

FORM

UPC



C6665801

MODEL 700 TM M24

ORDER NO. 5716

BARREL LENGTH

CAPACITY*

*INCLUDES 1 IN CHAMBER

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6665801
5 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.203
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2802
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .346007

THE AMR FOR THIS RIFLE IS: 1.305

CENTROIDAL DISTANCES

0 TO	1	.351411
1 TO	2	.16772
1 TO	3	.450682
1 TO	4	.230868
1 TO	5	.200569

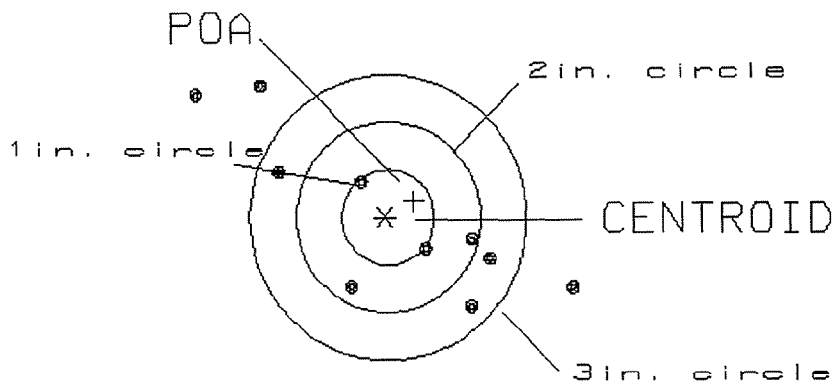
 + <----POA
 4
1 3
5

PATTERN #: ☐ 1 ☐
 POA TO CENTROID: .352
 MIN RADIUS : .459
 MEAN RADIUS : 1.309
 MAX RADIUS : 2.470
 CENTROID X : -.307
 CENTROID Y : -.171

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6665801

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.16
 VS= 2.30
 GS= 4.63

1
 4
 7

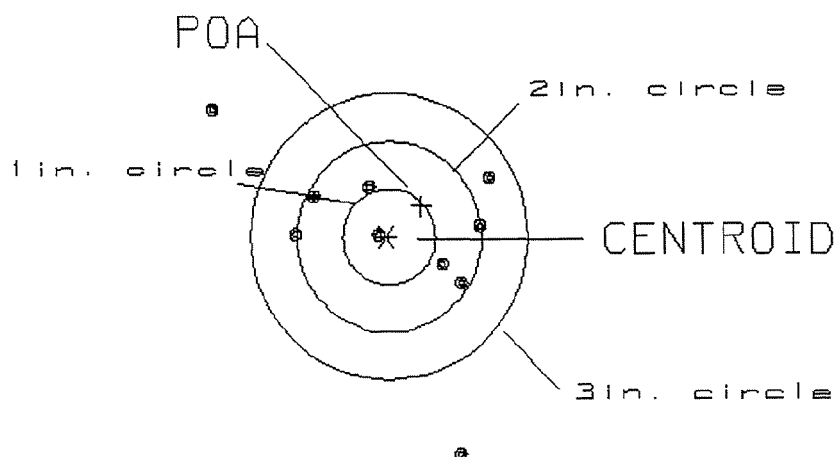
PATTERN #: 2

POA TO CENTROID: .498
 MIN RADIUS : .141
 MEAN RADIUS : 1.119
 MAX RADIUS : 2.440
 CENTROID X : -.380
 CENTROID Y : -.322

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6665801

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.95
 VS= 3.66
 GS= 4.52

1
 6
 3

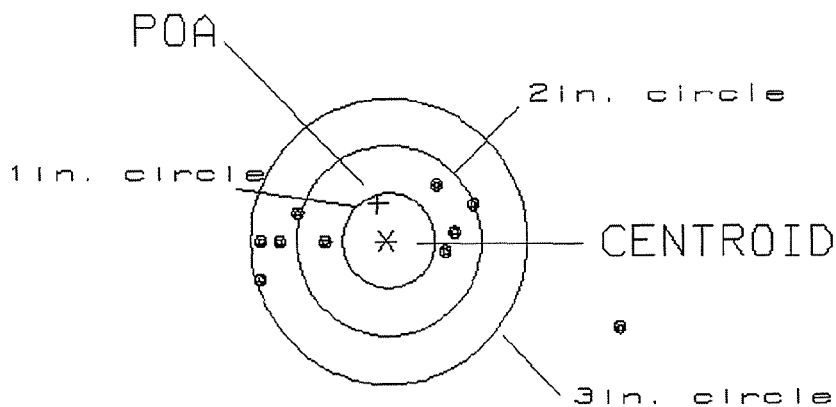
PATTERN #: ☐ 3 ☐

POA TO CENTROID: .398
 MIN RADIUS : .645
 MEAN RADIUS : 1.150
 MAX RADIUS : 2.702
 CENTROID X : .088
 CENTROID Y : -.388

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6665801

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.92

0

VS= 1.44

5

GS= 4.01

9

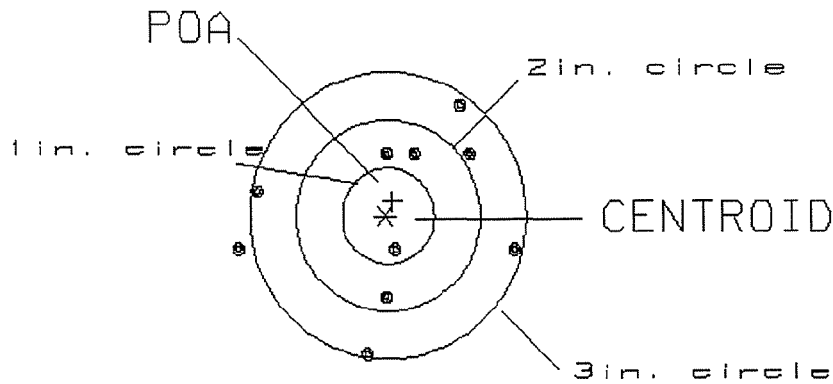
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .169
 MIN RADIUS : .317
 MEAN RADIUS : 1.108
 MAX RADIUS : 1.706
 CENTROID X : -.077
 CENTROID Y : -.151

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6665801

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.04
 VS= 2.66
 GS= 3.04

1
 4
 9

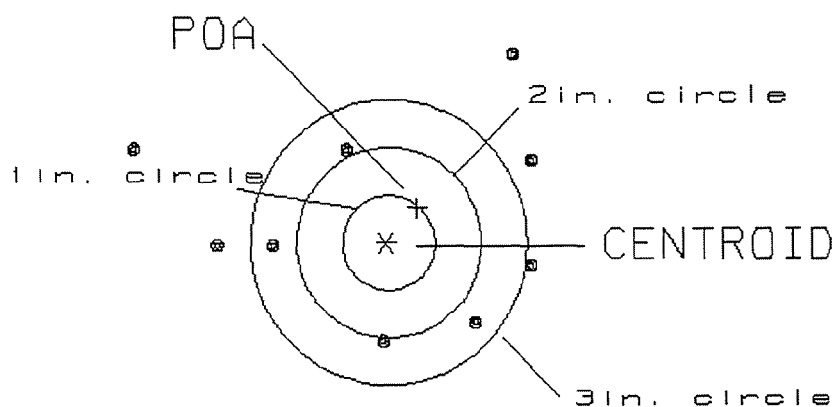
PATTERN #: ☐ 5 ☐

POA TO CENTROID: .501
 MIN RADIUS : 1.005
 MEAN RADIUS : 1.801
 MAX RADIUS : 2.972
 CENTROID X : -.339
 CENTROID Y : -.369

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6665801

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 4.37
 VS= 4.71
 GS= 5.35

☐
☐
 4

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # c6665801
5 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.203
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.2802
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .346007

THE AMR FOR THIS RIFLE IS: 1.305

CENTROIDAL DISTANCES

0 TO	1	.351411
1 TO	2	.16772
1 TO	3	.450682
1 TO	4	.230868
1 TO	5	.200569

 + <----POA
 4
 1
 5 3

PATTERN #: ☐ 1 ☐

POA TO CENTROID: .352

MIN RADIUS : .459

MEAN RADIUS : 1.309

MAX RADIUS : 2.470

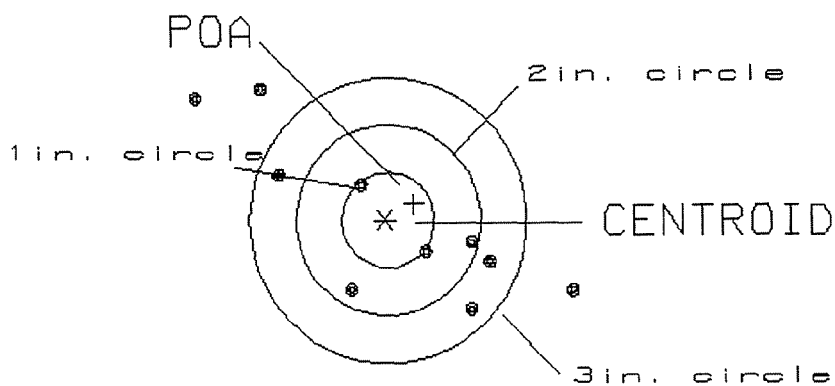
CENTROID X : -.307

CENTROID Y : -.171

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6665801

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 4.16

1

VS= 2.30

4

GS= 4.63

7

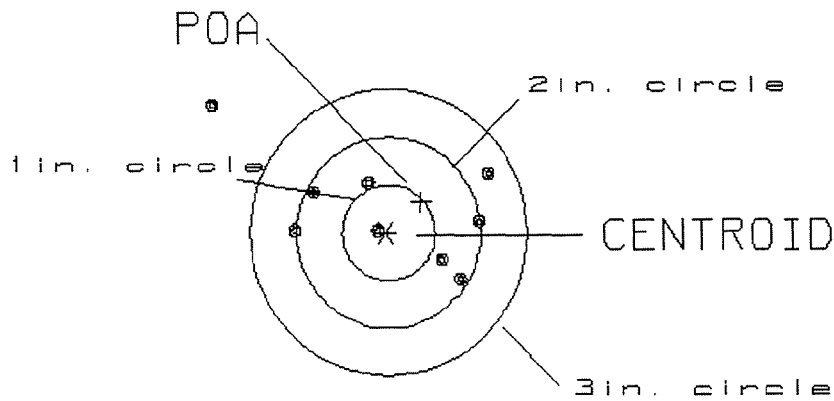
PATTERN #: ☐ 2 ☐

POA TO CENTROID: .498
 MIN RADIUS : .141
 MEAN RADIUS : 1.119
 MAX RADIUS : 2.440
 CENTROID X : -.380
 CENTROID Y : -.322

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6665801

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.95
 VS= 3.66
 GS= 4.52

1
 6
 8

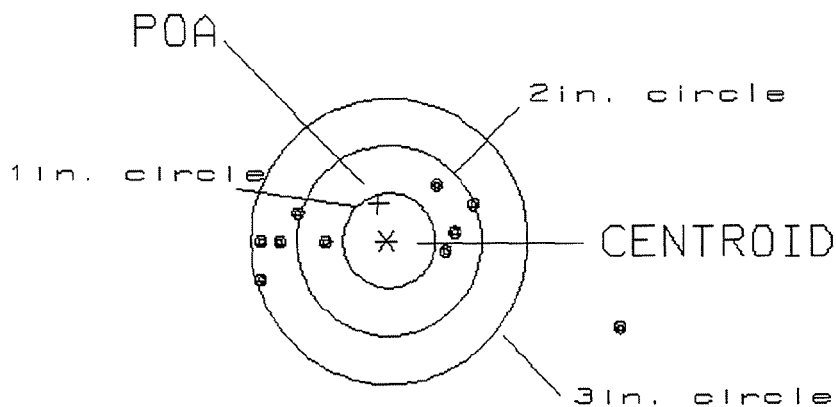
PATTERN #: ☐ 3 ☐

POA TO CENTROID: .398
 MIN RADIUS : .645
 MEAN RADIUS : 1.150
 MAX RADIUS : 2.702
 CENTROID X : .088
 CENTROID Y : -.388

5 Oct 2001

FILE://Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6665801

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= 3.92
 VS= 1.44
 GS= 4.01

0
 5
 9

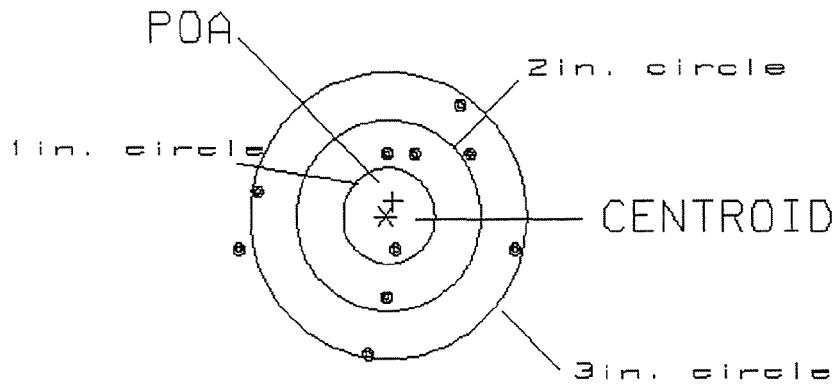
PATTERN #: ☐ 4 ☐

POA TO CENTROID: .169
 MIN RADIUS : .317
 MEAN RADIUS : 1.108
 MAX RADIUS : 1.706
 CENTROID X : -.077
 CENTROID Y : -.151

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6665801

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 3.04
 VS= 2.66
 GS= 3.04

1
 4
 9

PATTERN #: 5

POA TO CENTROID: .501

MIN RADIUS : 1.005

MEAN RADIUS : 1.801

MAX RADIUS : 2.972

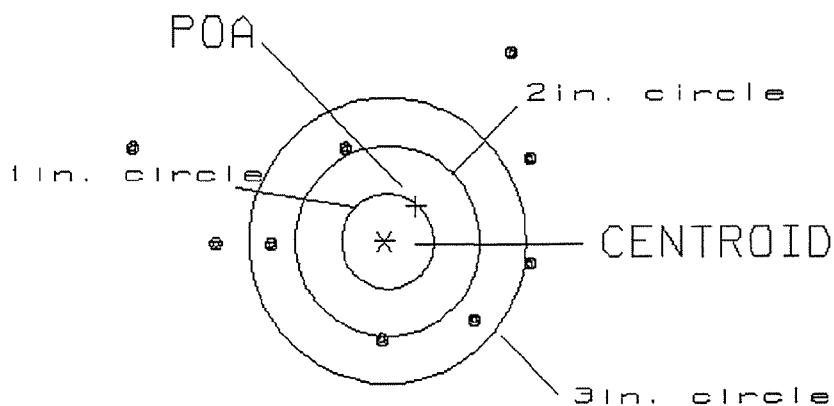
CENTROID X : -.339

CENTROID Y : -.369

5 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/c6665801

CENTERFIRE PATTERN # 5



OF SHOTS= 10

IN CIRCLE

HS= 4.37

0

VS= 4.71

0

GS= 5.35

4

Remington Test Lab, Ilion, N.Y.

