

1 TEST PLAN Model 700 Lt. Wt. Centerfire Rifle Design Acceptance Test Rev. 5.

3 Start of Test | M/700 Lt Wt | Rev 5.

4 Divide Test Into Two Phases:

5 (Phase I|Long Action | 30-06)

6 Rifles A1 to A15.

7 >PHASEI.

8 (Phase II | Short Action | 7mm08)

9 Rifles B1 to B15.

10 >PHASEII.

11

12 -PHASEI.

13 PROOF & HEADSPACE.

14 Measure Rifles for Headspace |TLW0175A|Rifles A1 to A15.

15 Proof Test |TLW0175B|Rifles A1 to A15.

16 Re-Measure Rifles for Headspace After Proof|TLW0175C|Rifles A1 to A15.

17 ACCURACY TESTING.

18 Accuracy Testing|Group Size at 100 Yards|TLW0175AG|Rifles A1-A5 & A9-A13.

19 MEASUREMENTS|FORCES.

20 Measure Firing Pin Indent|TLW0175D|Rifles A1-A15.

21 Measure Sear/Trigger Engagement & Sear Lift|TLW0175E|Rifles A1-A15.

22 Measure Trigger Pull Force|TLW0175F|Rifles A1-A15.

23 Measure Safe On/Off Forces|TLW0175G|Rifles A1-A5 & A9-A13.

24 Perform Function Check of ISS System|TLW0175GI|Rifles A1-A5 & A9-A13.

25 Measure Bolt Lift and Bolt Closing Forces|TLW0175H|Rifles A1-A5 & A9-A13.

26 Measure Magazine Spring Force|TLW0175I|Rifles A1-A5 & A9-A13.

27 Measure Recoil Force|TLW0175J|Rifles A1-A5 & A9-A13.

28 Measure Lock Time|TLW0175K|Rifles A1-A13.

29 MEASUREMENTS|WEIGHTS OF MAJOR COMPONENTS.

30 Overall Weight|TLW0175L|Rifles A4-A7 & A14-A15.

31 Weight of Stock Assembly|TLW0175M|Rifles A4-A7 & A14-A15.

32 Weight of Barrel Assembly|TLW0175N|Rifles A4-A7 & A14-A15.

33 Weight of Bolt Assembly|TLW0175O|Rifles A4-A7 & A14-A15.

34 MEASUREMENTS|LENGTHS OF MAJOR COMPONENTS.

35 Overall Length|TLW0175P|Rifles A4-A7 & A14-A15.

36 Barrel Length|TLW0175Q|Rifles A4-A7 & A14-A15.

37 Length of Pull TLW0175R|Rifles A4-A7 & A14-A15.

38 MEASUREMENTS|GUN CHARACTERISTICS.

39 Balance Point|TLW0175S|Rifles A4-A7 & A14-A15.

40 Stock Drop|TLW0175T|Rifles A4-A7 & A14-A15.

41 Safety Operation (SAAMI)|TLW0175U|Rifles A4-A7 & A14-A15.

42 40 lb Trigger Pull Test (Remington Test)|TLW0175U1|Rifles A4-A7 & A14-A15

43 MEASUREMENTS|FIREARMS MEASUREMENTS.

44 Chamber Cast|TLW0175V|Rifles A1-A3.

45 Measure Bore Diameter|TLW0175W|Rifles A1-A3.

46 Measure Groove Diameter|TLW0175X|Rifles A1-A3.

47 Measure Twist Rate (30-06)|TLW0175Y|Rifles A1-A3.

48 Magazine Capacity Test|TLW0175Z|Rifles A1-A5 & A9-A13.

49 FUNCTION & ENDURANCE TESTING.

50 Basic Jack Function Test|(to 200 Rounds)|TLW0175AA|Rifles A1-A15.

51 Basic Shoulder Function Test|TLW0175AB|Rifles A1-A15.

52 Divide Rifle A1-A15:

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53 (Rifles A1-A5 & A9-A13)
 54 Extended Function & Endurance Test-Jack.
 55 >Extended.
 56 (Rifles A8 & A15)
 57 Dry Cycle to 5000 Rounds.
 58 >Dry.
 59 (Rifles A6-A7 & A11-A14)
 60 Abusive Tests.
 61 >Abusive.

