

FORM

UPC



0 47700 25716 7

C6649207

INCLUDES 1 IN CHAMBER

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

M2400066373

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 TM M24

SERIAL NO.

C6649207

ORDER NO.

5716

20

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



5716 C6649207

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

ORDER 5716

MODEL 700 TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6649207

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	10 1	91	RW
600	Proof	10 1	91	RW
607	Check Headspace	10 1	91	RW
610	Dis-assemble Gun	10 1	91	RW
612	Magnaflux Barrel Action	OCT 1 0 1991		KR
	Magnaflux Bolt	OCT 1 0 1991		KR
615	Rollmark Caliber	OCT 0 1991		LS
617	Drill and Tap Sight Holes	OCT 1 0 1991		LB
618	Polish Barrel		10/15/91	WB
620	Apply Coatings (Barrel Action)		11/27/91	WB
	Apply Coating (Bolt)			
625	Final Assembly			
	A) Clean inside of Bolt Assembly			
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head			
	C) Inspect Ejector Hole for Chamfer			
	D) Oil Firing Pin Ass'y			
	E) Adjust Trigger Pull to Min Setting and Stake		12/27/91	WB

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

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#

3.00# + .75#

4.00# + 1.00#

SERIAL NO. C6649207

DATE 12/27/91

TESTER WB

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

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

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

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6649207
30 Dec 1991

CENTROIDAL DISTANCES

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

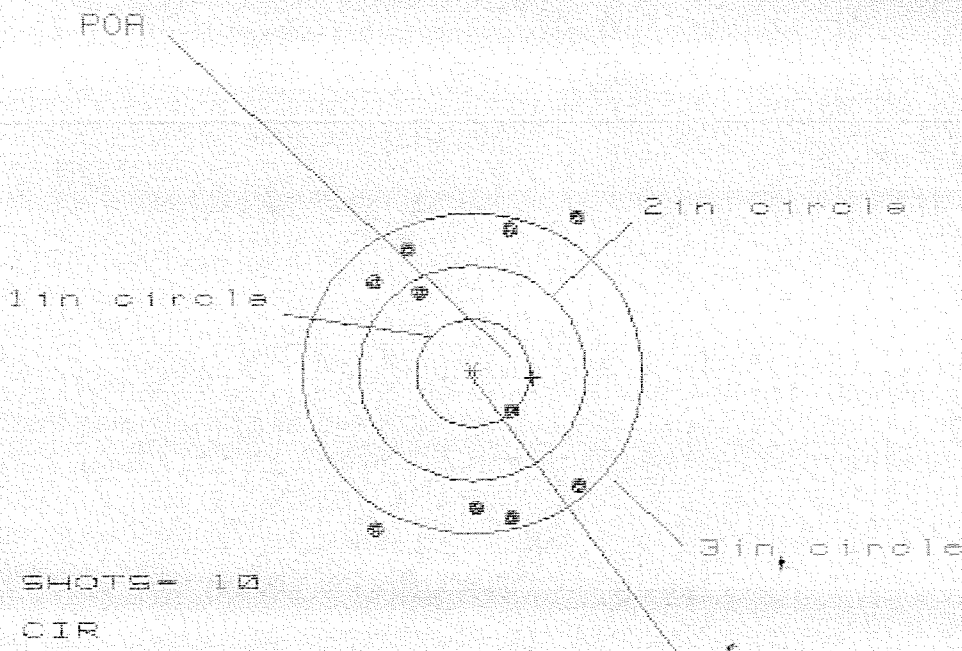
$\frac{2}{1} \frac{4}{153} \leftarrow \text{POA}$

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

30 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06649207

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1in = 1

2in = 2

3in = 8

HS= 1.768

VS= 2.846

GS= 3.342

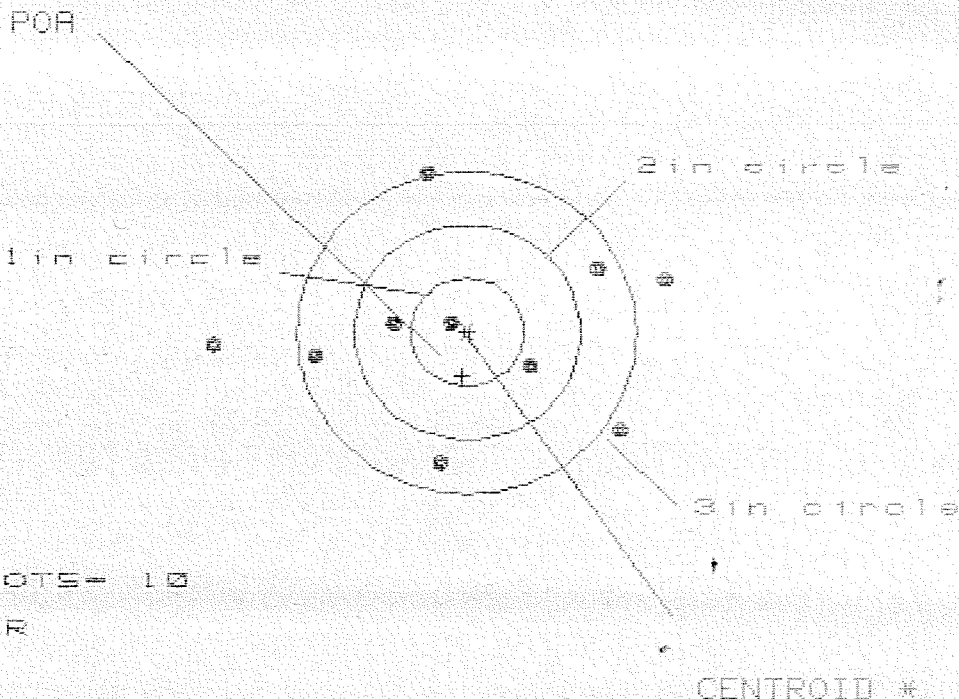
CENTROID #

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

30 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C66492B7

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 3

3 in = 6

HS= 3.986

VS= 2.707

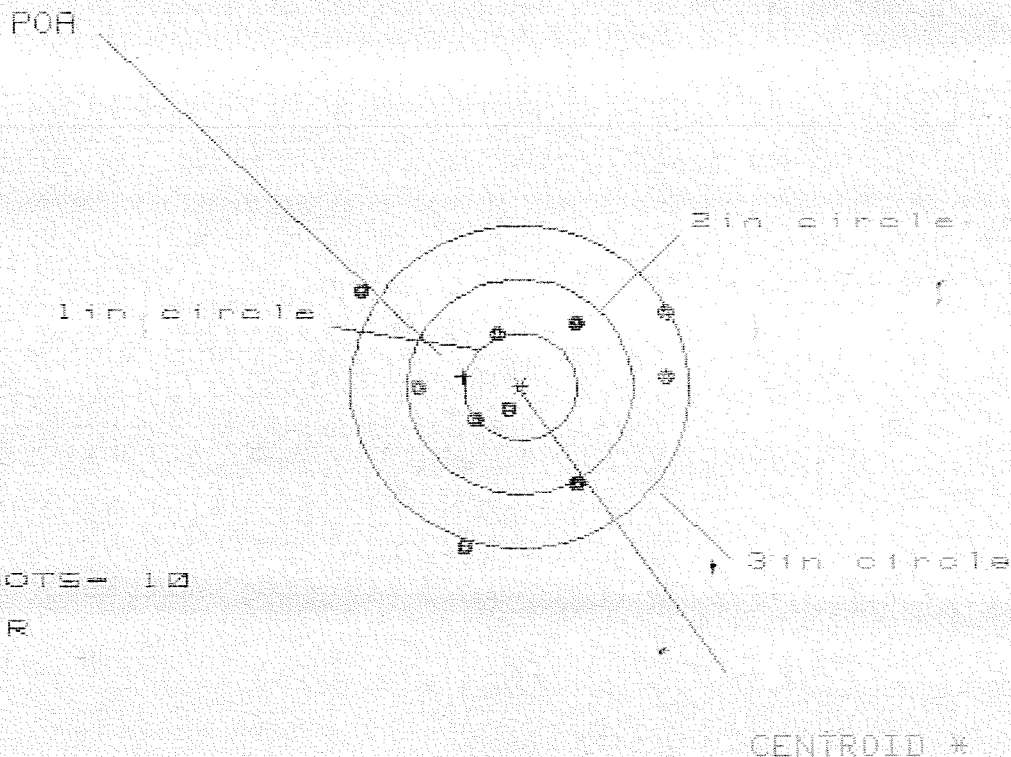
GS= 4.032

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.743	1.494	1.301
MINIMUM X	:	-2.243	-1.567	-1.380
MAXIMUM Y	:	1.528	1.512	1.568
MINIMUM Y	:	-1.179	-1.195	-1.139
CENTROID X	:	.046	.295	.108
CENTROID Y	:	.410	.426	.370
POA TO CENTROID in.	:	.412	.518	.385
MIN RADIUS	:	.116	.348	.190
MEAN RADIUS	:	1.252	1.143	1.064
MAX RADIUS	:	2.247	1.616	1.615
HORIZONTAL SPREAD	:	3.986	3.061	2.681
VERTICAL SPREAD	:	2.707	2.707	2.707
EXTREME SPREAD	:	4.032	3.134	2.937
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	3		
NUMBER IN THREE INCH CIRCLE	=	6		