Centroidal distance calculations for Rifle # C6665801
8 Oct 2001

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .1994
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.1264
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .236088

THE AMR FOR THIS RIFLE IS: .7718

CENTROIDAL DISTANCES

0 TO	1	.4278
1 TO	2	.0290689
1 TO	3	.207461
1 TO	4	.484322
1 TO	5	.480234

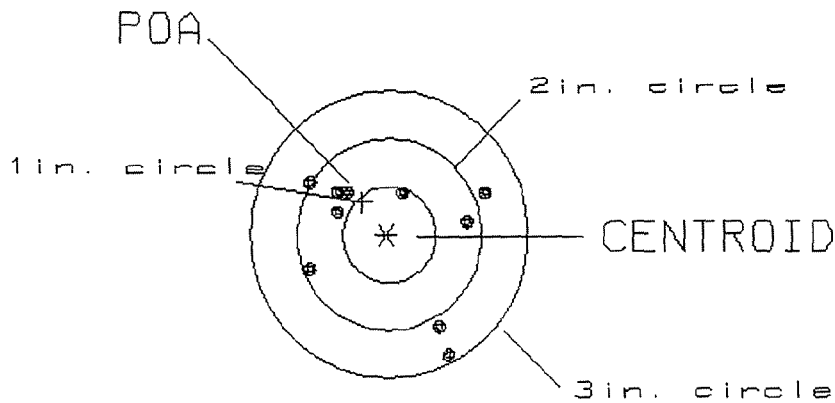
5 4
3 <----POA
2

PATTERN #: 1
 POA TO CENTROID: .428
 MIN RADIUS : .462
 MEAN RADIUS : .884
 MAX RADIUS : 1.462
 CENTROID X : .257
 CENTROID Y : -.342

8 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6665801.1

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 1.93

1

VS= 1.83

6

GS= 2.41

10

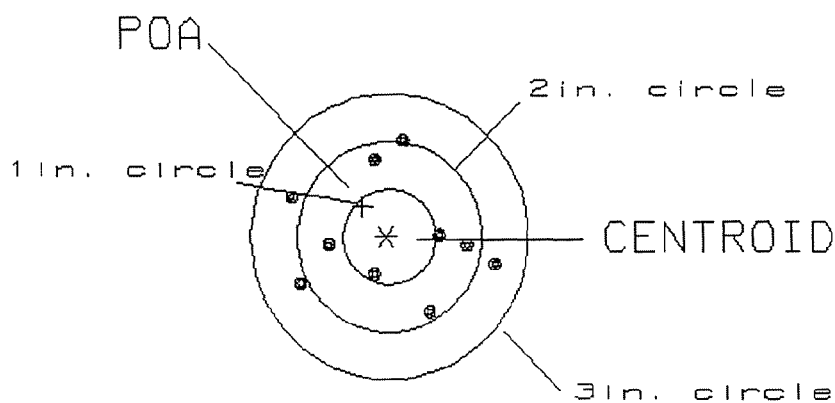
PATTERN #: 2

POA TO CENTROID: .407
 MIN RADIUS : .463
 MEAN RADIUS : .870
 MAX RADIUS : 1.190
 CENTROID X : .259
 CENTROID Y : -.313

8 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6665801.1

CENTERFIRE PATTERN # 2



OF SHOTS= 10

IN CIRCLE

HS= 2.20
 VS= 1.84
 GS= 2.31

1
 6
 10

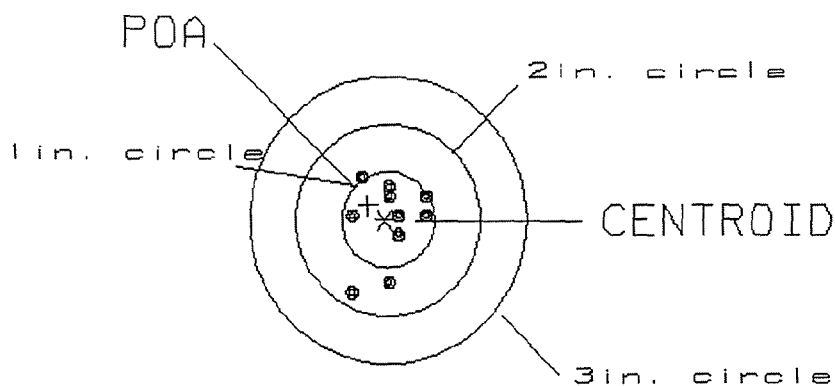
PATTERN #: ☐ 3 ☐

POA TO CENTROID: .239
 MIN RADIUS : .139
 MEAN RADIUS : .434
 MAX RADIUS : .882
 CENTROID X : .189
 CENTROID Y : -.146

8 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/CG6665801.1

CENTERFIRE PATTERN # 3



OF SHOTS= 10

IN CIRCLE

HS= .90

6

VS= 1.27

10

GS= 1.35

10

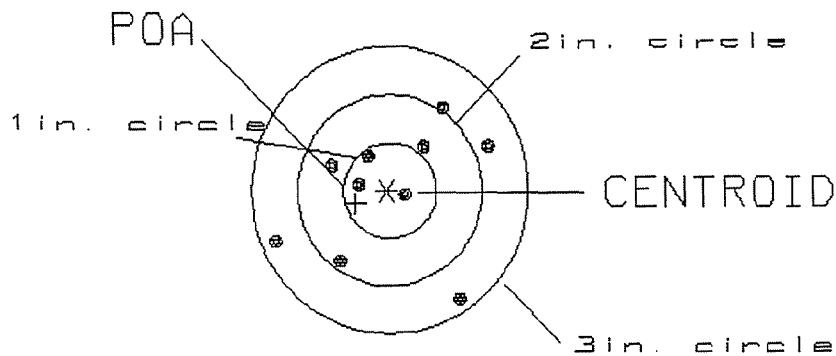
PATTERN #: □ 4 □

POA TO CENTROID: .361
 MIN RADIUS : .208
 MEAN RADIUS : .806
 MAX RADIUS : 1.354
 CENTROID X : .335
 CENTROID Y : .136

8 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/C6665801.1

CENTERFIRE PATTERN # 4



OF SHOTS= 10

IN CIRCLE

HS= 2.22

3

VS= 1.99

6

GS= 2.44

10

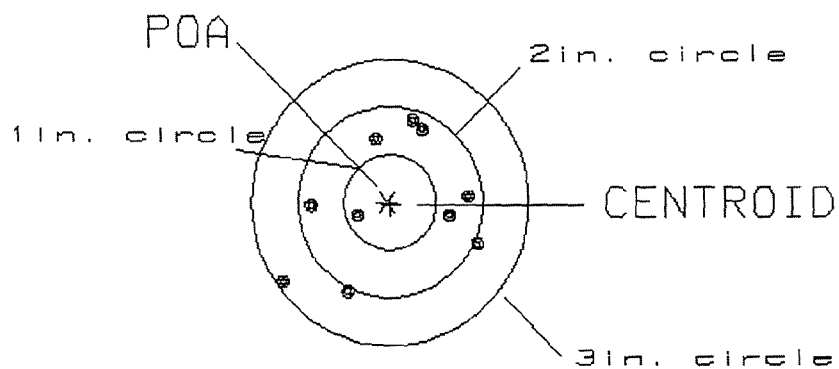
PATTERN #: ☐ 1 ☐

POA TO CENTROID: .054
 MIN RADIUS : .362
 MEAN RADIUS : .865
 MAX RADIUS : 1.400
 CENTROID X : -.043
 CENTROID Y : .033

8 Oct 2001

FILE:/Hpbasic/Accuracy/Patterning/Centerfire_Patt/CG6665801.15

CENTERFIRE PATTERN # 1



OF SHOTS= 10

IN CIRCLE

HS= 2.13

1

VS= 1.79

7

GS= 2.18

10

M-24 INSPECTION CHECKLIST
CONTRACT #: DAAE-20-97-C-242

R & E NUMBER		32507	
SERIAL NUMBER		C6006 5801	
LOG-IN DATE		9-13-01	
INSPECT AND VERIFY:			
OPERATION #	OPERATION NAME	DATE	INITIAL
550	DIS-ASSEMBLE GUN	9-17-01	RH
560 A	RE-BARREL AT CUSTOM SHOP	9/20/01	BWT
B	DRILL AND TAP	9/20/01	BWT
C	POLISH	9-20-01	RH
575	ASSEMBLE	9-20-01	RH
600	PROOF	9-21-01	RW
605	CHECK HEADSPACE	9-24-01	RH
610	DIS-ASSEMBLE GUN	9-24-01	RH
612	MAGNAFLUX		
615	ROLLMARK CALIBER	9-24-01	RH
618	ROTO-BLAST	9/25	
620	APPLY COATINGS	9/28	HP
625 A	FINAL ASSEMBLY	10-3-01	RH
B	TRIGGER PULL TEST	N/A	
C	SAFETY "ON" FORCE	N/A	
D	SAFETY "OFF" FORCE	N/A	
E	FIRING PIN INDENT	N/A	
640	TARGET	10/4/01	RW
655	FINAL INSPECT	10-8-01	RW
660	PACK	10-9-01	DA
		SHIP DATE	
		QAR INSPECTION DATE	

Final Inspection

In: C660 5801

DATE REC'D: 9-13-01

DATE RET'D: 10-9-01

AUDITOR: PK

Item:

BARREL ASSY.

- ☒ BARREL
- ☒ RECEIVER
- ☒ FRONT SIGHT BLOCK
- ☒ REAR SIGHT BLOCK
- ☒ SCREWS
- ☒ FINISH

Scope Assy.

- ☐ Scope
- ☒ Scope Rings
- ☒ Mounting Screws
- ☐ Mounting Base
- ☒ Screws
- ☒ Finish
- ☒ Looseness
- ☒ CLARITY

Misc.

- ☐ DD-250
- ☐ BAR CODE
- ☐ PACKAGING

Item:

STOCK ASSY.

- ☒ STOCK
- ☒ SLING SWIVEL STUDS
- ☒ ADJUSTABLE BUTT PLATE
- ☒ LOCK NUTS
- ☒ BARREL CLEARANCE
- ☒ COLOR/FINISH

Systems Case

- ☒ Scope Case
- ☒ Iron SIGHTS
- ☐ Deployment Kit

Trigger

- ☐ SAFETY OPERATION
- ☒ SET
- ☐

Comments: _____

Remington



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

MODEL 700TM M24

SERIAL NO.
C6665801

20

ORDER NO.
5716

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



5716 C6665801

ORDER **5716**
MODEL 700TM M24

UPC



0 47700 25716 7

ORDER **5716**
MODEL 700TM M24

UPC



0 47700 25716 7

GFM

CONTRACT # DAAA21-87-C-0086

GUN SERIAL #

C6665801

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock		9/24/91	YH
600	Proof		9/24/91	YH
607	Check Headspace		9/24/91	YH
610	Dis-assemble Gun		9/24/91	YH
612	Magnaflux Barrel Action		OCT 2 1991	KR
	Magnaflux Bolt		OCT 2 1991	KR
5	Rollmark Caliber		OCT 2 1991	LS
617	Drill and Tap Sight Holes		OCT 2 1991	LB
618	Polish Barrel		OCT 4 1991	WB
620	Apply Coatings (Barrel Action)		10-14-91	YH
	Apply Coating (Bolt)			YH
625	Final Assembly		10/18/91	YH
	A) Clean inside of Bolt Assembly		10/18/91	YH
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		10/18/91	YH
	C) Inspect Ejector Hole for Chamfer		10/18/91	YH
	D) Oil Firing Pin Ass'y		10/18/91	YH
	E) Adjust Trigger Pull to Min Setting and Stake		10/22/91	YH

op. #	OP. NAME	READINGS				DATE	INIT
625 cont.	F) Safety On Force	4	4	4		10/24/91	JH
	G) Safety Off Force	3	3	3		10/24/91	JH
	H) Trigger Pull Test & Retainability					10/22/91	JH
	I) Firing Pin Indent	.022	.022	.022		10/24/91	JH
	J) Assemble Stock					10/25/91	JH
	K) Assemble Swivel Studs					10-30-91	K
	L) Attach Front and Rear Sight Assemblies					10/25/91	JH
	M) Iron Sight Alignment					10/25/91	JH
	N) Detach Front & Rear Sights & place in numbered container					10/25/91	JH
	O) Attach Scope to Rifle					10/25/91	JH
	P) Detach & Attach Scope 20 Times					10/25/91	JH
640	Gallery Target & Test					10-28-91	AC
	A) Time					10-28-91	AC
	B) Malfunctions					10-28-91	AC
	C) Pierced Primers					10-28-91	AC
	D) Optical Clarity of Scope					10-28-91	AC
645	Inspect for Live Ammo					10-28-91	AC
655	Final Inspection						
	A) Headspace					10-30-91	K
	B) Trigger Pull	259	262	263	266	266	10-29-91 DH
	C) Function					10-30-91	AC
660	Pack					10-25-92	N

SWS TRIGGER PULL TEST

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

SERIAL NO. C-6665801

DATE 10-22-91

TESTER JH

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.24	2.34	2.35	259	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.21	2.35	2.38	262	
PULL #3	2.36	2.35	2.36	263	
PULL #4	2.32	2.32	2.28	266	
PULL #5	2.33	2.36	2.36	266	
TOTAL					
AVG.					

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.39	3.40		
PULL #2	3.45	3.42		
PULL #3	3.46	3.33		
PULL #4	3.46	3.36		
PULL #5	3.48	3.36		
TOTAL				
AVG.				

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.61	4.53		4.55
PULL #2	4.57	4.57		4.59
PULL #3	4.51	4.59		4.60
PULL #4	4.54	4.55		4.60
PULL #5	4.55	4.55		4.63
TOTAL				
AVG.				

