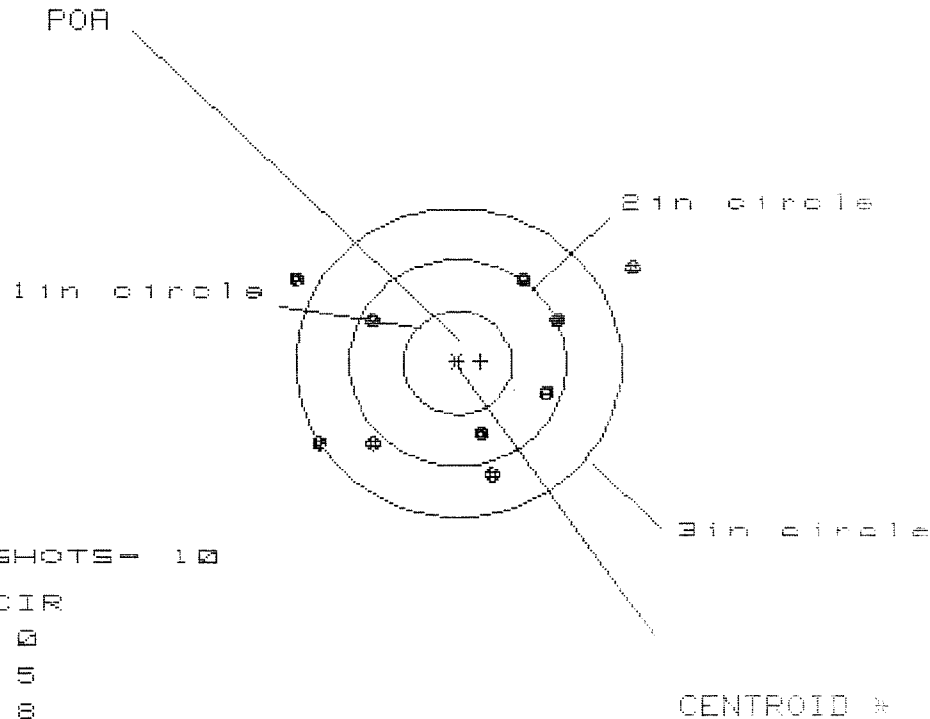
$\bar{x}$ + $\bar{y}$ <----FOR

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1612
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0264
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .163347
THE AMR FOR THIS RIFLE IS: .933

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B947.1.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 3.110

