

FORM

UPC



0 47700 25716 7

C6649163

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER  
KINZER V. REMINGTON

M2400065563

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY\*

# Remington



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

MODEL 700 <sup>TM</sup> M24

SERIAL NO.  
C6649163

ORDER NO.  
**5716**

20

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



5716 C6649163

ORDER **5716**

MODEL 700 <sup>TM</sup> M24

UPC



0 47700 25716 7

ORDER **5716**

MODEL 700 <sup>TM</sup> M24

UPC



0 47700 25716 7

**GFM**

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649163

| OP. #        | OP. NAME                                                       | READINGS     | DATE     | INIT |
|--------------|----------------------------------------------------------------|--------------|----------|------|
| 575 &<br>580 | Assemble Action<br>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<br>Action                                     | OCT 1 0 1991 |          | KR   |
|              | Magnaflux Bolt                                                 | OCT 1 0 1991 |          | KR   |
| 615          | Rollmark Caliber                                               | OCT 1 0 1991 |          | GL   |
| 617          | Drill and Tap Sight Holes                                      | OCT 1 0 1991 |          | LB   |
| 618          | Polish Barrel                                                  |              | 10/15/91 | WB   |
| 620          | Apply Coatings<br>(Barrel Action)                              |              | 11/7/91  | 1/2  |
|              | Apply Coating (Bolt)                                           |              |          | 1/2  |
| 625          | Final Assembly<br>A) Clean inside of<br>Bolt Assembly          |              | 11/11/91 | RW   |
|              | B) Inspect Rear Firing<br>Pin Hole for Chamfer<br>in Bolt Head |              | 11/11/91 | RW   |
|              | C) Inspect Ejector Hole<br>for Chamfer                         |              | 11/11/91 | RW   |
|              | D) Oil Firing Pin Ass'y                                        |              | 11/11/91 | RW   |
|              | E) Adjust Trigger Pull to<br>Min Setting and Stake             |              | 12/30/91 | WB   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE     | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|----------|------|
| 625<br>cont. | F) Safety On Force                                          | 3 1/2    | 3 1/2 | 3 1/2 |      |      | 12/31/91 | WB   |
|              | G) Safety Off Force                                         | 2        | 2     | 2     |      |      | 12/31/91 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 12/30/91 | WB   |
|              | I) Firing Pin Indent                                        | .021     | .0205 | .021  |      |      | 12/31/91 | WB   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 1/3/92   | RW   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 1-7-92   | AC   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 1/3/92   | RW   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 1/3/92   | RW   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 1/3/92   | RW   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 1/3/92   | RW   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 1/3/92   | RW   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 1-6-92   | DH   |
|              | A) Time                                                     |          |       |       |      |      | 1-6-92   | DH   |
|              | B) Malfunctions                                             |          |       |       |      |      | 1-6-92   | DH   |
|              | C) Pierced Primers                                          |          |       |       |      |      | 1-6-92   | DH   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | 1-6-92   | DH   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 1-6-92   | DH   |
| 655          | Final Inspection                                            |          |       |       |      |      | 1-7-92   | AC   |
|              | A) Headspace                                                |          |       |       |      |      | 1-7-92   | AC   |
|              | B) Trigger Pull                                             | 2.33     | 2.37  | 2.34  | 2.32 | 2.18 | 1/7/92   | RW   |
|              | C) Function                                                 |          |       |       |      |      | 1-7-92   | AC   |
| 660          | Pack                                                        |          |       |       |      |      | 2-25-92  | WB   |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # D6649163  
6 Jan 1992

CENTROIDAL DISTANCES

|        |         |
|--------|---------|
| 0 TO 1 | .370354 |
| 1 TO 2 | .647569 |
| 1 TO 3 | .461556 |
| 1 TO 4 | .468547 |
| 1 TO 5 | .76029  |

1.5 (----)POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0672  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0692  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0964597

THE AMR FOR THIS RIFLE IS: .964

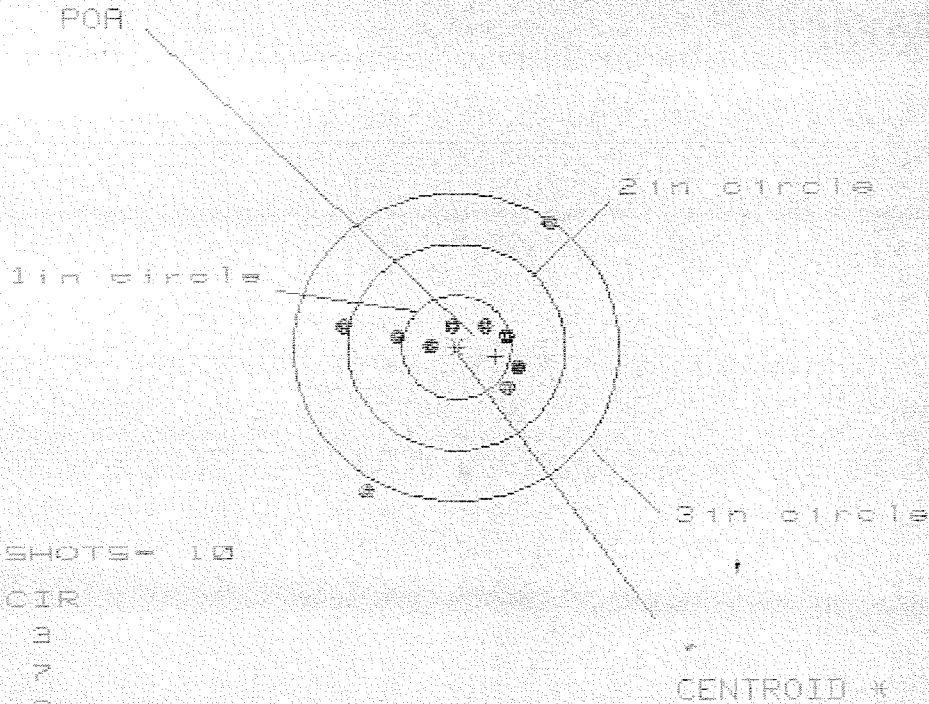
1.0 1.5 2.0

8 Jan 1992

FILE:/PATTERNING/CENTERFIRE\_PATT/C8849163

# CENTERFIRE PATTERNS

# 1



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.930

VS= 2.621

GS= 3.109

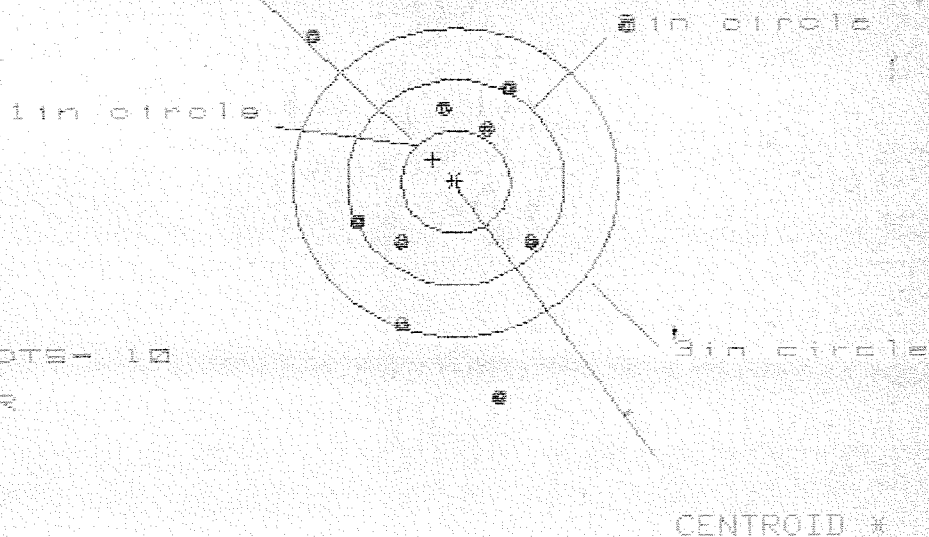
| PATTERN #                     | : | 10     | 9      | 8      |
|-------------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | .859   | .769   | .564   |
| MINIMUM X                     | : | -1.071 | -1.161 | -1.065 |
| MAXIMUM Y                     | : | 1.215  | 1.058  | .201   |
| MINIMUM Y                     | : | -1.406 | -.558  | -.425  |
| CENTROID X                    | : | -.359  | -.269  | -.365  |
| CENTROID Y                    | : | .891   | .248   | .115   |
| POA TO CENTROID in.           | : | .370   | .365   | .382   |
| MIN RADIUS                    | : | .204   | .128   | .196   |
| MEAN RADIUS                   | : | .725   | .605   | .515   |
| MAX RADIUS                    | : | 1.624  | 1.308  | 1.084  |
| HORIZONTAL SPREAD             | : | 1.930  | 1.930  | 1.629  |
| VERTICAL SPREAD               | : | 2.621  | 1.616  | .626   |
| EXTREME SPREAD                | : | 3.109  | 2.169  | 1.692  |
| NUMBER IN ONE INCH CIRCLE =   | : | 3      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | : | 7      |        |        |
| NUMBER IN THREE INCH CIRCLE = | : | 9      |        |        |

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# CENTERFIRE PATTERNS # 2

POA



# OF SHOTS- 10

# IN CIR

1 in = 0

2 in = 4

3 in = 6

HS= 2.910

VS= 3.562

GS= 3.850

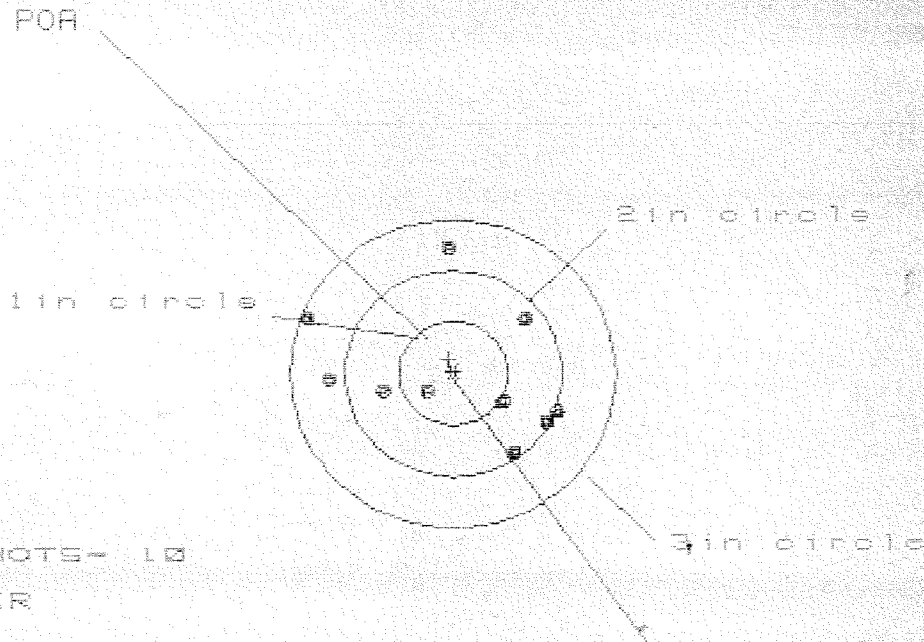
|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 2      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.596  | .851   | .917   |
| MINIMUM X                   | : | -1.314 | -1.137 | -1.071 |
| MAXIMUM Y                   | : | 1.528  | 1.687  | 1.374  |
| MINIMUM Y                   | : | -2.034 | -1.864 | -1.466 |
| CENTROID X                  | : | .209   | .032   | -.034  |
| CENTROID Y                  | : | -.220  | -.390  | -.157  |
| POA TO CENTROID in.         | : | .304   | .392   | .161   |
| MIN RADIUS                  | : | .573   | .578   | .683   |
| MEAN RADIUS                 | : | 1.281  | 1.166  | 1.055  |
| MAX RADIUS                  | : | 2.210  | 1.969  | 1.742  |
| HORIZONTAL SPREAD           | : | 2.910  | 1.988  | 1.988  |
| VERTICAL SPREAD             | : | 3.562  | 3.471  | 2.840  |
| EXTREME SPREAD              | : | 3.850  | 3.850  | 2.944  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 0      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 6      |        |



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# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 6

3in = 10

HS= 2.259

VS= 1.925

GS= 2.403

CENTROID #

| PATTERN #                     | 3      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | .948   | .802   | .775   |
| MINIMUM X                     | -1.311 | -1.307 | -1.334 |
| MAXIMUM Y                     | 1.201  | 1.256  | .755   |
| MINIMUM Y                     | -.724  | -.669  | -.512  |
| CENTROID X                    | .044   | .190   | .217   |
| CENTROID Y                    | -.134  | -.189  | -.346  |
| POA TO CENTROID in.           | .141   | .268   | .408   |
| MIN RADIUS                    | .310   | .354   | .281   |
| MEAN RADIUS                   | .894   | .914   | .730   |
| MAX RADIUS                    | 1.400  | 1.308  | 1.339  |
| HORIZONTAL SPREAD             | 2.259  | 2.109  | 2.109  |
| VERTICAL SPREAD               | 1.925  | 1.925  | 1.267  |
| EXTREME SPREAD                | 2.403  | 2.121  | 2.121  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 10     |        |        |

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# CENTERFIRE PATTERNS

# 4

POA

1in circle

2in circle

3in circle

CENTROID #

# OF SHOTS= 10

# IN CIR

1in = 2

2in = 5

3in = 8

HS= 1.973

VS= 3.219

GS= 3.312

PATTERN #

4

SHOTS (BEST OF)

10

9

8

MAXIMUM X

1.038

1.127

1.139

MINIMUM X

-.935

-.846

-.834

MAXIMUM Y

1.692

1.522

1.865

MINIMUM Y

-1.527

-1.234

-1.044

CENTROID X

.041

-.048

-.060

CENTROID Y

-.153

.017

-.173

POA TO CENTROID in.

