

C6611562

MODEL 700™ M24

Model **SAS**™

Action

Barrel Length

Capacity

Order No. **5715**

*Includes 1 in chamber.

Remington

Arms Services Repair & Estimate System

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

Repair Inquiry

Repair Number: **RE00127549** Serial: C6611562 Model M24 SWS Center Fire Repairman: _____
 Verify Repair Status: New 4/3/2007 7:02:26 AM

Address Information

Customer: ☒ Received From Return To: ☐ Received From

Name: **RAMON VELAZQUEZ STTD** **RAMON VELAZQUEZ STTD**

Address 1: **1401 ARTILLERY CIRCLE** **1401 ARTILLERY CIRCLE**

Address 2: **ATTN: SUPPLY BLDG 978** PO Box: **ATTN: SUPPLY BLDG 978** PO Box: _____

City: **FT LEONARD WOOD** **FT LEONARD WOOD**

State: **MO** Zip Code: **65473** Country: **US** State: **MO** Zip Code: **65473** Country: **US**

FFL: _____

Contact / Condition	Problems	Estimate	History / Status	Shipping / Billing																		
Contact Information Phone: 573 596 3420 Fax: _____ Email: _____ Comments: _____	Received Condition Fair Condition Notes: _____ CSR Notes: _____	Accessories Received <table border="1"> <thead> <tr> <th>Code</th> <th>Desc</th> <th>Qty</th> </tr> </thead> <tbody> <tr> <td>A007</td> <td>With Stud</td> <td>3</td> </tr> <tr> <td>A010</td> <td>Hard Case</td> <td>1</td> </tr> <tr> <td>A017</td> <td>Scope Base</td> <td>1</td> </tr> <tr> <td>A045</td> <td>Bi Pod</td> <td>1</td> </tr> <tr> <td>A057</td> <td>Fit and Rear Sgt Base</td> <td>2</td> </tr> </tbody> </table>			Code	Desc	Qty	A007	With Stud	3	A010	Hard Case	1	A017	Scope Base	1	A045	Bi Pod	1	A057	Fit and Rear Sgt Base	2
Code	Desc	Qty																				
A007	With Stud	3																				
A010	Hard Case	1																				
A017	Scope Base	1																				
A045	Bi Pod	1																				
A057	Fit and Rear Sgt Base	2																				

Repair Search | Refresh | Close

naglelj 4/3/2007 7:26 AM CAPS NUM INS SCRL

Start Microsoft Office Arms Services RAC0179-RAC... 3 Internet Ex... 7:26 AM

Serial Number: **C6611562**

Model: **M24 SWS**



RE00127549

Remington®

Factory Repair Instructions

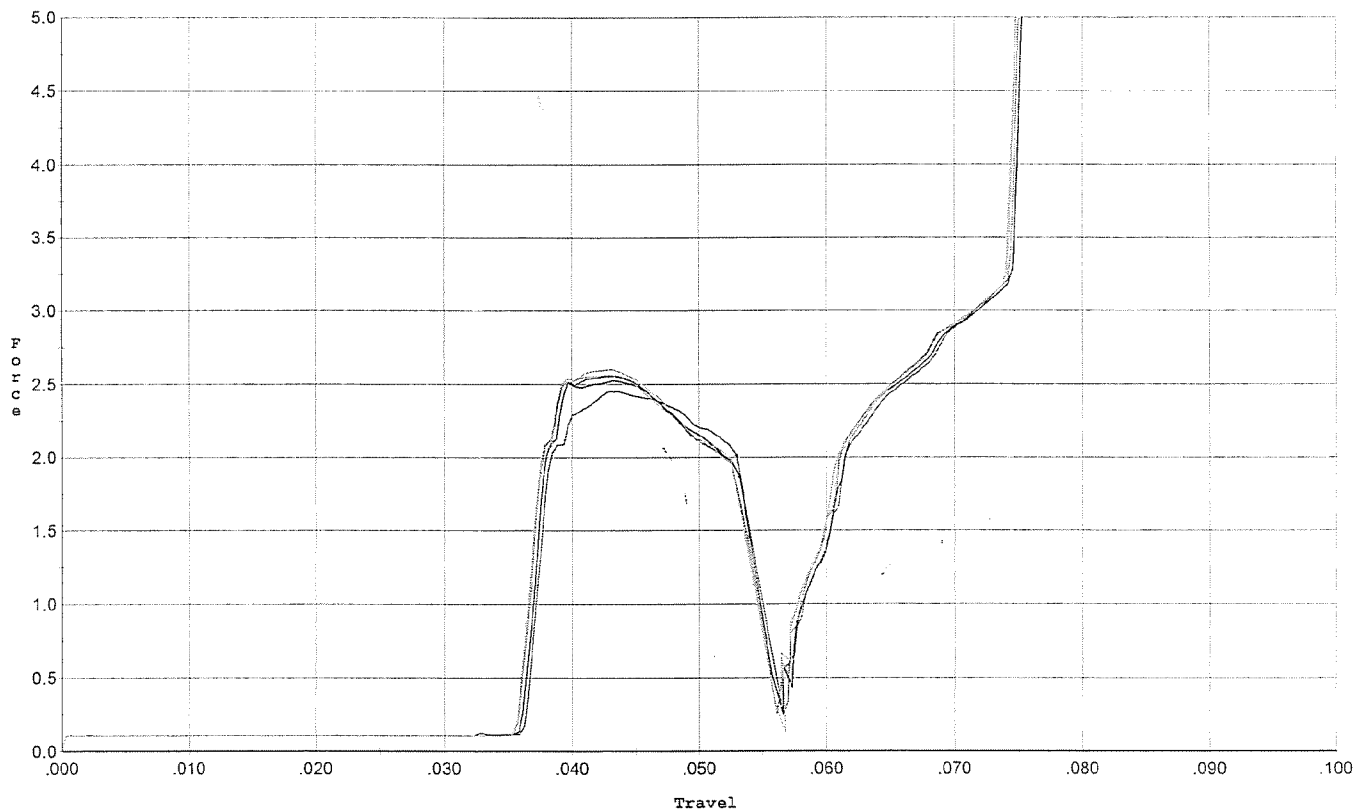
(NOTE: Please print and complete this form, and then include it with your firearm.)

Model Number: <u>M24A1</u>		Serial Number: <u>C6611562</u>	
Are you the original owner? ☒ YES ☐ NO <u>Contract# DAAE20-02-C-0149</u>			
Name: <u>US Army MPS-STTD</u>		Date of Purchase: <u>UNKNOWN</u>	
Address (no PO Boxes): <u>1401 ARTILLERY Circle</u> <u>Bldg 978</u> <u>ATTN: Ramon Velazquez</u>			
City: <u>FT. Leonard Wood</u>		State: <u>MO</u>	Zip: <u>65473</u>
Phone (Daytime): <u>(573) 596-0131 X6-390</u>		Fax: <u>(573) 596-0747</u>	
E-mail Address: ☐ I would like to receive future e-mail updates from Remington.			
Please describe your problem and date of occurrence: <u>(C6611562) x</u> <u>- Worn bolt catch / release spring</u>			
Ammunition Information:			
Manufacturer: <u>Military (Lake city)</u>		Type: <u>M118 MATCH BALL</u>	
Other (i.e. bullet weight/type, shot size, powder):			
Handload Information:			
Powder Used:		Powder Weight:	
Case/Hull Used:		Primer Used:	
Bullet Type/Shot Size:		Reloader Used:	
Firearms Care (Cleaning and Lubrication):			
Brand of cleaning solution used:			
How often do you clean the bore? (Months or Number of rounds)			
How often do you clean the action? (Months or Number of rounds)			
How often do you clean the trigger assembly? (Months or Number of rounds)			
Brand of lubricant used:			
How often do you lubricate the bore? (Months or Number of rounds)			
How often do you lubricate the action? (Months or Number of rounds)			
How often do you lubricate the trigger assembly? (Months or Number of rounds)			
Have you reviewed the cleaning and maintenance recommendations on our web site or in our owners manual? ☐ YES ☐ NO			

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/25/07

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. ini. +/- .50 lbs.



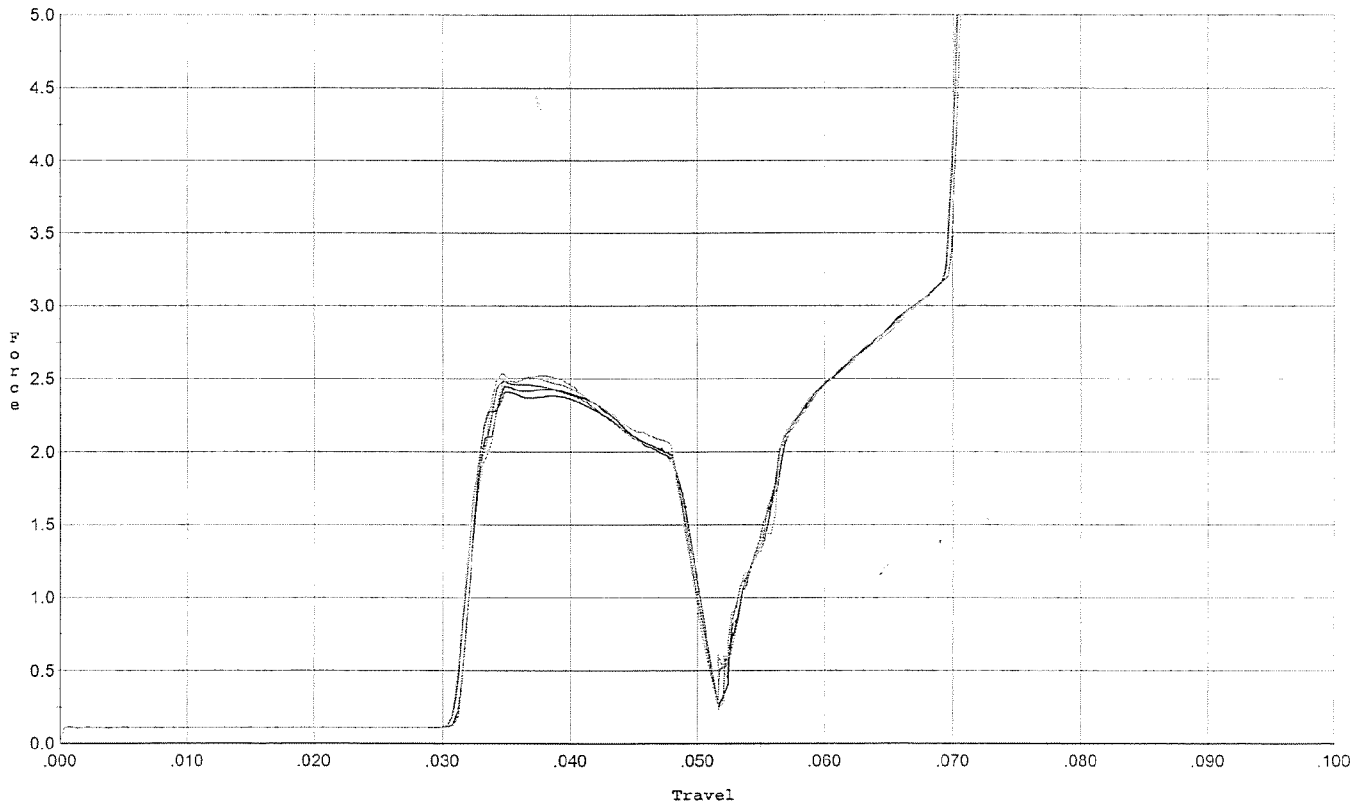
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.450	0.053	0.036	0.029	0.041		Set Trigger
2	2.524	0.053	0.036	0.029	0.042		Set Trigger
3	2.555	0.054	0.036	0.028	0.043		Set Trigger
4	2.602	0.054	0.036	0.028	0.044		Set Trigger
5	2.562	0.054	0.036	0.028	0.044		Set Trigger

Avg 2.53

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/25/07

Model: M/24
Serial No: Form #F005
Trigger: 2.5 lbs. after 50 cycles +/- .50 lbs.