VS= 1.991

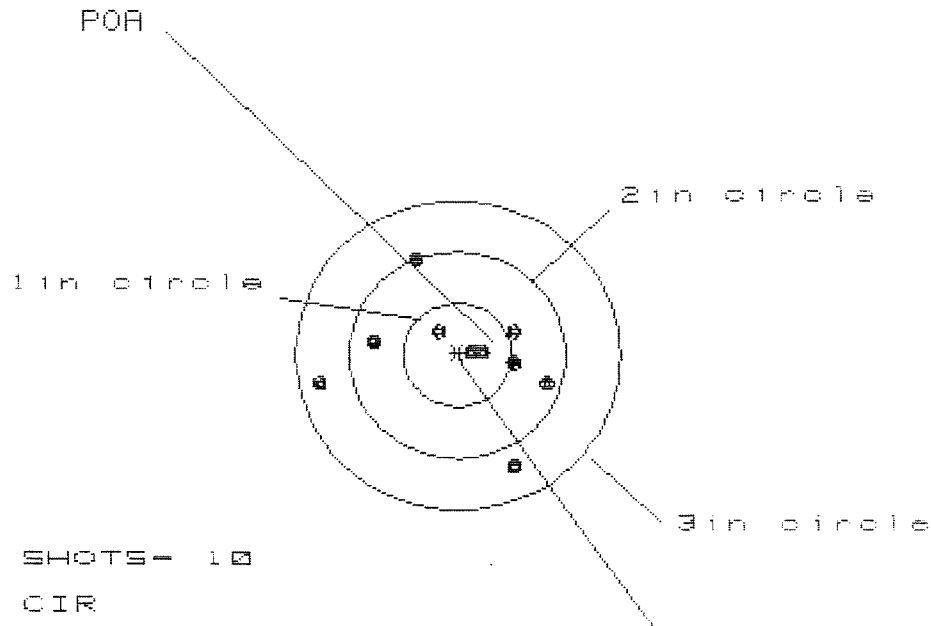
GS= 3.298

PATTERN #	:	1	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.581	1.056	.887
MINIMUM X	:	-1.529	-1.353	-1.246
MAXIMUM Y	:	.943	.932	1.000
MINIMUM Y	:	-1.048	-.943	-.826
CENTROID X	:	-.214	-.390	-.221
CENTROID Y	:	-.018	-.123	-.240
POA TO CENTROID in.	:	.215	.409	.326
MIN RADIUS	:	.674	.666	.475
MEAN RADIUS	:	1.159	1.074	.969
MAX RADIUS	:	1.841	1.643	1.351
HORIZONTAL SPREAD	:	3.110	2.409	2.133
VERTICAL SPREAD	:	1.991	1.875	1.826
EXTREME SPREAD	:	3.298	2.619	2.450
NUMBER IN ONE INCH CIRCLE	=	0		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=	8		

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B947.1.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 7

3 in = 10

HS= 2.086

VS= 1.952

GS= 2.182

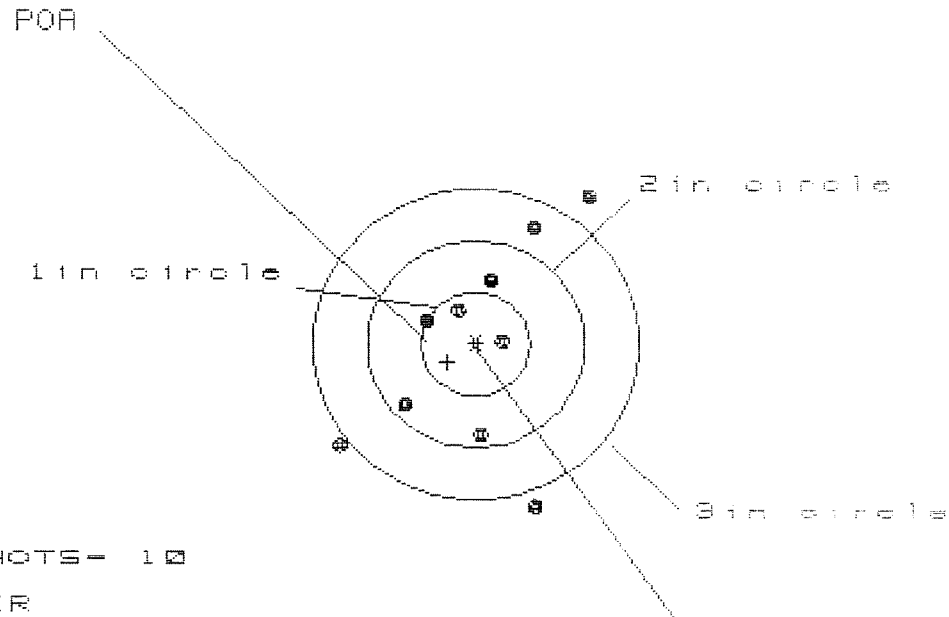
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.791	.648	.699
MINIMUM X	:	-1.295	-.936	-.885
MAXIMUM Y	:	.924	.897	.765
MINIMUM Y	:	-1.028	-1.055	-.385
CENTROID X	:	-.524	-.381	-.432
CENTROID Y	:	.071	.098	.230
POA TO CENTROID in.	:	.529	.393	.489
MIN RADIUS	:	.134	.014	.147
MEAN RADIUS	:	.684	.567	.516
MAX RADIUS	:	1.317	1.131	.923
HORIZONTAL SPREAD	:	2.086	1.584	1.584
VERTICAL SPREAD	:	1.952	1.952	1.150
EXTREME SPREAD	:	2.182	2.182	1.673
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Dec 1985

FILE:/PATTERNING/CENTERFIRE_PATT/06346347.1.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 2.361