30 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649207

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 7

HS= 2.722

VS= 2.367

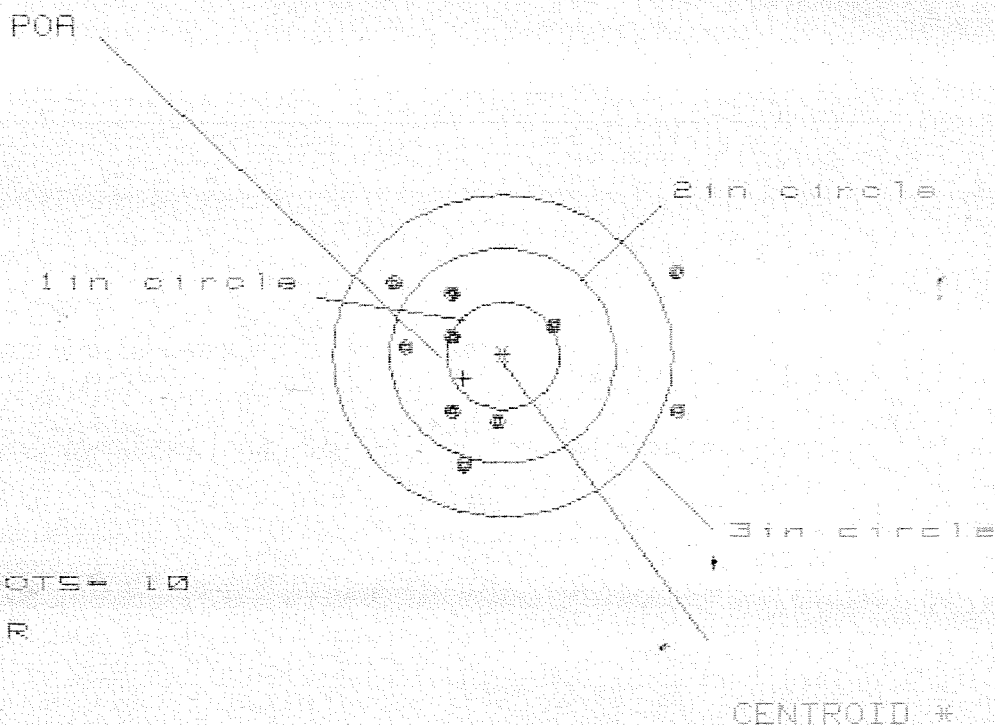
GS= 2.902

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.333	1.178	1.091
MINIMUM X	:	-1.389	-1.052	-1.139
MAXIMUM Y	:	.874	.816	.642
MINIMUM Y	:	-1.493	-1.396	-.981
CENTROID X	:	.504	.659	.746
CENTROID Y	:	-.100	-.197	-.023
POA TO CENTROID in.	:	.514	.688	.747
MIN RADIUS	:	.187	.271	.421
MEAN RADIUS	:	.992	.932	.851
MAX RADIUS	:	1.641	1.562	1.266
HORIZONTAL SPREAD	:	2.722	2.230	2.230
VERTICAL SPREAD	:	2.367	2.212	1.623
EXTREME SPREAD	:	2.902	2.902	2.348
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

30 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06B49207

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 8

HS= 2.513

VS= 1.836

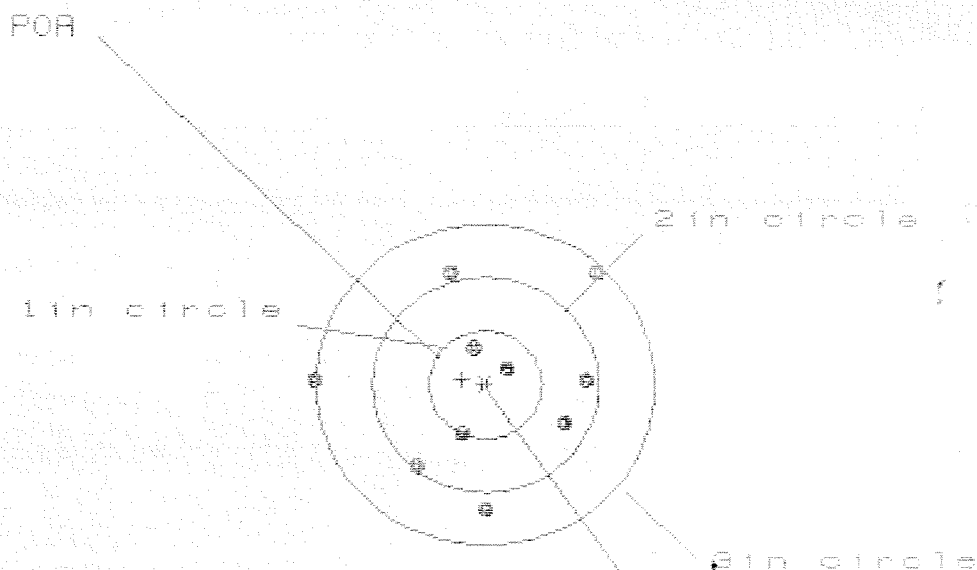
GS= 2.775

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.548	1.788	.861
MINIMUM X	:	-.965	-.793	-.579
MAXIMUM Y	:	.819	.821	.773
MINIMUM Y	:	-1.017	-.926	-.974
CENTROID X	:	.354	.182	-.032
CENTROID Y	:	.213	.122	.170
POA TO CENTROID in.	:	.413	.219	.173
MIN RADIUS	:	.457	.373	.238
MEAN RADIUS	:	.955	.825	.668
MAX RADIUS	:	1.751	1.750	.974
HORIZONTAL SPREAD	:	2.513	2.501	1.440
VERTICAL SPREAD	:	1.836	1.747	1.747
EXTREME SPREAD	:	2.775	2.775	1.848
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			8	

18 Dec 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6649207

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 3

2in = 5

3in = 9

HS= 2.531

VS= 2.185

GS= 2.724

CENTROID #

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.998	.828	.831
MINIMUM X	-1.533	-.813	-.710
MAXIMUM Y	1.025	1.026	1.153
MINIMUM Y	-1.160	-1.159	-1.032
CENTROID X	.209	.379	.276
CENTROID Y	-.045	-.046	-.173
POA TO CENTROID in.	.214	.382	.325
MIN RADIUS	.248	.165	.315
MEAN RADIUS	.897	.809	.747
MAX RADIUS	1.533	1.310	1.200
AVG CENTRAL SPREAD	2.531	1.641	1.540
AVG HORIZONTAL SPREAD	2.185	2.185	2.185
AVG VERTICAL SPREAD	2.724	2.422	2.201
ONE INCH CIRCLE =		3	
TWO INCH CIRCLE =		5	
THREE INCH CIRCLE =		9	

M-24

ENDURANCE GUN #1

CONTRACT # DAAA21-87-C-0086

LOT RAC91C001-012

GUN SERIAL #

C6594488

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

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

SWS TRIGGER PULL TEST

AVERAGE PULL FORCE BETWEEN
INITIAL & CYCLE TESTS

2.50# + .50#
3.00# + .75#
4.00# + 1.00#

SERIAL NO. C6594488

DATE 1-23-91

TESTER JEL

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

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

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

SWS ENDURANCE TEST REPORT

SERIAL NO. C 6594488 SHOOTER AW DATE 1/29/91

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	120	OK	NONE
		920	TOTAL	1/29/91 AW
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	40	OK	NONE
		1460	TOTAL	1/30/91 AW
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
		1860	TOTAL	1/31/91 AW

SWS ENDURANCE TEST REPORT

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

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

SWS ENDURANCE TEST REPORT

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

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
LC 86J136002	7.62	60	OK	NONE
	7.62	60	OK	-NONE
	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	60	OK	NONE
	7.62	40	OK	NONE
		4140	TOTAL 2/5/91	R.B.
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	60	OK	NONE
		4500	TOTAL 2/6/91 AW	
Test + Target 2/6/91 IF				
		60	TEST & TGT	
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	100	OK	NONE
	7.62	80	OK	NONE
		4940	TOTAL 2/7/91 AW	
Test + Target 60 Rds 2/7/91 IF				
		5000	RDS 2-8-91	