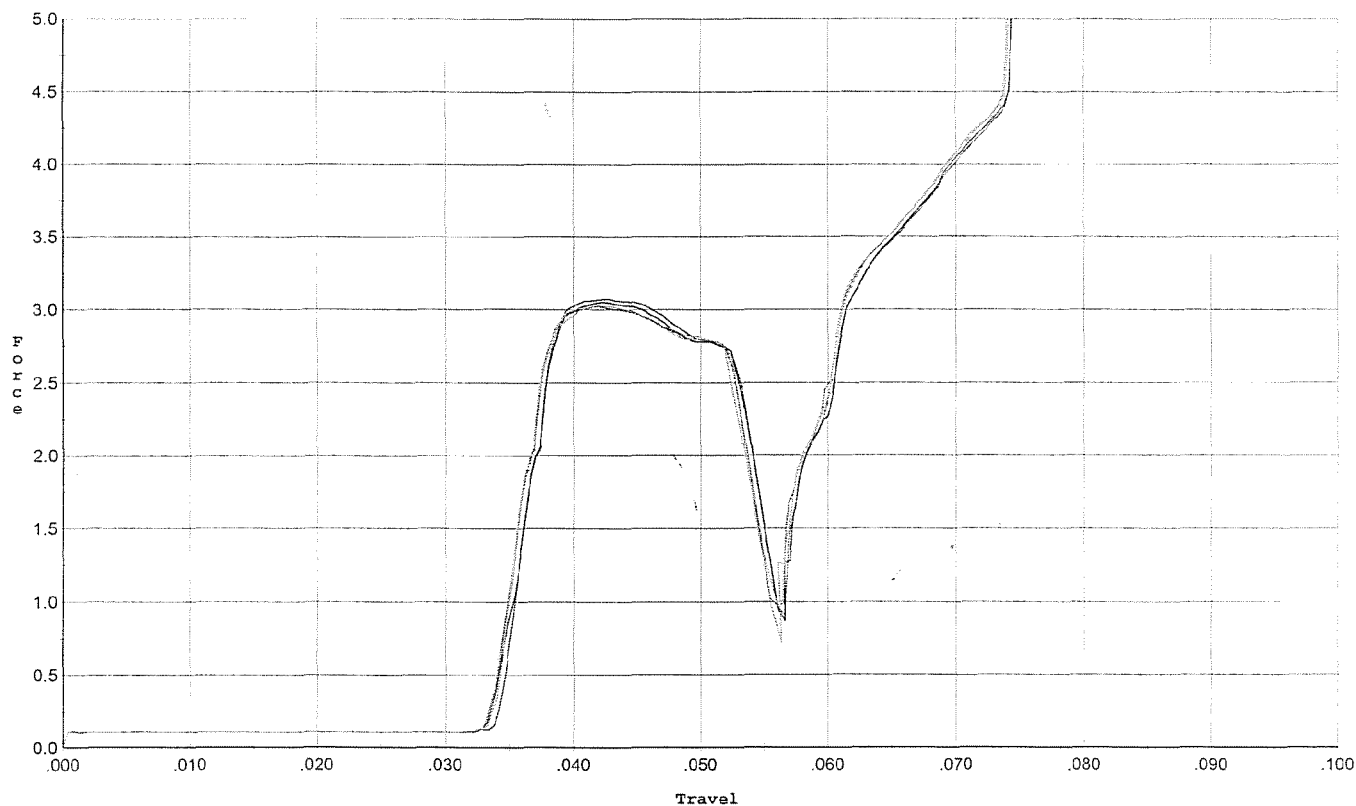
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.411	0.049	0.031	0.028	0.042		Set Trigger
2	2.447	0.049	0.031	0.029	0.042		Set Trigger
3	2.486	0.048	0.031	0.029	0.041		Set Trigger
4	2.507	0.049	0.031	0.029	0.042		Set Trigger
5	2.535	0.048	0.031	0.029	0.042		Set Trigger

Avg 2.47

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/25/07

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. ini. +/- .75 lbs.



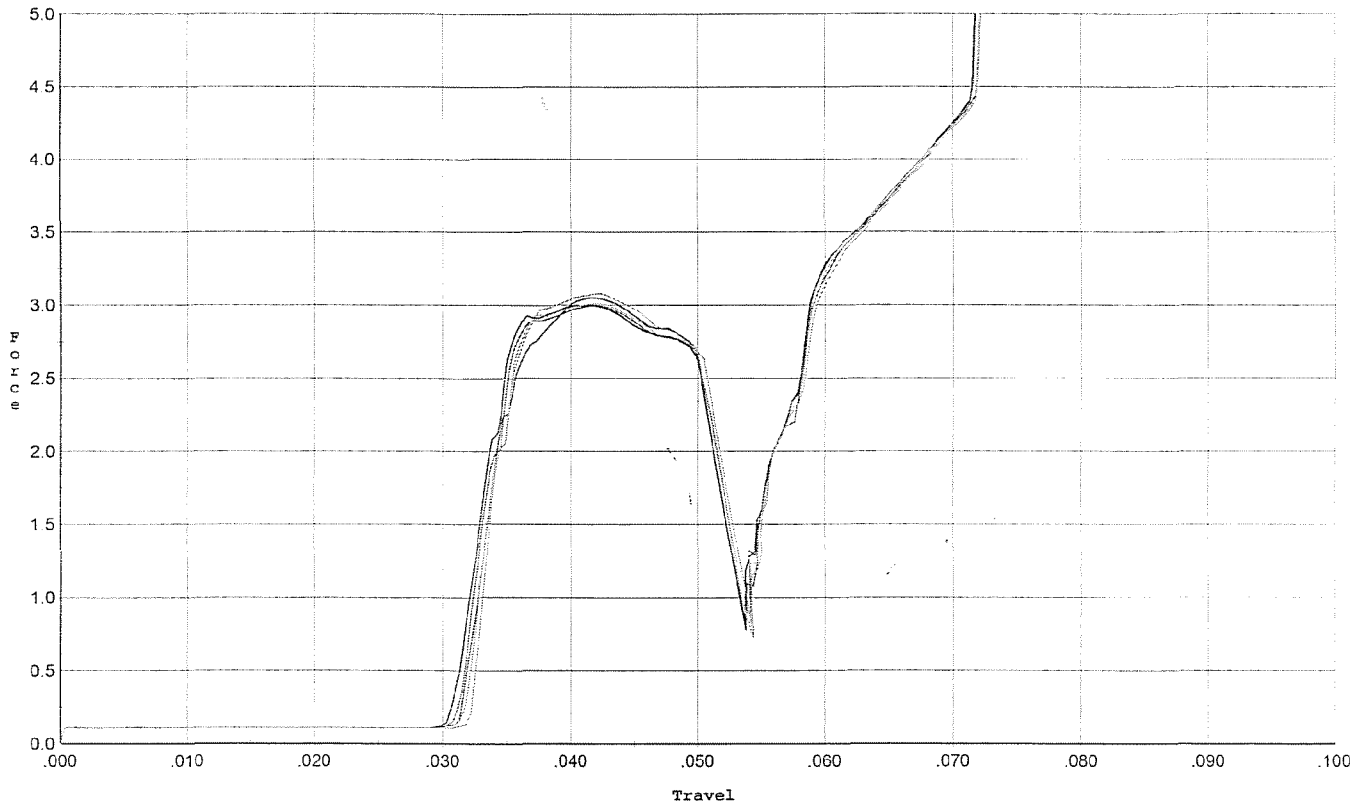
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.070	0.053	0.034	0.027	0.055		Set Trigger
2	3.050	0.053	0.034	0.027	0.055		Set Trigger
3	3.023	0.053	0.033	0.027	0.055		Set Trigger
4	3.026	0.053	0.034	0.027	0.055		Set Trigger
5	3.023	0.052	0.033	0.027	0.054		Set Trigger

Avg 3.03

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/25/07

Model: M/24
Serial No: Form #F005
Trigger: 3.0 lbs. after 20 cycles +/- .75 lbs.



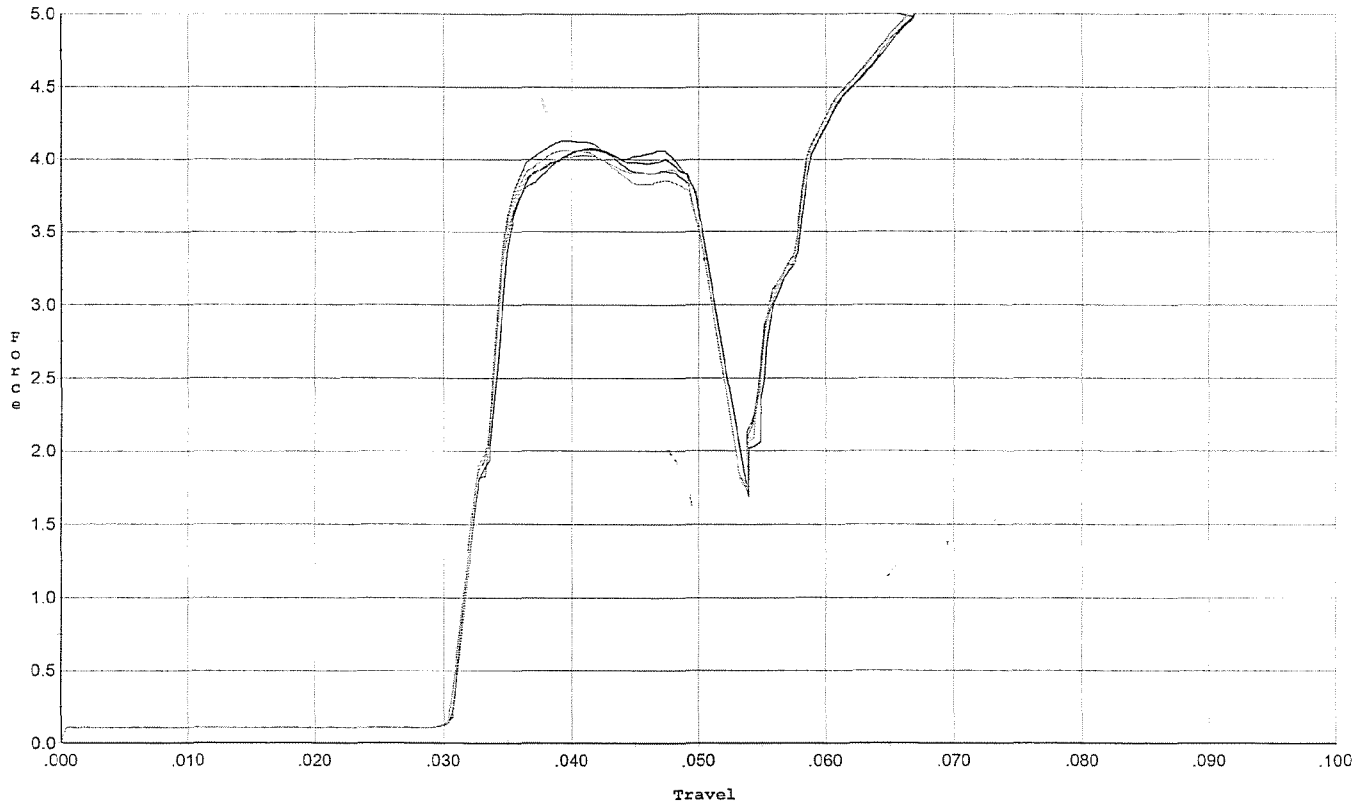
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.050	0.050	0.032	0.028	0.053		Set Trigger
2	2.999	0.050	0.031	0.027	0.054		Set Trigger
3	2.996	0.051	0.031	0.027	0.055		Set Trigger
4	3.010	0.050	0.032	0.027	0.054		Set Trigger
5	3.080	0.051	0.032	0.027	0.055		Set Trigger

Avg 3.02

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putsch 4/25/07

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. ini. +/- 1.0 lbs.