.158

.050

.184

MIN RADIUS

.120

.091

.100

MEAN RADIUS

1.025

.931

.856

MAX RADIUS

1.721

1.525

1.277

HORIZONTAL SPREAD

1.973

1.973

1.973

VERTICAL SPREAD

3.219

2.756

1.909

EXTREME SPREAD

3.312

2.884

2.211

NUMBER IN ONE INCH CIRCLE =

2

NUMBER IN TWO INCH CIRCLE =

5

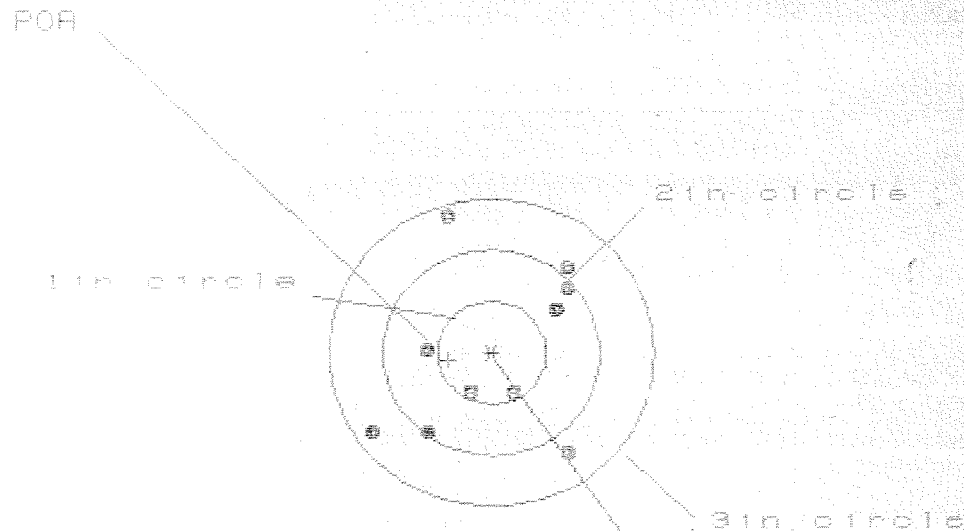
NUMBER IN THREE INCH CIRCLE =

8

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FILE:/PATTERNING/CENTERFIRE\_PATT/C8649163

# CENTERFIRE PATTERNS # 5



# OF SHOTS= 10

# IN CIR

1in = 2

2in = 5

3in = 10

HS= 1.809

VS= 2.254

GS= 2.532

CENTROID #

|                            |   |        |        |       |
|----------------------------|---|--------|--------|-------|
| PATTERN #                  | : | 5      |        |       |
| SHOTS (BEST OF)            | : | 10     | 9      | 8     |
| MAXIMUM X                  | : | .746   | .701   | .563  |
| MINIMUM X                  | : | -1.063 | -1.108 | -.824 |
| MAXIMUM Y                  | : | 1.284  | .959   | .886  |
| MINIMUM Y                  | : | -.970  | -.828  | -.901 |
| CENTROID X                 | : | .401   | .447   | .585  |
| CENTROID Y                 | : | .070   | -.072  | .001  |
| POA TO CENTROID in.        | : | .403   | .453   | .585  |
| MIN RADIUS                 | : | .399   | .272   | .315  |
| MEAN RADIUS                | : | .895   | .824   | .773  |
| MAX RADIUS                 | : | 1.347  | 1.254  | 1.062 |
| HORIZONTAL SPREAD          | : | 1.809  | 1.809  | 1.387 |
| VERTICAL SPREAD            | : | 2.254  | 1.787  | 1.787 |
| EXTREME SPREAD             | : | 2.532  | 2.375  | 2.066 |
| SHOTS IN ONE INCH CIRCLE   | = |        | 2      |       |
| SHOTS IN TWO INCH CIRCLE   | = |        | 6      |       |
| SHOTS IN THREE INCH CIRCLE | = |        | 10     |       |

SWS TRIGGER PULL TEST

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

SERIAL NO. C6649163  
DATE 12/30/91  
TESTER WB

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------------------------------------------------------------------------|
| PULL #1 | 2.35             | 2.27                     | 2.39                           | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.32             | 2.22                     | 2.35                           |                                                                        |
| PULL #3 | 2.39             | 2.22                     | 2.36                           |                                                                        |
| PULL #4 | 2.44             | 2.22                     | 2.31                           |                                                                        |
| PULL #5 | 2.40             | 2.20                     | 2.36                           |                                                                        |
| TOTAL   | 11.90            | 11.13                    | 11.77                          |                                                                        |
| AVG.    | 2.38             | 2.22                     | 2.35                           |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES | COMMENTS |
|---------|------------------|--------------------------|----------|
| PULL #1 | 3.09             | 3.17                     |          |
| PULL #2 | 3.12             | 3.18                     |          |
| PULL #3 | 3.13             | 3.17                     |          |
| PULL #4 | 3.00             | 3.15                     |          |
| PULL #5 | 3.14             | 3.14                     |          |
| TOTAL   | 15.48            | 15.81                    |          |
| AVG.    | 3.09             | 3.16                     |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.03             | 4.02                     |                                | 4.07                                 |
| PULL #2 | 4.02             | 4.02                     |                                | 4.12                                 |
| PULL #3 | 4.06             | 4.00                     |                                | 4.21                                 |
| PULL #4 | 4.04             | 4.00                     |                                | 4.18                                 |
| PULL #5 | 4.01             | 4.04                     |                                | 4.21                                 |
| TOTAL   | 20.16            | 20.08                    |                                | 20.79                                |
| AVG.    | 4.03             | 4.02                     |                                | 4.16                                 |

LOT RAC9/C001-012 M-24

CONTRACT # DAAA21-87-C-0086

CFM  
ENDURANCE GUN #2

GUN SERIAL #

C6611816

| OP. #     | OP. NAME                                                 | READINGS | DATE    | INIT |
|-----------|----------------------------------------------------------|----------|---------|------|
| 575 & 580 | Assemble Action and Stock                                |          | 1/22/91 | KS   |
| 600       | Proof                                                    |          | 1/22/91 | KS   |
| 607       | Check Headspace                                          |          | 1/22/91 | KS   |
| 610       | Dis-assemble Gun                                         |          | 1/22/91 | KS   |
| 612       | Magnaflux Barrel Action                                  |          | 1/29/91 | KR   |
|           | Magnaflux Bolt                                           |          | "       | KR   |
| 615       | Rollmark Caliber                                         |          | "       | LS   |
| 617       | Drill and Tap Sight Holes                                | 2 2 9    | 2 2 9   | FB   |
| 618       | Polish Barrel RBB                                        | 2 2 9    | 2 2 9   | WB   |
| 620       | Apply Coatings (Barrel Action)                           |          | 2-11-91 | JA   |
|           | Apply Coating (Bolt)                                     |          |         |      |
| 625       | Final Assembly                                           |          |         |      |
|           | A) Clean inside of Bolt Assembly                         |          | 2/12/91 | KS   |
|           | B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head |          | 2/12/91 | KS   |
|           | C) Inspect Ejector Hole for Chamfer                      |          | 2/12/91 | KS   |
|           | D) Oil Firing Pin Ass'y                                  |          | 2/12/91 | KS   |
|           | E) Adjust Trigger Pull to Min Setting and Stake          |          | 2/13/91 | JA   |

| op. #        | OP. NAME                                                    | READINGS |       |       |      |      | DATE    | INIT |
|--------------|-------------------------------------------------------------|----------|-------|-------|------|------|---------|------|
| 625<br>cont. | F) Safety On Force                                          | 5 1/2    | 5 1/2 | 5 1/2 |      |      | 2/13/91 | WB   |
|              | G) Safety Off Force                                         | 7 1/2    | 7 1/2 | 7 1/2 |      |      | 2/13/91 | WB   |
|              | H) Trigger Pull Test & Retainability                        |          |       |       |      |      | 2/13/91 | RL   |
|              | I) Firing Pin Indent                                        | .020     | .0202 | .0202 |      |      | 2/13/91 | WB   |
|              | J) Assemble Stock                                           |          |       |       |      |      | 2/13/91 | KA   |
|              | K) Assemble Swivel Studs                                    |          |       |       |      |      | 2-21-91 | AC   |
|              | L) Attach Front and Rear Sight Assemblies                   |          |       |       |      |      | 2/13/91 | KA   |
|              | M) Iron Sight Alignment                                     |          |       |       |      |      | 2/13/91 | KA   |
|              | N) Detach Front & Rear Sights & place in numbered container |          |       |       |      |      | 2/13/91 | KA   |
|              | O) Attach Scope to Rifle                                    |          |       |       |      |      | 2/13/91 | KA   |
|              | P) Detach & Attach Scope 20 Times                           |          |       |       |      |      | 2/13/91 | KA   |
| 640          | Gallery Target & Test                                       |          |       |       |      |      | 2-13-91 | NF   |
|              | A) Time                                                     |          |       |       |      |      | "       | NF   |
|              | B) Malfunctions                                             |          |       |       |      |      | "       | NF   |
|              | C) Pierced Primers                                          |          |       |       |      |      | "       | NF   |
|              | D) Optical Clarity of Scope                                 |          |       |       |      |      | "       | NF   |
| 645          | Inspect for Live Ammo                                       |          |       |       |      |      | 2-13-91 | NF   |
| 655          | Final Inspection                                            |          |       |       |      |      |         |      |
|              | A) Headspace                                                |          |       |       |      |      | 2-21-91 | AC   |
|              | B) Trigger Pull                                             | 2.75     | 2.72  | 2.74  | 2.84 | 2.76 | 2/19/91 | WB   |
|              | C) Function                                                 |          |       |       |      |      | 2-21-91 | AC   |
| 660          | Pack                                                        |          |       |       |      |      |         |      |

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN  
INITIAL & CYCLE TESTS

2.50# ± .50#

3.00# ± .75#

4.00# ± 1.00#

SERIAL NO. C6611816

DATE 2/13/91

TESTER J.H.

|         | 2.50#<br>INITIAL | 2.50# AFTER<br>50 CYCLES | FINAL TEST &<br>TO RESET 2.50# |      | COMMENTS                                                               |
|---------|------------------|--------------------------|--------------------------------|------|------------------------------------------------------------------------|
| PULL #1 | 2.33             | 2.28                     | 2.29                           | 2.75 | MIN. SETTING,<br>NO AVG. OF 5<br>READINGS ACCEPT-<br>ABLE LESS THAN 2# |
| PULL #2 | 2.33             | 2.30                     | 2.38                           | 2.74 |                                                                        |
| PULL #3 | 2.22             | 2.27                     | 2.26                           | 2.72 |                                                                        |
| PULL #4 | 2.21             | 2.27                     | 2.25                           | 2.84 |                                                                        |
| PULL #5 | 2.21             | 2.27                     | 2.30                           | 2.76 |                                                                        |
| TOTAL   |                  |                          |                                |      |                                                                        |
| AVG.    |                  |                          |                                |      |                                                                        |

|         | 3.00#<br>INITIAL | 3.00# AFTER<br>20 CYCLES |  | COMMENTS |
|---------|------------------|--------------------------|--|----------|
| PULL #1 | 3.50             | 3.15                     |  |          |
| PULL #2 | 3.49             | 3.38                     |  |          |
| PULL #3 | 3.44             | 3.35                     |  |          |
| PULL #4 | 3.48             | 3.39                     |  |          |
| PULL #5 | 3.51             | 3.39                     |  |          |
| TOTAL   |                  |                          |  |          |
| AVG.    |                  |                          |  |          |

|         | 4.00#<br>INITIAL | 4.00# AFTER<br>20 CYCLES | MAX SETTING<br>GREATER THAN 4# | RESET TO 4# FOR<br>TARGET & ACCURACY |
|---------|------------------|--------------------------|--------------------------------|--------------------------------------|
| PULL #1 | 4.19             | 4.29                     |                                | 4.50                                 |
| PULL #2 | 4.28             | 4.31                     |                                | 4.16                                 |
| PULL #3 | 4.25             | 4.28                     |                                | 4.29                                 |
| PULL #4 | 4.20             | 4.43                     |                                | 4.20                                 |
| PULL #5 | 4.25             | 4.39                     |                                | 4.39                                 |
| TOTAL   |                  |                          |                                |                                      |
| AVG.    |                  |                          |                                |                                      |