SWS ENDURANCE TEST REPORT

 SERIAL NO. C6594488 SHOOTER AW DATE 2/13

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

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06594488
24 Jan 1991

0 ROUNDS

CENTROIDAL DISTANCES

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

1
32

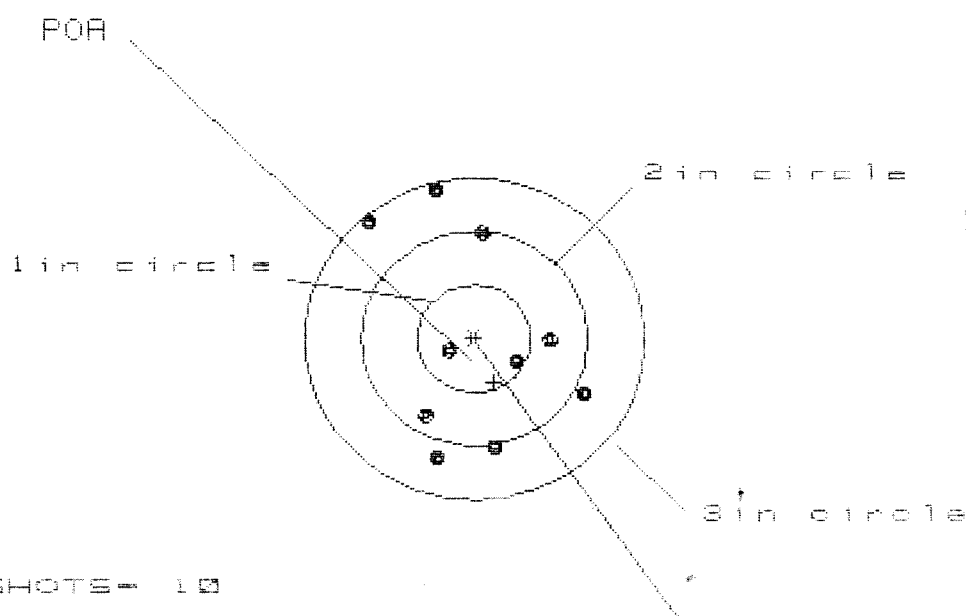
-----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0886
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0428
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0983961
THE AMR FOR THIS RIFLE IS: .8898

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8534488

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 5

3 in = 10

HS= 1.897

VS= 2.581

GS= 2.582

CENTROID #

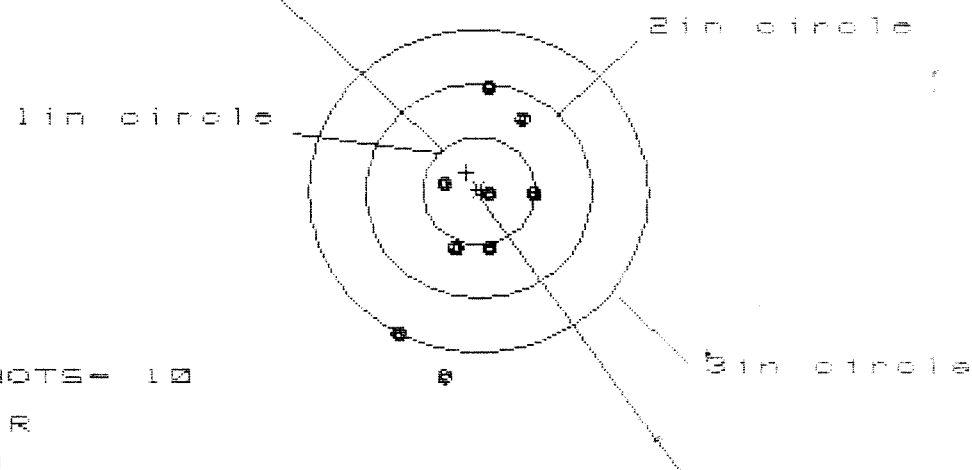
PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.958	.918	.795
MINIMUM X	-.939	-.979	-.564
MAXIMUM Y	1.437	1.283	1.356
MINIMUM Y	-1.144	-.985	-.824
CENTROID X	-.168	-.128	-.085
CENTROID Y	.409	.250	.089
POA TO CENTROID in.	.442	.280	.089
MIN RADIUS	.241	.261	.227
MEAN RADIUS	.932	.839	.710
MAX RADIUS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

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/065344B8

CENTERFIRE PATTERNS # 2

POA



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 8

HS= 1.141

VS= 4.096

GS= 4.143

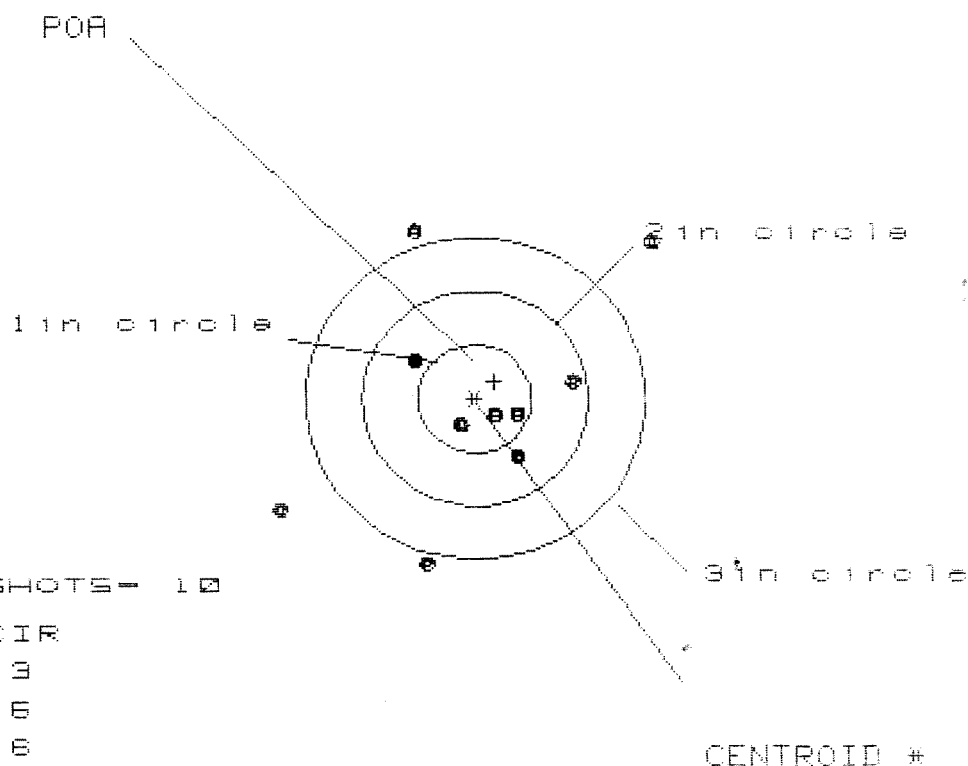
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.439	.478	.449
MINIMUM X	:	-.703	-.663	-.692
MAXIMUM Y	:	2.417	1.258	1.082
MINIMUM Y	:	-1.679	-1.411	-1.217
CENTROID X	:	.112	.072	.101
CENTROID Y	:	-.171	-.439	-.263
POA TO CENTROID in.	:	.204	.445	.282
MIN RADIUS	:	.112	.272	.128
MEAN RADIUS	:	.946	.765	.660
MAX RADIUS	:	2.442	1.430	1.400
HORIZONTAL SPREAD	:	1.141	1.141	1.141
VERTICAL SPREAD	:	4.096	2.669	2.299
EXTREME SPREAD	:	4.143	2.691	2.427
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		8	

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06534488

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 6

HS= 3.278

VS= 3.068

GS= 4.092

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.545	1.044	.848
MINIMUM X	:	-1.733	-1.561	-.561
MAXIMUM Y	:	1.548	1.710	1.687
MINIMUM Y	:	-1.520	-1.358	-1.461
CENTROID X	:	-.168	-.340	-.144
CENTROID Y	:	-.161	-.323	-.220
POA TO CENTROID in.	:	.232	.469	.263
MIN RADIUS	:	.236	.104	.176
MEAN RADIUS	:	1.032	.913	.758
MAX RADIUS	:	2.125	1.767	1.702
HORIZONTAL SPREAD	:	3.278	2.605	1.489
VERTICAL SPREAD	:	3.068	3.068	3.068
EXTREME SPREAD	:	4.092	3.070	3.070
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		6	