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6665801
28 Oct 1991

CENTROIDAL DISTANCES

0 TO 1	.71787
1 TO 2	.439602
1 TO 3	.601348
1 TO 4	.920214
1 TO 5	1.35483

4.5
10 1 <----POR

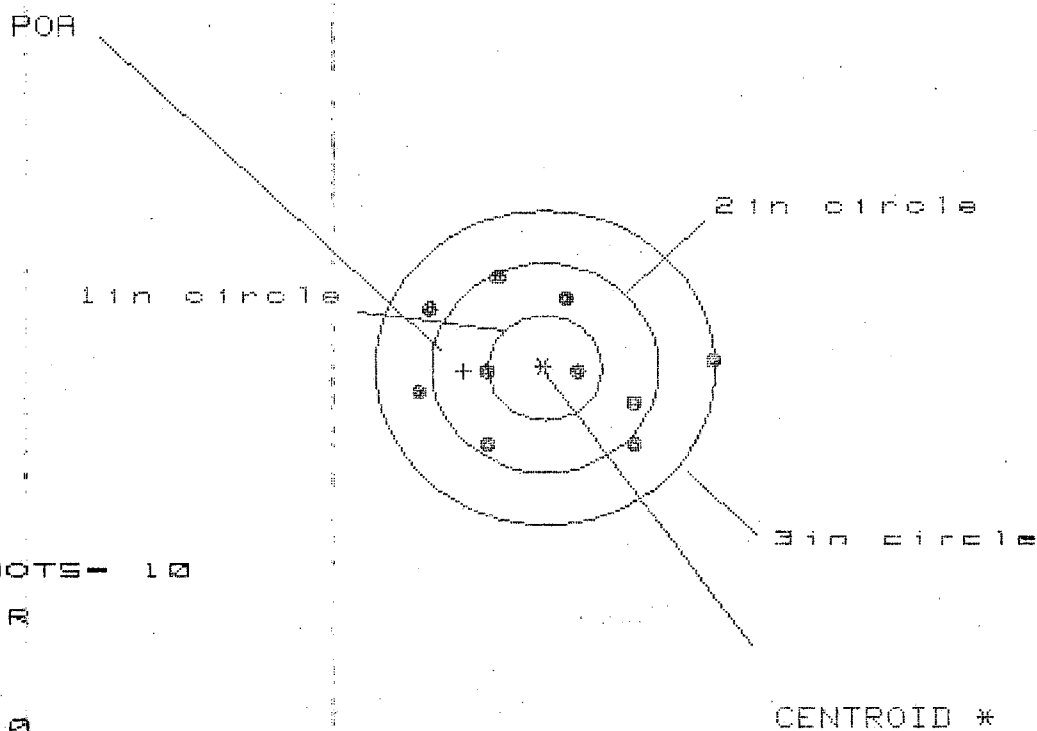
THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .0856
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: -.0072
THE RESULTING AVERAGE PCI-RADIUS FOR THIS RIFLE IS: .0859023
THE RMR FOR THIS RIFLE IS: .9942

28 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665881

CENTERFIRE PATTERNS

1



OF SHOTS- 10

IN CIR

1in = 2

2in = 5

3in = 10

HS= 2.810

VS= 1.682

GS= 2.627

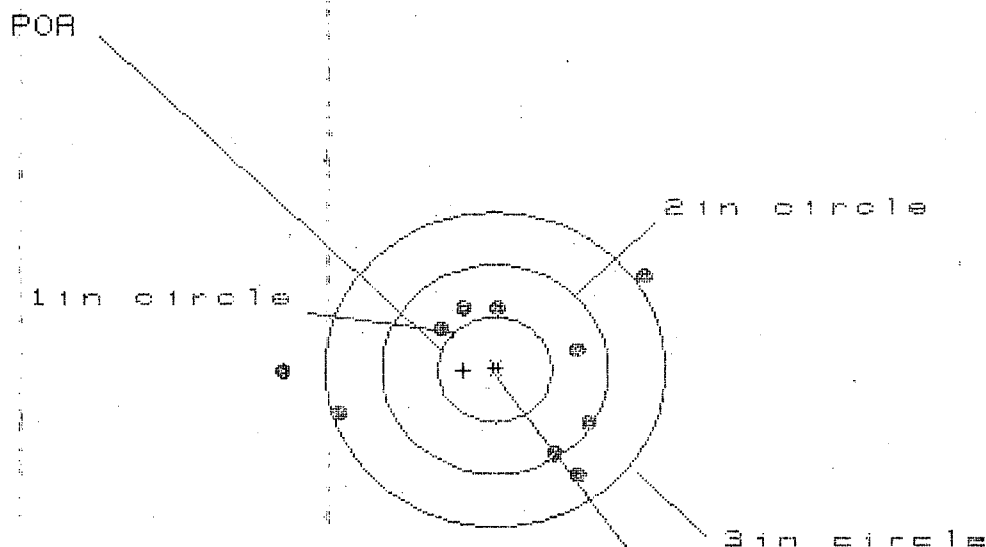
CENTROID *

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.488	.973	.853
MINIMUM X	:	-1.122	-.957	-.935
MAXIMUM Y	:	.906	.916	.891
MINIMUM Y	:	-.776	-.766	-.791
CENTROID X	:	.717	.552	.671
CENTROID Y	:	.031	.021	.046
POR TO CENTROID in.	:	.718	.552	.673
MIN RADIUS	:	.314	.311	.360
MEAN RADIUS	:	.908	.831	.806
MAX RADIUS	:	1.490	1.197	1.124
HORIZONTAL SPREAD	:	2.610	1.930	1.789
VERTICAL SPREAD	:	1.682	1.682	1.682
EXTREME SPREAD	:	2.627	2.165	2.165
NUMBER IN ONE INCH CIRCLE =	:	2		
NUMBER IN TWO INCH CIRCLE =	:	5		
NUMBER IN THREE INCH CIRCLE =	:	10		

28 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665801

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1in = 0

2in = 6

3in = 8

MS- 3.185

VS- 1.943

GS- 3.318

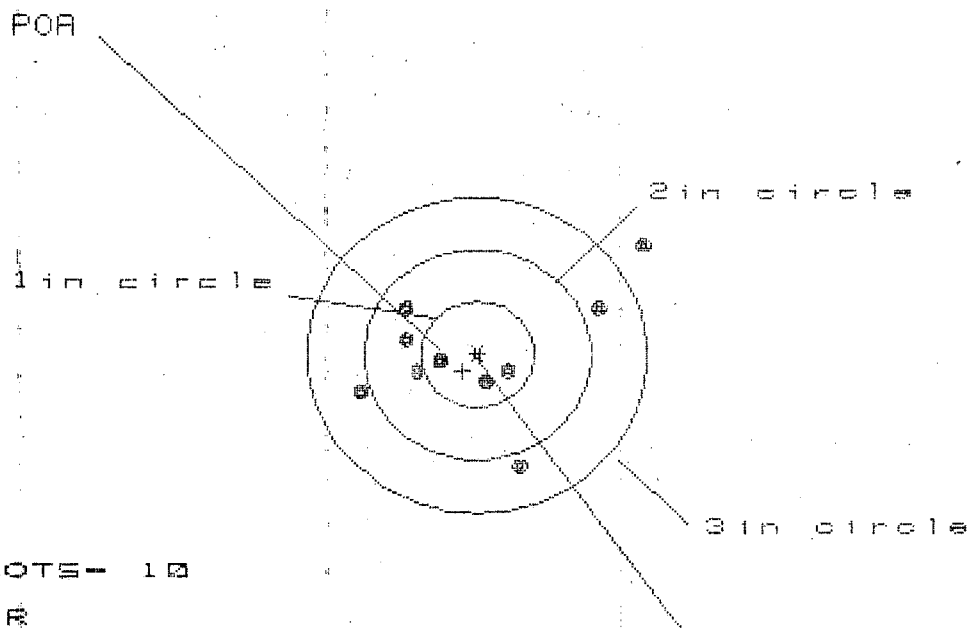
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.277	1.065	.754
MINIMUM X	:	-1.908	-1.634	-1.501
MAXIMUM Y	:	.929	.928	.750
MINIMUM Y	:	-1.014	-1.015	-.898
CENTROID X	:	.278	.490	.357
CENTROID Y	:	.008	.009	-.108
POA TO CENTROID in.	:	.279	.491	.373
MIN RADIUS	:	.568	.542	.703
MEAN RADIUS	:	1.080	.965	.916
1st RADIUS	:	1.908	1.685	1.530
HORIZONTAL SPREAD	:	3.185	2.699	2.255
VERTICAL SPREAD	:	1.943	1.943	1.648
EXTREME SPREAD	:	3.318	3.013	2.273
SHOTS IN ONE INCH CIRCLE	=		0	
SHOTS IN TWO INCH CIRCLE	=		6	
SHOTS IN THREE INCH CIRCLE	=		8	

28 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C8665801

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 6

3 in = 9

1st = 2.341

2nd = 2.041

3rd = 2.919

CENTROID #

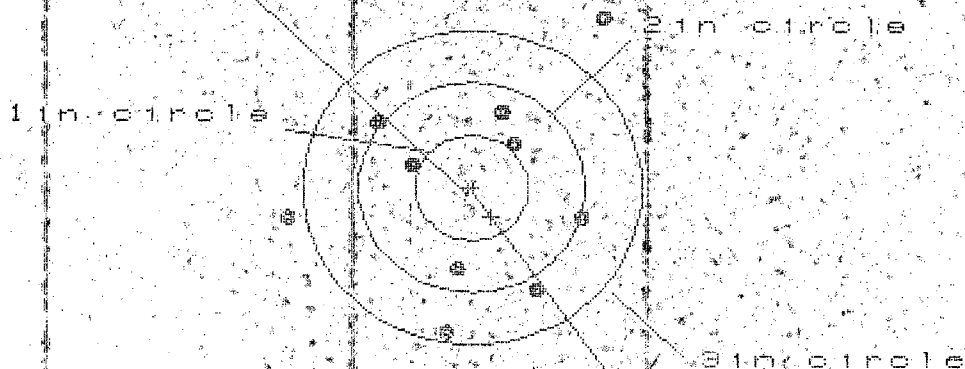
Parameter	10	9	8
1st IMP	1.493	1.196	.672
2nd IMP	-1.048	-.882	-.733
3rd IMP	1.030	.594	.595
4th IMP	-1.010	-.896	-.822
5th IMP	.129	-.037	-.186
6th IMP	.157	.043	-.031
POA - CENTERFIRE	.204	.056	.189
1st IMP	.275	.170	.143
2nd IMP	.801	.641	.534
3rd IMP	1.814	1.335	1.062
4th IMP	2.541	2.078	1.485
5th IMP	2.041	1.490	1.417
6th IMP	2.919	2.259	1.703
1st IMP	3	3	3
2nd IMP	6	6	6
3rd IMP	9	9	9

28 Oct 1991

FILE:/PATTERNING/CENTERFIRE PATT/C86658B1

CENTERFIRE PATTERNS # 4

POA



OF SHOTS- 10

IN CIR

1 in 5

2 in 3

3 in 2

1 in 5

2 in 3

3 in 2

CENTROID #

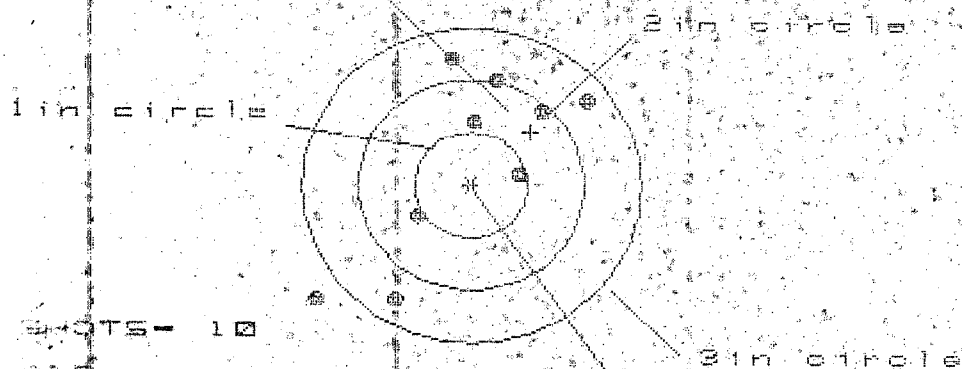
PATTERN #	1	2	3
SHOTS (B&A OR)	10	9	8
MAXIMUM X	1.137	1.084	.901
MINIMUM X	-1.589	-1.462	-1.058
MAXIMUM Y	1.601	.941	.930
MINIMUM Y	-1.334	-1.157	-1.168
CENTROID X	-.170	-.287	-.114
CENTROID Y	.276	.099	.110
POA TO CENTROID in.	.325	.313	.158
MIN RADIUS	.564	.566	.612
MAX RADIUS	1.075	.969	.892
AVG RADIUS	1.963	1.465	1.201
HORIZONTAL SPREAD	2.726	2.546	1.759
VERTICAL SPREAD	2.365	2.098	2.098
EXTREME SPREAD	3.305	2.547	2.162
NUMBER IN ONE INCH CIRCLE	5	5	5
NUMBER IN TWO INCH CIRCLE	8	8	8
NUMBER IN THREE INCH CIRCLE	10	9	8

28 Oct 1991

FILE:/PATTERNING/CENTERFIRE_PATT/C6665801

CENTERFIRE PATTERNS # 5

FOR



NUMBER OF SHOTS - 10

IN CIRCLE

1 10

2 4

3 4

4 2

5 1

6 1

7 1

8 1

9 1

10 1

CENTROID #

ATTACH #

15

SHOTS IN CIRCLE	10	9	8
MAXIMUM X	1.050	1.103	.938
MINIMUM X	-1.359	-1.314	-.824
MEAN X	1.246	1.029	.860
STANDARD DEVIATION X	1.249	1.355	1.428
CENTROID X	1.526	1.571	1.406
MAXIMUM Y	1.500	1.291	1.122
MINIMUM Y	1.711	1.641	1.424
MEAN Y	1.404	1.360	1.182
STANDARD DEVIATION Y	1.107	1.964	1.777
MEAN RADII	1.569	1.887	1.648
HORIZONTAL SPREAD	2.417	2.417	1.762
VERTICAL SPREAD	2.195	2.384	2.288
DIAMETER	3.247	3.090	2.540
NUMBER OF SHOTS IN CIRCLE	1	1	1
NUMBER IN TWO INCH CIRCLE	4	4	4
NUMBER IN THREE INCH CIRCLE	8	8	8

CONTRACT # DAAA21-87-C-0086

GUN SERIAL # C6348959

OP. #	OP. NAME	READINGS	DATE	INIT
575 & 580	Assemble Action and Stock	7 21 89	7 21 89	RW
600	Proof	7 21 89	7 21 89	RW
607	Check Headspace	7 21 89	7 21 89	RW
610	Dis-assemble Gun	7 21 89	7 21 89	RW
612	Magnaflux Barrel Action		7/25/89	KR
	Magnaflux Bolt		7/25/89	KR
615	Rollmark Caliber		7/25/89	JS
7	Drill and Tap Sight Holes		7/27/89	WC
618	Polish Barrel <i>KB</i>		7/31/89	KB
620	Apply Coatings (Barrel Action)		8/7/89	JH
	Apply Coating (Bolt)		8/7/89	JH
625	Final Assembly A) Clean inside of Bolt Assembly		8/7/89	RW
	B) Inspect Rear Firing Pin Hole for Chamfer in Bolt Head		8/7/89	RW
	C) Inspect Ejector Hole for Chamfer		8/7/89	RW
	D) Oil Firing Pin Ass'y		8/7/89	RW
	E) Adjust Trigger Pull to Min Setting and Stake		8/11/89	Ju

op. #	OP. NAME	READINGS					DATE	INIT
625 cont.	F) Safety On Force	5	5	5			8/11/89	JK
	G) Safety Off Force	4	4	4			8/11/89	JK
	H) Trigger Pull Test & Retainability						8/11/89	JK
	I) Firing Pin Indent	.20	.20	.20			8/11/89	JK
	J) Assemble Stock						8/15/89	RW
	K) Assemble Swivel Studs						23 Aug 89	JS
	L) Attach Front and Rear Sight Assemblies						8/15/89	RW
	M) Iron Sight Alignment						8/15/89	RW
	N) Detach Front & Rear Sights & place in numbered container						8/15/89	RW
	O) Attach Scope to Rifle						8/15/89	JK
	P) Detach & Attach Scope 20 Times						8/14/89	JK
640	Gallery Target & Test	68 R 83 L					8-21-89	AC
	A) Time						8-21-89	AC
	B) Malfunctions						8-21-89	AC
	C) Pierced Primers						8-21-89	AC
	D) Optical Clarity of Scope						8-21-89	AC
645	Inspect for Live Ammo						8-21-89	AC
655	Final Inspection							
	A) Headspace						23 Aug 89	JS
	B) Trigger Pull	2.71	2.75	2.82	2.76	2.80	23 Aug 89	JS
	C) Function						23 Aug 89	JS
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. C6348959
DATE 11 Aug 89
TESTER JEL