SWS ENDURANCE TEST REPORT

SERIAL NO. C 66118-16 SHOOTER R Bailey DATE 2/21/91

| AMMO<br>CODE | AMMO<br>TYPE | RDS. | RESULTS       | OBSERVATIONS |
|--------------|--------------|------|---------------|--------------|
| 60136-003    | 7.62         | 60   | TEST 3 TARGET | NONE         |
|              | 7.62         | 60   | OK R.B.       | - NONE       |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 20   | OK R.B.       | NONE         |
|              |              | 440  | TOTAL 2/21/91 |              |
|              | 7.62         | 60   | TEST 4 TARGET | 2-22-91 OK   |
|              |              | 500  | TOTAL         |              |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 40   | OK R.B.       | NONE         |
|              |              | 900  | TOTAL 2/22/91 |              |
|              |              |      |               |              |
|              |              |      |               |              |
|              |              |      |               |              |



SWS ENDURANCE TEST REPORT

SERIAL NO. C6611816 SHOOTER P. CRIM DATE 2-25-91

| AMMO<br>CODE      | AMMO<br>TYPE | RDS. | RESULTS       | OBSERVATIONS |
|-------------------|--------------|------|---------------|--------------|
| LC-8<br>GT136-002 | 7.62         | 60   | OK P.C.       | NONE         |
|                   | 7.62         | 60   | OK P.C.       | NONE         |
|                   | 7.62         | 60   | OK P.C.       | NONE         |
|                   | 7.62         | 60   | OK P.C.       | NONE         |
|                   | 7.62         | 60   | OK P.C.       | NONE         |
|                   | 7.62         | 60   | OK P.C.       | NONE         |
|                   |              | 1260 | TOTAL 2-25-91 |              |
|                   | 7.62         | 60   | OK RB         | NONE         |
|                   | 7.62         | 60   | OK RB         | NONE         |
|                   | 7.62         | 60   | OK RB         | NONE         |
|                   | 7.62         | 60   | OK RB         | NONE         |
|                   | 7.62         | 60   | OK RB         | NONE         |
|                   | 7.62         | 60   | OK RB         | NONE         |
|                   | 7.62         | 40   | OK RB         | NONE         |
|                   |              | 1660 | TOTAL 2/25/91 |              |
| LC                | 7.62         | 60   | OK WT         | NONE         |
|                   | 7.62         | 60   | OK WT         | NONE         |
|                   | 7.62         | 60   | OK WT         | NONE         |
|                   | 7.62         | 60   | OK WT         | NONE         |
|                   | 7.62         | 60   | OK WT         | NONE         |
|                   | 7.62         | 60   | OK WT         | NONE         |
|                   | 7.62         | 40   | OK WT         | NONE         |
|                   |              | 2060 | TOTAL 2/26/91 |              |

SWS ENDURANCE TEST REPORT

SERIAL NO. 66611816 SHOOTER R Bailey DATE 2/26/91

| AMMO CODE | AMMO TYPE | RDS. | RESULTS                   | OBSERVATIONS |
|-----------|-----------|------|---------------------------|--------------|
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 20   | OK R.B.                   | NONE         |
|           |           | 2500 | TOTAL 2/26/91 See Page 10 |              |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 20   | OK R.B.                   | NONE         |
|           |           | 3000 | TOTAL 2/27/91             |              |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           | 7.62      | 60   | OK R.B.                   | NONE         |
|           |           | 3180 | Total                     |              |

## SWS ENDURANCE TEST REPORT

 SERIAL NO. 06611816 SHOOTER STH, L DATE 2-28-91

| AMMO CODE | AMMO TYPE       | RDS. | RESULTS       | OBSERVATIONS |
|-----------|-----------------|------|---------------|--------------|
|           | <del>7.62</del> | 3180 | TOTAL         |              |
|           | 7.62            | 60   | OK RS         | NONE         |
|           | 7.60            | 60   | OK RS         | NONE         |
|           |                 | 3300 | 2-28-91       | RS           |
|           | 7.62            | 60   | OK RB         | NONE         |
|           | 7.62            | 40   | OK RB         | NONE         |
|           |                 | 3400 | TOTAL 2/28/90 | R.B.         |
|           | 7.62            | 60   | OK R.B.       | NONE         |
|           | 7.62            | 60   | OK R.B.       | NONE         |
|           | 7.62            | 60   | OK R.B.       | NONE         |
|           | 7.62            | 60   | OK R.B.       | NONE         |
|           | 7.62            | 60   | OK R.B.       | NONE         |
|           | 7.62            | 60   | OK R.B.       | NONE         |
|           | 7.62            | 40   | OK RB         | NONE         |
|           |                 | 3800 | TOTAL 2/1/91  | R. Bailey    |
|           | 7.62            | 60   | OK RA         | NONE         |
|           | 7.62            | 60   | OK RA         | "            |
|           | 7.62            | 60   | OK RA         | "            |
|           | 7.62            | 60   | OK RA         | "            |
|           | 7.62            | 30   | OK RA         | "            |
|           |                 | 4170 | TOTAL         |              |

SWS ENDURANCE TEST REPORT

SERIAL NO. C6611816

SHOOTER R Bailey

DATE 3/4/91

| AMMO CODE       | AMMO TYPE | RDS. | RESULTS      | OBSERVATIONS      |
|-----------------|-----------|------|--------------|-------------------|
| <del>7.62</del> | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 10   | OK R.B.      | NONE              |
|                 |           | 4500 | TOTAL 3/4/91 | R Bailey          |
|                 |           | 60   | 3-5-91       | TARGET & TEST 17H |
|                 |           | 4560 | TOTAL        |                   |
|                 | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 60   | OK R.B.      | NONE              |
|                 | 7.62      | 20   | OK R.B.      | NONE              |
|                 |           | 4940 | TOTAL 3/5/91 | R. Bailey         |
|                 |           | 60   | 3-6-91       | TARGET & TEST 17H |
|                 |           | 5000 | TOTAL        |                   |
|                 |           |      |              |                   |
|                 |           |      |              |                   |

## SWS ENDURANCE TEST REPORT

 SERIAL NO. C6611816 SHOOTER R Bailey DATE 3/6/91

| AMMO<br>CODE | AMMO<br>TYPE | RDS. | RESULTS      | OBSERVATIONS |
|--------------|--------------|------|--------------|--------------|
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 40   | OK R.B.      | NONE         |
|              |              | 6000 | TOTAL 3/6/91 | R. Bailey    |
|              |              |      |              |              |
|              |              |      |              |              |
|              |              |      |              |              |
|              |              |      |              |              |
|              |              |      |              |              |

SWS ENDURANCE TEST REPORT

SERIAL NO. C6611816 SHOOTER R Bailey DATE 3/7/91

| AMMO<br>CODE | AMMO<br>TYPE | RDS. | RESULTS      | OBSERVATIONS |
|--------------|--------------|------|--------------|--------------|
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              | 7.62         | 60   | OK R.B.      | NONE         |
|              |              | 6960 | TOTAL 3/7/91 | R Bailey     |
|              |              |      |              |              |
|              |              |      |              |              |
|              |              |      |              |              |
|              |              |      |              |              |
|              |              |      |              |              |
|              |              |      |              |              |
|              |              |      |              |              |

SWS ENDURANCE TEST REPORT

SERIAL NO. C661181C SHOOTER R Bailey DATE 3/8/91

| AMMO<br>CODE | AMMO<br>TYPE | RDS. | RESULTS       | OBSERVATIONS |
|--------------|--------------|------|---------------|--------------|
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              |              | 7860 | TOTAL 3/8/91  | R Bailey     |
|              |              | 140  | 3-11-91       |              |
|              |              | 8000 | TOTAL 3-11-91 |              |
|              |              |      |               |              |
|              |              |      |               |              |
|              |              |      |               |              |
|              |              |      |               |              |
|              |              |      |               |              |
|              |              |      |               |              |

## SWS ENDURANCE TEST REPORT

SERIAL NO. 66611816SHOOTER R BaileyDATE 3/11/91

| AMMO<br>CODE | AMMO<br>TYPE | RDS. | RESULTS       | OBSERVATIONS |
|--------------|--------------|------|---------------|--------------|
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | - NONE       |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 60   | OK R.B.       | NONE         |
|              | 7.62         | 8960 | TOTAL 3/11/91 | R Bailey     |
|              | 7.62         | 40   | OK AW         | NONE         |
|              |              | 9000 | TOTAL 3/12/91 | AW           |
|              |              |      |               |              |
|              |              |      |               |              |
|              |              |      |               |              |
|              |              |      |               |              |



## SWS ENDURANCE TEST REPORT

 SERIAL NO. 66611816 SHOOTER R Bailey DATE 3/13/91

| AMMO CODE         | AMMO TYPE                             | RDS.  | RESULTS       | OBSERVATIONS |
|-------------------|---------------------------------------|-------|---------------|--------------|
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   | 7.62                                  | 60    | OK R.B.       | NONE         |
|                   |                                       | 9960  | TOTAL 3/13/91 | R Bailey     |
|                   |                                       | 40    | OK            | NONE         |
|                   |                                       | 10000 | TOTAL AW      | 3/14/91      |
| NOTE: AT 2500 RDS | EXTRACTOR REPLACED - REMOVED IN ERROR |       |               |              |
| FOR MAGNAFLUX     | - TEST CONTINUED. EXTRACTORS CAN'T BE |       |               |              |
| ReAssembled:      |                                       |       |               |              |
|                   |                                       |       | 3/14/91       |              |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611816  
14 Feb 1991

*O RDS*

CENTROIDAL DISTANCES

|        |          |
|--------|----------|
| 0 TO 1 | .176664  |
| 1 TO 2 | .289249  |
| 1 TO 3 | .0909725 |
| 1 TO 4 | .0684471 |
| 1 TO 5 | .0610737 |

←----POA

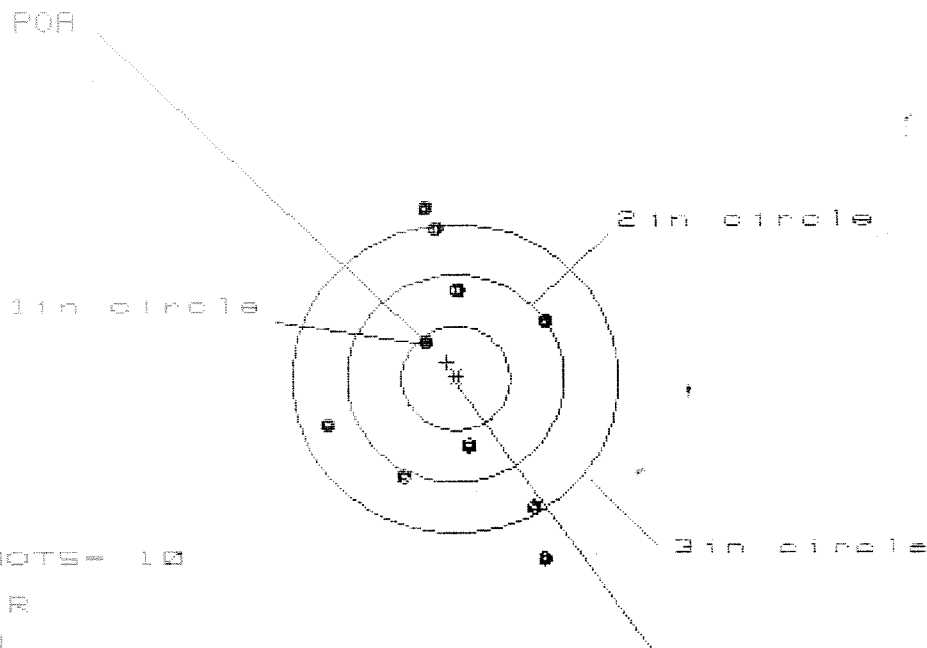
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1108  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1684  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .201582