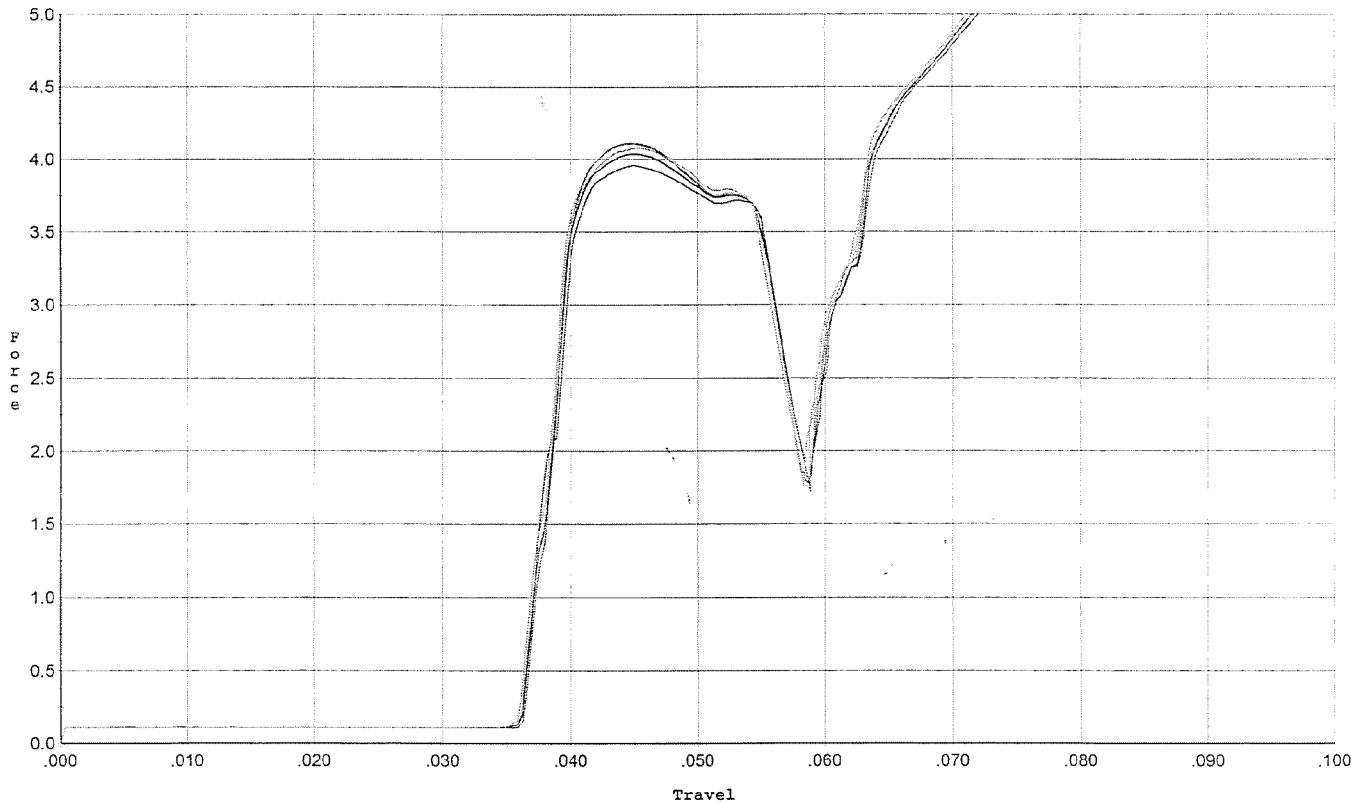
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.072	0.050	0.031	0.025	0.074		Set Trigger
2	4.077	0.050	0.031	0.025	0.073		Set Trigger
3	4.129	0.050	0.031	0.025	0.074		Set Trigger
4	4.027	0.050	0.031	0.025	0.073		Set Trigger
5	4.061	0.050	0.031	0.025	0.074		Set Trigger

AVG 4.07

Trigger Profile [lbs,inch]

Profile SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/25/07

Model: M/24
Serial No: Form #F005
Trigger: 4.0 lbs. after 20 cycles +/- 1.0 lbs.



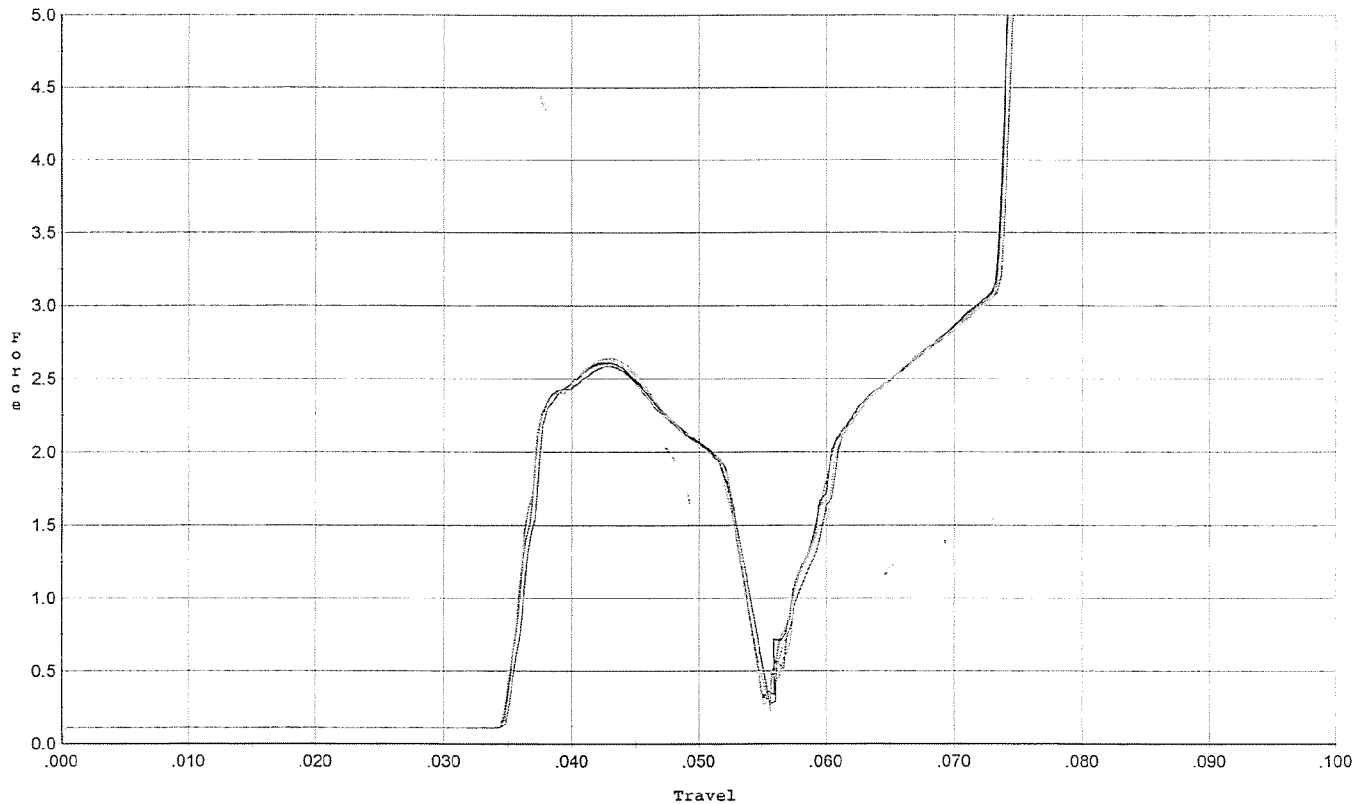
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	3.959	0.055	0.036	0.025	0.071		Set Trigger
2	4.038	0.055	0.036	0.025	0.073		Set Trigger
3	4.112	0.055	0.036	0.025	0.073		Set Trigger
4	4.082	0.056	0.036	0.025	0.073		Set Trigger
5	4.112	0.054	0.036	0.025	0.072		Set Trigger

Avg 4.06

Trigger Profile [lbs,inch]

Profile: SWS
 GunType: Rifle
 Make: Remington
 Note: R. Putch 4/25/07

Model: M/24
 Serial No: Form #F005
 Trigger: reset to 2.5 lbs. +/- .50 lbs. for final test



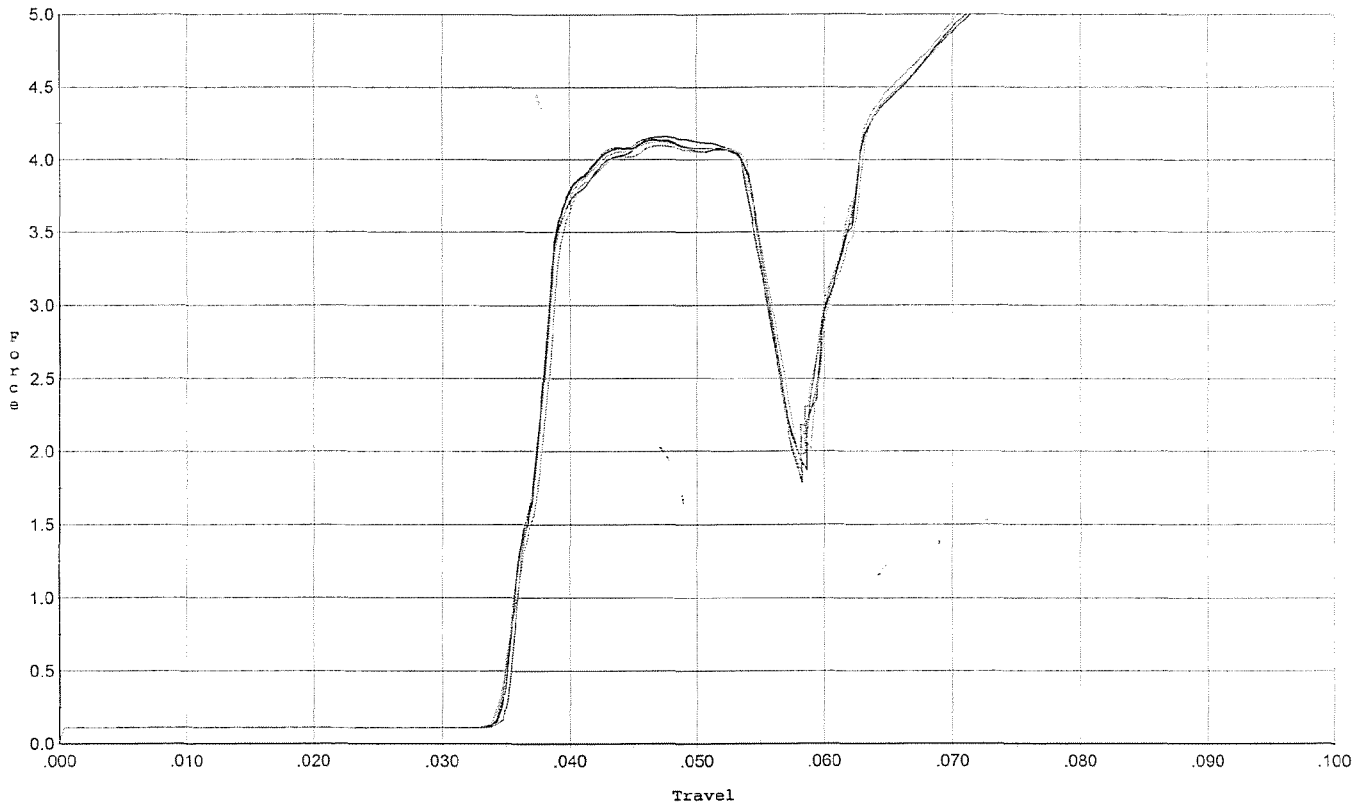
#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	2.585	0.054	0.035	0.029	0.043		Set Trigger
2	2.612	0.052	0.035	0.029	0.042		Set Trigger
3	2.605	0.052	0.035	0.029	0.042		Set Trigger
4	2.634	0.053	0.035	0.029	0.043		Set Trigger
5	2.642	0.052	0.035	0.029	0.042		Set Trigger