VS= 3.013

GS= 3.341

CENTROID *

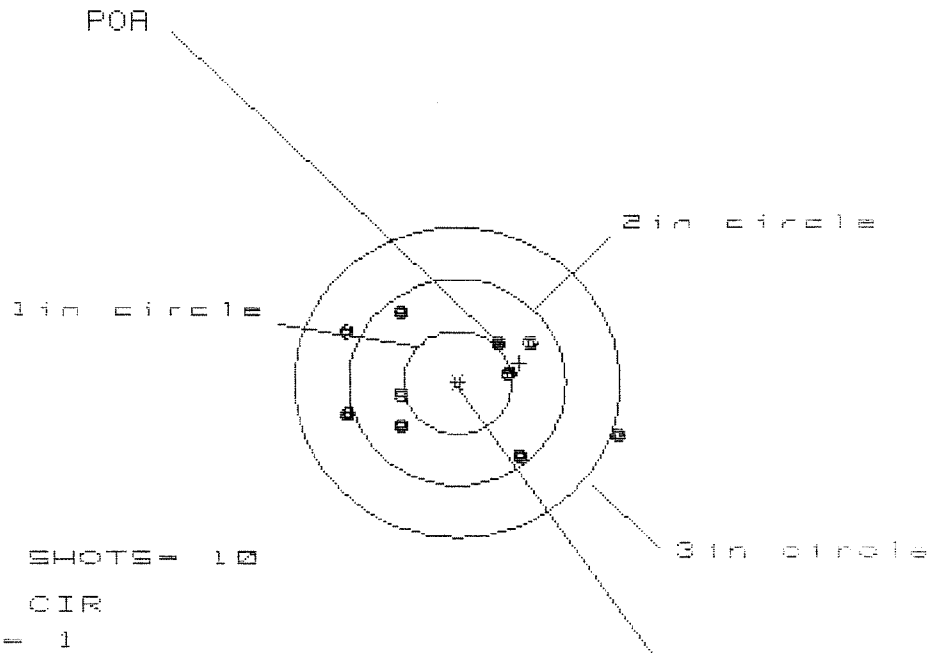
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.065	.684	.741
MINIMUM X	:	-1.296	-1.178	-1.093
MAXIMUM Y	:	1.427	1.294	1.116
MINIMUM Y	:	-1.586	-1.428	-.957
CENTROID X	:	.256	.138	.053
CENTROID Y	:	.172	.014	.192
POA TO CENTROID in.	:	.309	.139	.199
MIN RADIUS	:	.221	.397	.336
MEAN RADIUS	:	.989	.909	.787
MAX RADIUS	:	1.780	1.583	1.453
HORIZONTAL SPREAD	:	2.361	1.862	1.834
VERTICAL SPREAD	:	3.013	2.722	2.073
EXTREME SPREAD	:	3.341	2.768	2.768
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348947.1.1.1

CENTERFIRE PATTERNS

4



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 7

3 in = 9

HS = 2.473

VS = 1.446

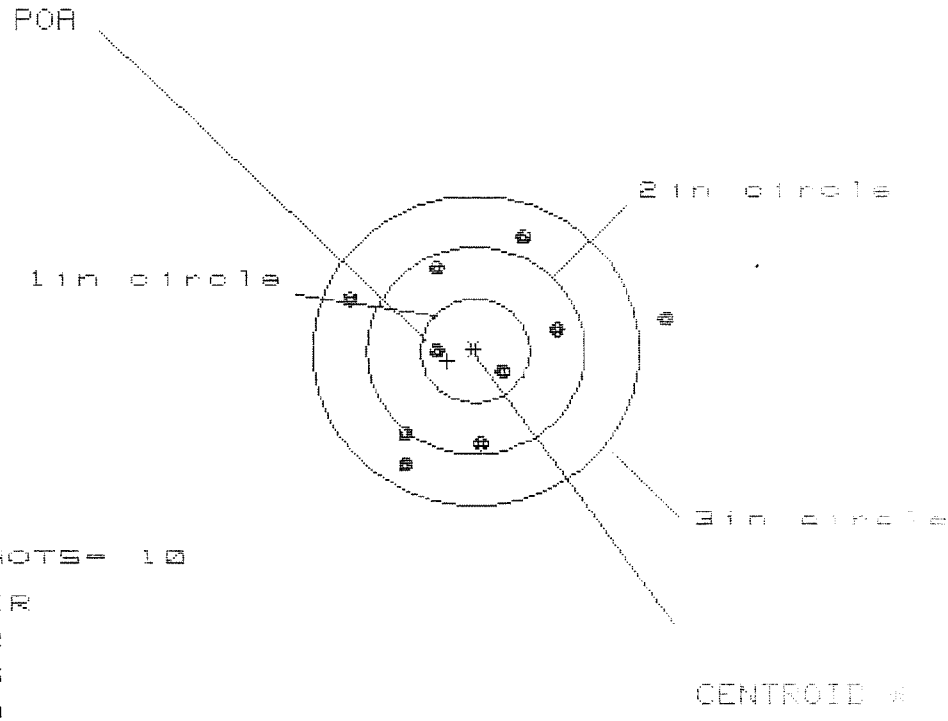
GS = 2.670

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.465	.860	.754
MINIMUM X	:	-1.008	-.845	-.929
MAXIMUM Y	:	.705	.642	.691
MINIMUM Y	:	-.741	-.804	-.756
CENTROID X	:	-.577	-.740	-.634
CENTROID Y	:	-.190	-.127	-.176
POA TO CENTROID in.	:	.607	.751	.658
MIN RADIUS	:	.494	.398	.482
MEAN RADIUS	:	.863	.767	.743
MAX RADIUS	:	1.568	1.106	1.000
HORIZONTAL SPREAD	:	2.473	1.705	1.693
VERTICAL SPREAD	:	1.446	1.446	1.446
EXTREME SPREAD	:	2.670	1.998	1.846
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			7	
NUMBER IN THREE INCH CIRCLE =			9	