THE AMR FOR THIS RIFLE IS: 1.069

14 Feb 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6511016

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 0

2in = 4

3in = 8

HS= 1.979

VS= 3.372

GS= 3.555

CENTROID #

| PATTERN #                   | 1      | 2      | 3      |
|-----------------------------|--------|--------|--------|
| SHOTS (BEST OF)             | 10     | 9      | 8      |
| MAXIMUM X                   | .801   | .886   | .856   |
| MINIMUM X                   | -1.177 | -1.088 | -1.118 |
| MAXIMUM Y                   | 1.663  | 1.473  | 1.432  |
| MINIMUM Y                   | -1.709 | -1.405 | -1.221 |
| CENTROID X                  | .081   | -.008  | .022   |
| CENTROID Y                  | -.157  | .033   | -.151  |
| POA TO CENTROID in.         | .177   | .034   | .152   |
| MIN RADIUS                  | .500   | .299   | .462   |
| MEAN RADIUS                 | 1.167  | 1.059  | 1.008  |
| MAX RADIUS                  | 1.888  | 1.621  | 1.448  |
| HORIZONTAL SPREAD           | 1.979  | 1.974  | 1.974  |
| VERTICAL SPREAD             | 3.372  | 2.878  | 2.653  |
| EXTREME SPREAD              | 3.555  | 3.062  | 2.792  |
| NUMBER IN ONE INCH CIRCLE = | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE = | 4      |        |        |

NUMBER IN THREE INCH CIRCLE =

8

14 Feb 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611816

# CENTERFIRE PATTERNS

# 2

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 1

2in = 3

3in = 8

HS= 2.436

VS= 2.934

GS= 3.016

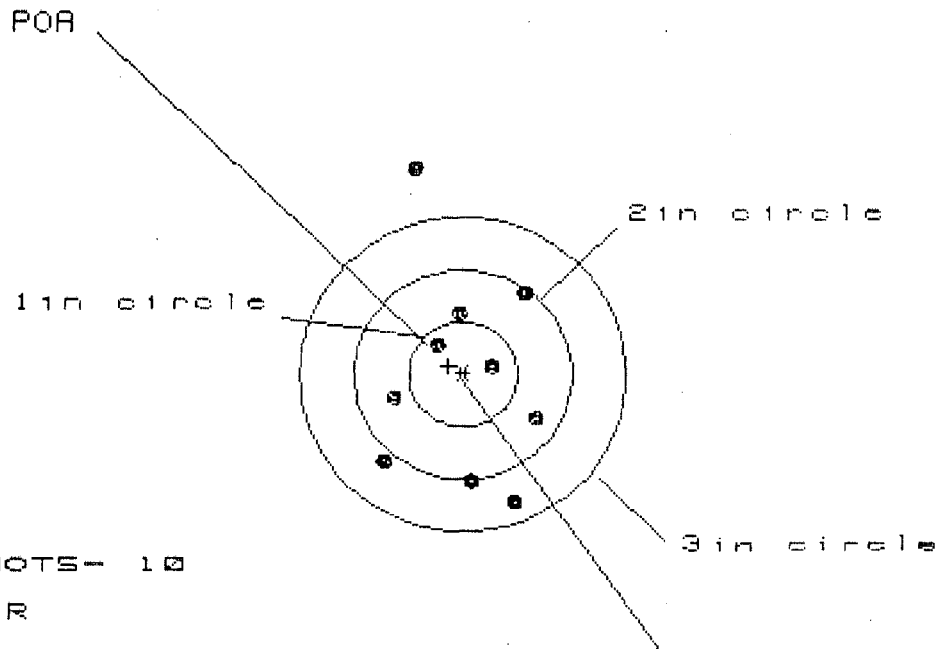
CENTROID \*

| PATTERN #                     | : | 2      |        |       |
|-------------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)               | : | 10     | 9      | 8     |
| MAXIMUM X                     | : | 1.366  | 1.325  | 1.353 |
| MINIMUM X                     | : | -1.071 | -1.111 | -.946 |
| MAXIMUM Y                     | : | 1.012  | .798   | .664  |
| MINIMUM Y                     | : | -1.922 | -1.077 | -.852 |
| CENTROID X                    | : | .289   | .330   | .165  |
| CENTROID Y                    | : | -.358  | -.144  | -.010 |
| POA TO CENTROID in.           | : | .460   | .360   | .165  |
| MIN RADIUS                    | : | .455   | .625   | .561  |
| MEAN RADIUS                   | : | 1.146  | 1.041  | .913  |
| MAX RADIUS                    | : | 1.957  | 1.707  | 1.384 |
| HORIZONTAL SPREAD             | : | 2.436  | 2.436  | 2.299 |
| VERTICAL SPREAD               | : | 2.934  | 1.875  | 1.516 |
| EXTREME SPREAD                | : | 3.016  | 2.788  | 2.320 |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 1      |       |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 3      |       |
| NUMBER IN THREE INCH CIRCLE = |   |        | 8      |       |

14 Feb 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611816

# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 6

3in = 9

HS= 1.375

VS= 3.214

GS= 3.340

CENTROID #

| PATTERN #                     | 3      | 3     | 3     |
|-------------------------------|--------|-------|-------|
| SHOTS (BEST OF)               | 10     | 9     | 8     |
| MAXIMUM X                     | .671   | .620  | .670  |
| MINIMUM X                     | -.704  | -.755 | -.705 |
| MAXIMUM Y                     | 2.018  | .977  | .855  |
| MINIMUM Y                     | -1.196 | -.971 | -.920 |
| CENTROID X                    | .131   | .182  | .132  |
| CENTROID Y                    | -.081  | -.306 | -.184 |
| POA TO CENTROID in.           | .154   | .355  | .226  |
| MIN RADIUS                    | .291   | .356  | .321  |
| MEAN RADIUS                   | .905   | .772  | .719  |
| MAX RADIUS                    | 2.070  | 1.092 | 1.010 |
| HORIZONTAL SPREAD             | 1.375  | 1.375 | 1.375 |
| VERTICAL SPREAD               | 3.214  | 1.948 | 1.775 |
| EXTREME SPREAD                | 3.340  | 1.985 | 1.985 |
| NUMBER IN ONE INCH CIRCLE =   |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE =   |        | 6     |       |
| NUMBER IN THREE INCH CIRCLE = |        | 9     |       |

14 Feb 1981

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611816

# CENTERFIRE PATTERNS # 4

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in = 1

2in = 4

3in = 6

HS= 3.228

VS= 3.724

GS= 4.155

CENTROID #

PATTERN #

4

| SHOTS (BEST OF)             | 10     | 9      | 8      |
|-----------------------------|--------|--------|--------|
| MAXIMUM X                   | 1.581  | 1.189  | 1.005  |
| MINIMUM X                   | -1.647 | -1.471 | -.939  |
| MAXIMUM Y                   | 1.866  | 1.660  | 1.457  |
| MINIMUM Y                   | -1.858 | -1.621 | -1.715 |
| CENTROID X                  | .019   | -.157  | .027   |
| CENTROID Y                  | -.128  | .078   | .281   |
| POA TO CENTROID in.         | .130   | .175   | .282   |
| MIN RADIUS                  | .316   | .233   | .098   |
| MEAN RADIUS                 | 1.316  | 1.147  | .942   |
| MAX RADIUS                  | 2.440  | 2.189  | 1.726  |
| HORIZONTAL SPREAD           | 3.228  | 2.660  | 1.944  |
| VERTICAL SPREAD             | 3.724  | 3.281  | 3.172  |
| EXTREME SPREAD              | 4.155  | 3.725  | 3.173  |
| NUMBER IN ONE INCH CIRCLE   | =      | 1      | 1      |
| NUMBER IN TWO INCH CIRCLE   | =      | 4      | 4      |
| NUMBER IN THREE INCH CIRCLE | =      | 6      | 6      |

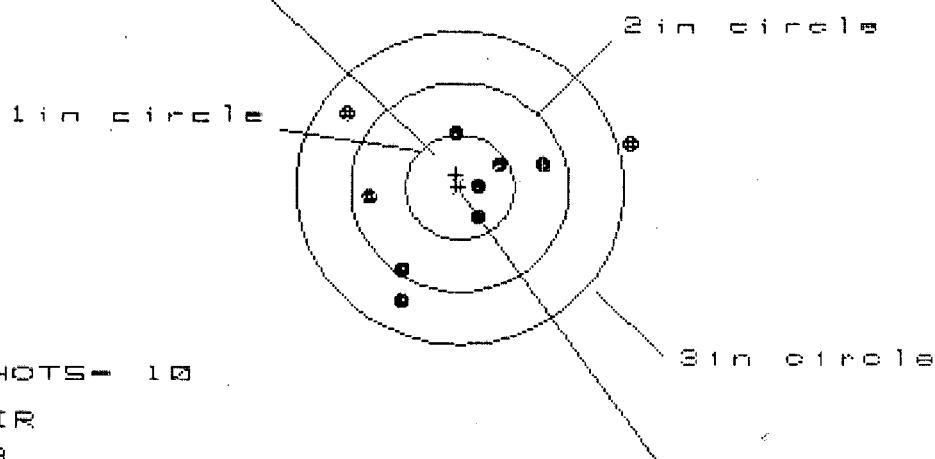
14 Feb 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611816

# CENTERFIRE PATTERNS

# 5

POA



# OF SHOTS- 10

# IN CIR

1in = 3

2in = 7

3in = 9

HS= 2.541

VS= 1.787

GS= 2.596

CENTROID #

| PATTERN #                   | : | 5      |        |       |
|-----------------------------|---|--------|--------|-------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8     |
| MAXIMUM X                   | : | 1.552  | .975   | .873  |
| MINIMUM X                   | : | -.989  | -.816  | -.787 |
| MAXIMUM Y                   | : | .726   | .777   | .684  |
| MINIMUM Y                   | : | -1.061 | -1.010 | -.913 |
| CENTROID X                  | : | .034   | -.139  | -.037 |
| CENTROID Y                  | : | -.118  | -.169  | -.266 |
| POA TO CENTROID in.         | : | .123   | .218   | .268  |
| MIN RADIUS                  | : | .193   | .344   | .209  |
| MEAN RADIUS                 | : | .813   | .741   | .670  |
| MAX RADIUS                  | : | 1.617  | 1.127  | 1.035 |
| HORIZONTAL SPREAD           | : | 2.541  | 1.791  | 1.660 |
| VERTICAL SPREAD             | : | 1.787  | 1.787  | 1.597 |
| EXTREME SPREAD              | : | 2.596  | 1.894  | 1.894 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 7      |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |       |



CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611816  
22 Feb 1991

500 Rbz

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| Ø TO | 1 | .289012 |
| 1 TO | 2 | .338638 |
| 1 TO | 3 | .323487 |
| 1 TO | 4 | .447153 |
| 1 TO | 5 | .117924 |

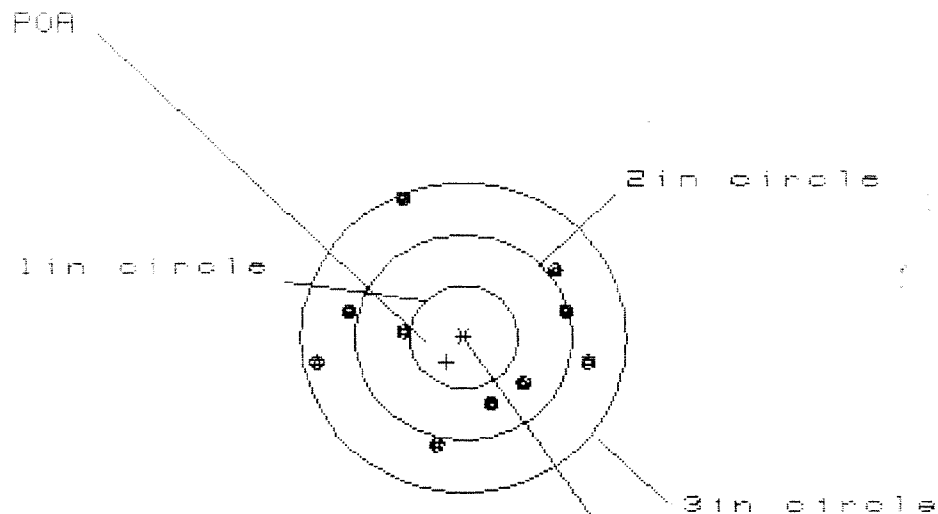
$\frac{3.5}{4.2}$  <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1076  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0736  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .130364  
  