Avg 2.61

Trigger Profile [lbs,inch]

Profile: SWS
GunType: Rifle
Make: Remington
Note: R. Putch 4/25/07

Model: M/24
Serial No: Form #F005
Trigger: set to 4.0 lbs. +/- 1.0 lbs. for target & accuracy



#	Peak Force	Travel To Actuate	Initial Take-up	Overtravel	Energy To Actuate	Lock Time	Action Type
1	4.157	0.055	0.035	0.025	0.077		Set Trigger
2	4.134	0.054	0.035	0.025	0.076		Set Trigger
3	4.145	0.054	0.035	0.025	0.076		Set Trigger
4	4.099	0.054	0.034	0.025	0.075		Set Trigger
5	4.125	0.054	0.034	0.025	0.077		Set Trigger

Avg 4.13

SNIPER WEAPON SYSTEM - UNIQUE STATISTICAL INFORMATION

FIREARM SERIAL NUMBER / DATASET NAME: C6611562.___0

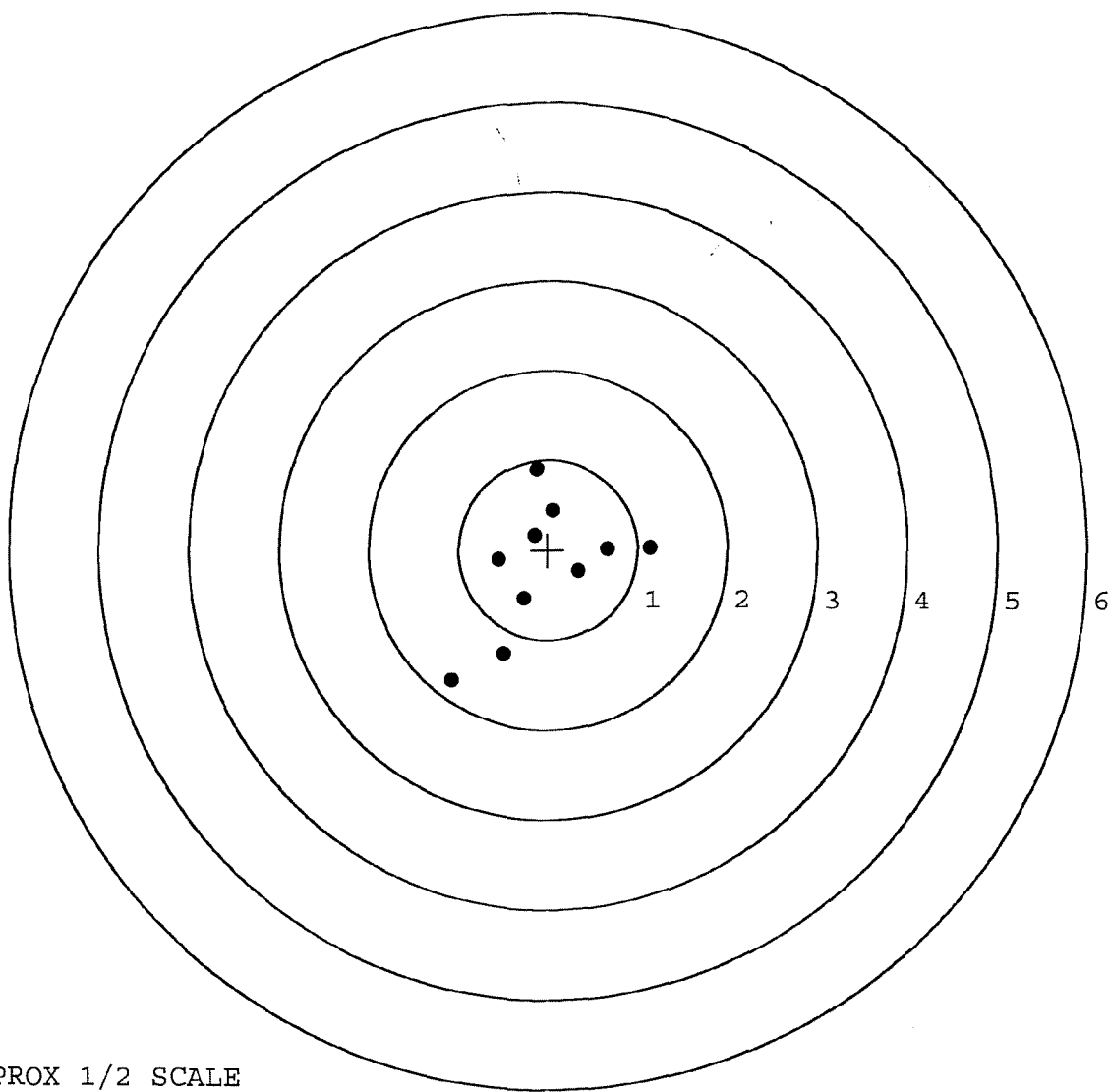
FILE DATE AND TIME: 05/15/2007 01:22

THE FOLLOWING DATA IS ALL REPORTED IN UNITS OF INCHES

The Average X Centroid of the Five Target Set:	0.009
The Average Y Centroid of the Five Target Set:	-0.106
The Average Point of Impact of the Five Target Set:	0.106
The Average Mean Radius of the Five Target Set:	0.705
The Distance from POA to Centroid Target #1:	0.201
The Distance from Centroid Target #2 to Centroid Target #1:	0.263
The Distance from Centroid Target #3 to Centroid Target #1:	0.147
The Distance from Centroid Target #4 to Centroid Target #1:	0.098
The Distance from Centroid Target #5 to Centroid Target #1:	0.180

SERIAL NUMBER: C6611562. __0
TARGET NUMBER: 1
FILE DATE: 05/15/2007
FILE TIME: 01:22

	POINT#	X	Y
	1:	-0.122	0.898
	2:	0.054	0.437
	3:	-0.147	0.165
	4:	-0.547	-0.113
	5:	-0.269	-0.534
	6:	0.340	-0.235
	7:	0.664	0.014
	8:	1.138	0.021
	9:	-0.494	-1.158
	10:	-1.080	-1.453
X CENTROID:		-0.046	
Y CENTROID:		-0.196	
POA TO CENTROID:		0.201	
HORZ SPREAD:		2.218	
VERT SPREAD:		2.351	
GROUP SPREAD:		2.663	
MIN RADIUS:		0.375	
MAX RADIUS:		1.628	
MEAN RADIUS:		0.805	
# IN 1 IN DIAMETER:		3	
# IN 2 IN DIAMETER:		6	
# in 3 IN DIAMETER:		9	

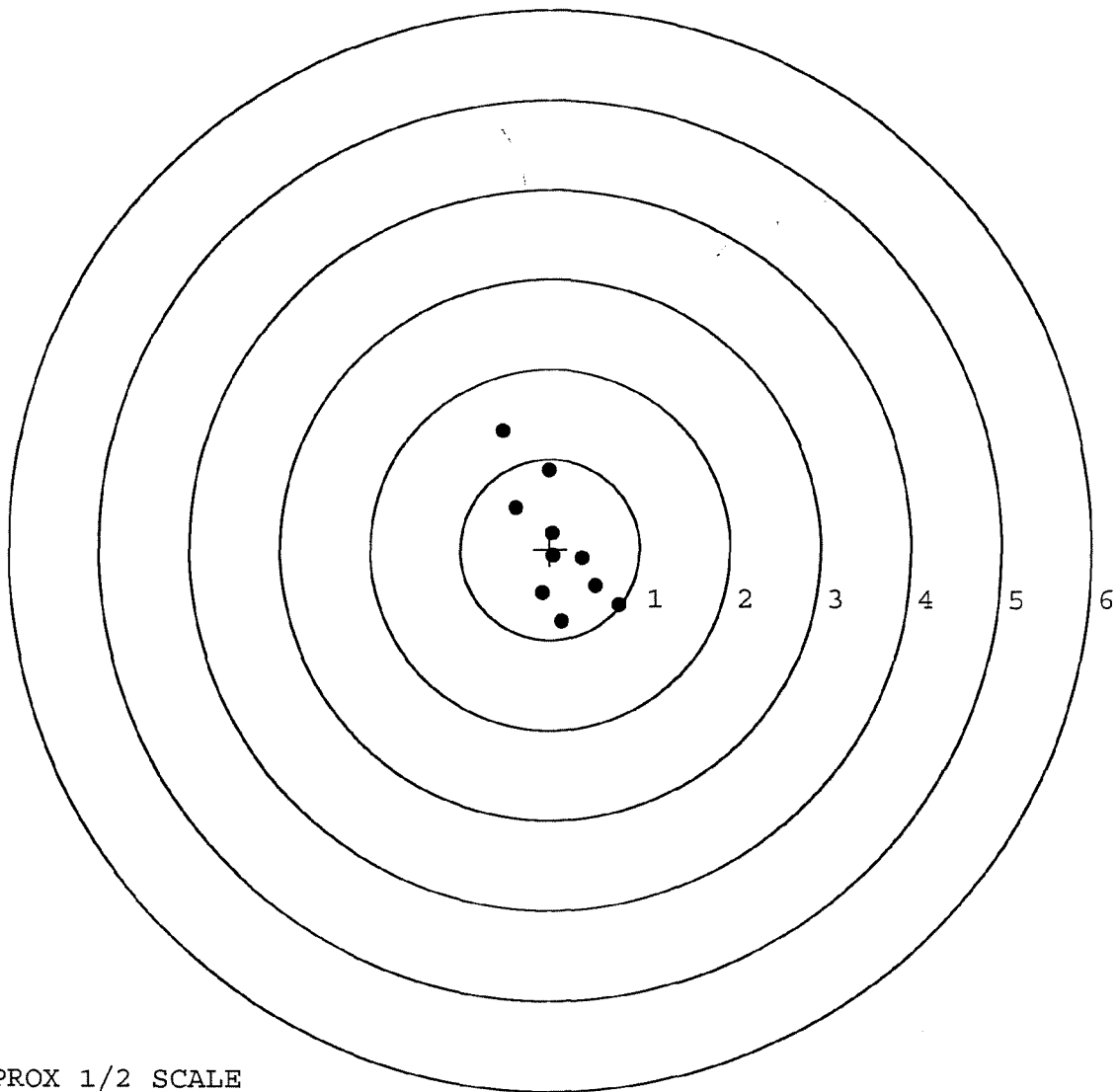


TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611562. __0
TARGET NUMBER: 2
FILE DATE: 05/15/2007
FILE TIME: 01:22