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8534488

CENTERFIRE PATTERNS

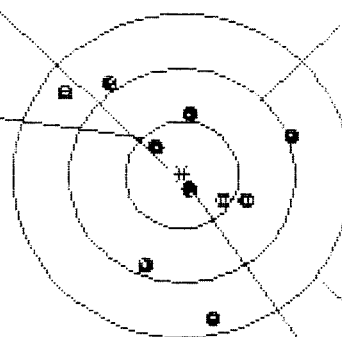
4

POA

1 in circle

2 in circle

3 in circle



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

HS= 1.937

VS= 2.243

GS= 2.458

CENTROID #

PATTERN #

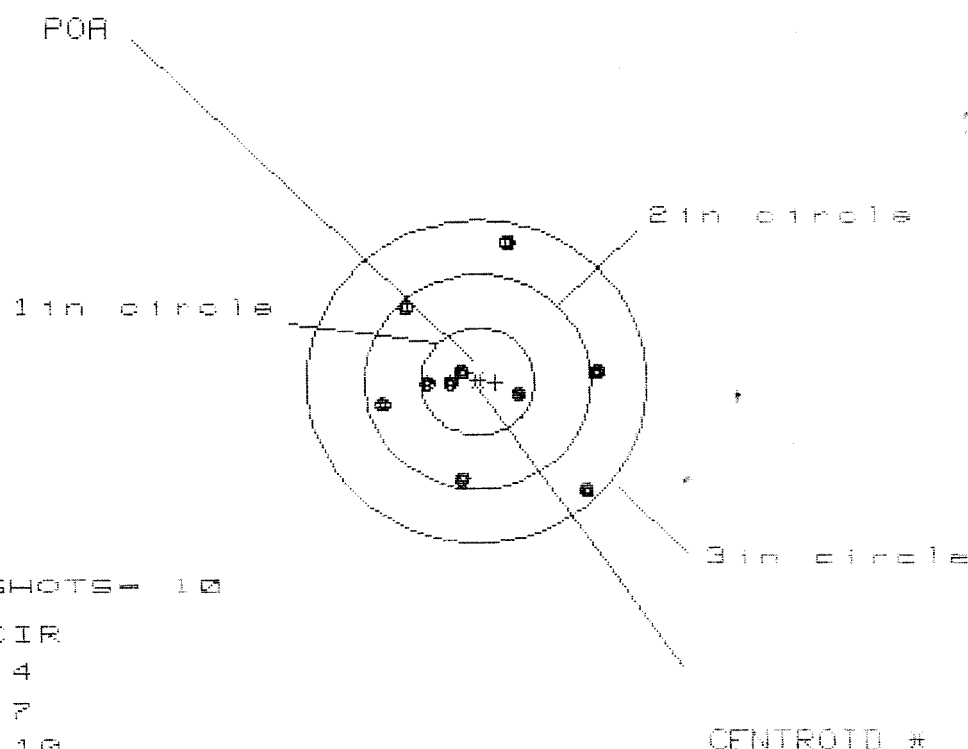
4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.912	.940	.815
MINIMUM X	:	-1.025	-.997	-.728
MAXIMUM Y	:	.882	.731	.805
MINIMUM Y	:	-1.361	-1.006	-.932
CENTROID X	:	-.062	-.090	.035
CENTROID Y	:	.128	.279	.205
POA TO CENTROID in.	:	.142	.293	.208
MIN RADIUS	:	.136	.194	.216
MEAN RADIUS	:	.765	.693	.619
MAX RADIUS	:	1.384	1.158	1.085
HORIZONTAL SPREAD	:	1.937	1.937	1.543
VERTICAL SPREAD	:	2.243	1.737	1.737
EXTREME SPREAD	:	2.458	1.970	1.766
NUMBER IN ONE INCH CIRCLE	=	3		
NUMBER IN TWO INCH CIRCLE	=	7		
NUMBER IN THREE INCH CIRCLE	=	10		

24 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594488

CENTERFIRE PATTERNS # 5



OF SHOTS = 10

IN CIR

1in = 4

2in = 7

3in = 10

HS = 1.881

VS = 2.333

GS = 2.441

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

NUMBER IN THREE INCH CIRCLE = 10

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594488
29 Jan 1991

500 ROUNDS

CENTROIDAL DISTANCES

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

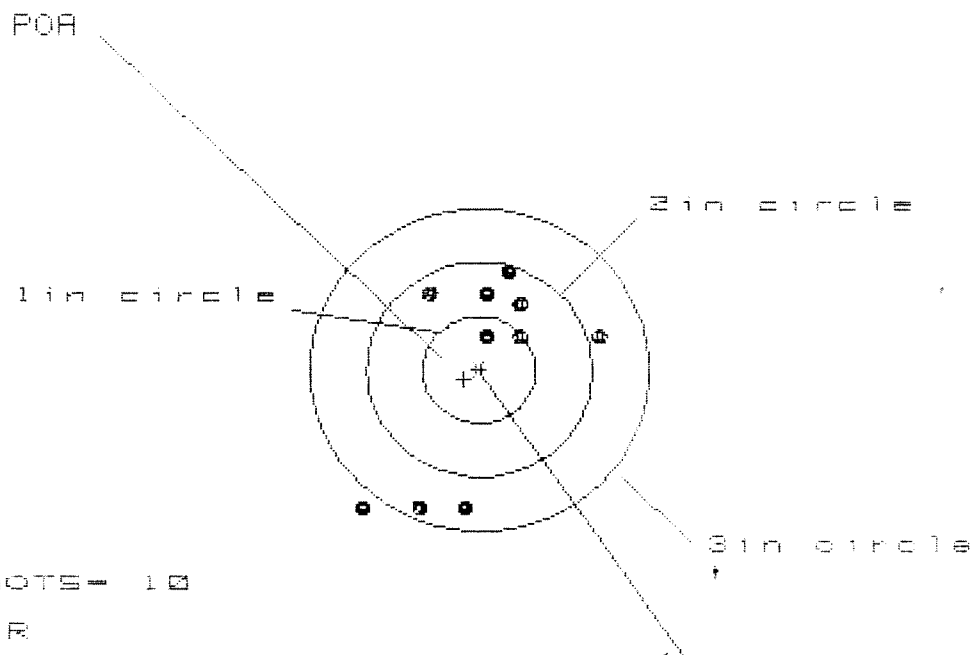
 <----POA

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

29 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C85944B8.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 9

HS= 2.126

VS= 2.231

GS= 2.640

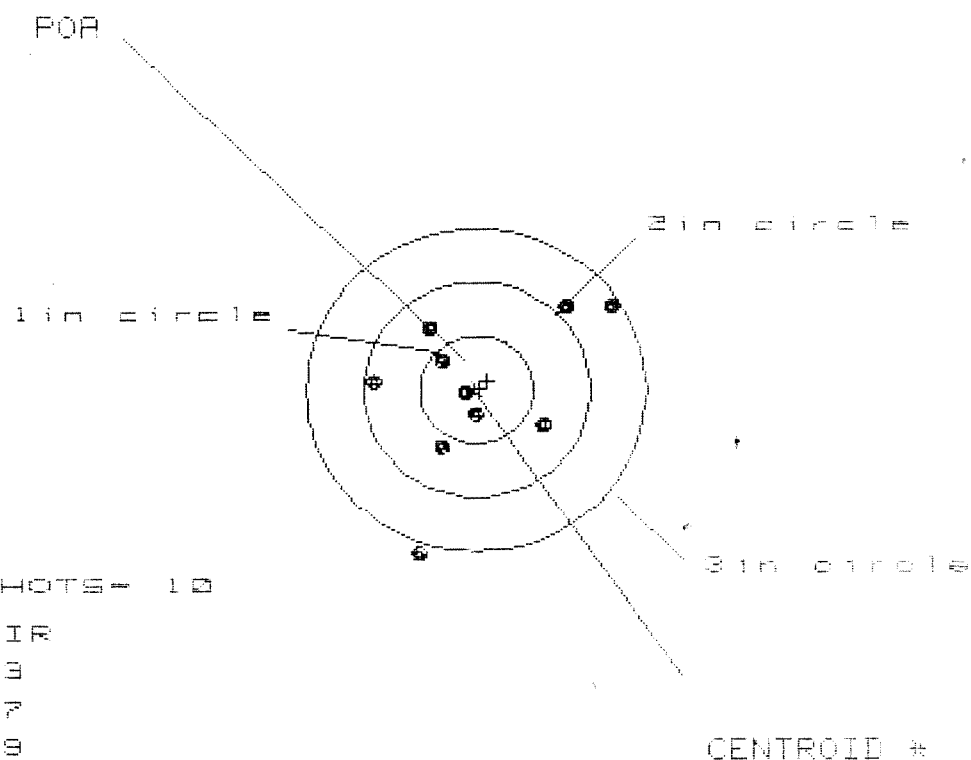
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.081	.965	.882
MINIMUM X	:	-1.044	-.669	-.595
MAXIMUM Y	:	.917	.774	.592
MINIMUM Y	:	-1.314	-1.457	-1.604
CENTROID X	:	.140	.257	.340
CENTROID Y	:	.085	.228	.410
POA TO CENTROID in.	:	.164	.343	.533
MIN RADIUS	:	.359	.205	.108
MEAN RADIUS	:	.948	.795	.601
MAX RADIUS	:	1.658	1.603	1.635
HORIZONTAL SPREAD	:	2.126	1.634	1.477
VERTICAL SPREAD	:	2.231	2.231	2.196
EXTREME SPREAD	:	2.640	2.362	2.222
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