THE AMR FOR THIS RIFLE IS: .9096

22 Feb 1981

FILE:/PATTERNING/CENTERFIRE\_PATT/C8611816.1

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 0

2in = 4

3in = 9

HS= 2.524

VS= 2.415

GS= 2.524

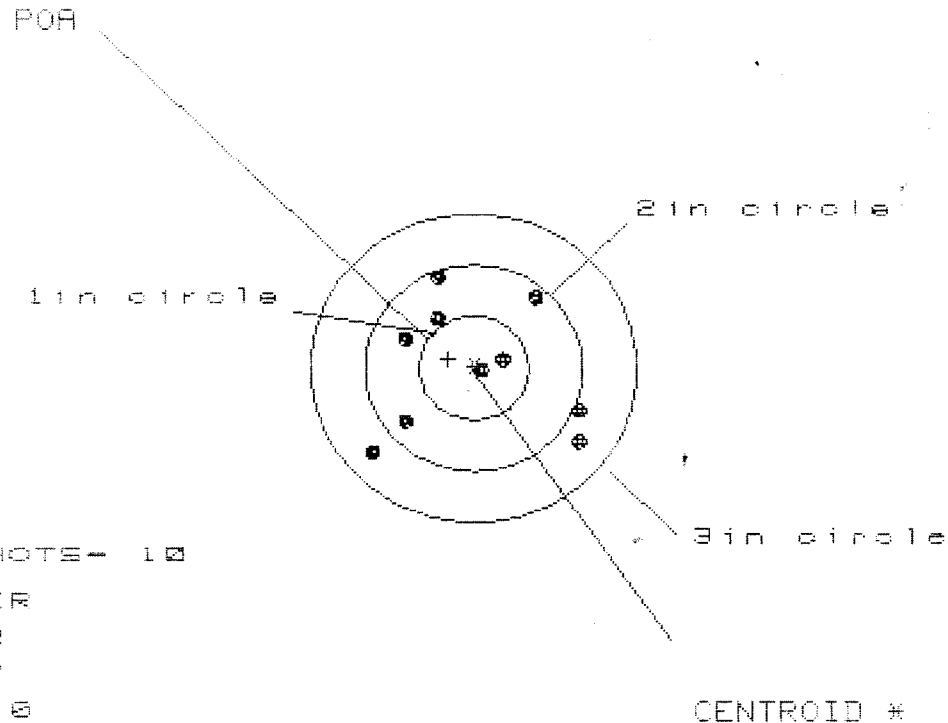
CENTROID \*

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.174  | 1.111  | .935   |
| MINIMUM X                     | -1.350 | -1.413 | -1.333 |
| MAXIMUM Y                     | 1.407  | .790   | .777   |
| MINIMUM Y                     | -1.008 | -.852  | -.865  |
| CENTROID X                    | .158   | .221   | .397   |
| CENTROID Y                    | .242   | .086   | .099   |
| POA TO CENTROID in.           | .289   | .237   | .410   |
| MIN RADIUS                    | .535   | .533   | .435   |
| MEAN RADIUS                   | 1.025  | .944   | .860   |
| MAX RADIUS                    | 1.518  | 1.417  | 1.401  |
| HORIZONTAL SPREAD             | 2.524  | 2.524  | 2.268  |
| VERTICAL SPREAD               | 2.415  | 1.642  | 1.642  |
| EXTREME SPREAD                | 2.524  | 2.524  | 2.322  |
| NUMBER IN ONE INCH CIRCLE =   | 0      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 9      |        |        |

22 Feb 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611016.1

# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 2

2in = 7

3in = 10

HS= 1.887

VS= 1.729

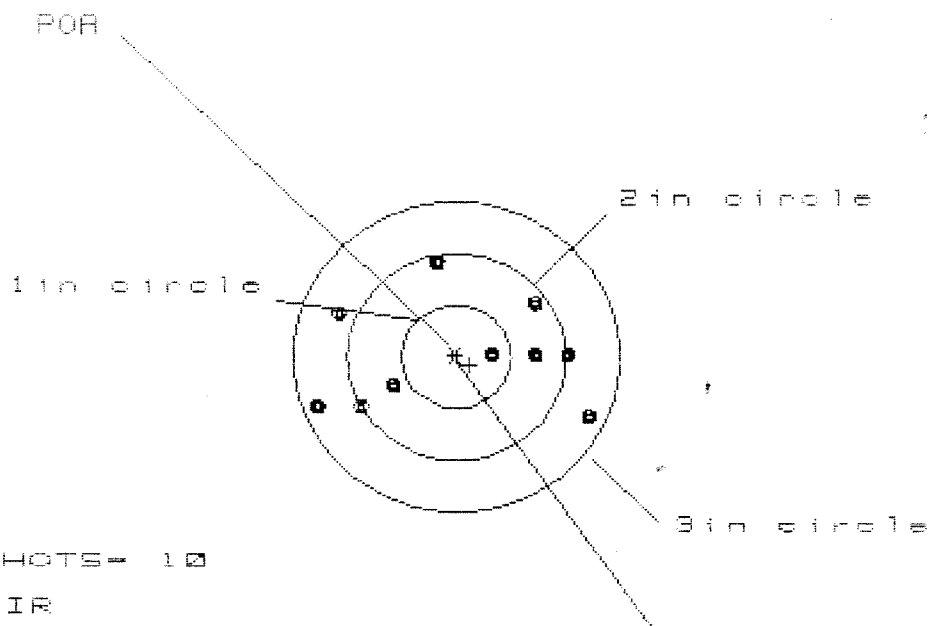
GS= 2.149

| PATTERN #                     | : | 2     |       |       |
|-------------------------------|---|-------|-------|-------|
| SHOTS (BEST OF)               | : | 10    | 9     | 8     |
| MAXIMUM X                     | : | .968  | .866  | .968  |
| MINIMUM X                     | : | -.919 | -.751 | -.649 |
| MAXIMUM Y                     | : | .910  | .819  | .714  |
| MINIMUM Y                     | : | -.819 | -.847 | -.709 |
| CENTROID X                    | : | .234  | .336  | .234  |
| CENTROID Y                    | : | -.088 | .003  | .108  |
| POA TO CENTROID in.           | : | .250  | .336  | .250  |
| MIN RADIUS                    | : | .036  | .103  | .184  |
| MEAN RADIUS                   | : | .781  | .722  | .658  |
| MAX RADIUS                    | : | 1.231 | 1.174 | 1.129 |
| HORIZONTAL SPREAD             | : | 1.887 | 1.617 | 1.617 |
| VERTICAL SPREAD               | : | 1.729 | 1.666 | 1.423 |
| EXTREME SPREAD                | : | 2.149 | 2.057 | 1.805 |
| NUMBER IN ONE INCH CIRCLE =   |   |       | 2     |       |
| NUMBER IN TWO INCH CIRCLE =   |   |       | 7     |       |
| NUMBER IN THREE INCH CIRCLE = |   |       | 10    |       |

22 Feb 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611016.1

# CENTERFIRE PATTERNS # 3



# OF SHOTS= 10

# IN CIR

1 in = 1

2 in = 6

3 in = 10

HS= 2.497

VS= 1.523

GS= 2.542

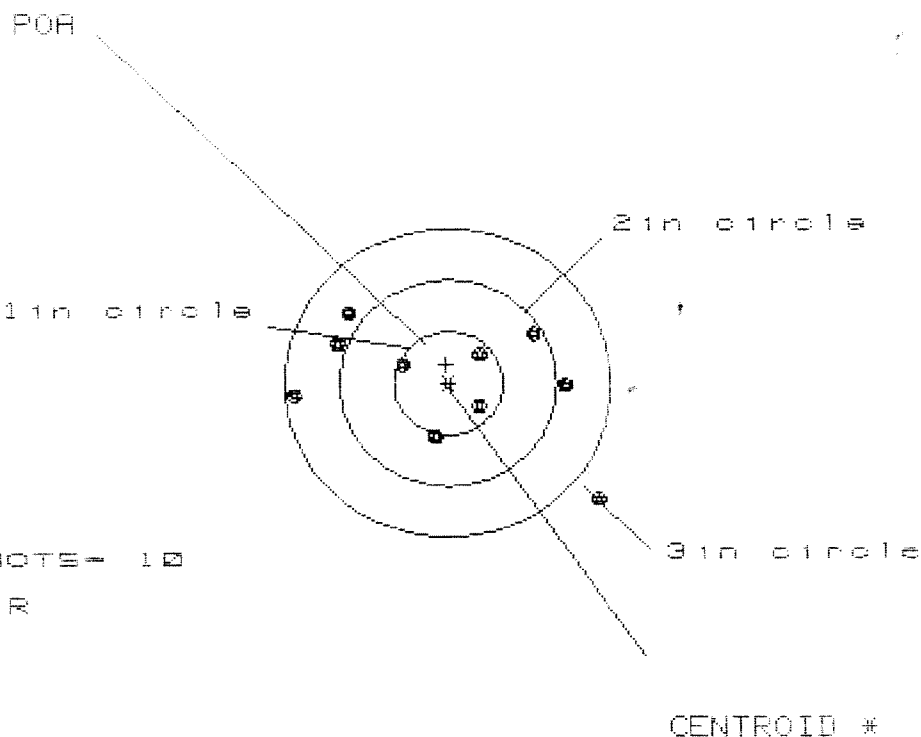
CENTROID #

| PATTERN #                   | : | 3      |        |        |
|-----------------------------|---|--------|--------|--------|
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.198  | 1.054  | 1.043  |
| MINIMUM X                   | : | -1.299 | -1.262 | -1.130 |
| MAXIMUM Y                   | : | .898   | .844   | .759   |
| MINIMUM Y                   | : | -.625  | -.679  | -.639  |
| CENTROID X                  | : | -.122  | .022   | -.110  |
| CENTROID Y                  | : | .088   | .134   | .219   |
| POA TO CENTROID in.         | : | .146   | .136   | .245   |
| MIN RADIUS                  | : | .298   | .163   | .318   |
| MEAN RADIUS                 | : | .937   | .857   | .820   |
| MAX RADIUS                  | : | 1.387  | 1.315  | 1.165  |
| HORIZONTAL SPREAD           | : | 2.497  | 2.316  | 2.173  |
| VERTICAL SPREAD             | : | 1.523  | 1.523  | 1.398  |
| EXTREME SPREAD              | : | 2.542  | 2.542  | 2.202  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 10     |        |

22 Feb 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611816.1

# CENTERFIRE PATTERNS # 4



# OF SHOTS = 10

# IN CIR

1in = 3

2in = 5

3in = 9

HS = 2.794

VS = 1.852

GS = 2.973

|                     |   |        |        |       |
|---------------------|---|--------|--------|-------|
| PATTERN #           | : | 4      |        |       |
| SHOTS (BEST OF)     | : | 10     | 9      | 8     |
| MAXIMUM X           | : | 1.378  | 1.212  | 1.054 |
| MINIMUM X           | : | -1.416 | -1.263 | -.984 |
| MAXIMUM Y           | : | .722   | .596   | .567  |
| MINIMUM Y           | : | -1.130 | -.615  | -.645 |
| CENTROID X          | : | .019   | -.134  | .024  |
| CENTROID Y          | : | -.183  | -.057  | -.027 |
| POA TO CENTROID in. | : | .184   | .146   | .036  |
| MIN RADIUS          | : | .363   | .253   | .323  |
| MEAN RADIUS         | : | .912   | .808   | .736  |
| MAX RADIUS          | : | 1.782  | 1.285  | 1.095 |
| HORIZONTAL SPREAD   | : | 2.794  | 2.475  | 2.038 |
| VERTICAL SPREAD     | : | 1.852  | 1.211  | 1.211 |
| EXTREME SPREAD      | : | 2.973  | 2.479  | 2.108 |

22 Feb 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/CG611816.1

# CENTERFIRE PATTERNS # 5

POA

1in circle

2in circle

3in circle

# OF SHOTS- 10

# IN CIR

1in - 3

2in - 6

3in - 9

HS= 2.384

VS= 2.531

GS= 3.042

CENTROID #

PATTERN #

5

| SHOTS (BEST OF)     | 10     | 9      | 8      |
|---------------------|--------|--------|--------|
| MAXIMUM X           | 1.296  | 1.410  | .611   |
| MINIMUM X           | -1.088 | -.974  | -.798  |
| MAXIMUM Y           | 1.285  | .813   | .755   |
| MINIMUM Y           | -1.246 | -1.104 | -1.162 |
| CENTROID X          | .249   | .135   | -.041  |
| CENTROID Y          | .317   | .175   | .233   |
| POA TO CENTROID in. | .403   | .221   | .237   |
| MIN RADIUS          | .177   | .030   | .216   |
| MEAN RADIUS         | .893   | .792   | .712   |
| MAX RADIUS          | 1.643  | 1.485  | 1.220  |
| HORIZONTAL SPREAD   | 2.384  | 2.384  | 1.409  |

|                 |             |       |       |       |
|-----------------|-------------|-------|-------|-------|
| VERTICAL        | SPREAD :    | 2.531 | 1.917 | 1.917 |
| EXTREME         | SPREAD :    | 3.042 | 2.706 | 1.964 |
| NUMBER IN ONE   | INCH CIRCLE | =     | 3     |       |
| NUMBER IN TWO   | INCH CIRCLE | =     | 6     |       |
| NUMBER IN THREE | INCH CIRCLE | =     | 9     |       |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611816  
5 Mar 1991