POINT#	X	Y
1:	-0.527	1.316
2:	-0.010	0.878
3:	-0.381	0.466
4:	0.031	0.178
5:	0.040	-0.079
6:	0.364	-0.103
7:	-0.085	-0.491
8:	0.509	-0.409
9:	0.133	-0.805
10:	0.772	-0.625

X CENTROID: 0.085
Y CENTROID: 0.033
POA TO CENTROID: 0.091
HORZ SPREAD: 1.299
VERT SPREAD: 2.121
GROUP SPREAD: 2.336
MIN RADIUS: 0.120
MAX RADIUS: 1.422
MEAN RADIUS: 0.645
IN 1 IN DIAMETER: 3
IN 2 IN DIAMETER: 9
in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611562. __0

TARGET NUMBER: 3

FILE DATE: 05/15/2007

FILE TIME: 01:22

POINT#	X	Y
--------	---	---

1:	0.021	-0.302
----	-------	--------

2:	-0.043	-0.871
----	--------	--------

3:	0.262	-1.397
----	-------	--------

4:	0.282	-1.622
----	-------	--------

5:	0.757	0.465
----	-------	-------

6:	0.214	0.717
----	-------	-------

7:	0.105	0.219
----	-------	-------

8:	-0.030	0.277
----	--------	-------

9:	-0.139	0.381
----	--------	-------

10:	-0.440	-0.028
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X CENTROID: 0.099

Y CENTROID: -0.216

POA TO CENTROID: 0.238

HORZ SPREAD: 1.197

VERT SPREAD: 2.339

GROUP SPREAD: 2.340

MIN RADIUS: 0.116

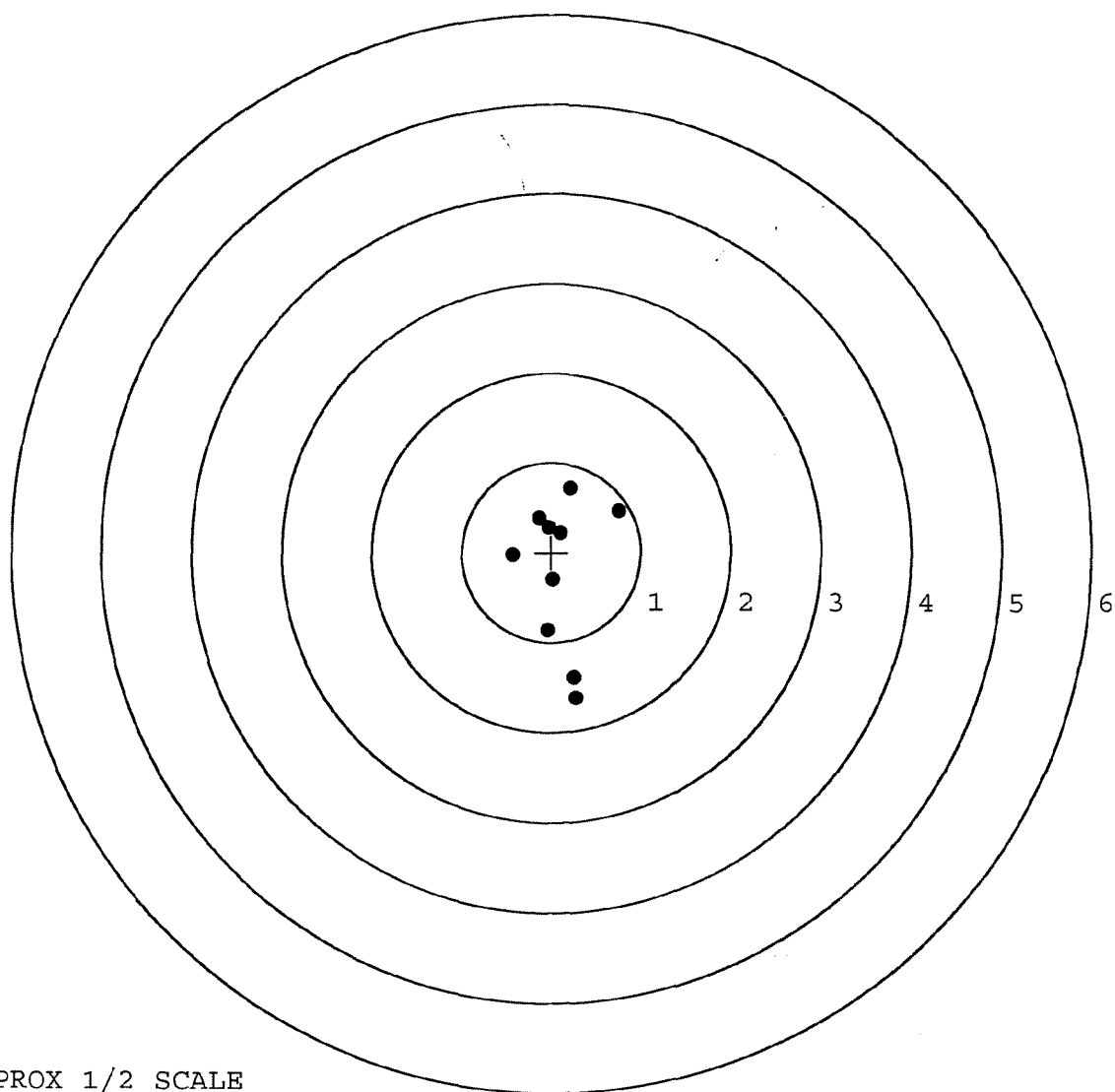
MAX RADIUS: 1.418

MEAN RADIUS: 0.744

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611562. 0

TARGET NUMBER: 4

FILE DATE: 05/15/2007

FILE TIME: 01:22

POINT#	X	Y
1:	0.212	0.987
2:	0.005	0.479
3:	0.524	0.245
4:	1.035	-0.446
5:	0.288	-0.267
6:	-0.161	-0.216
7:	0.007	-0.999
8:	-0.967	-0.156
9:	-1.031	-0.328
10:	-1.022	-0.521

X CENTROID: -0.111

Y CENTROID: -0.122

POA TO CENTROID: 0.165

HORZ SPREAD: 2.066

VERT SPREAD: 1.986

GROUP SPREAD: 2.069

MIN RADIUS: 0.106

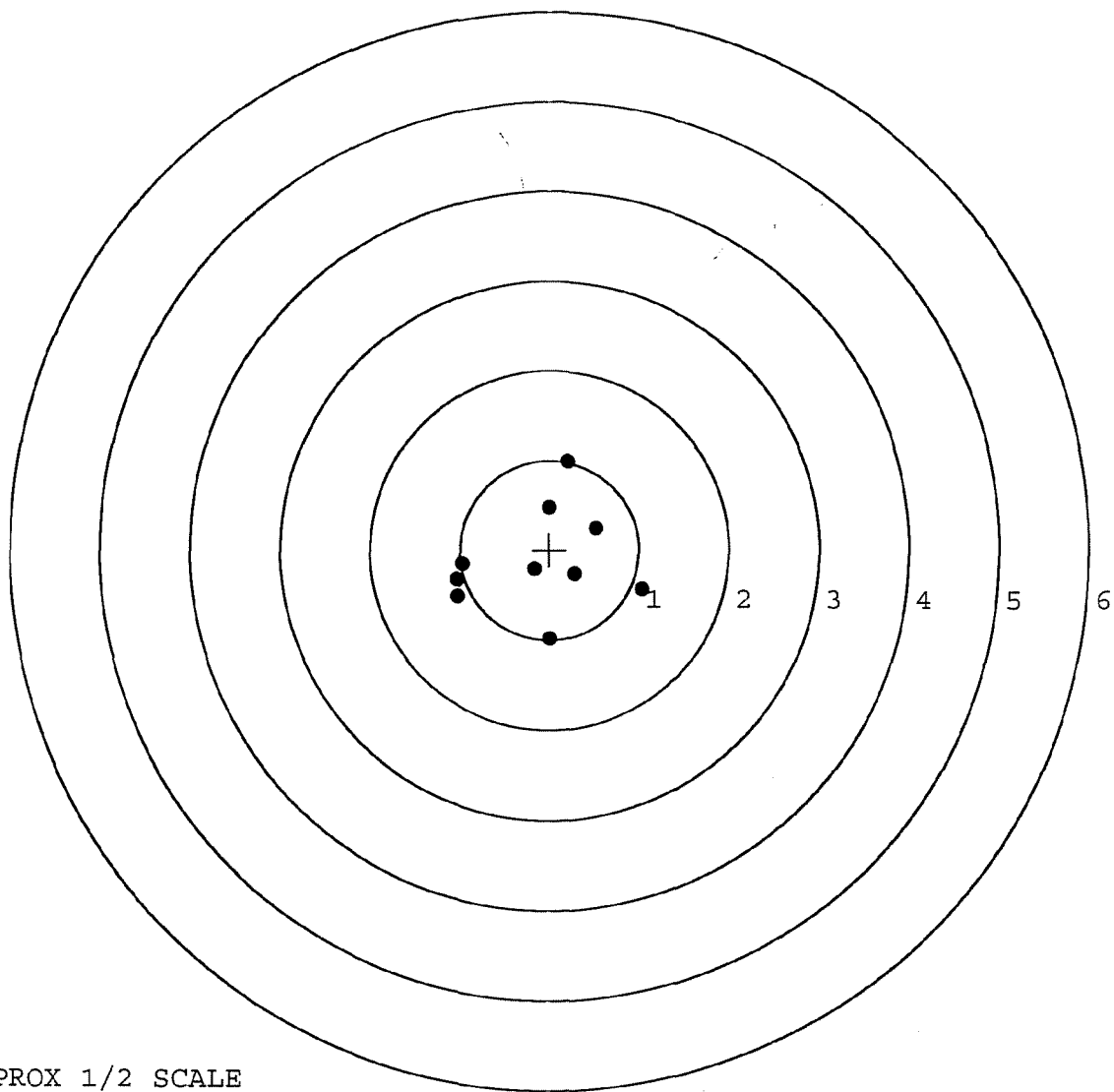
MAX RADIUS: 1.191

MEAN RADIUS: 0.790

IN 1 IN DIAMETER: 2

IN 2 IN DIAMETER: 8

in 3 IN DIAMETER: 10



TARGET APPROX 1/2 SCALE

SERIAL NUMBER: C6611562. 0

TARGET NUMBER: 5

FILE DATE: 05/15/2007

FILE TIME: 01:22

POINT#	X	Y
1:	0.648	0.396
2:	-0.782	-0.574
3:	-0.145	-0.694
4:	0.081	-0.667
5:	-0.056	-0.329
6:	-0.105	0.022
7:	0.304	0.182
8:	-0.157	0.424
9:	0.220	0.627
10:	0.161	0.340