29 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/095944B8.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HS= 2.165

VS= 2.318

GS= 2.877

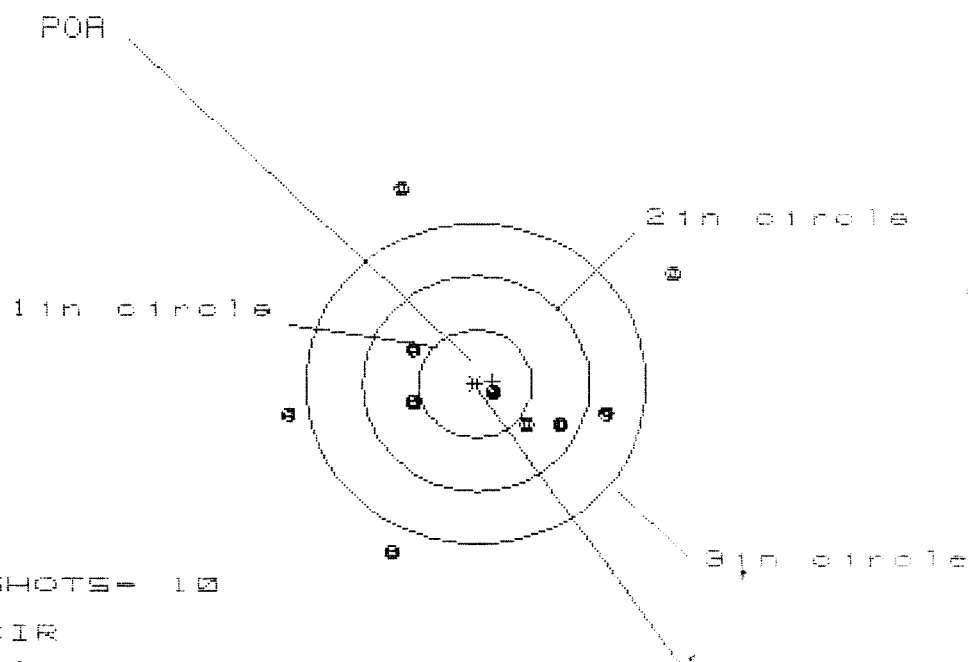
CENTROID *

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.236	1.182	.855
MINIMUM X	:	-.929	-.983	-.835
MAXIMUM Y	:	.815	.648	.727
MINIMUM Y	:	-1.503	-.731	-.652
CENTROID X	:	-.088	-.034	-.182
CENTROID Y	:	-.075	.092	.013
POA TO CENTROID in.	:	.116	.098	.182
MIN RADIUS	:	.139	.265	.113
MEAN RADIUS	:	.796	.725	.601
MAX RADIUS	:	1.580	1.341	1.122
HORIZONTAL SPREAD	:	2.165	2.165	1.690
VERTICAL SPREAD	:	2.318	1.379	1.379
EXTREME SPREAD	:	2.877	2.286	1.848
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

25 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08534488.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 6

HS= 3.386

VS= 3.455

GS= 3.632

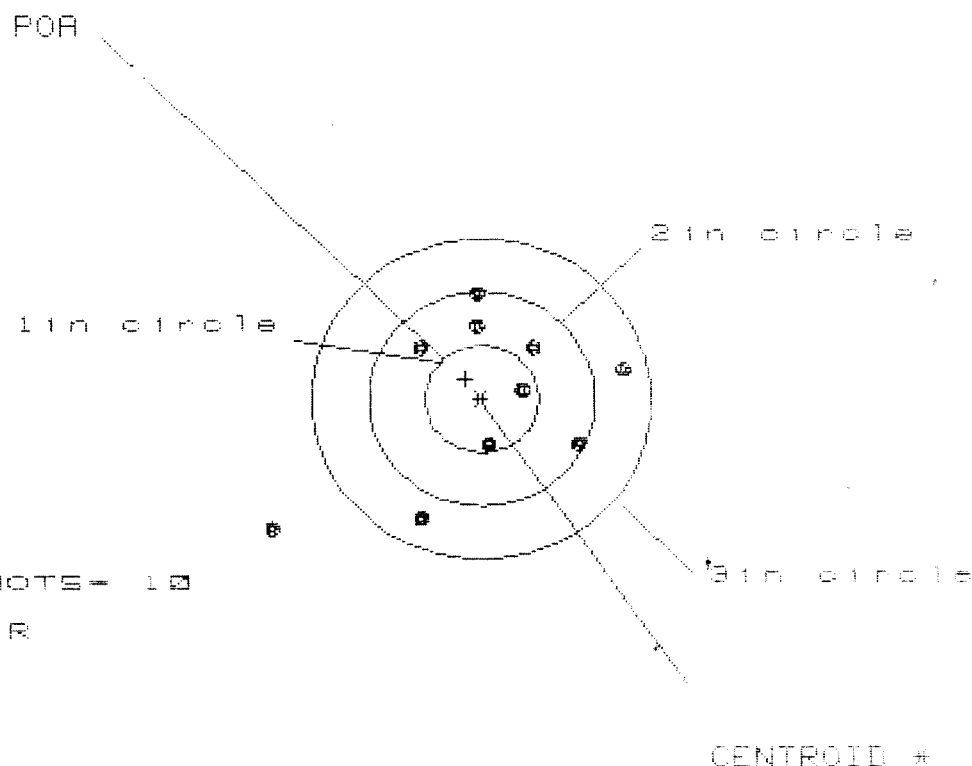
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.738	1.327	1.269
MINIMUM X	:	-1.659	-1.465	-1.523
MAXIMUM Y	:	1.856	1.965	.626
MINIMUM Y	:	-1.599	-1.490	-1.245
CENTROID X	:	-.146	-.339	-.281
CENTROID Y	:	-.022	-.131	-.376
POA TO CENTROID in.	:	.147	.363	.470
MIN RADIUS	:	.145	.297	.348
MEAN RADIUS	:	1.137	1.037	.911
MAX RADIUS	:	1.995	2.018	1.524
HORIZONTAL SPREAD	:	3.396	2.792	2.792
VERTICAL SPREAD	:	3.455	3.455	1.871
EXTREME SPREAD	:	3.632	3.457	2.793
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		6	

25 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06534468.1

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 3.039

VS = 2.167

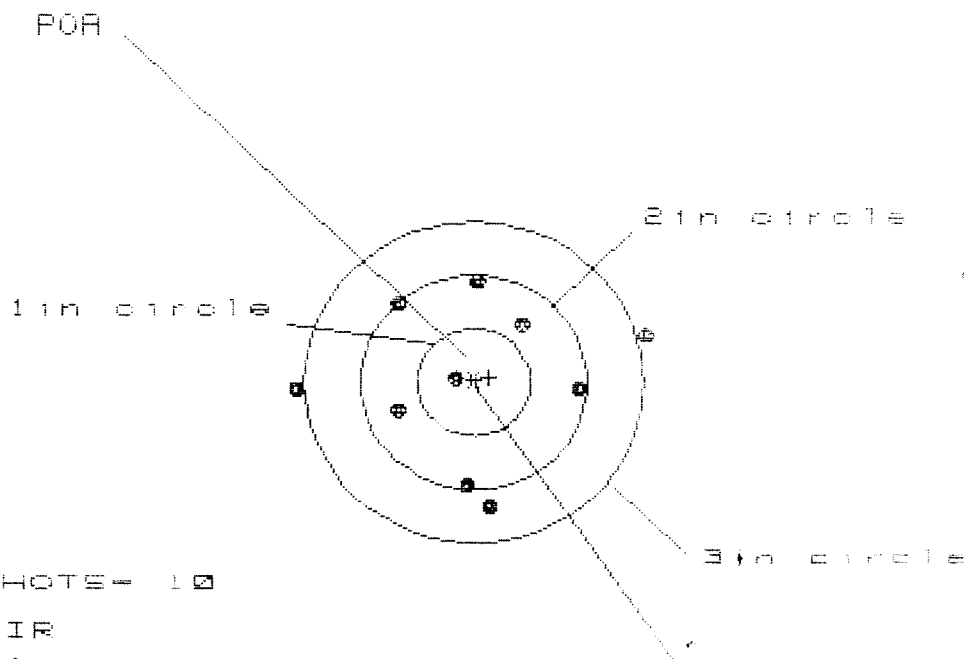
GS = 3.389

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.239	1.039	.921
MINIMUM X	:	-1.800	-.740	-.610
MAXIMUM Y	:	.978	.846	.868
MINIMUM Y	:	-1.189	-1.216	-1.194
CENTROID X	:	.144	.344	.214
CENTROID Y	:	-.182	-.050	-.072
POA TO CENTROID in.	:	.232	.348	.226
MIN RADIUS	:	.347	.126	.256
MEAN RADIUS	:	.937	.745	.716
MAX RADIUS	:	2.158	1.407	1.327
HORIZONTAL SPREAD	:	3.039	1.779	1.431
VERTICAL SPREAD	:	2.167	2.062	2.062
EXTREME SPREAD	:	3.389	2.236	2.112
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