4500RDS

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .222445 |
| 1 TO | 2 | .20401  |
| 1 TO | 3 | .2728   |
| 1 TO | 4 | .342243 |
| 1 TO | 5 | .516501 |

$\frac{S}{PA}$  <----POA

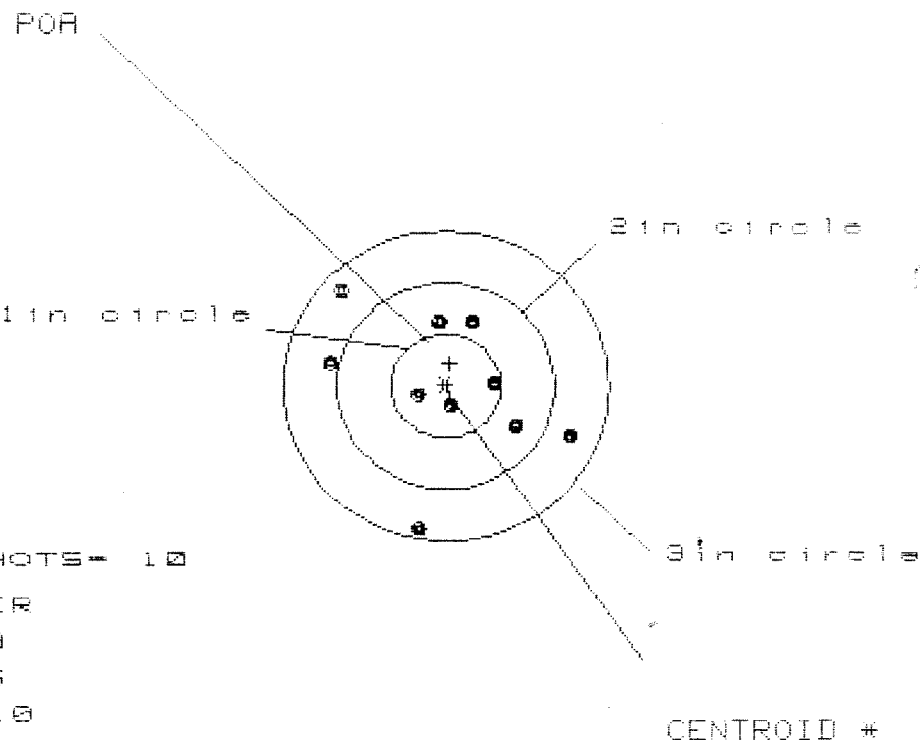
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .123  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0368  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .128387  
THE AMR FOR THIS RIFLE IS: .9256



5 Mar 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C8611816.1.1

# CENTERFIRE PATTERNS # 1



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 6

3in = 10

HS= 2.169

VS= 2.323

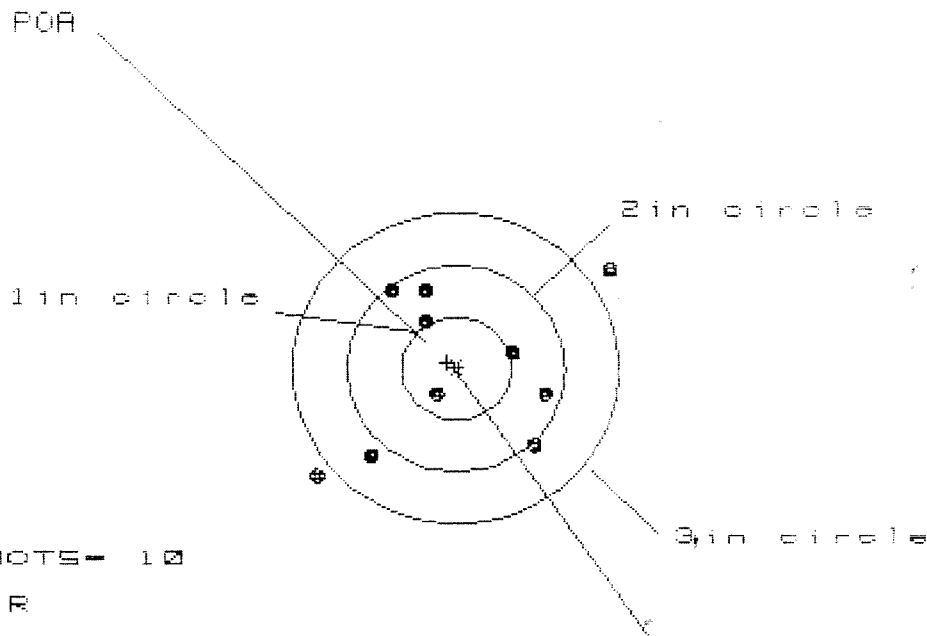
GS= 2.523

|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : | 1      |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.147  | 1.113  | .989   |
| MINIMUM X                     | : | -1.022 | -1.056 | -1.180 |
| MAXIMUM Y                     | : | .962   | .811   | .587   |
| MINIMUM Y                     | : | -1.361 | -.588  | -.486  |
| CENTROID X                    | : | -.039  | -.005  | .119   |
| CENTROID Y                    | : | -.219  | -.068  | -.170  |
| POA TO CENTROID in.           | : | .223   | .068   | .207   |
| MIN RADIUS                    | : | .178   | .323   | .247   |
| MEAN RADIUS                   | : | .791   | .720   | .631   |
| MAX RADIUS                    | : | 1.395  | 1.278  | 1.186  |
| HORIZONTAL SPREAD             | : | 2.169  | 2.169  | 2.169  |
| VERTICAL SPREAD               | : | 2.323  | 1.399  | 1.073  |
| EXTREME SPREAD                | : | 2.523  | 2.523  | 2.253  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 10     |        |

5 Mar 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611816.1.1

# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 6

3in = 8

HS= 2.775

VS= 1.998

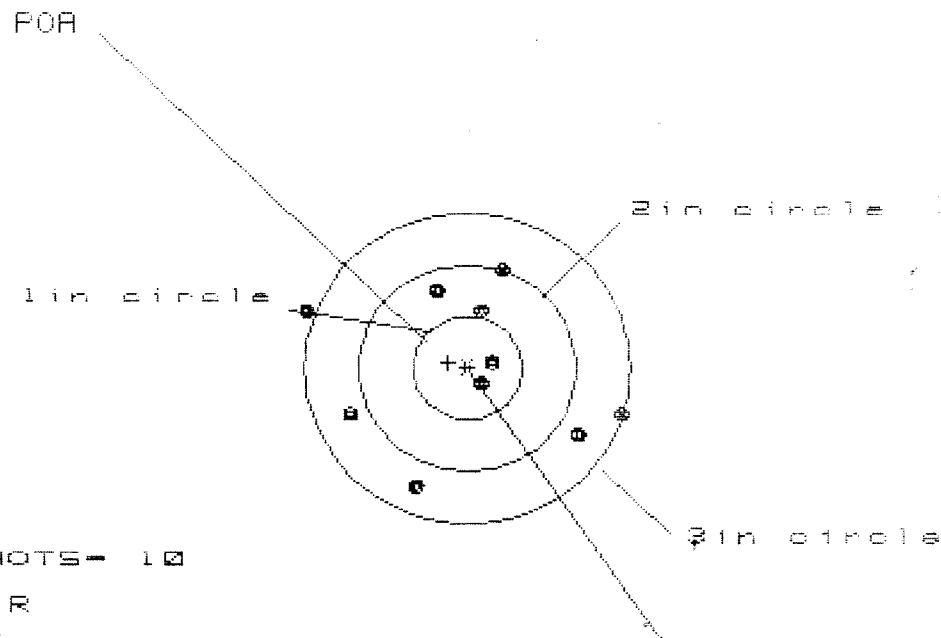
GS= 3.419

| PATTERN #                     | 2      |
|-------------------------------|--------|
| SHOTS (BEST OF)               | 10     |
| MAXIMUM X                     | 1.445  |
| MINIMUM X                     | -1.330 |
| MAXIMUM Y                     | .994   |
| MINIMUM Y                     | -1.004 |
| CENTROID X                    | .085   |
| CENTROID Y                    | -.057  |
| POA TO CENTROID in.           | .102   |
| MIN RADIUS                    | .344   |
| MEAN RADIUS                   | .959   |
| MAX RADIUS                    | 1.754  |
| HORIZONTAL SPREAD             | 2.775  |
| VERTICAL SPREAD               | 1.998  |
| EXTREME SPREAD                | 3.419  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |
| NUMBER IN TWO INCH CIRCLE =   | 6      |
| NUMBER IN THREE INCH CIRCLE = | 8      |

5 Mar 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611816.1.1

# CENTERFIRE PATTERNS # 3



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 5

3 in = 8

HS= 2.916

VS= 2.110

GS= 3.087

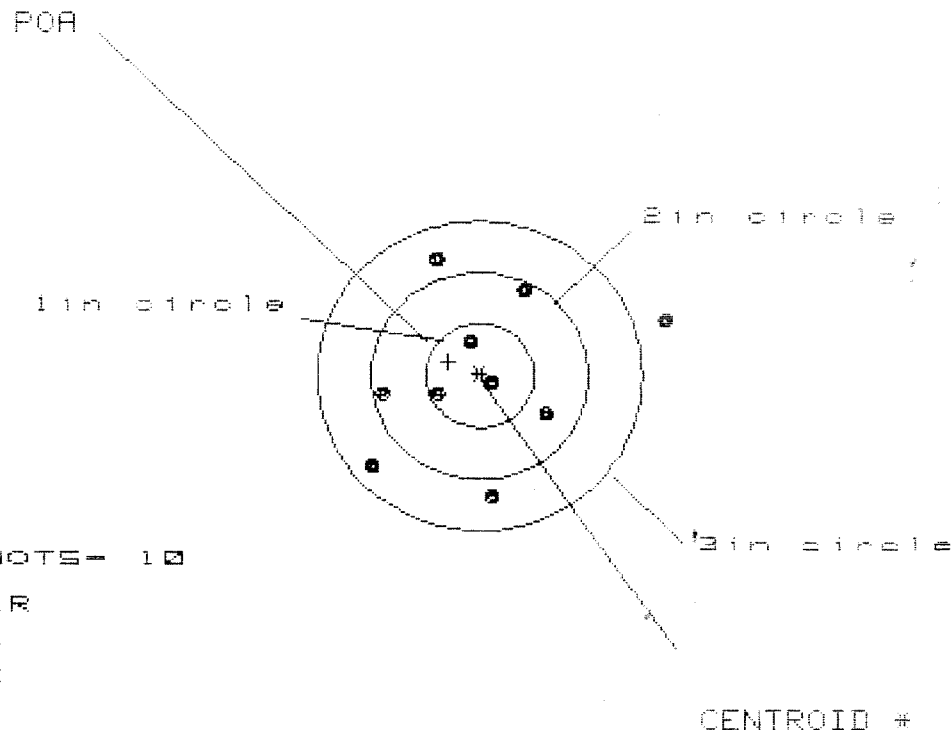
CENTROID \*

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 3      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.463  | 1.301  | .996   |
| MINIMUM X                   | : | -1.453 | -1.212 | -1.049 |
| MAXIMUM Y                   | : | .919   | .985   | .942   |
| MINIMUM Y                   | : | -1.191 | -1.125 | -1.168 |
| CENTROID X                  | : | .179   | .341   | .178   |
| CENTROID Y                  | : | -.055  | -.121  | -.078  |
| POA TO CENTROID in.:        | : | .187   | .361   | .194   |
| MIN RADIUS                  | : | .202   | .071   | .194   |
| MEAN RADIUS                 | : | .944   | .850   | .796   |
| MAX RADIUS                  | : | 1.571  | 1.347  | 1.274  |
| HORIZONTAL SPREAD           | : | 2.916  | 2.513  | 2.045  |
| VERTICAL SPREAD             | : | 2.110  | 2.110  | 2.110  |
| EXTREME SPREAD              | : | 3.087  | 2.513  | 2.252  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 5      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 8      |        |