X CENTROID: 0.017

Y CENTROID: -0.027

POA TO CENTROID: 0.032

HORZ SPREAD: 1.430

VERT SPREAD: 1.321

GROUP SPREAD: 1.728

MIN RADIUS: 0.131

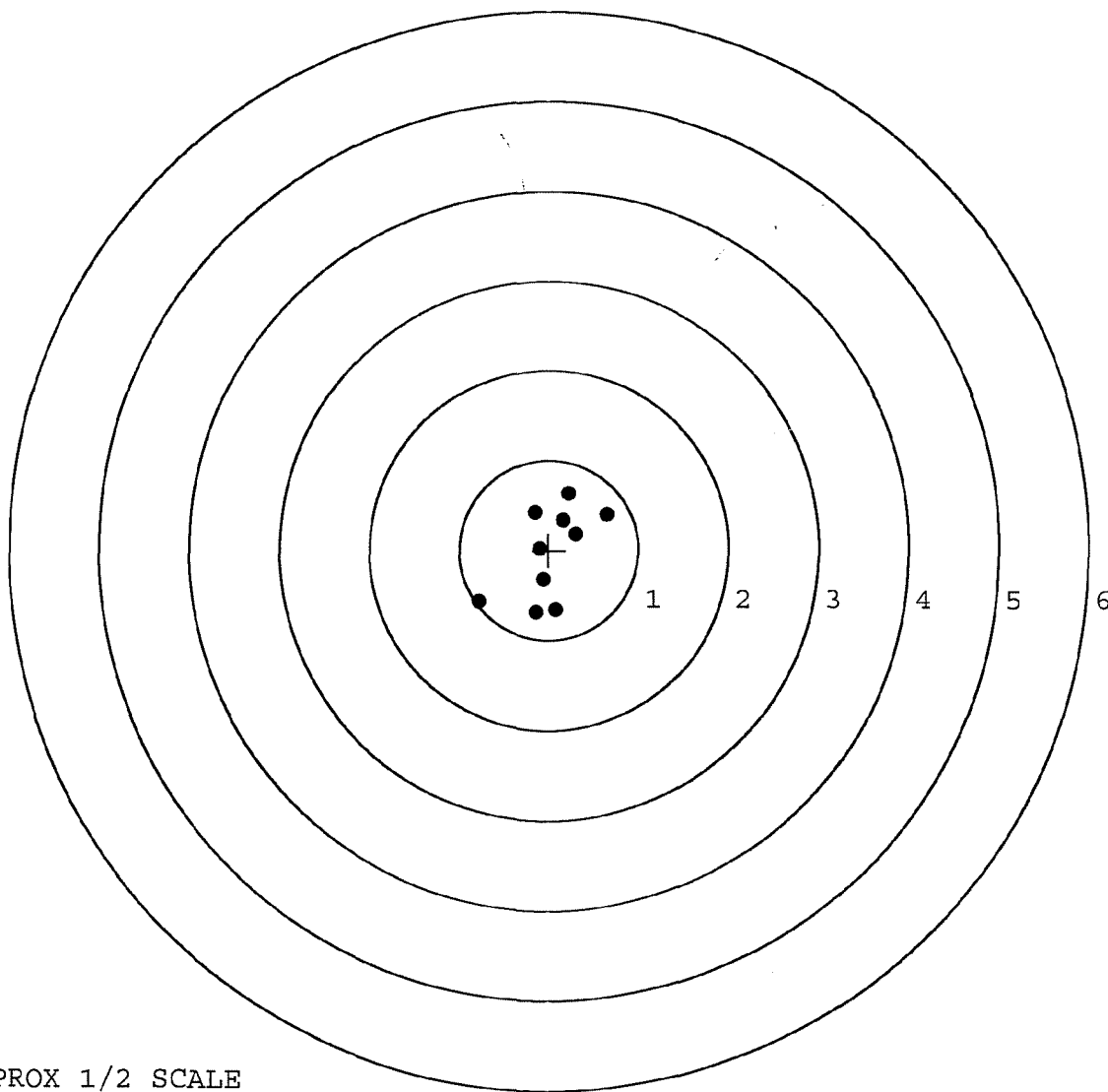
MAX RADIUS: 0.968

MEAN RADIUS: 0.542

IN 1 IN DIAMETER: 5

IN 2 IN DIAMETER: 10

in 3 IN DIAMETER: 10

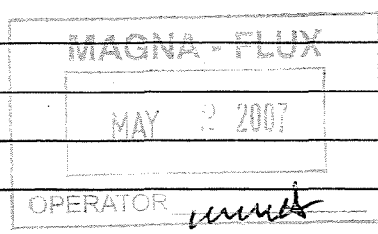


TARGET APPROX 1/2 SCALE

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-02-C-0149

R & E NUMBER		127 549	
SERIAL NUMBER		C6611562	
LOG-IN DATE		4-3-07	

OPERATION #	OPERATION NAME	DATE	INITIAL
500	DIS-ASSEMBLE GUN	4-26-07	RTZ
505	RE-BARREL	4-30-07	RTZ
560	ASSEMBLE	4-30-07	RTZ
600	PROOF	5-1-07	TRW
605	CHECK HEADSPACE	5-1-07	TRW
610	DIS-ASSEMBLE GUN	5-1-07	RTZ
612	MAGNAFLUX	5-2-07	turnt
510	DRILL AND TAP	5-1-07	FM
615	ROLLMARK CALIBER	5-1-07	CW
618	ROTO-BLAST	5-2-07	UB
620	APPLY COATINGS	5/4/07	WJ
625	FINAL ASSEMBLY	5-14-07	RTZ
640	FUNCTION TEST AND	5/14/07	nm
650	TARGET	5/14/07	nm
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
	MALFUNCTION	CORRECTION	
670	FINAL INSPECTION	5/15/07	nm
	A) HEADSPACE	5/15/07	nm
	B) TRIGGER PULL	2.69 2.55 2.60 2.66 2.57 5-15-07	TRW
680	F) SAFETY ON FORCE	7.25 7.25 7.75 5-15-07	TRW
	G) SAFETY OFF FORCE	2.75 3.0 3.0 5-15-07	TRW
	I) FIRING PIN INDENT	.0235 .0235 .0235 5-15-07	TRW
690	PACK	5-17-07	SA






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

REG. U.S. PAT. & TM. OFF.

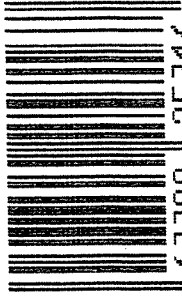
MODEL 700TM M24

46

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

SERIAL NO.	C6611562
ORDER NO.	5716

UPC



0 47700 25716 7



5716 C6611562

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C 6611562

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		2/1/91	KA
600	Proof		2/1/91	KA
607	Check Headspace		2/1/91	KA
610	Dis-assemble Gun		2/1/91	KA
612	Magnaflux Barrel Action	2 11 91		Kcd
	Magnaflux Bolt	2 11 91		Kcd
615	Rollmark Caliber	2 11 91		GB
617	Drill and Tap Sight Holes	2 13 91		LB
618	Polish Barrel RBB	2 13 91		WB
620	Apply Coatings (Barrel Action)		2-12-91	JA
	Apply Coating (Bolt)			
625	Final Assembly A) Clean inside of Bolt Assembly		3/20/91	KS
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		3/20/91	KS
	C) Inspect Ejector Hole for Chamfer		3/20/91	KS
	D) Oil Firing Pin Ass'y		3/20/91	KS
	E) Adjust Trigger Pull to Min Setting and Stake		3/21/91	JA

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	4 1/2	4	4			3/21/91	KS
	G) Safety Off Force	2 1/2	2 1/2	2 1/2			3/21/91	KS
	H) Trigger Pull Test & Retainability						3/21/91	JH
	I) Firing Pin Indent	.021	.021	.021			3/21/91	KS
	J) Assemble Stock						3/21/91	KS
	K) Assemble Swivel Studs					9-10-91	3/21/91	D/H
	L) Attach Front and Rear Sight Assemblies						3/21/91	KS
	M) Iron Sight Alignment						3/21/91	KS
	N) Detach Front & Rear Sights & place in numbered container						3/21/91	KS
	O) Attach Scope to Rifle						3/21/91	KS
	P) Detach & Attach Scope 20 Times						3/21/91	KS
640	Gallery Target & Test						4/2/91	HJ
	A) Time							KJ
	B) Malfunctions							KJ
	C) Pierced Primers							KJ
	D) Optical Clarity of Scope							KJ
645	Inspect for Live Ammo						4/2/91	KJ
655	Final Inspection						4-10-91	D/H
	A) Headspace							
	B) Trigger Pull	2.34	2.27	2.25	2.25	2.25	4/10/91	JH
	C) Function						4-10-91	D/H
660	Pack						6-17-91	NF

SWS TRIGGER PULL TEST

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

SERIAL NO. C6611562
DATE 3-21-91
TESTER JM

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.44	2.31	2.50	2.34	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.44	2.48	2.46	2.27	
PULL #3	2.44	2.43	2.48	2.25	
PULL #4	2.42	2.48	2.45	2.25	
PULL #5	2.46	2.48	2.43	2.25	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.37	3.28		
PULL #2	3.23	3.30		
PULL #3	3.38	3.31		
PULL #4	3.30	3.33		
PULL #5	3.31	3.34		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.40	4.39		4.40
PULL #2	4.36	4.37		4.38
PULL #3	4.35	4.11		4.44
PULL #4	4.37	4.37		4.42
PULL #5	4.37	4.40		4.47
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6611562
8 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.505273
1 TO	2	.45664
1 TO	3	.529181
1 TO	4	.286923
1 TO	5	.349092

4.1 <----POA

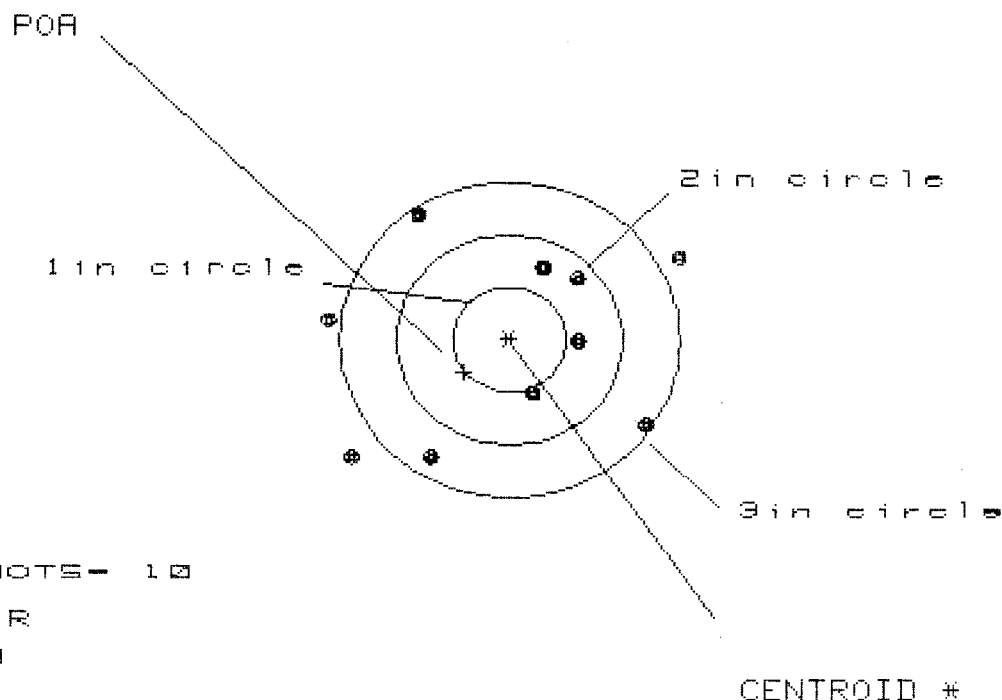
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1686
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0942
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .193131