29 Jan 1991

FILE:/PATTERNING/CENTERFIRE_PATT/085944B8.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 7

3 in = 8

HS= 3.094

VS= 2.100

GS= 3.142

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.540	1.130	.957
MINIMUM X	-1.554	-1.383	-.691
MAXIMUM Y	.890	.942	.939
MINIMUM Y	-1.210	-1.158	-1.151
CENTROID X	-.128	-.299	-.126
CENTROID Y	-.038	-.090	-.087
POA TO CENTROID in.	.134	.312	.153
MIN RADIUS	.203	.085	.217
MEAN RADIUS	.982	.890	.834
MAX RADIUS	1.609	1.383	1.168
HORIZONTAL SPREAD	3.094	2.513	1.648
VERTICAL SPREAD	2.100	2.100	2.100
EXTREME SPREAD	3.142	2.513	2.101
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	8		

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6594488
7 Feb 1991

4500 RDS

CENTROIDAL DISTANCES

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

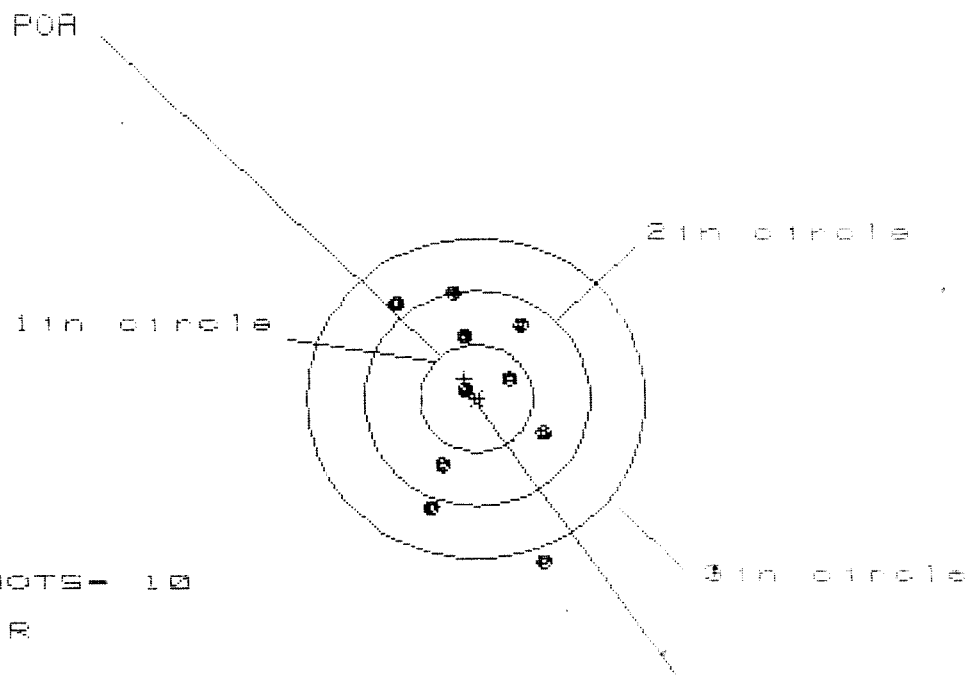
<----FOR

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

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/08594408.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 2

2in = 6

3in = 8

HS= 1.363

VS= 2.481

GS= 2.724

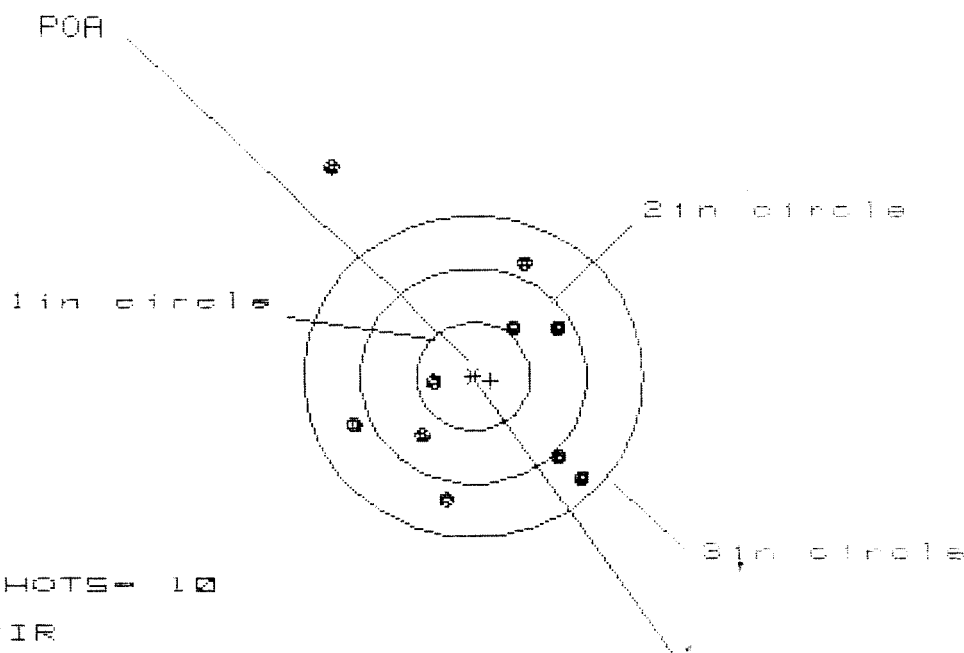
CENTROID *

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

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6594468.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 9

HS= 2.131

VS= 3.186

GS= 3.662

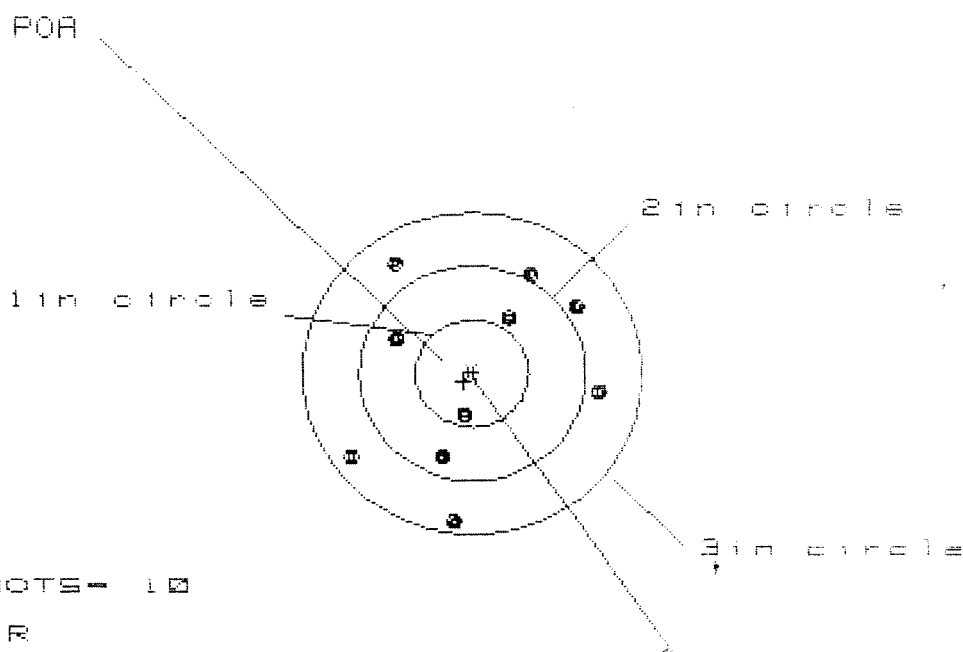
CENTROID *

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

7 Feb 1981

FILE:/PATTERNING/CENTERFIRE_PATT/C6594468.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 4