5 Mar 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6811816.1.1

# CENTERFIRE PATTERNS # 4



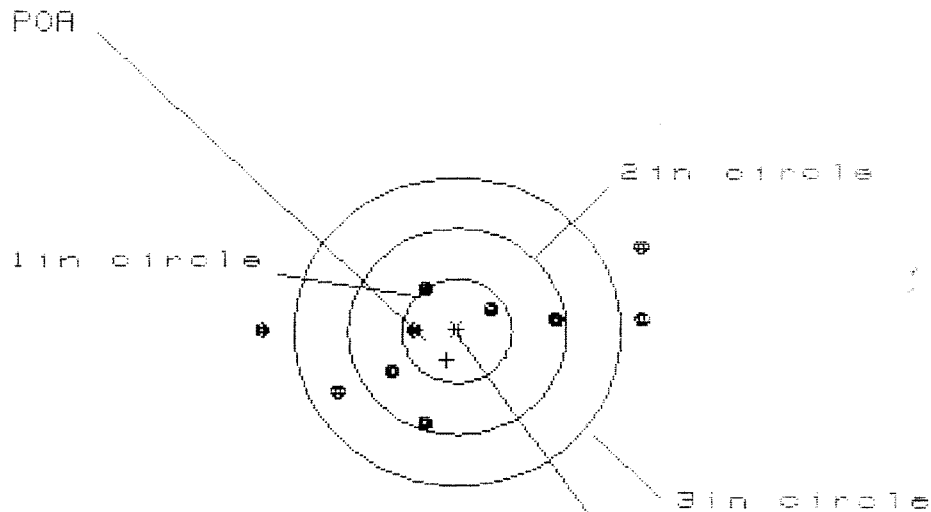
# OF SHOTS- 10  
 # IN CIR  
 1 in = 3  
 2 in = 6  
 3 in = 9  
 HS= 2.739  
 VS= 2.283  
 GS= 3.067

|                             |   |        |        |        |
|-----------------------------|---|--------|--------|--------|
| PATTERN #                   | : | 4      |        |        |
| SHOTS (BEST OF)             | : | 10     | 9      | 8      |
| MAXIMUM X                   | : | 1.702  | .809   | .703   |
| MINIMUM X                   | : | -1.037 | -.848  | -.826  |
| MAXIMUM Y                   | : | 1.148  | 1.204  | 1.101  |
| MINIMUM Y                   | : | -1.135 | -1.079 | -1.182 |
| CENTROID X                  | : | .292   | .103   | .209   |
| CENTROID Y                  | : | -.132  | -.188  | -.085  |
| POA TO CENTROID in.         | : | .320   | .214   | .225   |
| MIN RADIUS                  | : | .148   | .278   | .241   |
| MEAN RADIUS                 | : | .895   | .787   | .726   |
| MAX RADIUS                  | : | 1.775  | 1.222  | 1.191  |
| HORIZONTAL SPREAD           | : | 2.739  | 1.657  | 1.529  |
| VERTICAL SPREAD             | : | 2.283  | 2.283  | 2.283  |
| EXTREME SPREAD              | : | 3.067  | 2.330  | 2.330  |
| NUMBER IN ONE INCH CIRCLE   | = |        | 3      |        |
| NUMBER IN TWO INCH CIRCLE   | = |        | 6      |        |
| NUMBER IN THREE INCH CIRCLE | = |        | 9      |        |

5 Mar 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611816.1.1

# CENTERFIRE PATTERNS # 5



# OF SHOTS- 10

# IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 2.497

VS= 1.606

GS= 3.501

CENTROID #

| PATTERN #                     | 5      | 9      | 8      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.738  | 1.922  | 1.726  |
| MINIMUM X                     | -1.759 | -1.575 | -1.125 |
| MAXIMUM Y                     | .776   | .491   | .506   |
| MINIMUM Y                     | -.830  | -.744  | -.729  |
| CENTROID X                    | .098   | -.086  | .111   |
| CENTROID Y                    | .279   | .193   | .178   |
| POA TO CENTROID in.           | .296   | .211   | .210   |
| MIN RADIUS                    | .350   | .299   | .406   |
| MEAN RADIUS                   | 1.039  | .919   | .854   |
| MAX RADIUS                    | 1.833  | 1.937  | 1.744  |
| HORIZONTAL SPREAD             | 3.497  | 3.497  | 2.850  |
| VERTICAL SPREAD               | 1.606  | 1.235  | 1.235  |
| EXTREME SPREAD                | 3.501  | 3.499  | 2.937  |
| NUMBER IN ONE INCH CIRCLE =   | 2      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 6      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 7      |        |        |

CENTROIDAL DISTANCE CALCULATIONS  
FOR RIFLE # C6611816  
6 Mar 1991

5000 RDS

CENTROIDAL DISTANCES

|      |   |         |
|------|---|---------|
| 0 TO | 1 | .403788 |
| 1 TO | 2 | .293143 |
| 1 TO | 3 | .408883 |
| 1 TO | 4 | .616623 |
| 1 TO | 5 | .580535 |

$\sigma^2$   
#3 (----POA

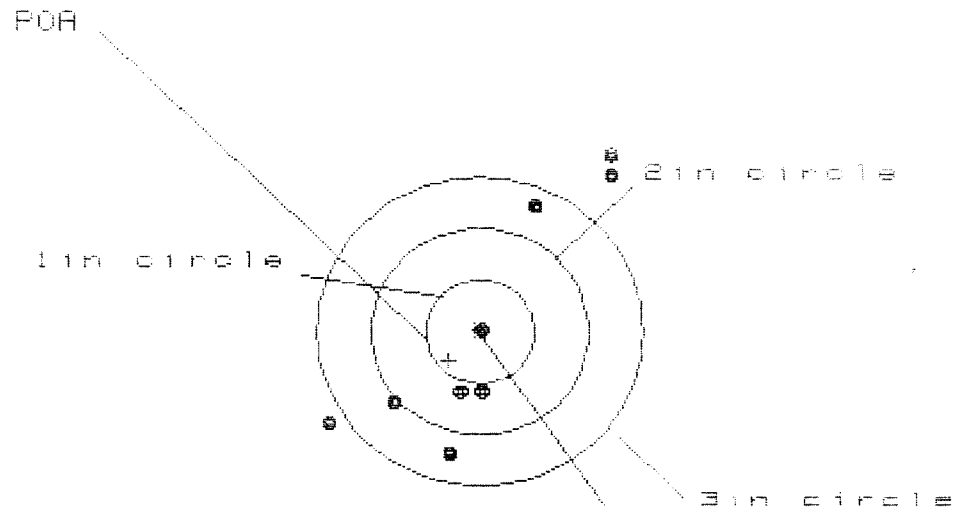
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0776  
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0124  
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0785845

THE AMR FOR THIS RIFLE IS: .9172

8 Mar 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6811816.1.1.1

# CENTERFIRE PATTERNS # 1



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 4

3in = 7

HS= 2.663

VS= 2.927

GS= 3.689

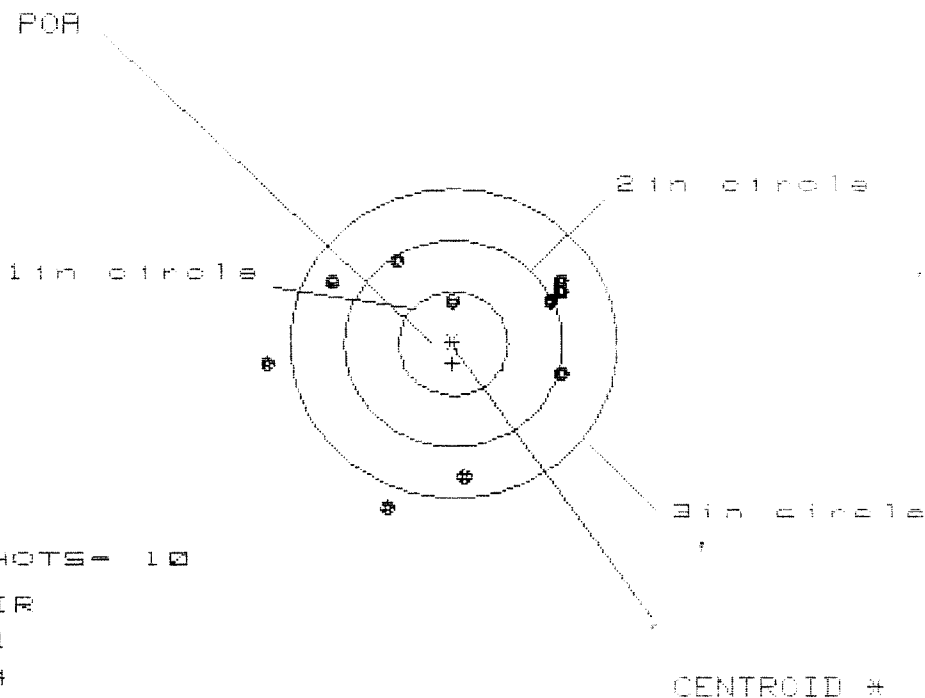
CENTROID #

| PATTERN #                     | 1      | 2      | 3      |
|-------------------------------|--------|--------|--------|
| SHOTS (BEST OF)               | 10     | 9      | 8      |
| MAXIMUM X                     | 1.241  | 1.327  | .802   |
| MINIMUM X                     | -1.422 | -1.284 | -1.118 |
| MAXIMUM Y                     | 1.717  | 1.727  | 1.613  |
| MINIMUM Y                     | -1.210 | -1.019 | -.803  |
| CENTROID X                    | .289   | .151   | -.015  |
| CENTROID Y                    | .282   | .091   | -.125  |
| POA TO CENTROID in.           | .404   | .176   | .126   |
| MIN RADIUS                    | .020   | .230   | .228   |
| MEAN RADIUS                   | 1.114  | .939   | .708   |
| MAX RADIUS                    | 2.119  | 2.178  | 1.801  |
| HORIZONTAL SPREAD             | 2.663  | 2.611  | 1.920  |
| VERTICAL SPREAD               | 2.927  | 2.746  | 2.416  |
| EXTREME SPREAD                | 3.689  | 3.528  | 2.803  |
| NUMBER IN ONE INCH CIRCLE =   | 1      |        |        |
| NUMBER IN TWO INCH CIRCLE =   | 4      |        |        |
| NUMBER IN THREE INCH CIRCLE = | 7      |        |        |

6 Mar 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/C6611816.1.1.1

# CENTERFIRE PATTERNS # 2



# OF SHOTS- 10

# IN CIR

1in = 1

2in = 4

3in = 5

HS= 2.747

VS= 2.416

GS= 2.864

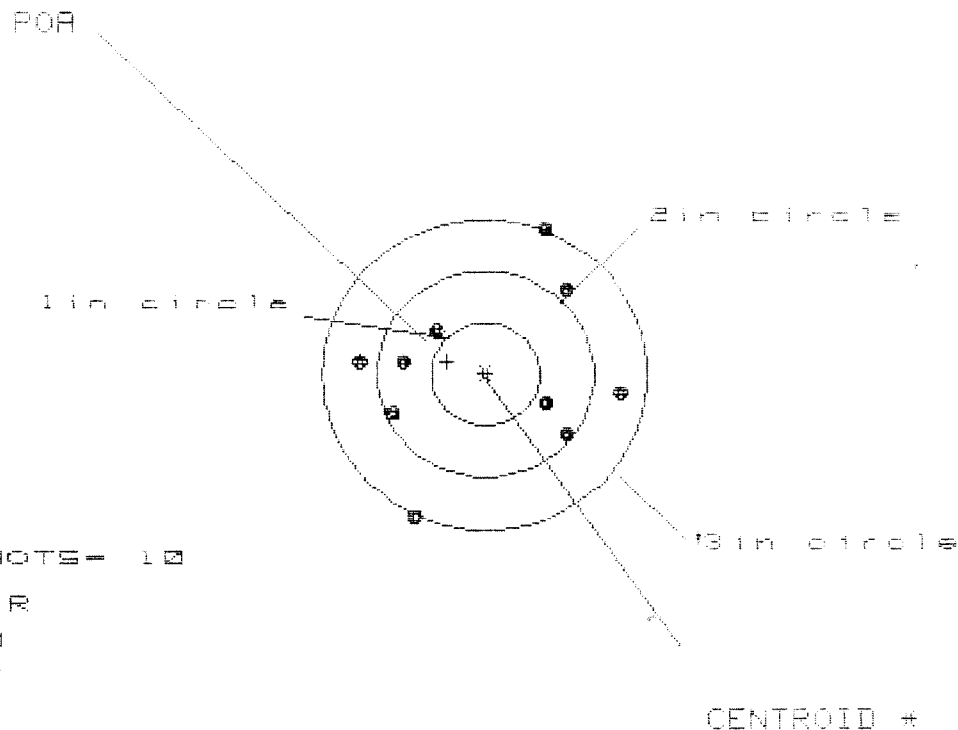
|                               |   |        |        |        |
|-------------------------------|---|--------|--------|--------|
| PATTERN #                     | : | 2      |        |        |
| SHOTS (BEST OF)               | : | 10     | 9      | 8      |
| MAXIMUM X                     | : | 1.013  | .821   | .725   |
| MINIMUM X                     | : | -1.734 | -1.280 | -1.376 |
| MAXIMUM Y                     | : | .801   | .782   | .578   |
| MINIMUM Y                     | : | -1.615 | -1.634 | -1.498 |
| CENTROID X                    | : | .011   | .203   | .299   |
| CENTROID Y                    | : | .189   | .208   | .412   |
| POA TO CENTROID in.           | : | .189   | .291   | .509   |
| MIN RADIUS                    | : | .377   | .401   | .315   |
| MEAN RADIUS                   | : | 1.153  | 1.054  | .903   |
| MAX RADIUS                    | : | 1.742  | 1.805  | 1.511  |
| HORIZONTAL SPREAD             | : | 2.747  | 2.101  | 2.101  |
| VERTICAL SPREAD               | : | 2.416  | 2.416  | 2.076  |
| EXTREME SPREAD                | : | 2.864  | 2.756  | 2.217  |
| NUMBER IN ONE INCH CIRCLE =   |   |        | 1      |        |
| NUMBER IN TWO INCH CIRCLE =   |   |        | 4      |        |
| NUMBER IN THREE INCH CIRCLE = |   |        | 5      |        |