 63 -Extended.
 64 Extended Function & Endurance Test-Jack|TLW0175AC|Rifles A1-A5 & A9-A13.
 65 Clean Rifles and Inspect per schedule|TLW0175AD|Rifles A1-A5 & A9-A13.
 66 >TLW0175PhaseI.

 68 -Dry.
 69 Dry Cycle to 5000 Cycles|TLW0175AE|Rifles A8 & A15.
 70 Re-Measure Bolt Lift & Bolt Closing Forces after Dry Cycle|TLW0175AE1|Rif
 les A8 & A15. 83
 71 Hot Function Test|TLW0175AH|Rifle A8 & A15.
 72 Cold Function Test|TLW0175AI|Rifle A8 & A15.
 73 Thermal Cycle Test|TLW0175AJ|Rifle A8 & A15.
 74 Heat & Humidity Function Test|TLW0175AK|Rifle A8 & A15.
 75 Divide Rifles A8 & A15:
 76 (Rifle A8)
 77 Rain Test.
 78 >Rain.
 79 (Rifle A15)
 80 High Pressure Test.
 81 >Highpress.

 83 -Rain.
 84 Rain Test|TLW0175AO|Rifle A8.
 85 >Obstruct.

 87 -Abusive.
 88 Slam Test|TLW0175AP1|Rifles A6-A7 & A11-A14.
 89 SAAMI Drop Test|TLW0175AQ|Rifles A6-A7 & A11-A14.
 90 SAAMI Drop Test w/Check of ISS System|TLW0175AQ1|Rifles A6-A7 & A11-A14.
 91 SAAMI Jar-Off Test|TLW0175AR|Rifles A6-A7 & A11-A14.
 92 SAAMI Rotation Test|TLW0175AS|Rifles A6-A7 & A11-A14.
 93 Extended Jar-Off Test|TLW0175AT|Rifles A6-A7 & A11-A14.
 94 Extended Rotation Test|TLW0175AU|Rifles A6-A7 & A11-A14.
 95 Extended Drop Test|TLW0175AV|Rifles A6-A7 & A11-A14.
 96 >Pierced.

 98 -Pierced.
 99 Rifles A6 A14.
 100 Pierced Primer Test|TLW0175AW|Rifles A6 & A14.
 101 >TLW0175PhaseI.
 102
 103 -Highpress.
 104 High Pressure Test|TLW0175AX|Rifle A15.
 105 Solvent Test|TLW0175AP|Rifle A15.

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106 >TLW0175PhaseI.
 108 -Obstruct.
 109 Obstructed Bore Test|TLW0175AY|Rifles A8 & A13.
 110 >TLW0175PhaseI.
 113 -PHASEII.
 114 PROOF & HEADSPACE.
 115 Measure Rifles for Headspace |TLW0175A|Rifles B1 to B15.
 116 Proof Test |TLW0175B|Rifles B1 to B15.
 117 Re-Measure Rifles for Headspace After Proof|TLW0175C|Rifles B1 to B15.
 118 ACCURACY TESTING.
 119 Accuracy Testing|Group Size at 100 Yards|TLW0175AG|Rifles B1-B10.
 120 MEASUREMENTS|FORCES.
 121 Measure Firing Pin Indent|TLW0175D|Rifles B1-B15.
 122 Measure Sear/Trigger Engagement & Sear Lift|TLW0175E|Rifles B1-B15.
 123 Measure Trigger Pull Force|TLW0175F|Rifles B1-B15.
 124 Measure Safe On/Off Forces|TLW0175G|Rifles B1-B10.
 125 Perform Function Check of ISS System|TLW0175G1|Rifles B1-B10.
 126 Measure Bolt Lift and Bolt Closing Forces|TLW0175H|Rifles B1-B10.
 127 Measure Magazine Spring Force|TLW0175I|Rifles B1-B10.
 128 Measure Recoil Force|TLW0175J|Rifles B1-B10.
 129 Measure Lock Time|TLW0175K|Rifles B1-B3.
 130 MEASUREMENTS|WEIGHTS OF MAJOR COMPONENTS.
 131 Overall Weight|TLW0175L|Rifles B4-B10.
 132 Weight of Stock Assembly|TLW0175M|Rifles B4-B10.
 133 Weight of Barrel Assembly|TLW0175N|Rifles A4-B10.
 134 Weight of Bolt Assembly|TLW0175O|Rifles A4-B10.
 135 MEASUREMENTS|LENGTHS OF MAJOR COMPONENTS.
 136 Overall Length|TLW0175P|Rifles B4-B10.
 137 Barrel Length|TLW0175Q|Rifles B4-B10.
 138 Length of Pull|TLW0175R|Rifles B4-B10.
 139 MEASUREMENTS|GUN CHARACTERISTICS.
 140 Balance Point|TLW0175S|Rifles B4-B10.
 141 Stock Drop|TLW0175T|Rifles B4-B10.
 142 Safety Operation (SAAMI)|TLW0175U|Rifles B4-B10.
 143 40 lb Trigger Pull Test (Remington Test)|TLW0175U1|Rifles B4-B10.
 144 MEASUREMENTS|FIREARMS MEASUREMENTS.
 145 Chamber Cast|TLW0175V|Rifles B1-B3.
 146 Measure Bore Diameter|TLW0175W|Rifles B1-B3.
 147 Measure Groove Diameter|TLW0175X|Rifles B1-B3.
 148 Measure Twist Rate (30-06)|TLW0175Y|Rifles B1-B3.
 149 Magazine Capacity Test|TLW0175Z|Rifles B1-B10.
 150 FUNCTION & ENDURANCE TESTING.
 151 Basic Jack Function Test|(to 200 Rounds)|TLW0175AA|Rifles B1-B15.
 152 Basic Shoulder Function Test|TLW0175AB|Rifles B1-B15.
 153 Divide Rifles B1-B15:
 154 (Rifles B1-B10)
 155 Extended Function & Endurance Test-Jack.
 156 >ExtendedB.
 157 (Rifle B11)
 158 Environmental Tests.
 159 >EnvironB.