3 in = 10

HS= 2.156

VS= 2.427

GS= 2.487

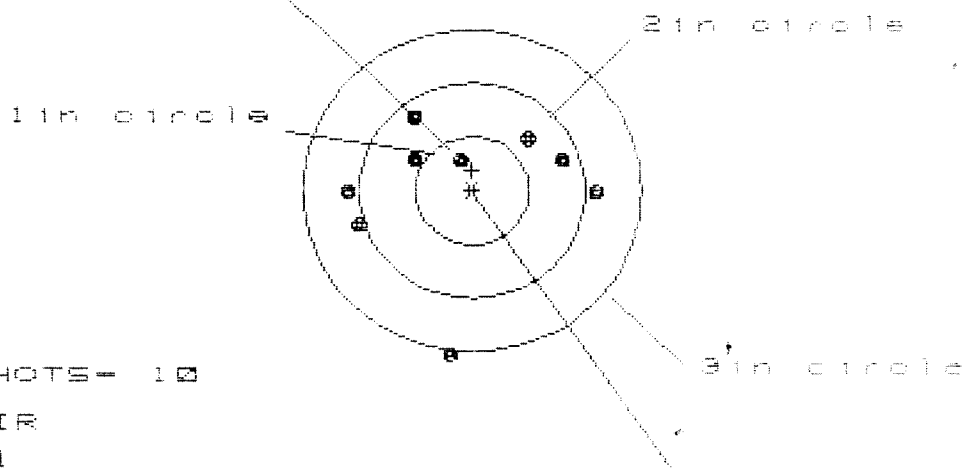
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.108	1.089	.956
MINIMUM X	:	-1.048	-1.067	-.863
MAXIMUM Y	:	1.030	.875	.753
MINIMUM Y	:	-1.397	-.972	-1.016
CENTROID X	:	.076	.095	.228
CENTROID Y	:	.077	.232	.354
POA TO CENTROID in.	:	.108	.251	.421
MIN RADIUS	:	.339	.495	.341
MEAN RADIUS	:	.982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

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/06594488.1.1

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1in = 1

2in = 5

3in = 9

HS= 2.274

VS= 2.216

GS= 2.274

CENTROID #

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.128	1.107	.961
MINIMUM X	:	-1.146	-1.167	-1.181
MAXIMUM Y	:	.653	.479	.451
MINIMUM Y	:	-1.563	-.502	-.530
CENTROID X	:	.005	.026	.172
CENTROID Y	:	-.183	-.009	.019
POA TO CENTROID in.	:	.183	.027	.173
MIN RADIUS	:	.264	.135	.264
MEAN RADIUS	:	.914	.799	.744
MAX RADIUS	:	1.574	1.188	1.294
HORIZONTAL SPREAD	:	2.274	2.274	2.142
VERTICAL SPREAD	:	2.216	.981	.981
EXTREME SPREAD	:	2.274	2.274	2.165
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		9	

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C65944B8.1.1

CENTERFIRE PATTERNS # 5

POA

1 in circle

2 in circle

3 in circle

CENTROID #

OF SHOTS = 10

IN CIR

1 in = 1

2 in = 4

3 in = 6

HS = 2.971

VS = 3.326

GS = 3.921

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.486	1.321	1.374
MINIMUM X	:	-1.485	-1.354	-1.361
MAXIMUM Y	:	1.772	1.599	1.179
MINIMUM Y	:	-1.554	-1.413	-1.213
CENTROID X	:	-.061	.104	.051
CENTROID Y	:	.014	.187	-.013
POA TO CENTROID in.	:	.062	.214	.053
MIN RADIUS	:	.436	.454	.416
MEAN RADIUS	:	1.249	1.148	1.052
MAX RADIUS	:	2.150	1.655	1.515
HORIZONTAL SPREAD	:	2.971	2.675	2.675
VERTICAL SPREAD	:	3.326	3.012	2.392
EXTREME SPREAD	:	3.921	3.028	2.809
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		6	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06594488
8 Feb 1991

5000 RDS

CENTROIDAL DISTANCES

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

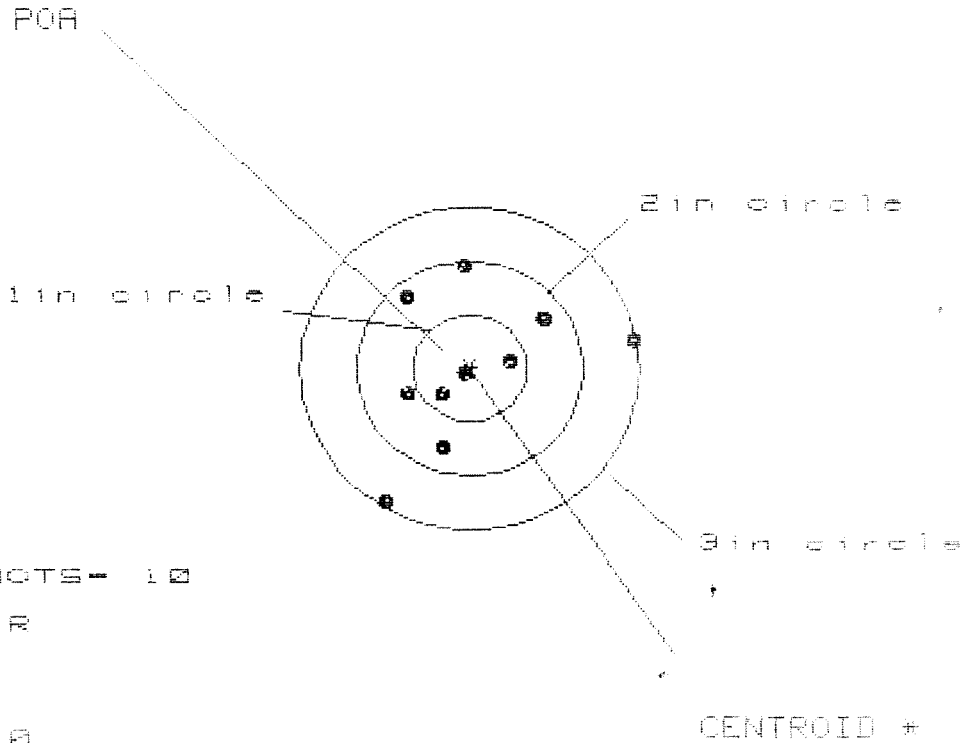
5 <----POB

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0568
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0642
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0657198
THE AMR FOR THIS RIFLE IS: .7922

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C65944B9.1.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 8

3in = 10

HS= 2.146

VS= 2.173

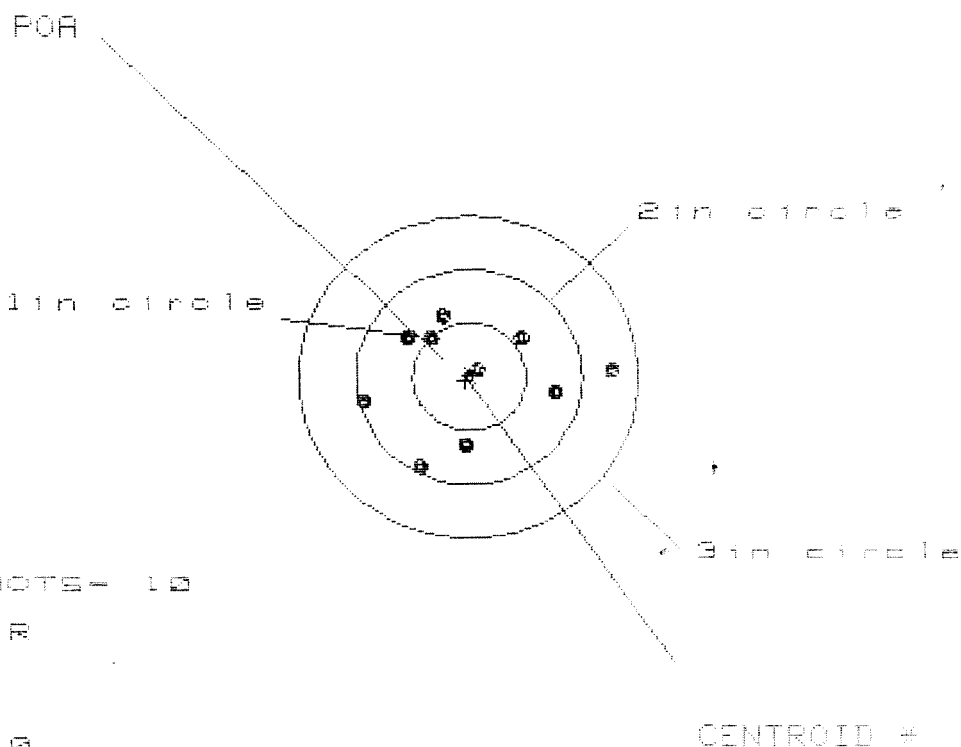
GS= 2.580

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.423	.805	.735
MINIMUM X	:	-.723	-.565	-.497
MAXIMUM Y	:	.987	1.015	.870
MINIMUM Y	:	-1.186	-1.158	-.890
CENTROID X	:	.048	-.110	-.040
CENTROID Y	:	.035	.007	.152
POA TO CENTROID in.	:	.059	.111	.157
MIN RADIUS	:	.048	.113	.125
MEAN RADIUS	:	.767	.682	.611
MAX RADIUS	:	1.445	1.289	.910
HORIZONTAL SPREAD	:	2.146	1.370	1.232
VERTICAL SPREAD	:	2.173	2.173	1.760
EXTREME SPREAD	:	2.580	2.283	1.778
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		10	

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8534488.1.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 10

