



M/722 RIFLE
300 SAV. 257 ROBERTS

Subject: Gallery (Proof, Test and target)

Proof: 100% of production, all guns passing First Inspection.

(1) Loading procedure

- A. Check bore for obstruction.
- B. Place in holding jack.
- C. Close action.
- D. Attach lanyard to trigger.
- E. Close cover.
- F. Step outside booth and close door.
- G. Pull lanyard.

(2) Watch for:

- A. Fractured parts - action open and action closed.
- B. Lack of smoothness of oper.
- C. Swelling or cracks in empty case.
- D. Blown primers.

(3) Inspect each gun after proof.

- A. Visually check chamber for live ammunition.

(4) Stamp Proof mark.

- A. (RP) right side of barrel ahead of receiver.
- B. Prick punch bolt underneath bolt handle.

(5) Inspect complete truck load.

- A. Visually check chamber.

Test: 100% of guns passing proof (Check each gun for proof work before test).

(1) Ammunition

- A. For 300 Sav. Cal.
 - 1. Load 4 - 180 grain express soft point cartridges in magazine and 1 in chamber and fire.
- B. For 257 Roberts Cal.
 - 1. Load 4 - 100 grain express high speed soft point cartridges in magazine and 1 in chamber and fire.

(2) Proper feed

- A. Should not stem chamber.
- B. Action should not close hard.
- C. Shell should not catch on face of block.
- D. Shell not override, (Press down rear of loaded mag. before testing).
- E. Shell must not be hard under extractor.
- F. Shell should not be hard under rail.

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4 sheets

Authorization

Test (Cont)

3. Proper Extraction

- A. Action open easily.
- B. Withdraw fired case from chamber.

4. Proper Ejection

- A. With action in full rearward position shell to be thrown clear.

5. Proper Firing Pin blow

- A. Visually inspect one fired case from each gun.
- B. Must be equal to sample.

6. Rejection

- A. One failure in above test rejects gun.
- B. Exception may be defective ammunition in which case repeat test and pass if no additional failures occur.

7. Inspect for live ammunition (each gun)

- A. Visually check magazine and chamber.

8. Stamp

- A. Individual inspectors stamp for test.
- B. Right side of barrel, ahead of receiver, ahead of proof mark.

9. Inspect for live ammunition (complete truck load)

- A. Visually check chamber.
- B. Visually check magazine.

Target: 100% of guns passing test (Check for test and proof mark)

1. Ammunition

- A. For 300 Sav. - use 180 grain express soft point cartridges.
- B. For 257 Roberts - use 100 grain express high speed soft point cartridges.

2. Alignment

- A. Load 4 cartridges in magazine.
 - a. Fire necessary shots to align sights for 100 yds.
 - b. See data sheet #1 on "Sighting picture" Fig. #4.

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M/722 Rifle (Cont)

Target (Cont)

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Authorization

2. Alignment (Cont)

B. Limits permissible from point of aim (6 o'clock).

- a. See data sheet on "Sight Align Limits,"
Fig. #4, area "B".
- b. 4 in. high.
- c. 2 in. low.
- d. 3 in. right.
- e. 3 in. left.

C. Adjust Front Sight (Horizontal Align.)

- a. Tap on base of sight with copper hammer.
- b. To correct guns shooting to the left, tap
on right side.
- c. To correct guns shooting to the right,
tap on left side.
- d. Front sight bead maybe no more than .050
(1/32") to right or left of center line
of barrel O.D.

D. Adjust Rear Sight (Vertical Alignment)

- a. If gun shoots low - change to higher step.
- b. If gun shoots high - change to lower step.

E. Adjust Rear Sight (Horizontal Alignment)

- a. Rear Sight leaf should be parallel to
barrel and shoulders of base should not
protrude beyond barrel dovetail more
than 1/16".

3. Maximum Spread 300 Yds. (Distance between inside edges
of two shots farthest apart).

A. Refill Magazine

- a. Fire 1-5 shot group from each gun using
ammunition under target 1-A or B.
- b. 100% of shots fired to be within 3.5 inches.

(1) If not in this spec. and more than
4 inches, reject gun.

B. If more than 5 1/2 inches and less than 4 inches,
refill magazine.

- a. Fire another 5 shot group for a total of 10 shots.

(1) 100% of 10 shots must be within 4 inches.

(2) 80% of 10 shots must be within 3 inches.

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4 sheets

M/722 Rifle (Cont)

Authorization

Target (Cont)

4. Maximum Spread 257 Roberts
(Distance between inside edges of two shots farthest apart).
 - A. Refill Magazine
 - a. Fire 1-5 shot group from each gun using ammunition under target 1-B.
 - b. 5 shots fired to be within 2 inches. 4 shots to be within 1½ inches.
 - c. If not in this specification, reject gun.
 5. Center of impact (Average position of all shots fired).
 - A. From point of aim, not to be more than:
 - a. 4 in. high.
 - b. 3 in. right.
 - c. 3 in. left.
 - d. 2 in. low.
 - e. See data sheet on "Alignment Limits," Fig. #4, area "B".
 6. If any trend is noted on majority of guns, that is, if guns consistently shoot outside allowable limits, or if more than 10% of guns targeted do not meet specifications, notify foreman.
 7. Check each gun for live ammunition
 - A. Visually check follower and chamber empty.
 8. Stamp
 - A. Use individual inspectors stamp for target.
 - B. Right side of barrel ahead of testers stamp.
 9. Inspect for live ammunition
 - A. Complete truck load.
 - B. Visually check chamber and magazine empty.
1. Live ammunition inspection.