	2.50# INITIAL	2.50# AFTER 50 CYCLES	FINAL TEST & TO RESET 2.50#		COMMENTS
PULL #1	2.49	2.53	2.63	2.71	MIN. SETTING, NO AVG. OF 5 READINGS ACCEPT- ABLE LESS THAN 2#
PULL #2	2.56	2.51	2.47	2.75	
PULL #3	2.50	2.47	2.53	2.82	
PULL #4	2.60	2.55	2.50	2.76	
PULL #5	2.45	2.50	2.60	2.80	
TOTAL	12.60	12.56	12.73	13.84	
AVG.	2.52	2.512	2.546	2.768	

	3.00# INITIAL	3.00# AFTER 20 CYCLES		COMMENTS
PULL #1	3.31	3.44		
PULL #2	3.27	3.39		
PULL #3	3.27	3.39		
PULL #4	3.40	3.41		
PULL #5	3.36	3.28		
TOTAL	16.61	16.89		
AVG.	3.322	3.378		

	4.00# INITIAL	4.00# AFTER 20 CYCLES	MAX SETTING GREATER THAN 4#	RESET TO 4# FOR TARGET & ACCURACY
PULL #1	4.44	4.51		3.91
PULL #2	4.31	4.37		4.27
PULL #3	4.40	4.44		4.21
PULL #4	4.41	4.40		4.30
PULL #5	4.37	4.47		4.16
TOTAL	21.93	22.19		20.85
AVG.	4.386	4.438		4.17

SWS ENDURANCE TEST REPORT

SERIAL NO. 6348959 SHOOTER DH & AC DATE Aug 31, 1989

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	NONE
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	OK	NONE
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	TOTAL	840		

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348959 SHOOTER JU+ DIT DATE 9-1-89

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	NONE
	7.62	60	OK	"
	7.62	60	OK	"
	7.62	60	OK	"
	7.62	60	OK	NONE
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	40	"	"
TOTAL	700		PAGE 3	
	840		PAGE 2	
	960		PAGE 1	
TOTAL	2500		9-1-89	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348959 SHOOTER AC + DH DATE Sept 5 1989

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	NONE
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	30	"	"
	TOTAL	270		
	7.62	60	OK	NONE
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	TOTAL	480		
	TOTAL	(750)	9-5-89	

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348959 SHOOTER AC & DH DATE 9-6-89

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	NONE
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	TOTAL	420		
	7.62	60	OK	NONE
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	60	"	"
	"	10	"	"
	TOTAL	430	9-6-89	
		850		

SWS ENDURANCE TEST REPORT

SERIAL NO. CG348959 SHOOTER AC & DH DATE 9-7-89

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	60	OK	NONE
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	60	"	"
	7.62	40	"	"
	Total	400		
	Page 1	960		
	Page 2	840		
	Page 3	700		
	Page 4	750		
	Page 5	850		
	Total	4500		
	TARGET	60	OK	NONE
	TOTAL	4560	9-8-89	

SWS ENDURANCE TEST REPORT

9-12-89

9/13/89

SWS ENDURANCE TEST REPORT

SERIAL NO. C6348959 SHOOTER AK & DH DATE Sept. 14 1989

AMMO CODE	AMMO TYPE	RDS.	RESULTS	OBSERVATIONS
	7.62	100	OK	NONE
	7.62	100	"	"
	7.62	100	"	"
	7.62	100	"	"
	7.62	100	"	"
	7.62	100	9-14-89	"
	11	100	11	11
	11	100	11	11
	11	100	11	11
	11	100	11	11
	11	100	11	11
TOTAL	1000			
	6000			
	7000			

SERIAL NO

[illegible]

1

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348959
21 Aug 1989

0 ROUNDS

CENTROIDAL DISTANCES

0 TO	1	.296892
1 TO	2	.42518
1 TO	3	.382126
1 TO	4	.938186
1 TO	5	.348941

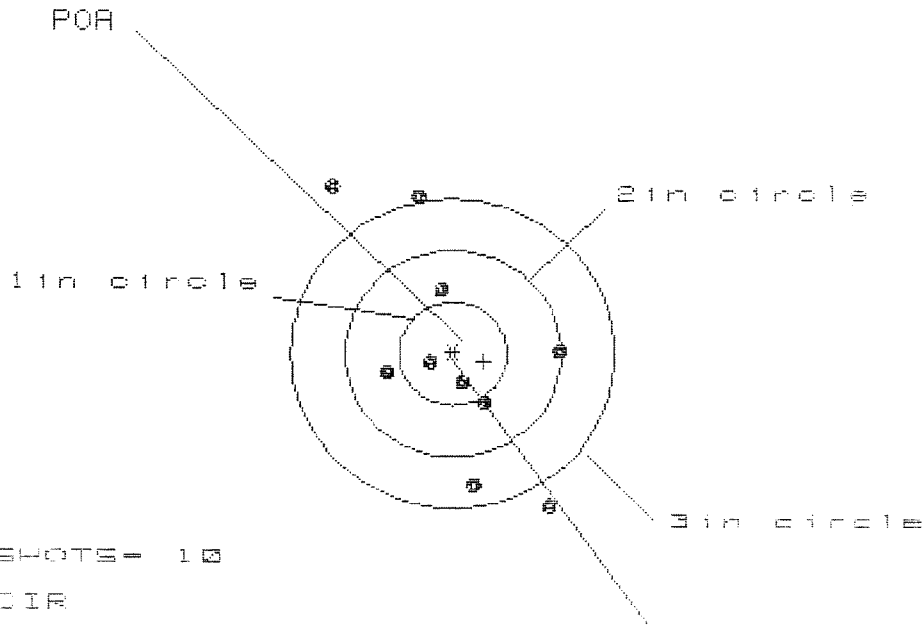
$\frac{5^3}{4}$ (----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.4836
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0584
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .407803
THE AMP FOR THIS RIFLE IS: 1.048

21 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348959

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1 in = 2

2 in = 6

3 in = 7

HS= 2.044

VS= 3.061

GS= 3.651

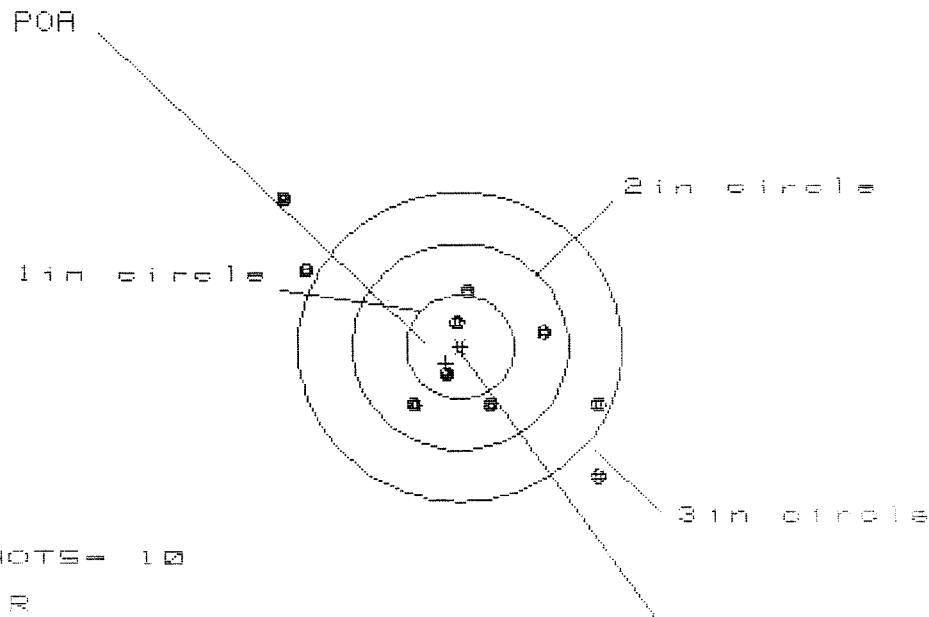
CENTROID #

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.945	.823	.919
MINIMUM X	:	-1.099	-.712	-.616
MAXIMUM Y	:	1.612	1.718	1.560
MINIMUM Y	:	-1.449	-1.270	-1.236
CENTROID X	:	-.287	-.165	-.261
CENTROID Y	:	.076	-.103	.055
POA TO CENTROID in.	:	.297	.194	.267
MIN RADIUS	:	.243	.080	.246
MEAN RADIUS	:	.974	.831	.759
MAX RADIUS	:	1.951	1.780	1.603
HORIZONTAL SPREAD	:	2.044	1.535	1.535
VERTICAL SPREAD	:	3.061	2.988	2.796
EXTREME SPREAD	:	3.651	3.233	2.850
NUMBER IN ONE INCH CIRCLE =			2	
NUMBER IN TWO INCH CIRCLE =			6	
NUMBER IN THREE INCH CIRCLE =			7	

21 Aug 1985

FILE:/PATTERNING/CENTERFIRE_PATT/C634B359

CENTERFIRE PATTERNS # 2



OF SHOTS - 10

IN CIR

1in = 2

2in = 6

3in = 7

HS = 3.085

VS = 2.613

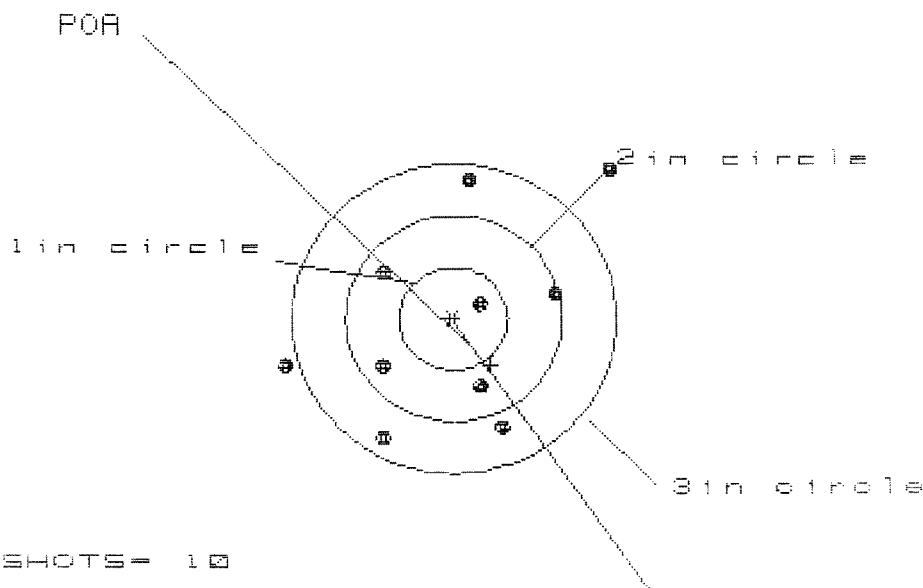
GS = 3.878

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.266	1.088	1.183
MINIMUM X	:	-1.599	-1.594	-1.458
MAXIMUM Y	:	1.399	.934	.801
MINIMUM Y	:	-1.214	-1.058	-.556
CENTROID X	:	.130	.308	.172
CENTROID Y	:	.159	.003	.136
POA TO CENTROID in.	:	.205	.308	.219
MIN RADIUS	:	.237	.278	.257
MEAN RADIUS	:	.997	.857	.760
MAX RADIUS	:	2.125	1.847	1.664
HORIZONTAL SPREAD	:	2.865	2.682	2.641
VERTICAL SPREAD	:	2.613	1.992	1.357
EXTREME SPREAD	:	3.878	3.341	2.945
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		7	

21 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348959

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 4

3 in = 8

HS= 2.997

VS= 2.587

GS= 3.536

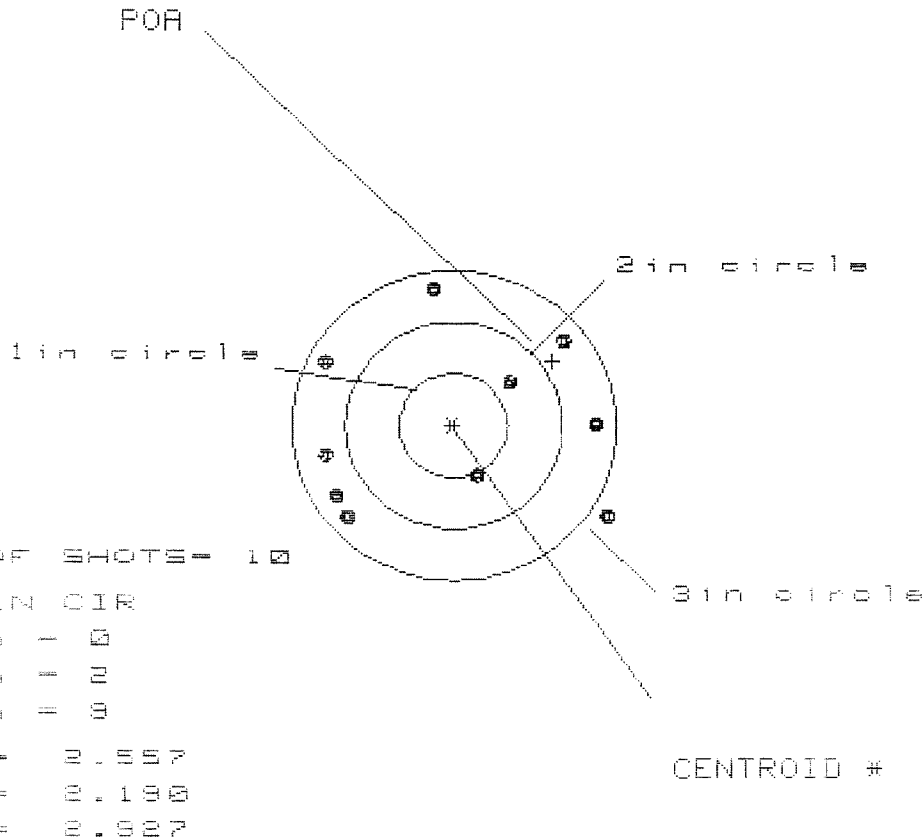
PATTERN #	3	3	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.465	1.134	.963
MINIMUM X	-1.532	-1.369	-.686
MAXIMUM Y	1.431	1.548	1.513
MINIMUM Y	-1.156	-.997	-1.032
CENTROID X	-.343	-.506	-.335
CENTROID Y	.454	.295	.330
POA TO CENTROID in.	.569	.586	.471
MIN RADIUS	.274	.493	.336
MEAN RADIUS	1.107	.984	.917
MAX RADIUS	2.048	1.575	1.517
HORIZONTAL SPREAD	2.997	2.503	1.649
VERTICAL SPREAD	2.587	2.545	2.545
EXTREME SPREAD	3.536	2.667	2.667
NUMBER IN ONE INCH CIRCLE =		1	
NUMBER IN TWO INCH CIRCLE =		4	
NUMBER IN THREE INCH CIRCLE =		8	