8 Dec 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B347.1.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.877

VS= 2.196

GS= 2.883

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.704	.955	.896
MINIMUM X	:	-1.173	-.984	-1.043
MAXIMUM Y	:	1.103	1.136	1.004
MINIMUM Y	:	-1.093	-1.060	-.974
CENTROID X	:	.253	.064	.123
CENTROID Y	:	.097	.064	.196
POA TO CENTROID in.	:	.271	.091	.232
MIN RADIUS	:	.334	.175	.238
MEAN RADIUS	:	.970	.867	.829
MAX RADIUS	:	1.729	1.279	1.134
HORIZONTAL SPREAD	:	2.877	1.939	1.939
VERTICAL SPREAD	:	2.196	2.196	1.977
EXTREME SPREAD	:	2.883	2.438	2.137
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

Tracy Pull - Endurance Gun

• 7000 lbs - 4.5 # Reddjust
70
2.53, 2.40, 2.51

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348947 SHOOTER DH + AC DATE 12-4-89

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
	TOTAL	600		
	7.62	60	OK	NONE 12-5-89
	7.62	60	11	11
	7.62	60	11	11
	7.62	60	11	11
	7.62	60	11	11
	7.62	60	11	11
	7.62	60	11	11
	7.62	60	11	11
		60		
		540		
		600		
Total				1140

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348947 SHOOTER AC & DH DATE 12-6-89

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
	TOTAL	660		
	7.62	60	OK	NONE 12/7/89
	7.62	60	11	11
	7.62	60	11	11
	7.62	20	11	11
	Total	860		
	Page 1	500		
	Page 2	780		
	Page 3	1220		
	Page 4	1140		
	Total	4500		
		60	target	12/7/89 AC.
		4560	and	Accuracy

SWS ENDURANCE TEST REPORT

 SERIAL NO. C6348947 SHOOTER AC & DH DATE 12/8/89

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	NONE
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	300	"	"
	7.62	60	OK	NONE 12/11/89
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	40	"	"
	total	1000		
			6000	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348947 SHOOTER AC & DH DATE 12-12-89

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	NONE
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	40	"	"
		1000	12-12-89	
			7000	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348947 SHOOTER DHJ AC DATE 12-13-89

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	60	11	11
	11	60	11	11
	11	40	11	11
		1000		
			8000	

SWS ENDURANCE TEST REPORT

 SERIAL NO. C63489417 SHOOTER AC & D.H. DATE 12/14/89

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	NONE
	7.62	60	OK	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	40	"	"
		1000		
			total	9000

12/1/89 - Endurance B/A 6 BOLT
H C-6348947

QP 0041

MAGNETIC PARTICLE INSPECTION

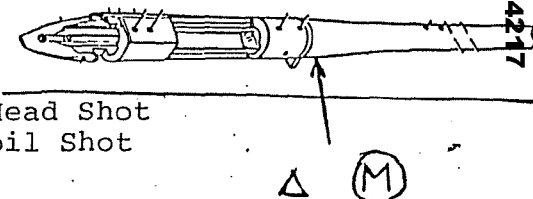
PART NUMBER _____

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)		
NON-FLUORESCENT RESIDUAL WET						
FLUORESCENT RESIDUAL WET						

SKETCH AND/OR REMARKS



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

ACCEPTANCE STANDARD

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

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 mangafux 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. _____

Enclosure B/A + BOLT

QP 0041

C-6348947

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS	
				ACCEPTED	REJECTED
12/1/89	2,500 Rounds	C-6348947	OK		
12/8/89	5,000 Rounds	C-6348947	OK		
12/11/89	6,000 Rounds	C-6348947	OK		
12/13/89	7,000 Rounds	C-6348947	OK		
12/14/89	8,000 Rounds	C-6348947	OK		
12/15/89	9,000 Rounds	C-6348947	OK		
12/18/89	10,000 Rounds	C-6348947	OK		

Karl C Rice

8158-8096

"H" STAMP