THE AMR FOR THIS RIFLE IS: 1.047

6 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611562.1

CENTERFIRE PATTERNS # 1



OF SHOTS - 10

IN CIR

1 in = 0

2 in = 4

3 in = 7

HS = 3.042

VS = 2.250

GS = 3.443

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.491	1.336	1.201
MINIMUM X	-1.551	-1.706	-1.539
MAXIMUM Y	1.163	1.042	1.124
MINIMUM Y	-1.087	-1.191	-1.109
CENTROID X	.399	.554	.387
CENTROID Y	.310	.431	.349
POA TO CENTROID in.	.505	.702	.521
MIN RADIUS	.531	.489	.570
MEAN RADIUS	1.193	1.092	1.061
MAX RADIUS	1.773	1.707	1.545
HORIZONTAL SPREAD	3.042	3.042	2.740
VERTICAL SPREAD	2.250	2.233	2.233
EXTREME SPREAD	3.443	3.104	2.902
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	7		

8 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611562.1

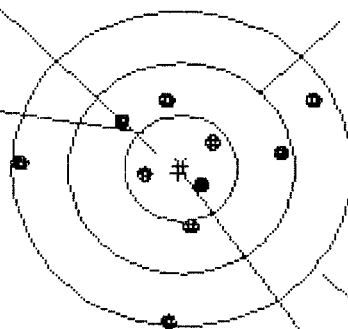
CENTERFIRE PATTERNS # 2

POA

1in circle

2in circle

3in circle



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 10

HS= 2.503

VS= 2.053

GS= 2.662

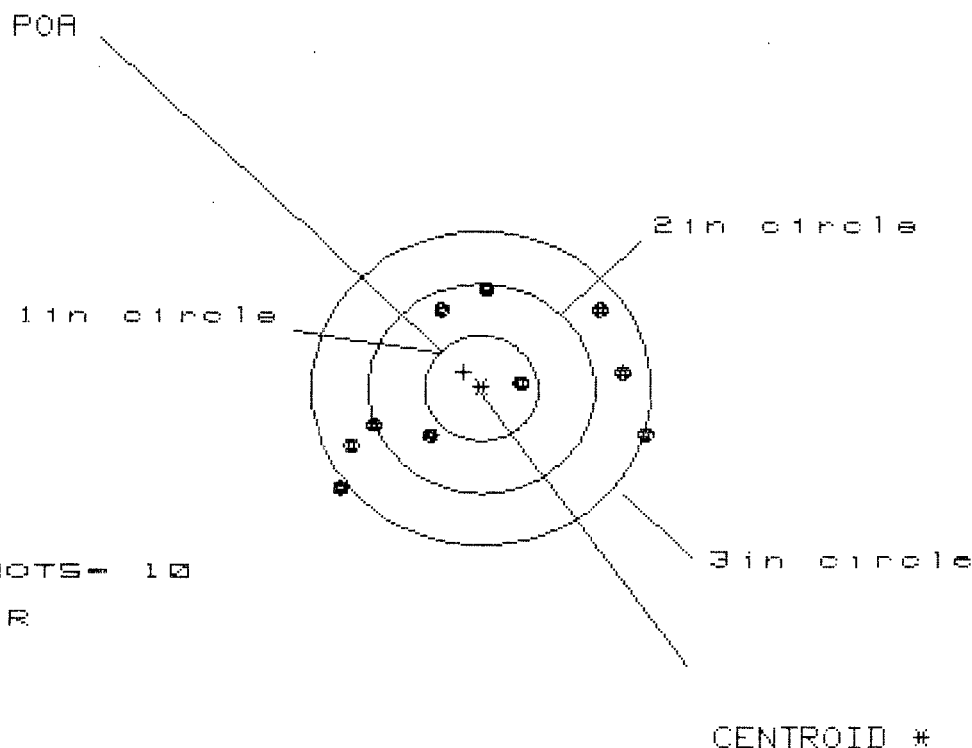
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.170	1.011	.970
MINIMUM X	:	-1.433	-.671	-.713
MAXIMUM Y	:	.631	.636	.459
MINIMUM Y	:	-1.422	-1.417	-.727
CENTROID X	:	.025	.184	.226
CENTROID Y	:	.048	.043	.220
POA TO CENTROID in.	:	.054	.189	.315
MIN RADIUS	:	.208	.150	.087
MEAN RADIUS	:	.792	.711	.606
MAX RADIUS	:	1.434	1.455	1.063
HORIZONTAL SPREAD	:	2.603	1.682	1.682
VERTICAL SPREAD	:	2.053	2.053	1.186
EXTREME SPREAD	:	2.662	2.434	1.687
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611562.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 4

3in = 8

HS= 2.7000

VS= 1.844

GS= 2.882

CENTROID *

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.446	1.387	1.277
MINIMUM X	:	-1.254	-1.261	-1.098
MAXIMUM Y	:	.916	.813	.745
MINIMUM Y	:	-.928	-.595	-.663
CENTROID X	:	.152	.291	.128
CENTROID Y	:	-.158	-.055	.013
POR TO CENTROID in.	:	.219	.296	.128
MIN RADIUS	:	.316	.184	.360
MEAN RADIUS	:	1.065	.991	.932
MAX RADIUS	:	1.560	1.414	1.282
HORIZONTAL SPREAD	:	2.700	2.568	2.375
VERTICAL SPREAD	:	1.844	1.408	1.408
EXTREME SPREAD	:	2.882	2.569	2.531
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

8 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611562.1

CENTERFIRE PATTERNS

4

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 5

3in = 8

HS= 2.714

VS= 2.678

GS= 3.488

CENTROID *

PATTERN #

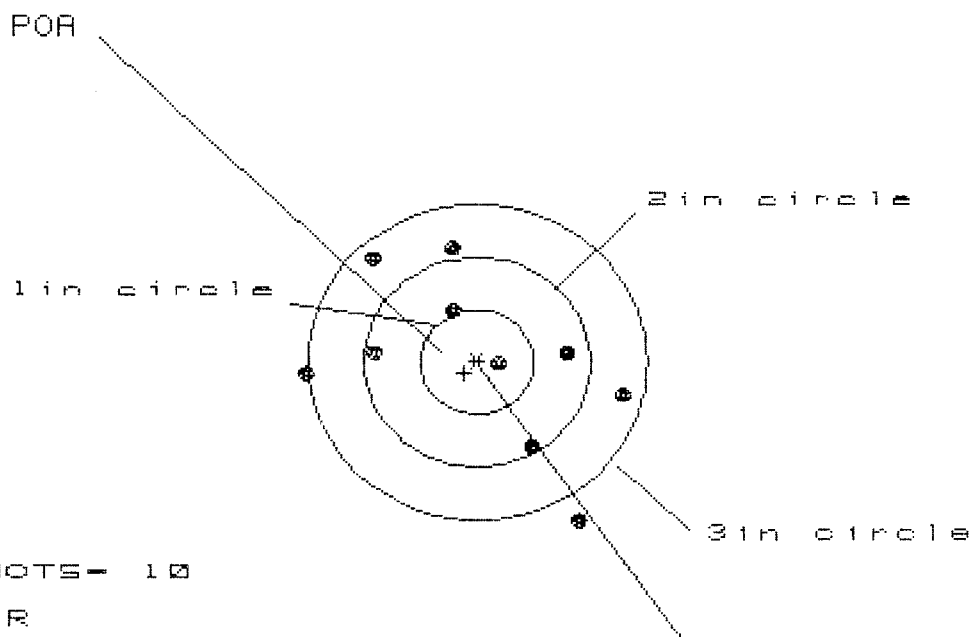
4

SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.685	1.095	1.023
MINIMUM X	-1.030	-.842	-.914
MAXIMUM Y	1.098	1.199	1.014
MINIMUM Y	-1.580	-1.479	-1.473
CENTROID X	.152	-.036	.036
CENTROID Y	.164	.063	.248
POA TO CENTROID in.	.223	.072	.250
MIN RADIUS	.632	.498	.613
MEAN RADIUS	1.150	1.040	.970
MAX RADIUS	1.915	1.624	1.475
HORIZONTAL SPREAD	2.714	1.937	1.937
VERTICAL SPREAD	2.678	2.678	2.487
EXTREME SPREAD	3.488	3.153	2.724
NUMBER IN ONE INCH CIRCLE =		0	
NUMBER IN TWO INCH CIRCLE =		5	
NUMBER IN THREE INCH CIRCLE =		8	

8 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6811562.1

CENTERFIRE PATTERNS # 5



OF SHOTS- 10

IN CIR

1 in - 1

2 in - 5

3 in - 8

HS- 2.853

VS- 2.594

GS- 3.022

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.324	1.423	1.244
MINIMUM X	:	-1.529	-1.430	-.962
MAXIMUM Y	:	1.110	.945	.914
MINIMUM Y	:	-1.484	-1.016	-1.047
CENTROID X	:	.115	.016	.195
CENTROID Y	:	.107	.272	.303
POA TO CENTROID in.	:	.157	.272	.360
MIN RADIUS	:	.208	.320	.223
MEAN RADIUS	:	1.036	.941	.859
MAX RADIUS	:	1.731	1.490	1.331
HORIZONTAL SPREAD	:	2.853	2.853	2.206
VERTICAL SPREAD	:	2.594	1.961	1.961
EXTREME SPREAD	:	3.022	2.859	2.527
NUMBER IN ONE INCH CIRCLE =			1	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			8	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06611562
3 Apr 1991

CENTROIDAL DISTANCES

0 TO	1	.0465296
1 TO	2	.0615873
1 TO	3	.082201
1 TO	4	.123309
1 TO	5	.113

* <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0194
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.014
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .023924