21 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/06348959

CENTERFIRE PATTERNS

4

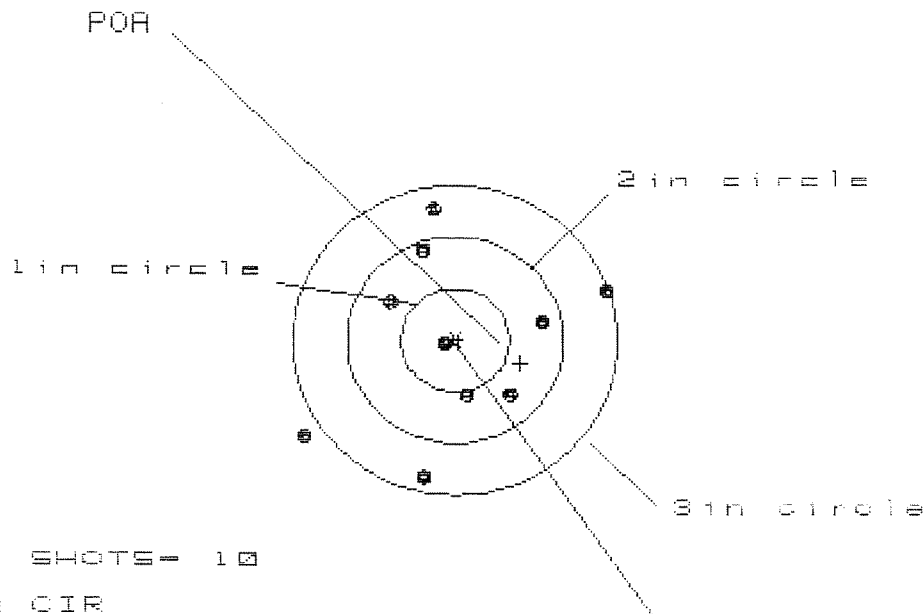


PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.401	1.506	1.393
MINIMUM X	-1.157	-1.001	-0.813
MAXIMUM Y	1.322	1.229	1.220
MINIMUM Y	-0.868	-0.961	-0.970
CENTROID X	-0.915	-1.071	-1.259
CENTROID Y	-0.621	-0.528	-0.519
POA TO CENTROID in.	1.106	1.194	1.362
MIN RADIUS	.570	.730	.859
MEAN RADIUS	1.199	1.145	1.084
MAX RADIUS	1.630	1.508	1.559
HORIZONTAL SPREAD	2.557	2.507	2.206
VERTICAL SPREAD	2.190	2.190	2.190
EXTREME SPREAD	2.927	2.662	2.662
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	2		
NUMBER IN THREE INCH CIRCLE =	9		

21 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348959

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 1

2in = 6

3in = 8

HE= 2.858

VE= 2.605

GE= 3.196

CENTROID *

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.437	1.279	.845
MINIMUM X	:	-1.421	-.735	-.575
MAXIMUM Y	:	1.316	1.211	1.259
MINIMUM Y	:	-1.289	-1.394	-1.346
CENTROID X	:	-.603	-.445	-.605
CENTROID Y	:	.224	.329	.281
POA TO CENTROID in.	:	.644	.554	.667
MIN RADIUS	:	.108	.296	.137
MEAN RADIUS	:	.965	.890	.808
MAX RADIUS	:	1.704	1.451	1.368
HORIZONTAL SPREAD	:	2.858	2.014	1.420
VERTICAL SPREAD	:	2.605	2.605	2.605
EXTREME SPREAD	:	3.196	2.605	2.605
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		8	

2

500 ROUNDS

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348959
31 Aug 1989

CENTROIDAL DISTANCES

0 TO	1	.403838
1 TO	2	.482271
1 TO	3	.751394
1 TO	4	.610551
1 TO	5	.345984

3
5
1

<----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.0862
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .0002
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .0862002
THE AMR FOR THIS RIFLE IS: .8452

30 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6340959.1

CENTERFIRE PATTERNS # 1

POA

1 in circle

2 in circle

3 in circle

CENTROID *

OF SHOTS= 10

IN CIR

1 in = 6

2 in = 8

3 in = 8

HS= 1.076

VS= 3.518

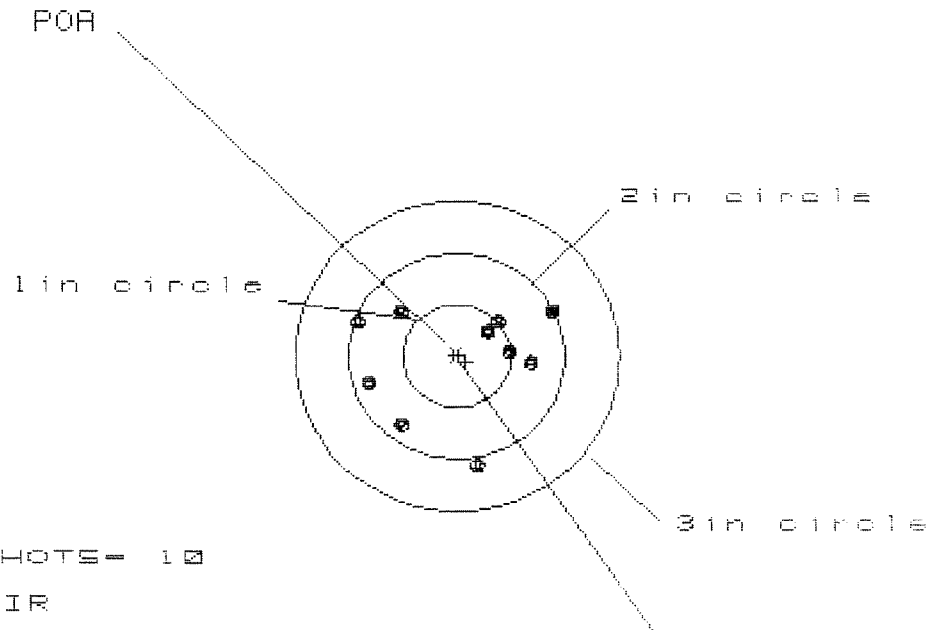
GS= 3.547

PATTERN #	:	1		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.445	.375	.344
MINIMUM X	:	-.631	-.442	-.473
MAXIMUM Y	:	1.791	1.599	.480
MINIMUM Y	:	-1.727	-1.094	-.894
CENTROID X	:	.074	.144	.175
CENTROID Y	:	-.397	-.205	-.405
POA TO CENTROID in.	:	.404	.250	.441
MIN RADIUS	:	.166	.249	.235
MEAN RADIUS	:	.713	.585	.424
MAX RADIUS	:	1.839	1.617	.895
HORIZONTAL SPREAD	:	1.076	.817	.817
VERTICAL SPREAD	:	3.518	2.693	1.374
EXTREME SPREAD	:	3.547	2.704	1.425
NUMBER IN ONE INCH CIRCLE	=		6	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		8	

30 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348353.1

CENTERFIRE PATTERNS # 2



OF SHOTS = 10

IN CIR

1 in = 1

2 in = 8

3 in = 10

HS = 1.814

VS = 1.515

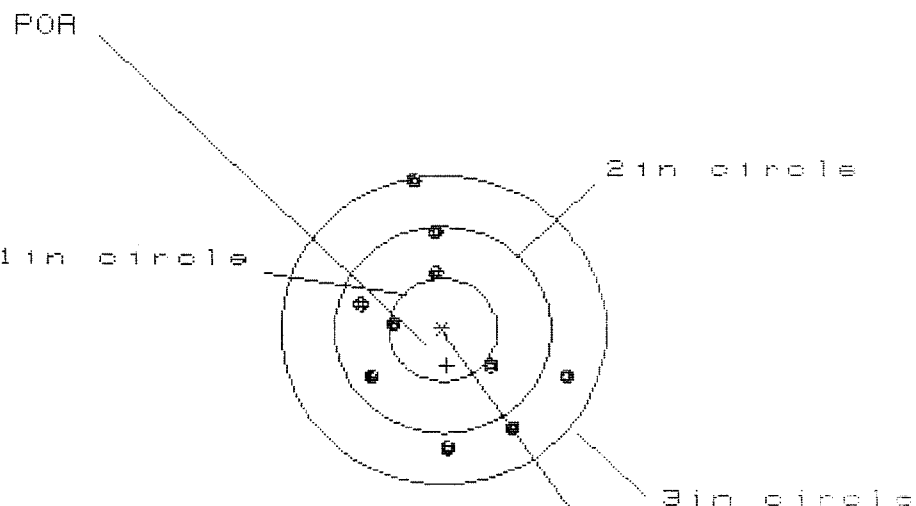
GS = 1.864

PATTERN #	2	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.889	.909	.791
MINIMUM X	-.925	-.905	-.791
MAXIMUM Y	.475	.359	.402
MINIMUM Y	-1.040	-.745	-.702
CENTROID X	-.083	-.103	-.217
CENTROID Y	.059	.175	.132
POA TO CENTROID in.	.102	.203	.254
MIN RADIUS	.348	.294	.415
MEAN RADIUS	.758	.712	.689
MAX RADIUS	1.056	.972	.843
HORIZONTAL SPREAD	1.814	1.814	1.582
VERTICAL SPREAD	1.515	1.104	1.104
EXTREME SPREAD	1.864	1.864	1.648
NUMBER IN ONE INCH CIRCLE =	1		
NUMBER IN TWO INCH CIRCLE =	8		
NUMBER IN THREE INCH CIRCLE =	10		

30 Aug 1985

FILE:/PATTERNING/CENTERFIRE_PATT/C6346353.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 1

2in = 6

3in = 10

HE= 1.077

VS= 2.571

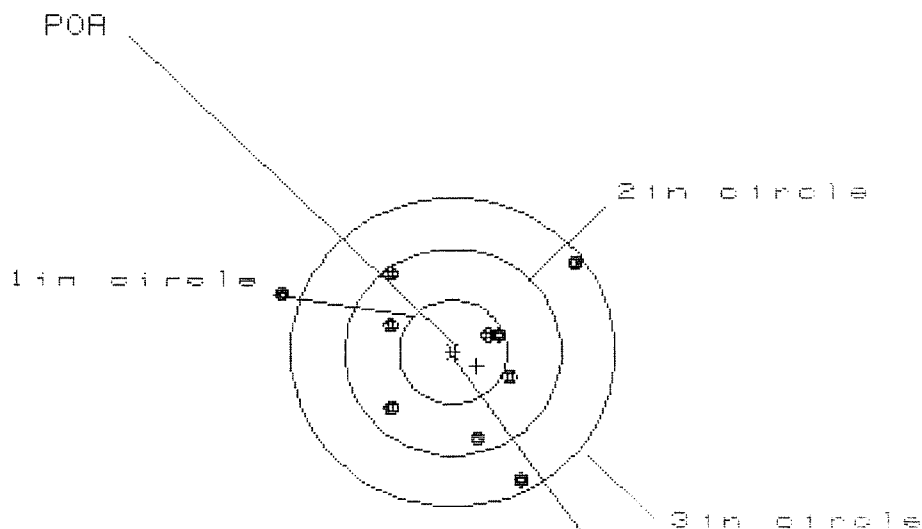
GS= 2.593

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.108	1.079	.755
MINIMUM X	:	-.769	-.798	-.663
MAXIMUM Y	:	1.433	1.089	1.048
MINIMUM Y	:	-1.138	-.979	-1.020
CENTROID X	:	-.038	-.009	-.144
CENTROID Y	:	.346	.187	.228
POA TO CENTROID in.	:	.348	.187	.269
MIN RADIUS	:	.460	.447	.394
MEAN RADIUS	:	.911	.846	.791
MAX RADIUS	:	1.456	1.127	1.119
HORIZONTAL SPREAD	:	1.877	1.877	1.418
VERTICAL SPREAD	:	2.571	2.068	2.068
EXTREME SPREAD	:	2.593	2.070	2.070
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		10	

30 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348359.1

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1in = 2

2in = 7

3in = 9

HS = 2.659

VS = 2.016

GS = 2.816

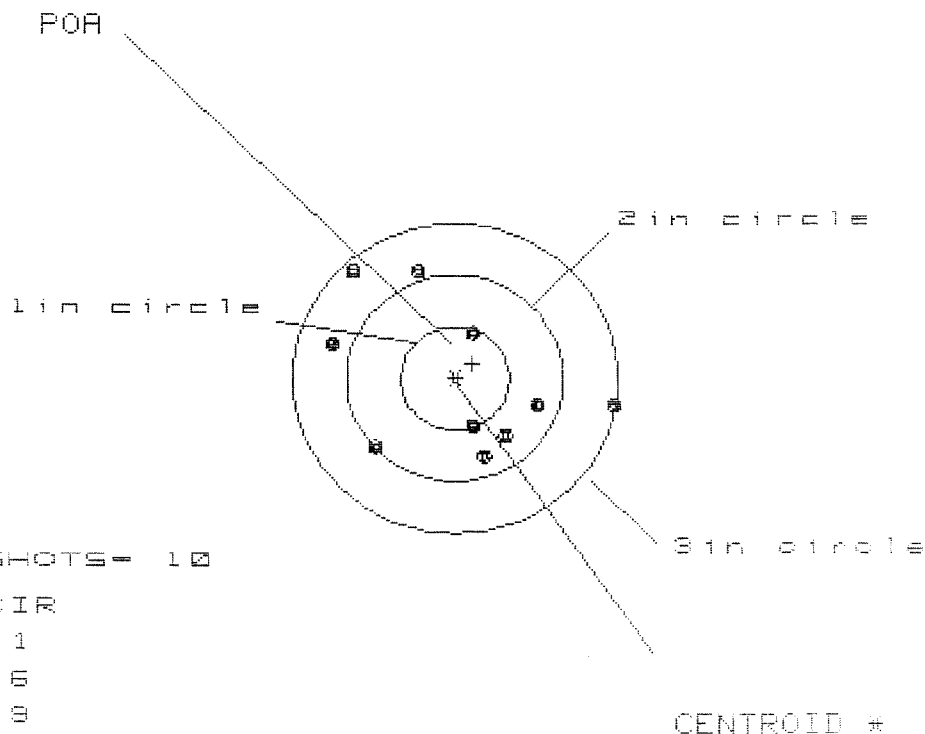
CENTROID #

PATTERN #	4		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.113	.941	.607
MINIMUM X	-1.546	-.721	-.604
MAXIMUM Y	.817	.878	.961
MINIMUM Y	-1.199	-1.138	-1.028
CENTROID X	-.222	-.050	-.167
CENTROID Y	.137	.076	-.034
POA TO CENTROID in.	.260	.091	.171
MIN RADIUS	.393	.303	.435
MEAN RADIUS	.890	.779	.724
MAX RADIUS	1.641	1.287	1.194
HORIZONTAL SPREAD	2.659	1.662	1.211
VERTICAL SPREAD	2.016	2.016	1.989
EXTREME SPREAD	2.816	2.329	2.329
NUMBER IN ONE INCH CIRCLE =		2	
NUMBER IN TWO INCH CIRCLE =		7	
NUMBER IN THREE INCH CIRCLE =		9	

30 Aug 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B353.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1 in = 1

2 in = 6

3 in = 9

HS= 2.672

VS= 1.751

GS= 2.788

PATTERN #	:	5		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	1.489	.957	.856
MINIMUM X	:	-1.183	-1.018	-1.119
MAXIMUM Y	:	1.036	1.005	1.097
MINIMUM Y	:	-.715	-.746	-.620
CENTROID X	:	-.162	-.327	-.226
CENTROID Y	:	-.144	-.113	-.239
POA TO CENTROID in.	:	.216	.346	.329
MIN RADIUS	:	.458	.563	.404
MEAN RADIUS	:	.954	.900	.818
MAX RADIUS	:	1.514	1.288	1.201
HORIZONTAL SPREAD	:	2.672	1.975	1.975
VERTICAL SPREAD	:	1.751	1.751	1.717
EXTREME SPREAD	:	2.788	2.180	2.061
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		6	
NUMBER IN THREE INCH CIRCLE	=		9	