8 Mar 1981

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# CENTERFIRE PATTERNS # 3



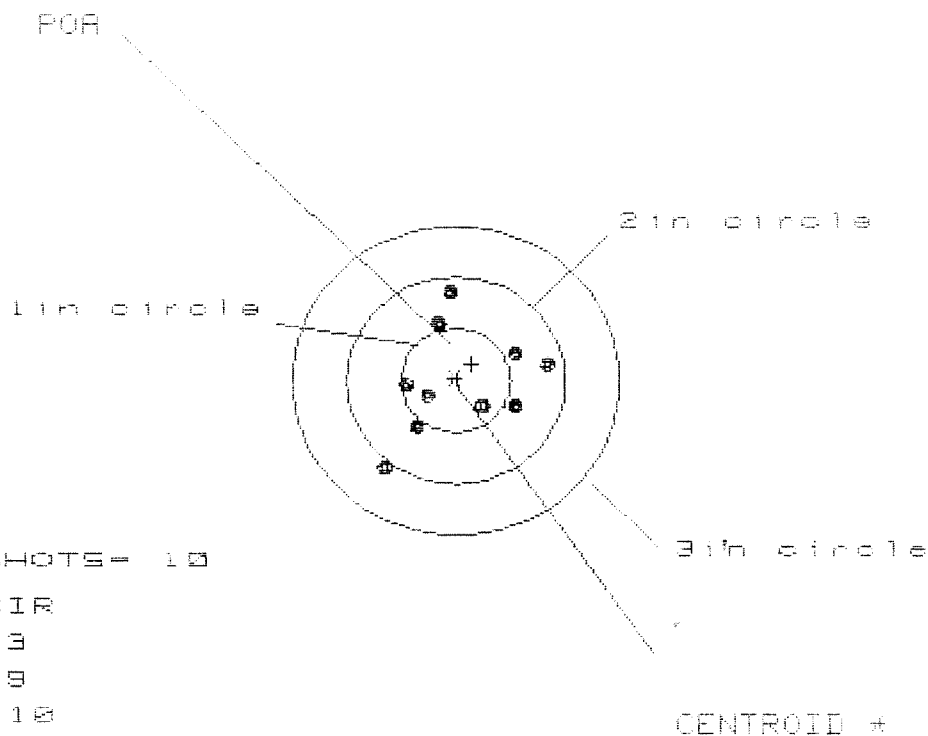
# OF SHOTS- 10  
 # IN CIR  
 1 in = 0  
 2 in = 5  
 3 in = 8  
 HS= 2.410  
 VS= 2.813  
 GS= 3.067

| PATTERN #                   | 3      |
|-----------------------------|--------|
| SHOTS (BEST OF)             | 10     |
| MAXIMUM X                   | 1.251  |
| MINIMUM X                   | -1.159 |
| MAXIMUM Y                   | 1.402  |
| MINIMUM Y                   | -1.411 |
| CENTROID X                  | .352   |
| CENTROID Y                  | -.122  |
| POA TO CENTROID in.         | .373   |
| MIN RADIUS                  | .599   |
| MEAN RADIUS                 | 1.040  |
| MAX RADIUS                  | 1.569  |
| HORIZONTAL SPREAD           | 2.410  |
| VERTICAL SPREAD             | 2.813  |
| EXTREME SPREAD              | 3.067  |
| NUMBER IN ONE INCH CIRCLE   | 0      |
| NUMBER IN TWO INCH CIRCLE   | 5      |
| NUMBER IN THREE INCH CIRCLE | 8      |

B Mar 1991

FILE:/PATTERNING/CENTERFIRE\_PATT/CAB11818.1.1.1

# CENTERFIRE PATTERNS # 4



# OF SHOTS= 10

# IN CIR

1in = 3

2in = 9

3in = 10

HE= 1.516

VS= 1.513

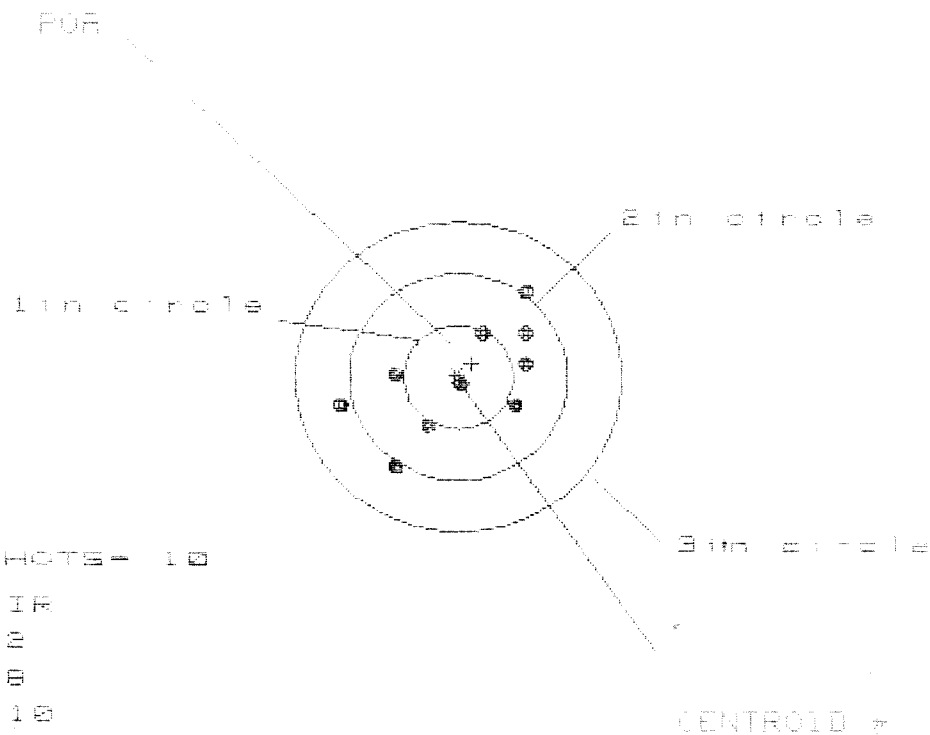
GS= 1.791

| PATTERN #                   | : | 4     |       |       |
|-----------------------------|---|-------|-------|-------|
| SHOTS (BEST OF)             | : | 10    | 9     | 8     |
| MAXIMUM X                   | : | .837  | .762  | .536  |
| MINIMUM X                   | : | -.679 | -.564 | -.469 |
| MAXIMUM Y                   | : | .814  | .725  | .733  |
| MINIMUM Y                   | : | -.799 | -.545 | -.537 |
| CENTROID X                  | : | -.143 | -.068 | -.163 |
| CENTROID Y                  | : | -.158 | -.069 | -.077 |
| POA TO CENTROID in.         | : | .213  | .097  | .181  |
| MIN RADIUS                  | : | .289  | .319  | .321  |
| MEAN RADIUS                 | : | .608  | .557  | .523  |
| MAX RADIUS                  | : | 1.048 | .765  | .735  |
| HORIZONTAL SPREAD           | : | 1.516 | 1.326 | 1.005 |
| VERTICAL SPREAD             | : | 1.613 | 1.270 | 1.270 |
| EXTREME SPREAD              | : | 1.791 | 1.377 | 1.310 |
| NUMBER IN ONE INCH CIRCLE   | = |       | 3     |       |
| NUMBER IN TWO INCH CIRCLE   | = |       | 9     |       |
| NUMBER IN THREE INCH CIRCLE | = |       | 10    |       |

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FILE: PATTERNING/CENTERFIRE\_PATT/C6811818.1.1.1

# CENTERFIRE PATTERNS # 5



# OF SHOTS= 10  
 # IN CIR  
 1 in = 2  
 2 in = 8  
 3 in = 10  
 HS= 1.838  
 VS= 1.669  
 GS= 2.038

|                             |   |        |       |       |
|-----------------------------|---|--------|-------|-------|
| PATTERN #                   | : | 5      |       |       |
| SHOTS (BEST OF)             | : | 10     | 9     | 8     |
| MAXIMUM X                   | : | .588   | .464  | .375  |
| MINIMUM X                   | : | -1.110 | -.716 | -.756 |
| MAXIMUM Y                   | : | .811   | .777  | .666  |
| MINIMUM Y                   | : | -.858  | -.892 | -.616 |
| CENTROID X                  | : | -.121  | .003  | .092  |
| CENTROID Y                  | : | -.129  | -.095 | .016  |
| POA TO CENTROID (in.)       | : | .177   | .095  | .094  |
| MIN RADIUS                  | : | .029   | .122  | .260  |
| MEAN RADIUS                 | : | .671   | .608  | .526  |
| MAX RADIUS                  | : | 1.151  | 1.143 | .766  |
| HORIZONTAL SPREAD           | : | 1.698  | 1.180 | 1.131 |
| VERTICAL SPREAD             | : | 1.669  | 1.669 | 1.282 |
| EXTREME SPREAD              | : | 2.038  | 2.038 | 1.521 |
| NUMBER IN ONE INCH CIRCLE   | = |        | 2     |       |
| NUMBER IN TWO INCH CIRCLE   | = |        | 8     |       |
| NUMBER IN THREE INCH CIRCLE | = |        | 10    |       |

Endurance B/A

QP 0041

# C-6611816

PART NUMBER C-6611816

MAGNETIC PARTICLE INSPECTION

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

OPERATION NUMBER 615

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

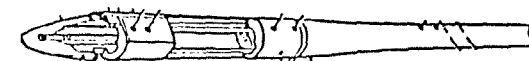
SKETCH AND/OR REMARKS

NON-FLUORSECENT  
CONTINUOUS WET

FLUORESCENT  
CONTINUOUS WET Yes

Yes (2 Overlapping)

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



△ (M)

NON-FLUORESCENT  
RESIDUAL WET

FLUORESCENT  
RESIDUAL WET

APPROVAL:

INSP. \_\_\_\_\_ LEV III \_\_\_\_\_  
DATE: \_\_\_\_\_ DATE: \_\_\_\_\_

ACCEPTANCE STANDARD

STEEL STAMP ON. Triangular stamp (△) 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. 8158-8096

FORM QP-0041-1 "B" Stamp

QP 0041

Endurance B/A M-24-SW S  
# C 6611816

| DATE    | MFG.<br>ORDER NO. | Rds<br>Fixed<br>QUANTITY | SERIAL # | QUANTITY OF PARTS |          |
|---------|-------------------|--------------------------|----------|-------------------|----------|
|         |                   |                          |          | ACCEPTED          | REJECTED |
| 2-27-91 |                   | 2,500                    |          | 1                 | 0        |
| 3-6-91  |                   | 5,000                    |          | 1                 | 0        |
| 3-7-91  |                   | 6,000                    |          | 1                 | 0        |
| 3-8-91  |                   | 7,000                    |          | 1                 | 0        |
| 3-11-91 |                   | 8,000                    |          | 1                 | 0        |
| 3-12-91 |                   | 9,000                    |          | 1                 | 0        |
| 3-14-91 |                   | 10,000                   |          | 1                 | 0        |