THE AMR FOR THIS RIFLE IS: 1.341

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611562

CENTERFIRE PATTERNS # 1

POA

1in circle

2in circle

3in circle

OF SHOTS- 10

IN CIR

1in = 0

2in = 4

3in = 8

HS= 1.989

VS= 4.143

GS= 4.347

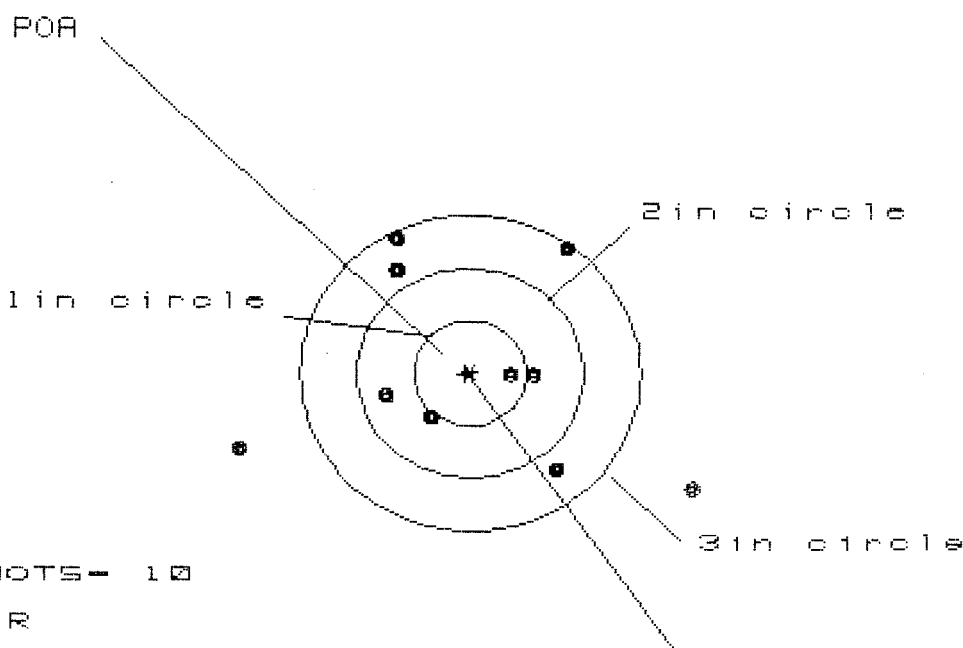
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.919	.947	.817
MINIMUM X	-1.070	-1.042	-.619
MAXIMUM Y	2.524	1.751	1.583
MINIMUM Y	-1.619	-1.338	-1.193
CENTROID X	-.007	-.035	.096
CENTROID Y	.046	-.235	-.067
POA TO CENTROID in.	.046	.237	.117
MIN RADIUS	.562	.479	.607
MEAN RADIUS	1.299	1.103	1.042
MAX RADIUS	2.536	1.752	1.595
HORIZONTAL SPREAD	1.989	1.989	1.435
VERTICAL SPREAD	4.143	3.089	2.776
EXTREME SPREAD	4.347	3.336	2.848
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	4		
NUMBER IN THREE INCH CIRCLE =	8		

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611562

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 1

2in = 4

3in = 8

HS = 3.950

VS = 2.474

GS = 3.974

CENTROID #

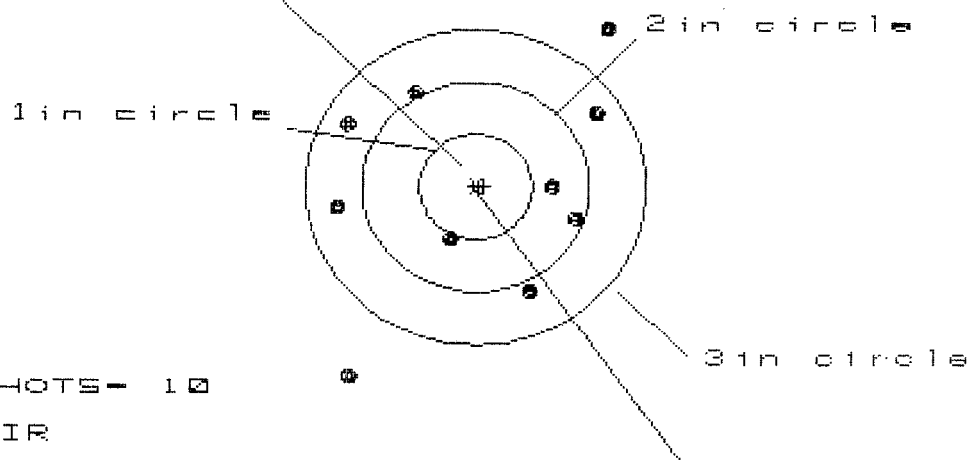
PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.907	1.064	.835
MINIMUM X	:	-2.043	-1.831	-.760
MAXIMUM Y	:	1.317	1.189	1.082
MINIMUM Y	:	-1.157	-1.055	-1.162
CENTROID X	:	.045	-.167	.062
CENTROID Y	:	.013	.141	.248
POA TO CENTROID in.	:	.047	.218	.255
MIN RADIUS	:	.335	.531	.403
MEAN RADIUS	:	1.185	1.076	.937
MAX RADIUS	:	2.230	2.020	1.376
HORIZONTAL SPREAD	:	3.950	2.895	1.595
VERTICAL SPREAD	:	2.474	2.244	2.244
EXTREME SPREAD	:	3.974	3.446	2.651
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611562

CENTERFIRE PATTERNS # 3

POB



OF SHOTS- 10

IN CIR

1 in = 0

2 in = 3

3 in = 8

HS= 2.446

VS= 3.310

GS= 4.020

CENTROID #

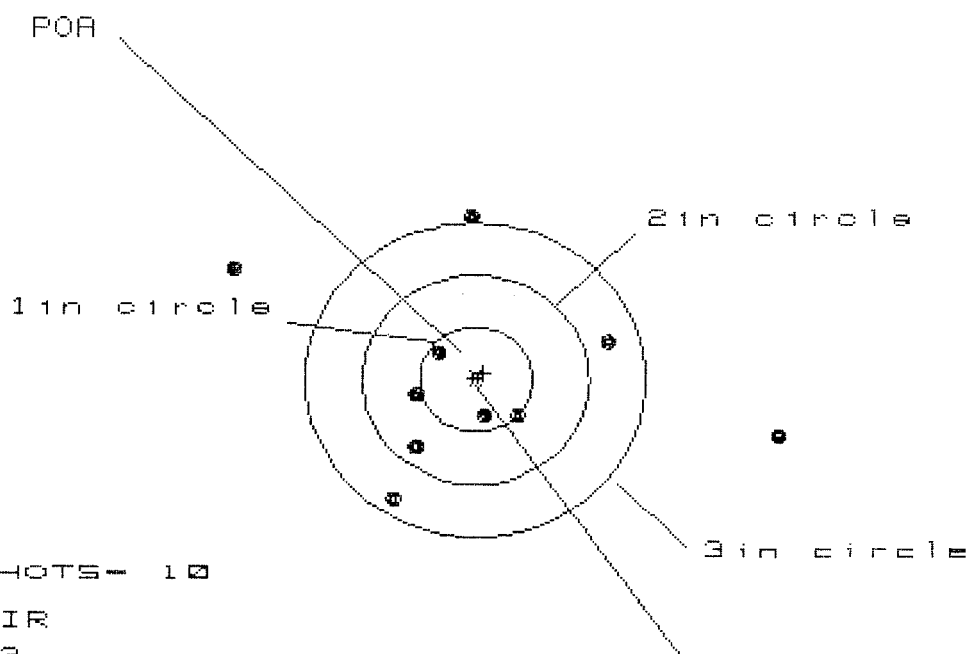
PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.181	1.059	1.035
MINIMUM X	:	-1.265	-1.387	-1.255
MAXIMUM Y	:	1.494	1.292	.910
MINIMUM Y	:	-1.816	-1.237	-1.075
CENTROID X	:	-.073	.049	-.083
CENTROID Y	:	-.003	.199	.037
POB TO CENTROID in.	:	.073	.205	.091
MIN RADIUS	:	.605	.595	.638
MEAN RADIUS	:	1.236	1.126	1.044
MAX RADIUS	:	2.124	1.670	1.303
HORIZONTAL SPREAD	:	2.446	2.446	2.290
VERTICAL SPREAD	:	3.310	2.529	1.986
EXTREME SPREAD	:	4.020	2.986	2.481
NUMBER IN ONE INCH CIRCLE	=		0	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		8	

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611562

CENTERFIRE PATTERNS

4



OF SHOTS - 10

IN CIR

1 in = 3

2 in = 5

3 in = 7

HS = 4.824

VS = 2.692

GS = 5.069

CENTROID #

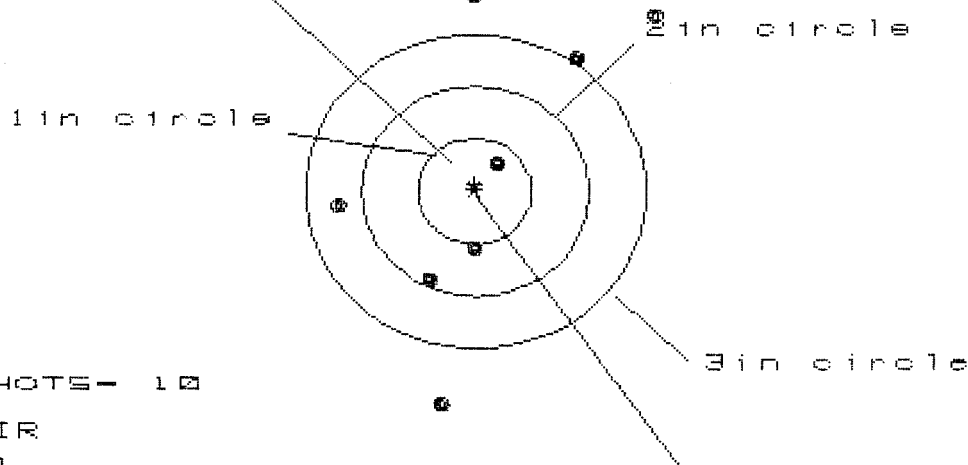
PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	2.698	1.467	1.238
MINIMUM X	:	-2.126	-1.826	-.682
MAXIMUM Y	:	1.559	1.500	1.620
MINIMUM Y	:	-1.133	-1.192	-1.072
CENTROID X	:	-.070	-.370	-.141
CENTROID Y	:	-.060	-.001	-.121
POA TO CENTROID in.	:	.092	.370	.186
MIN RADIUS	:	.394	.197	.367
MEAN RADIUS	:	1.194	.998	.837
MAX RADIUS	:	2.750	2.066	1.621
HORIZONTAL SPREAD	:	4.824	3.293	1.920
VERTICAL SPREAD	:	2.692	2.692	2.692
EXTREME SPREAD	:	5.069	3.365	2.788
NUMBER IN ONE INCH CIRCLE =			3	
NUMBER IN TWO INCH CIRCLE =			5	
NUMBER IN THREE INCH CIRCLE =			7	

3 Apr 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6611562

CENTERFIRE PATTERNS # 5

POB



OF SHOTS- 10

IN CIR

1 in = 1

2 in = 3

3 in = 4

HS= 3.143

VS= 6.639

GS= 7.045

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.616	1.447	1.529
MINIMUM X	:	-1.527	-1.394	-1.312
MAXIMUM Y	:	2.595	2.146	1.708
MINIMUM Y	:	-4.044	-2.526	-2.258
CENTROID X	:	.008	.177	.095
CENTROID Y	:	-.066	.383	.115
POB TO CENTROID in.	:	.067	.422	.149
MIN RADIUS	:	.339	.146	.139
MEAN RADIUS	:	1.790	1.474	1.348
MAX RADIUS	:	4.322	2.578	2.299
HORIZONTAL SPREAD	:	3.143	2.841	2.841
VERTICAL SPREAD	:	6.639	4.672	3.966
EXTREME SPREAD	:	7.045	4.818	4.182
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		3	
NUMBER IN THREE INCH CIRCLE	=		4	