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348959
8 Sep 1989

4500# Rou

3

CENTROIDAL DISTANCES

0 TO	1	.0756637
1 TO	2	.20412
1 TO	3	.277115
1 TO	4	.605483
1 TO	5	.0663099

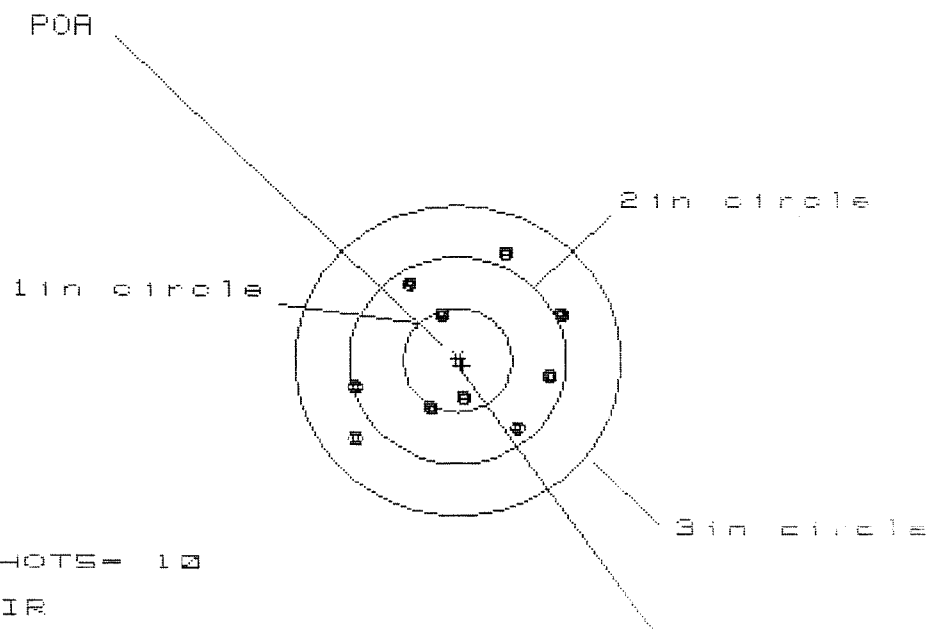
$\frac{4}{24}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -.1442
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1974
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .244459
THE AMR FOR THIS RIFLE IS: .7882

8 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B359.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS- 10

IN CIR

1in = 3

2in = 6

3in = 10

HS= 1.920

VS= 1.745

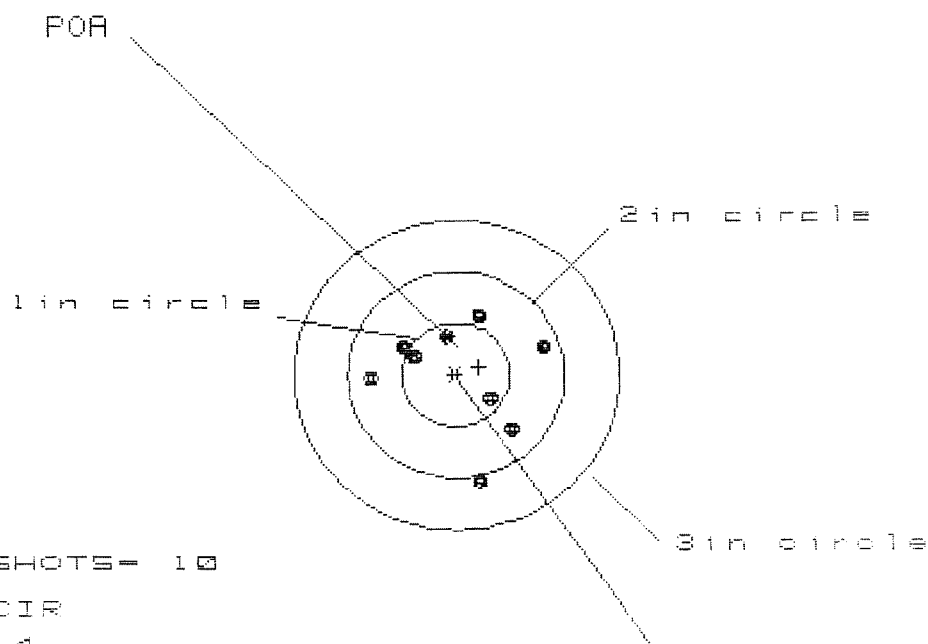
GS= 2.224

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.941	.834	.871
MINIMUM X	-.980	-1.086	-1.049
MAXIMUM Y	.997	.913	.784
MINIMUM Y	-.748	-.778	-.663
CENTROID X	-.053	.054	.017
CENTROID Y	.054	.138	.023
POA TO CENTROID in.	.076	.148	.029
MIN RADIUS	.357	.428	.314
MEAN RADIUS	.823	.777	.737
MAX RADIUS	1.218	1.128	1.067
HORIZONTAL SPREAD	1.920	1.920	1.920
VERTICAL SPREAD	1.745	1.691	1.447
EXTREME SPREAD	2.224	2.020	2.020
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	6		
NUMBER IN THREE INCH CIRCLE =	10		

8 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6346359.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS= 10

IN CIR

1 in = 4

2 in = 9

3 in = 10

HS= 1.588

VS= 1.569

GS= 1.616

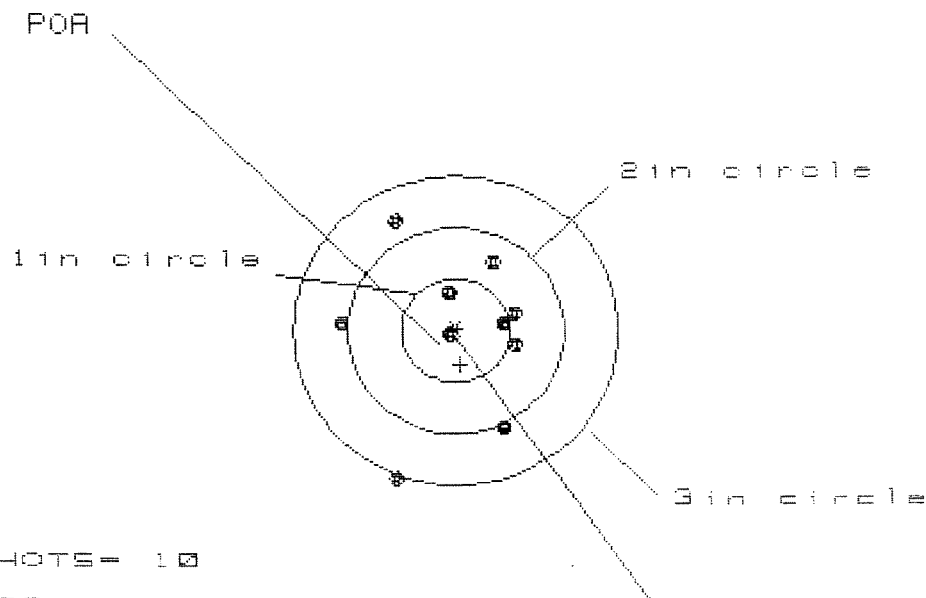
CENTROID #

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.839	.863	.653
MINIMUM X	:	-.749	-.725	-.617
MAXIMUM Y	:	.546	.432	.457
MINIMUM Y	:	-1.023	-.679	-.654
CENTROID X	:	-.212	-.236	-.344
CENTROID Y	:	-.074	.040	.015
POA TO CENTROID in.	:	.224	.240	.345
MIN RADIUS	:	.370	.266	.226
MEAN RADIUS	:	.619	.548	.482
MAX RADIUS	:	1.047	.886	.925
HORIZONTAL SPREAD	:	1.588	1.588	1.270
VERTICAL SPREAD	:	1.569	1.111	1.111
EXTREME SPREAD	:	1.616	1.616	1.394
NUMBER IN ONE INCH CIRCLE	=		4	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C834B959.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 1.693

VS= 2.513

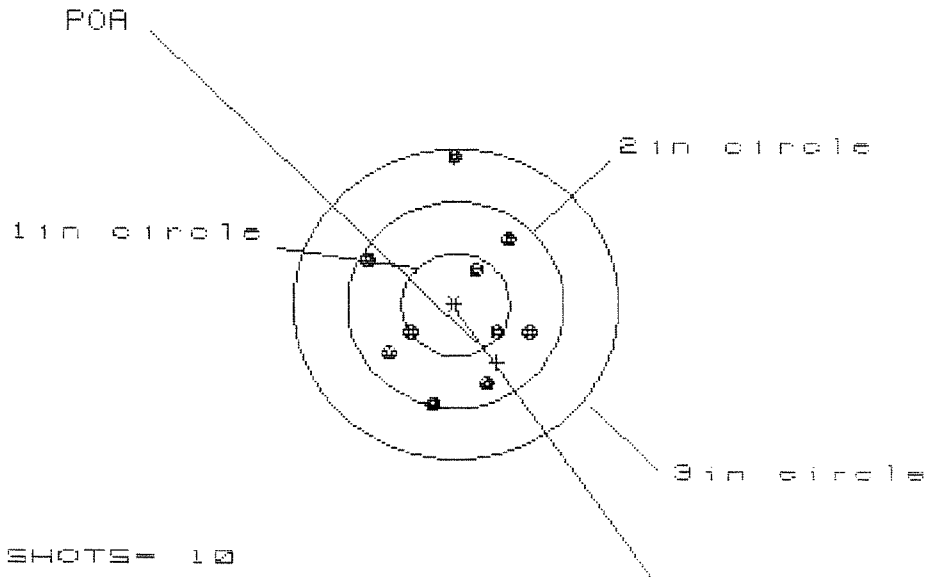
GS= 2.513

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.589	.525	.448
MINIMUM X	:	-1.104	-1.168	-1.245
MAXIMUM Y	:	1.051	.889	.643
MINIMUM Y	:	-1.462	-1.048	-.937
CENTROID X	:	-.045	.019	.096
CENTROID Y	:	.331	.493	.382
POA TO CENTROID in.	:	.334	.493	.394
MIN RADIUS	:	.057	.203	.204
MEAN RADIUS	:	.771	.657	.590
MAX RADIUS	:	1.572	1.170	1.246
HORIZONTAL SPREAD	:	1.693	1.693	1.693
VERTICAL SPREAD	:	2.513	1.937	1.580
EXTREME SPREAD	:	2.513	2.179	1.849
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

8 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B359.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS= 10

IN CIR

1 in = 3

2 in = 3

3 in = 10

HS= 1.525

VS= 2.375

GS= 2.392

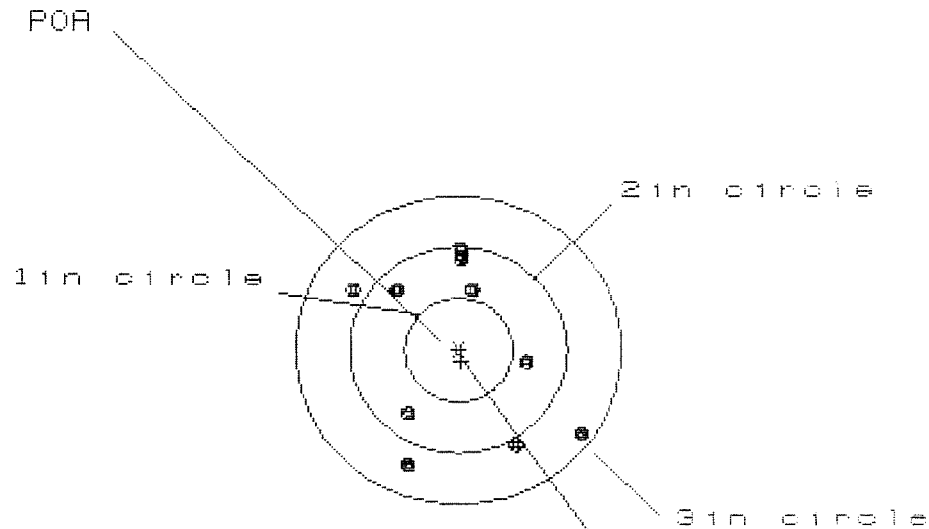
CENTROID *

PATTERN #	:	4		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.699	.703	.671
MINIMUM X	:	-.826	-.822	-.854
MAXIMUM Y	:	1.452	.819	.724
MINIMUM Y	:	-.923	-.762	-.666
CENTROID X	:	-.384	-.388	-.356
CENTROID Y	:	.561	.400	.495
POA TO CENTROID in.	:	.680	.557	.610
MIN RADIUS	:	.367	.403	.414
MEAN RADIUS	:	.782	.688	.671
MAX RADIUS	:	1.452	1.002	.978
HORIZONTAL SPREAD	:	1.525	1.525	1.525
VERTICAL SPREAD	:	2.375	1.581	1.390
EXTREME SPREAD	:	2.392	1.765	1.650
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		9	
NUMBER IN THREE INCH CIRCLE	=		10	

8 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B959.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 0

2in = 5

3in = 10

HS= 2.126

VS= 2.147

GS= 2.537

CENTROID *

PATTERN #	5	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.152	.752	.712
MINIMUM X	-.974	-.846	-.886
MAXIMUM Y	1.010	.919	.765
MINIMUM Y	-1.137	-1.228	-1.121
CENTROID X	-.027	-.155	-.115
CENTROID Y	.115	.206	.360
POA TO CENTROID in.	.118	.258	.378
MIN RADIUS	.558	.528	.380
MEAN RADIUS	.946	.876	.793
MAX RADIUS	1.415	1.270	1.282
HORIZONTAL SPREAD	2.126	1.598	1.598
VERTICAL SPREAD	2.147	2.147	1.886
EXTREME SPREAD	2.537	2.193	2.085
NUMBER IN ONE INCH CIRCLE =	0		
NUMBER IN TWO INCH CIRCLE =	5		
NUMBER IN THREE INCH CIRCLE =	10		

(4)

5000
~~4500~~ ROUNDS

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # C6348959
11 Sep 1989

CENTROIDAL DISTANCES

0 TO	1	.922338
1 TO	2	.32966
1 TO	3	.387363
1 TO	4	.458813
1 TO	5	.842639

$\frac{5}{31}$ <----POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: .634
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .1132
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .644627

THE AMR FOR THIS RIFLE IS: .6874

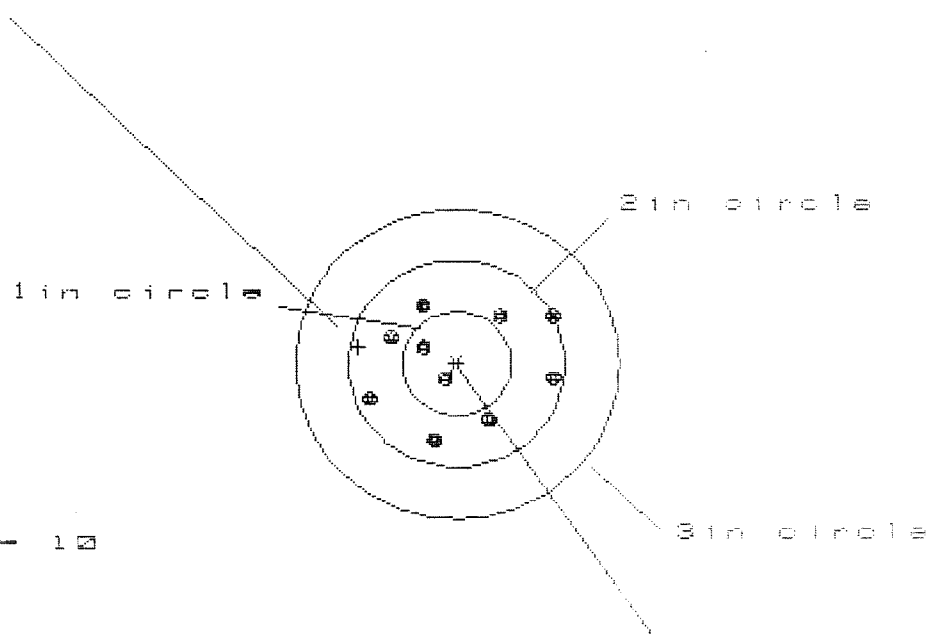
11 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B959.1.1.1