HS= 2.242

VS= 1.406

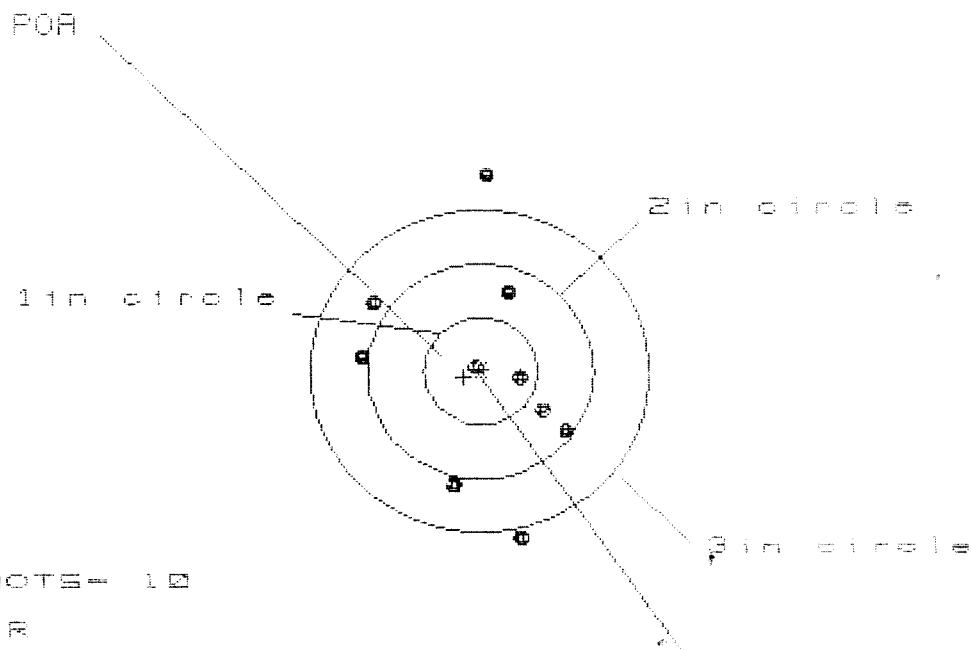
GS= 2.256

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

7 Feb 1981

FILE/PATTERNING/CENTERFIRE_PATT/C8534468.1.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 5

3in = 8

HS= 1.859

VS= 3.362

GS= 3.371

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.765	.773	.815
MINIMUM X	:	-1.094	-1.086	-1.044
MAXIMUM Y	:	1.849	.996	.833
MINIMUM Y	:	-1.513	-1.308	-1.030
CENTROID X	:	.149	.141	.099
CENTROID Y	:	.057	-.148	.015
POA TO CENTROID in.	:	.160	.204	.100
MIN RADIUS	:	.063	.243	.075
MEAN RADIUS	:	.952	.858	.772
MAX RADIUS	:	1.851	1.350	1.097
HORIZONTAL SPREAD	:	1.859	1.859	1.859
VERTICAL SPREAD	:	3.362	2.304	1.863
EXTREME SPREAD	:	3.371	2.470	2.049
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		5	
NUMBER IN THREE INCH CIRCLE	=		8	

7 Feb 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8594488.1.1.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

CENTROID *

OF SHOTS- 10

IN CIR

1in = 5

2in = 5

3in = 9

HS= 2.114

VS= 2.843

GS= 2.852

PATTERN #

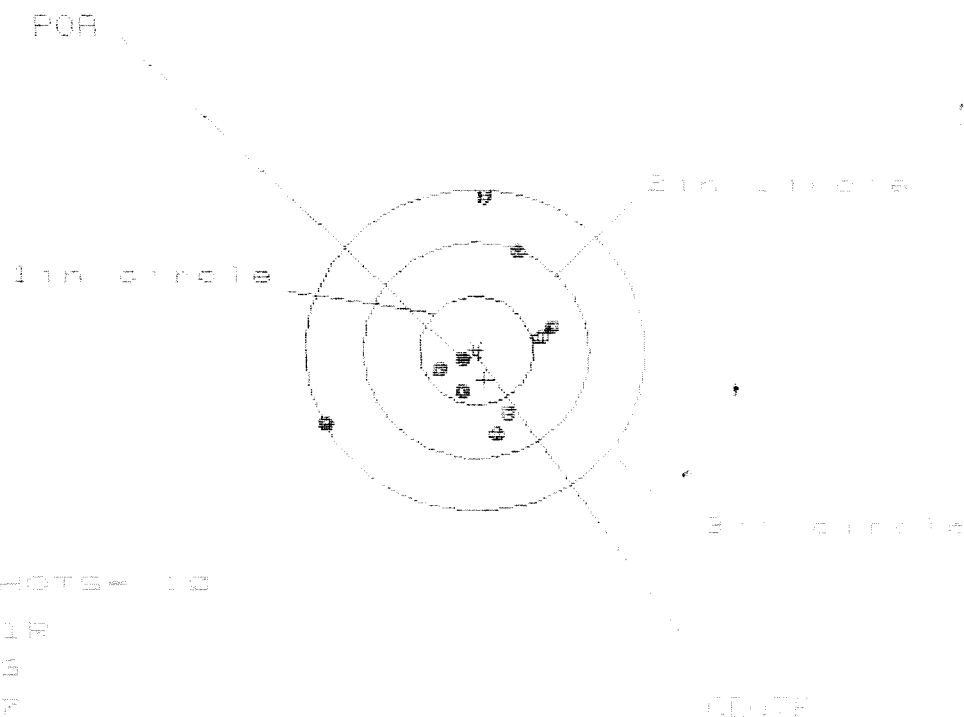
4

SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.091	1.081	1.042
MINIMUM X	:	-1.023	-1.033	-1.072
MAXIMUM Y	:	1.607	.604	.472
MINIMUM Y	:	-1.236	-1.057	-.917
CENTROID X	:	.117	.127	.166
CENTROID Y	:	-.078	-.257	-.125
POA TO CENTROID in.	:	.141	.286	.208
MIN RADIUS	:	.113	.171	.177
MEAN RADIUS	:	.773	.699	.621
MAX RADIUS	:	1.609	1.196	1.172
HORIZONTAL SPREAD	:	2.114	2.114	2.114
VERTICAL SPREAD	:	2.843	1.661	1.389
EXTREME SPREAD	:	2.852	2.253	2.253
NUMBER IN ONE INCH CIRCLE	=	5		
NUMBER IN TWO INCH CIRCLE	=	5		
NUMBER IN THREE INCH CIRCLE	=		9	

7 FEB 1963

FILE:XPATTERNING/CENTERFIRE_PATT/C6594468.1.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 7

3 in = 10

RS= 1.966

VS= 2.233

GS= 2.543

PATTERN #	:	5		
SHOTS BEET OF	:	10	9	8
MAXIMUM X	:	1.657	1.512	1.498
MINIMUM X	:	-1.388	-1.512	-1.520
MAXIMUM Y	:	1.471	1.393	1.04
MINIMUM Y	:	-1.762	-1.840	-1.608
CENTROID X	:	-1.069	.076	.091
CENTROID Y	:	.275	.353	.178
POA TO CENTROID (in.)	:	.284	.361	.201
MIN RADIUS	:	.171	.336	.311
MEAN RADIUS	:	.755	.681	.552
MAX RADIUS	:	1.482	1.399	1.064
HORIZONTAL SPREAD	:	1.966	1.924	1.924
VERTICAL SPREAD	:	2.233	2.233	1.713
EXTREME SPREAD	:	2.543	2.236	1.726
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

QP 0041

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

MAGNETIC PARTICLE INSPECTION

PART NUMBER _____

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

OPERATION NUMBER 615

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

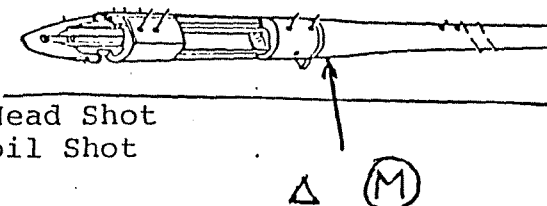
SKETCH AND/OR REMARKS

NON-FLUORSECENT
CONTINUOUS WET

FLUORESCENT :
CONTINUOUS WET Yes

Yes (2 Overlapping)

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



NON-FLUORESCENT
RESIDUAL WET

FLUORESCENT
RESIDUAL WET

APPROVAL:

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

STAMPING

STEEL STAMP ON. Triangular stamp (Δ) and letter "M" circled

OTHER Location-right side near Receiver.

ACCEPTANCE STANDARD

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

PROCEDURE:

1. All parts must be cleaned before testing.
2. All parts shall be satisfactorily demagnetized after all magnetization has been completed.
3. The magnetic substance shall be completely removed from all parts after inspection and demagnetization.
4. All accepted parts must be marked with a 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. *Karl C. Rice*
INSP. *8158-3096*

FORM QP-0041-1

"B" Stamp

M2400066423

Endurance B/A- M-24 SWS

QP 0041 #C 659 44 88

Rounds

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