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160 (Rifles B12-B14)
 161 Abusive Tests.
 162 >AbusiveB.

 164 -ExtendedB.
 165 Extended Function & Endurance Test-Jack|TLW0175AC|Rifles B1-B10.
 166 Clean Rifles and Inspect per schedule|TLW0175AD|Rifles B1-B10.
 167 Divide Rifles B1-B6 & B9-B10 & B8 & B7:
 168 (Rifle B8)
 169 Rain Test.
 170 >RainB.
 171 (Rifle B7)
 172 Pierce Primer Test.
 173 >PiercedB.
 174 (Rifle B9)
 175 Obstructed Bore Test.
 176 >ObstructedB.

 179 -EnvironB.
 180 Hot Function Test|TLW0175AH|Rifle B11.
 181 Cold Function Test|TLW0175AI|Rifle B11.
 182 Thermal Cycle Test|TLW0175AJ|Rifle B11.
 183 Heat & Humidity Function Test|TLW0175AK|Rifle B11.
 184 >AbusiveB.
 185
 186 -RainB.
 187 Rain Test|TLW0175AO|Rifle B8.
 188 >HighpressB.

 190 -AbusiveB.
 191 Slam Test|TLW0175AP|Rifles B11-B14.
 192 SAAMI Drop Test|TLW0175AQ|Rifles B11-B14.
 193 SAAMI Drop Test w/Check of ISS System|TLW0175AQ1|Rifles B11-B14.
 194 SAAMI Jar-Off Test|TLW0175AR|Rifles B11-B14.
 195 SAAMI Rotation Test|TLW0175AS|Rifles B11-B14.
 196 Extended Jar-Off Test|TLW0175AT|Rifles B11-B14.
 197 Extended Rotation Test|TLW0175AU|Rifles B11-B14.
 198 Extended Drop Test|TLW0175AV|Rifles B11-B14.
 199 >TLW0175PhaseII.

 201 -PiercedB.
 202 Pierced Primer Test|TLW0175AW|Rifles B7.
 203 >TLW0175PhaseII.
 204
 205 -HighpressB.
 206 High Pressure Test|TLW0175AX|Rifle B8.
 207 >TLW0175PhaseII.

 209 -ObstructedB.
 210 Obstructed Bore Test|TLW0175AY|Rifles B9.
 211 >TLW0175PhaseII.

 214 -TLW0175PhaseI.

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215 Compile Data for Phase I Testing.
216 >TLW0175.

219 -TLW0175PhaseII.
220 Compile Data for Phase II Testing.
221 >TLW0175.

223 -TLW0175.
224 Write Final Report.

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