CENTERFIRE PATTERNS

1

POA



OF SHOTS- 10

IN CIR

1 in = 2

2 in = 10

3 in = 10

HS= 1.679

VS= 1.284

GS= 1.804

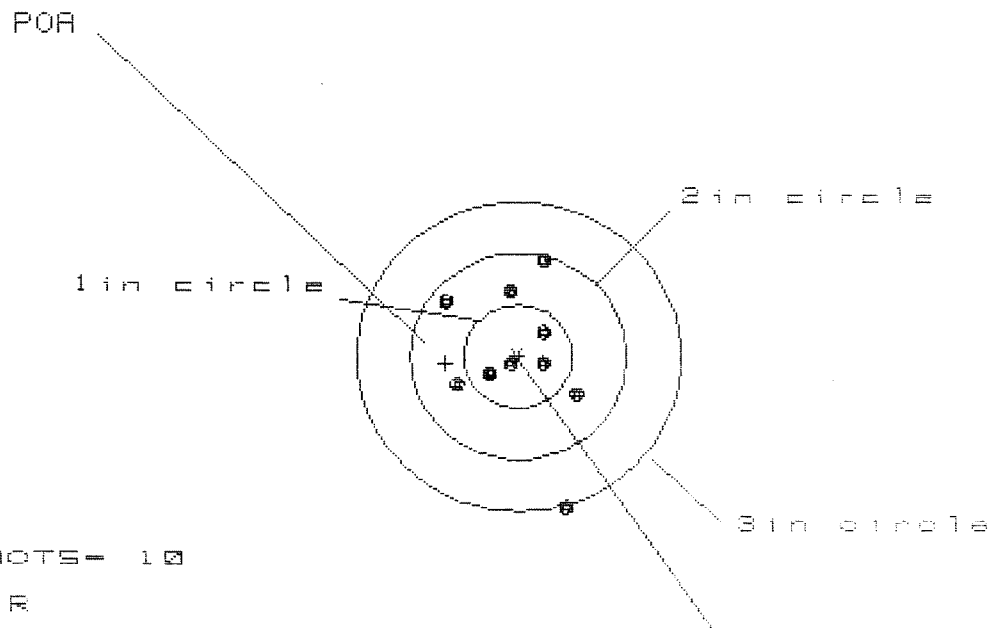
CENTROID #

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.879	.973	.639
MINIMUM X	-.800	-.706	-.585
MAXIMUM Y	.561	.611	.600
MINIMUM Y	-.723	-.673	-.684
CENTROID X	.908	.814	.693
CENTROID Y	-.162	-.212	-.201
POA TO CENTROID in.	.922	.841	.721
MIN RADIUS	.203	.130	.174
MEAN RADIUS	.658	.606	.543
MAX RADIUS	.957	.977	.828
HORIZONTAL SPREAD	1.679	1.679	1.224
VERTICAL SPREAD	1.284	1.284	1.284
EXTREME SPREAD	1.804	1.686	1.451
NUMBER IN ONE INCH CIRCLE =	2		
NUMBER IN TWO INCH CIRCLE =	10		
NUMBER IN THREE INCH CIRCLE =	10		

01 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6346359.1.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 4

2 in = 9

3 in = 9

HS= 1.195

VS= 2.383

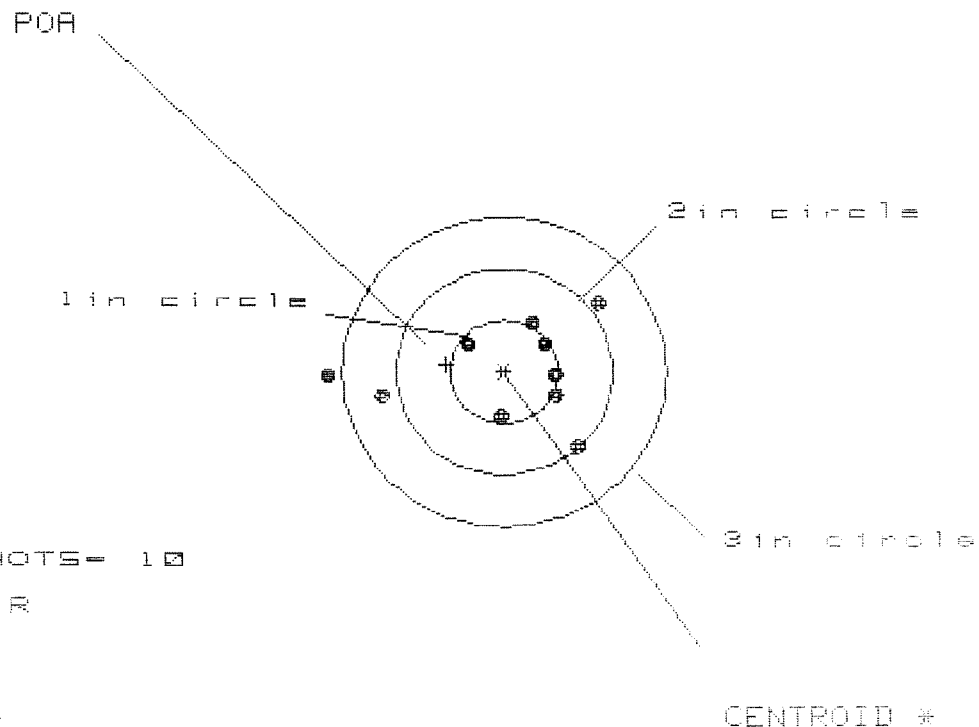
GS= 2.393

PATTERN #	:	2		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.497	.550	.589
MINIMUM X	:	-.698	-.645	-.606
MAXIMUM Y	:	.934	.773	.534
MINIMUM Y	:	-1.449	-.494	-.398
CENTROID X	:	.668	.615	.576
CENTROID Y	:	.064	.225	.129
POA TO CENTROID in.	:	.671	.655	.590
MIN RADIUS	:	.093	.216	.119
MEAN RADIUS	:	.617	.520	.463
MAX RADIUS	:	1.526	.834	.786
HORIZONTAL SPREAD	:	1.195	1.195	1.195
VERTICAL SPREAD	:	2.383	1.267	.932
EXTREME SPREAD	:	2.393	1.495	1.495
NUMBER IN ONE INCH CIRCLE =			4	
NUMBER IN TWO INCH CIRCLE =			9	
NUMBER IN THREE INCH CIRCLE =			9	

11 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348359.1.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS- 10

IN CIR

1in = 3

2in = 7

3in = 9

HS= 0.846

VS= 1.413

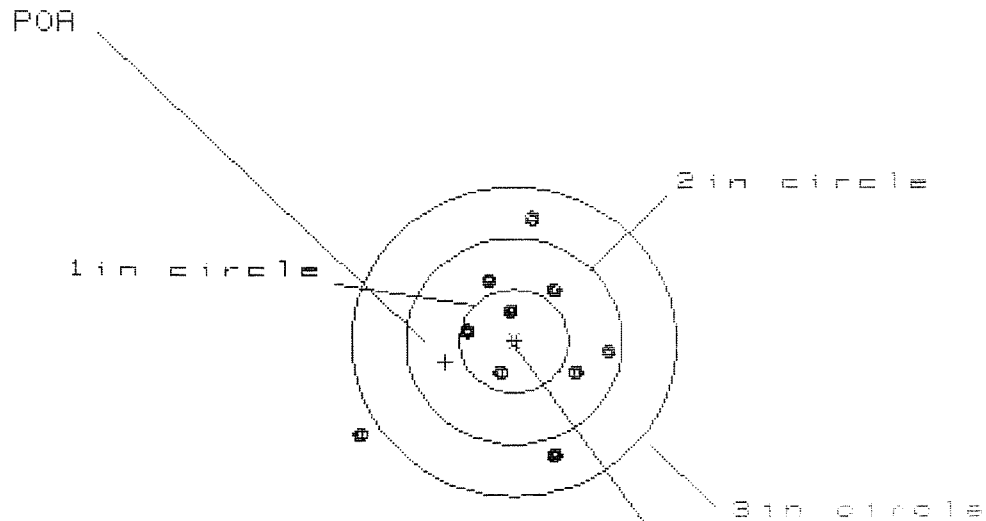
GS= 2.641

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.907	.725	.557
MINIMUM X	:	-1.639	-1.348	-.701
MAXIMUM Y	:	.669	.666	.641
MINIMUM Y	:	-.744	-.747	-.772
CENTROID X	:	.531	.713	.881
CENTROID Y	:	-.073	-.070	-.045
POA TO CENTROID in.	:	.536	.716	.883
MIN RADIUS	:	.419	.315	.152
MEAN RADIUS	:	.784	.646	.523
MAX RADIUS	:	1.639	1.362	.849
HORIZONTAL SPREAD	:	2.546	2.073	1.258
VERTICAL SPREAD	:	1.413	1.413	1.413
EXTREME SPREAD	:	2.641	2.246	1.434
NUMBER IN ONE INCH CIRCLE	=		3	
NUMBER IN TWO INCH CIRCLE	=		7	
NUMBER IN THREE INCH CIRCLE	=		9	

11 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6346359.1.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS = 10

IN CIR

1 in = 3

2 in = 7

3 in = 9

HE = 2.264

VE = 2.261

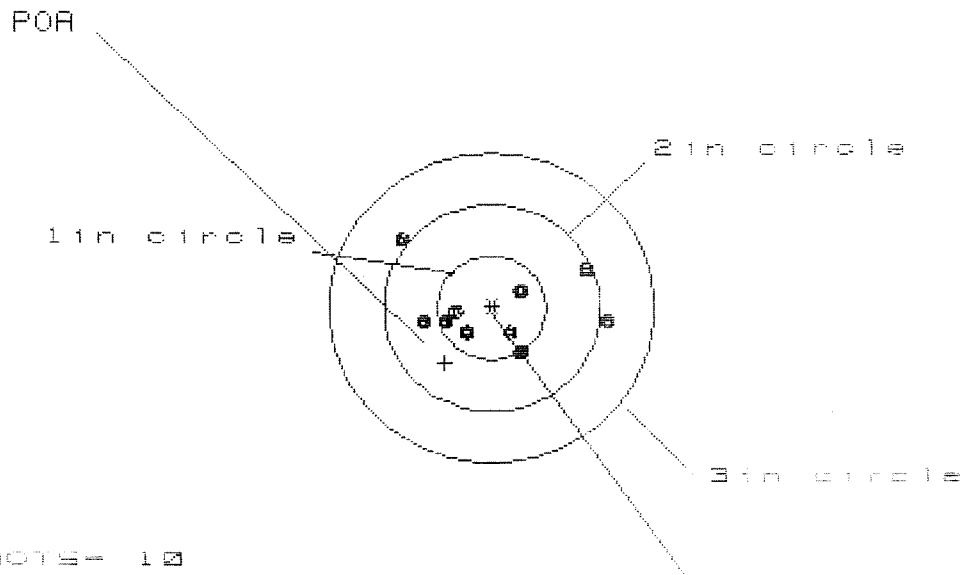
GE = 2.643

PATTERN #	4	9	8
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.820	.659	.662
MINIMUM X	-1.444	-1.572	-1.569
MAXIMUM Y	1.180	1.080	.633
MINIMUM Y	-1.081	-1.181	-1.046
CENTROID X	.630	.791	.788
CENTROID Y	.203	.303	.168
POA TO CENTROID in.	.662	.847	.805
MIN RADIUS	.302	.287	.391
MEAN RADIUS	.779	.662	.611
MAX RADIUS	1.702	1.197	1.064
HORIZONTAL SPREAD	2.264	1.231	1.231
VERTICAL SPREAD	2.261	2.261	1.679
EXTREME SPREAD	2.643	2.267	1.776
NUMBER IN ONE INCH CIRCLE =	3		
NUMBER IN TWO INCH CIRCLE =	7		
NUMBER IN THREE INCH CIRCLE =	9		

11 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6346359.1.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 6

2in = 8

3in = 10

HE= 1.886

VE= 1.857

GE= 2.038

CENTROID *

PATTERN #	5		
SHOTS (BEST OF)	10	9	8
MAXIMUM X	1.022	.925	.920
MINIMUM X	-.874	-.758	-.643
MAXIMUM Y	.659	.456	.454
MINIMUM Y	-.398	-.324	-.326
CENTROID X	.433	.530	.415
CENTROID Y	.534	.460	.462
POA TO CENTROID in.	.687	.702	.621
MIN RADIUS	.242	.126	.208
MEAN RADIUS	.599	.534	.470
MAX RADIUS	1.095	.925	1.026
HORIZONTAL SPREAD	1.896	1.683	1.563
VERTICAL SPREAD	1.857	.780	.780
EXTREME SPREAD	2.038	1.684	1.653
NUMBER IN ONE INCH CIRCLE =		6	
NUMBER IN TWO INCH CIRCLE =		8	
NUMBER IN THREE INCH CIRCLE =		10	

PART NUMBER C 634 8957

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

OPERATION NUMBER 615

MAGNETIC PARTICLE INSPECTION

METHOD	<u>S I N G L E P A R T S</u>			<u>M U L T I P L E P A R T S</u>		
	HEAD SHOT	CENTRAL		HEAD SHOT	COIL SHOT	
	HEAD SHOT	CONDUCTOR	COIL SHOT	CONDUCTOR	IN BASKET	AMPERES

SKETCH AND/OR REMARKS

NON-FLUORESCENT CONTINUOUS WET

FLUORESCENT :
CONTINUOUS WET Yes Yes (2 Overlapping)

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

NON-FLUORESCENT RESIDUAL WET

FLUORESCENT
RESIDUAL WET

APPROVAL:

INSP. LEV III

DATE: _____ DATE: _____

ACCEPTANCE STANDARD

STEEL STAMP ON. Triangular stamp STAMPING (A) 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 mangaflex stamp, acid etch, or ink stamp (If the part is too small or is a critical part, contact inspection supervisor).
5. Parts having indications not acceptable shall be segregated and identified, and are to be reviewed by Metallurgy and inspection groups.
6. All areas to be inspected 100%.
7. Inspection to be performed by a certified Level I, acceptance or rejection of product will be done by a certified Level II, or Level III.

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

ALL BLOCKS MUST BE PROPERLY FILLED IN.

LEV III.

INSP. Carl C. Rice
8157-8096

FORM QP-0041-1 "B" STAMP

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER

M2400102806

QP 0041

ENDURANCE
BBL & BOLT
C-634 8959

DATE	MFG. ORDER NO.	QUANTITY	SERIAL #	QUANTITY OF PARTS	
				ACCEPTED	REJECTED
9/5/89	2,500 Rds			OK	
9/12/89	3,000 Rds			OK	
9/13/89	4,000 Rds			OK	
9/14/89	7,000 Rds			OK	
9/15/89	8,000 Rds			OK	BLT worn in
9/19/89	9,000 Rds			OK	
9/20/89	10,000 Rds			OK	

Karl Rice
8158-8096
'B" STAMP

CENTROIDAL DISTANCE CALCULATIONS
FOR RIFLE # 06348959
20 Sep 1989

CENTROIDAL DISTANCES

0 TO	1	.339638
1 TO	2	.305247
1 TO	3	.186553
1 TO	4	.491423
1 TO	5	.561957

---POA

THE AVERAGE X-COORDINATE FOR THIS RIFLE IS: -1.0792
THE AVERAGE Y-COORDINATE FOR THIS RIFLE IS: .2028
THE RESULTING AVERAGE POI RADIUS FOR THIS RIFLE IS: .217717

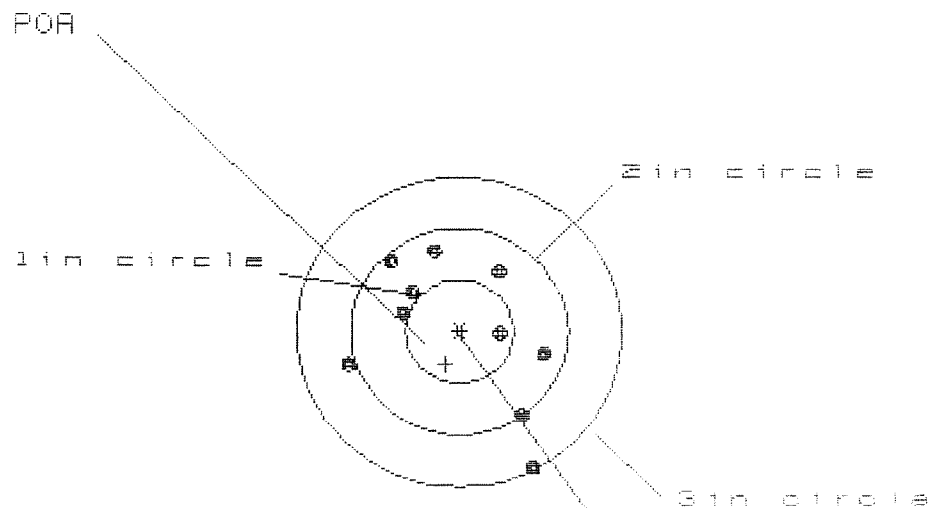
THE AMR FOR THIS RIFLE IS: 1.8502

After 10,000 Rds

20 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08348959.1.1.1.1

CENTERFIRE PATTERNS # 1



OF SHOTS= 10

IN CIR

1" = 1

2" = 8

3" = 10

HS= 1.801

VS= 2.128

GS= 2.352

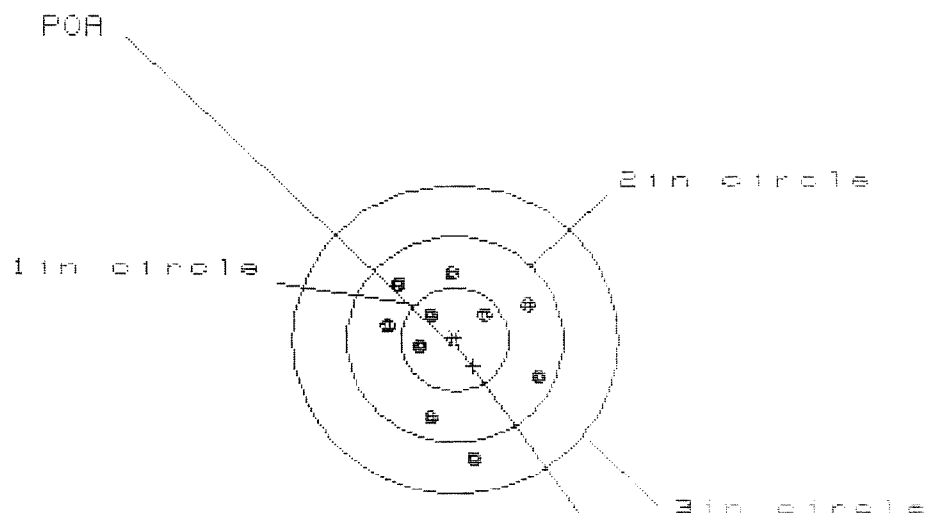
CENTROID #

PATTERN #	:	1	2	3
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.766	.845	.726
MINIMUM X	:	-1.036	-.956	-.636
MAXIMUM Y	:	.819	.674	.612
MINIMUM Y	:	-1.309	-.932	-.994
CENTROID X	:	.127	.047	.166
CENTROID Y	:	.315	.460	.522
POA TO CENTROID in.	:	.339	.462	.548
MIN RADIUS	:	.376	.404	.386
MEAN RADIUS	:	.826	.721	.665
MAX RADIUS	:	1.493	1.141	1.131
HORIZONTAL SPREAD	:	1.801	1.801	1.362
VERTICAL SPREAD	:	2.128	1.606	1.606
EXTREME SPREAD	:	2.352	1.849	1.849
NUMBER IN ONE INCH CIRCLE	=	1		
NUMBER IN TWO INCH CIRCLE	=	8		
NUMBER IN THREE INCH CIRCLE	=	10		

20 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C6348959.1.1.1.1

CENTERFIRE PATTERNS # 2



OF SHOTS- 10

IN CIR

1 in = 3

2 in = 9

3 in = 10

HS= 1.329

VS= 1.784

GS= 1.882

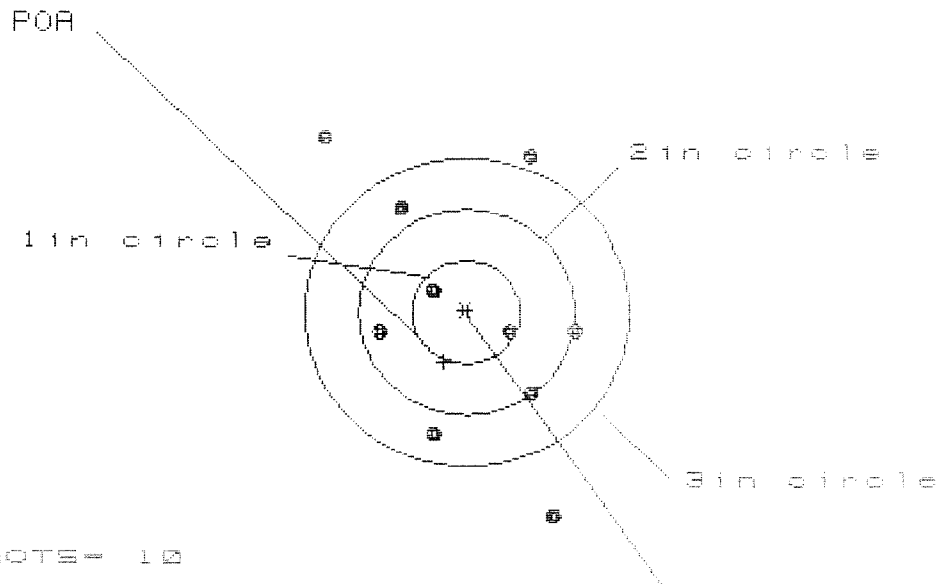
CENTROID *

PATTERN #	1	2	3
SHOTS (BEST OF)	10	9	8
MAXIMUM X	.748	.771	.863
MINIMUM X	-.581	-.558	-.466
MAXIMUM Y	.673	.549	.583
MINIMUM Y	-1.111	-.886	-.852
CENTROID X	-.173	-.196	-.288
CENTROID Y	.256	.380	.346
POA TO CENTROID in.	.389	.427	.451
MIN RADIUS	.296	.285	.234
MEAN RADIUS	.668	.593	.552
MAX RADIUS	1.130	.914	.962
HORIZONTAL SPREAD	1.329	1.329	1.329
VERTICAL SPREAD	1.784	1.435	1.435
EXTREME SPREAD	1.882	1.545	1.545
NUMBER IN ONE INCH CIRCLE =		3	
NUMBER IN TWO INCH CIRCLE =		9	
NUMBER IN THREE INCH CIRCLE =		10	

20 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/C634B959.1.1.1.1

CENTERFIRE PATTERNS # 3



OF SHOTS= 10

IN CIR

1in = 2

2in = 4

3in = 7

IS= 2.288

VS= 3.640

GS= 4.200

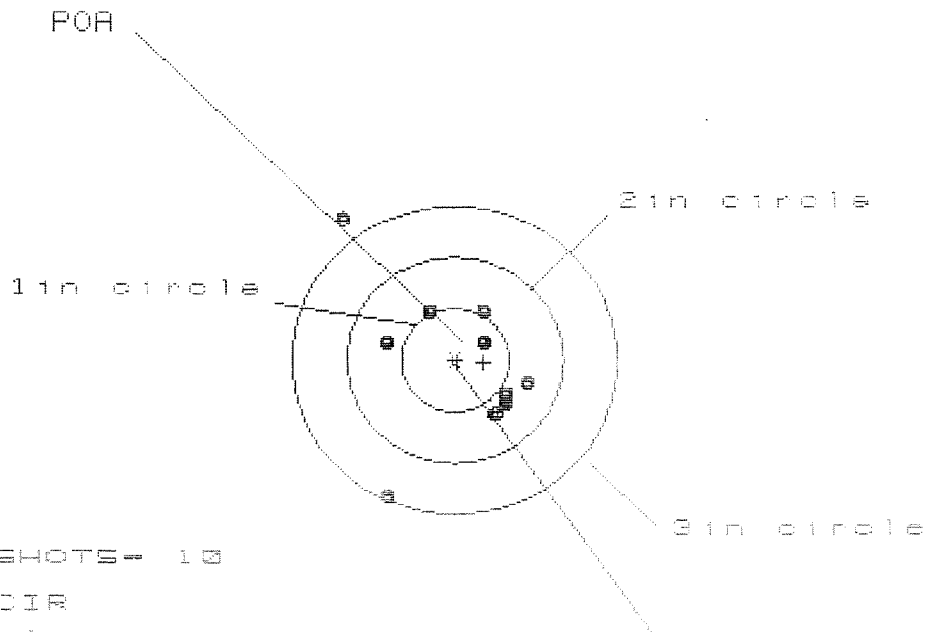
CENTROID #

PATTERN #	:	3		
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.946	.797	.874
MINIMUM X	:	-1.342	-.941	-.863
MAXIMUM Y	:	1.685	1.688	1.467
MINIMUM Y	:	-1.955	-1.768	-1.227
CENTROID X	:	.206	.355	.278
CENTROID Y	:	.484	.297	.518
POA TO CENTROID in.	:	.526	.463	.588
MIN RADIUS	:	.406	.295	.422
MEAN RADIUS	:	1.188	1.061	.933
MAX RADIUS	:	2.154	1.874	1.568
HORIZONTAL SPREAD	:	2.288	1.738	1.738
VERTICAL SPREAD	:	3.640	3.456	2.694
EXTREME SPREAD	:	4.200	3.459	2.864
NUMBER IN ONE INCH CIRCLE	=		2	
NUMBER IN TWO INCH CIRCLE	=		4	
NUMBER IN THREE INCH CIRCLE	=		7	

20 Sep 1985

FILE:/PATTERNING/CENTERFIRE_PATT/C6346959.1.1.1.1

CENTERFIRE PATTERNS # 4



OF SHOTS- 10

IN CIR

1in = 1

2in = 8

3in = 9

HS= 1.662

VS= 2.697

GS= 2.731

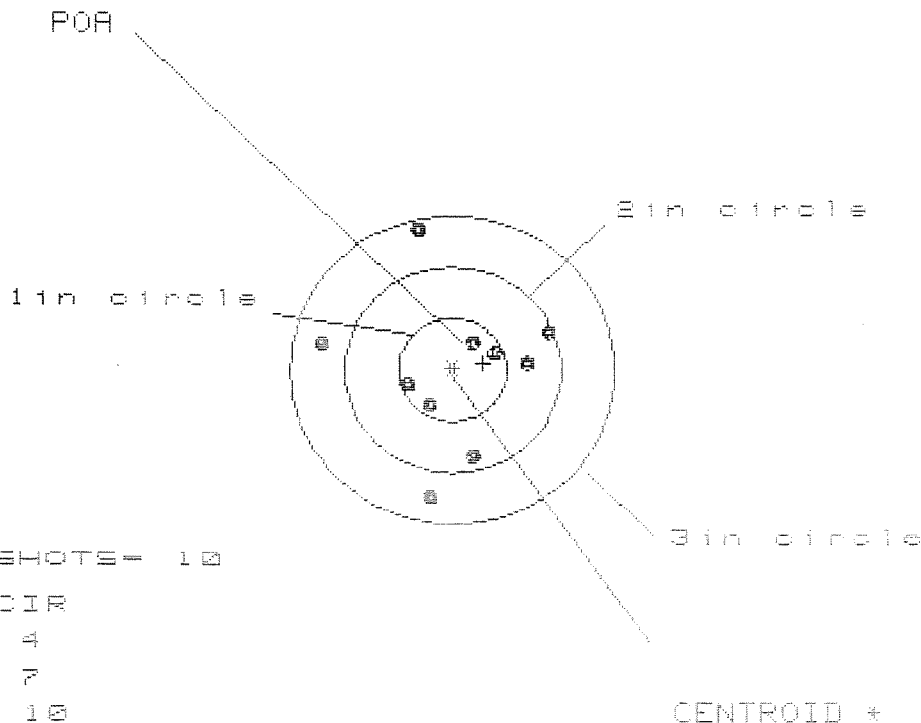
CENTROID X

PATTERN #	:	4	9	8
SHOTS (BEST OF)	:	10	9	8
MAXIMUM X	:	.637	.523	.434
MINIMUM X	:	-1.025	-.761	-.850
MAXIMUM Y	:	1.367	.673	.526
MINIMUM Y	:	-1.330	-1.178	-.549
CENTROID X	:	-.269	-.155	-.066
CENTROID Y	:	.024	-.128	.019
POA TO CENTROID in.	:	.270	.201	.068
MIN RADIUS	:	.341	.393	.223
MEAN RADIUS	:	.782	.651	.526
MAX RADIUS	:	1.709	1.377	.875
HORIZONTAL SPREAD	:	1.662	1.284	1.234
VERTICAL SPREAD	:	2.697	1.851	1.075
EXTREME SPREAD	:	2.731	2.036	1.342
NUMBER IN ONE INCH CIRCLE	=		1	
NUMBER IN TWO INCH CIRCLE	=		8	
NUMBER IN THREE INCH CIRCLE	=		9	

20 Sep 1989

FILE:/PATTERNING/CENTERFIRE_PATT/08346959.1.1.1.1

CENTERFIRE PATTERNS # 5



OF SHOTS= 10

IN CIR

1in = 4

2in = 7

3in = 10

HE= 2.070

VS= 2.571

GS= 2.574

PATTERN #	5
SHOTS (BEST OF)	10
MAXIMUM X	.884
MINIMUM X	-1.186
MAXIMUM Y	1.382
MINIMUM Y	-1.189
CENTROID X	-.287
CENTROID Y	-.065
POA TO CENTROID in.	.295
MIN RADIUS	.372
MEAN RADIUS	.787
MAX RADIUS	1.426
HORIZONTAL SPREAD	2.070
VERTICAL SPREAD	2.571
EXTREME SPREAD	2.574
NUMBER IN ONE INCH CIRCLE =	4
NUMBER IN TWO INCH CIRCLE =	7
NUMBER IN THREE INCH CIRCLE =	10