

Snedeker, Jim

**From:** Franz, Scott  
**Sent:** Thursday, June 30, 2005 3:04 PM  
**To:** Norton, Vince; James, Will  
**Cc:** Snedeker, Jim; Reesor, Phillip K.  
**Subject:** FW: Re: Model 710 Short Action Test Plan  
**Importance:** High  
**Sensitivity:** Confidential

fyi

**From:** Franz, Scott  
**Sent:** Thursday, June 30, 2005 2:25 PM  
**To:** Bristol II, Ronald H  
**Cc:** Millner, Tommy; Campbell, Don H.; Trull, John; Lance, Kevin D.; Diaz, Danny  
**Subject:** RE: Re: Model 710 Short Action Test Plan  
**Importance:** High  
**Sensitivity:** Confidential

M710 SHORT ACTION DAT/T&P TEST PLAN							Ammo
TEST & MEASUREMENTS							Needed
FIRE CONTROL OPTIONS							C710/SPL
Out of Box Inspection (All 30 Guns)							
(Packaging, cosmetics, etc.)							
Preliminary Measurements & Tests (All 30 Guns)							
Headspace/Proof/Headspace							30 Prf/30 Prf
Check Chamber Dimensions, Bore, Groove, Twist Rate							
Check Bolt Head and Barrel Hardness							
Firing Pin Indent							
Trigger Pull							
SPL Specific Measurements							
Slam Test - 3 Guns							
Jack Function (All 30 Guns)							
200 rds /Gun w/Rem. and Competitive Ammo							6,000/6,000
Accuracy (5 Guns/Caliber)							
Three 5-Shot Groups/gun/ammo (2 Ammo Types)							600/600
Thermal Testing (One Gun/Caliber)							
Hot, Cold, Heat & Humidity							0/900
Trigger Tests (One Gun/Caliber)							
SAMMI Test							
Remington Test							
Dynamic Dust & Debris							
SAAMI Jar-Off, Rotation, Drop Tests (3 Guns/Caliber)							
Extended Function & Endurance							
500 rd. Level (5 Guns/Caliber)							4,500/4,500
1,000 rd. Level (2 Guns/Caliber)							1,000/3,000
2,000 rd. Level (1 Gun/Caliber)							0/3,000
Ammo Required							12,100/18,000

The above table shows two tests, one for the 710 SA with the current fire control and one if the SPL is used. With the SPL included there is a greater focus on fire control related testing.

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An X means that this test is to be done at the sample size listed to the left. Exceptions are noted. With the current fire control I would only test the .243 Win. in the SAAMI Jar-Off, Drop and Rotation tests since this will be the heaviest version of the 710 made to date.

Let me know if you have any questions.

Scott

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**From:** Bristol II, Ronald H  
**Sent:** Wednesday, June 29, 2005 6:52 PM  
**To:** Franz, Scott; Trull, John  
**Subject:** RE: Re: Model 710 Short Action Test Plan  
**Sensitivity:** Confidential

I want a test plan assuming a spl fire control and a test plan assuming same fire control as now  
thanks

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**From:** Franz, Scott  
**Sent:** Wed 6/29/2005 10:24 AM  
**To:** Bristol II, Ronald H; Diaz, Danny; Lance, Kevin D.  
**Cc:** Millner, Tommy; Campbell, Don H.; Trull, John; Norton, Vince; Snedeker, Jim; Reesor, Phillip K.  
**Subject:** Re: Model 710 Short Action Test Plan

Ron,

As requested we have reviewed this program with Diaz's group and Mayfield and have put together a test plan to qualify this product for production. The short action utilizes the same parts as the existing M/710 with the following exceptions:

**PART DIFFERENCES**

- Magazine Box
- Magazine Follower
- Magazine Box Bottom
- Receiver Insert
- Support Bracket
- SPL Fire Control
- Magazine Box Spacer

Changes to the stock tool will be required to add additional clearance for the safety arm/button and the fire control housing. The receiver rear diameter that accepts the new insert will also be different (larger) than the existing M/710.

With these changes the main focus in testing will be accuracy (for the 3 new calibers), feeding, and then function, endurance and abuse testing due to the integration of a new fire control in the Model 710 action. Based on manufacturing methods to produce parts, the long tooling lead times, and the risk involved a combined DAT/T&P test was requested. I concur with this approach. Since this will also be a T&P class test we should still sample product from a larger pool. With three calibers Mayfield's plan to build 50 guns/caliber should be adequate. We will randomly select 10 guns of each caliber for our test for a total sample size of 30 guns. With that said the following tests are planned:

**TEST & MEASUREMENTS**

- Out of Box Inspection (All 30 Guns)
  - (Packaging, cosmetics, etc.)
- Preliminary Measurements & Tests (All 30 Guns)
  - Headspace/Proof/Headspace
  - Check Chamber Dimensions, Bore, Groove, Twist Rate
  - Check Bolt Head and Barrel Hardness
  - Firing Pin Indent
  - Trigger Pull + other SPL Specific Measurements (Engagement, Over Travel, etc.)
  - Slam Test - 3 Guns
- Jack Function (All 30 Guns)
  - 200 rds./Gun using Rem. and Competitive Ammo Types

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- Accuracy (5 Guns/Caliber)
  - Three 5-Shot Groups/gun/ammo (2 Ammo Types)
- Thermal Testing (One Gun/Caliber)
  - Hot, Cold, Heat & Humidity
- Trigger Tests (One Gun/Caliber)
  - SAMMI Test
  - Remington Test
  - Dynamic Dust & Debris
- SAAMI Jar-Off, Rotation, Drop Tests (3 Guns/Caliber)
- Extended Function & Endurance
  - 500 rds/Gun (5 Guns/Caliber)
  - 1,000 rds/Gun (2 Guns/Caliber)
  - 2,000 rds/Gun (1 Gun/Caliber)

Ammo requirements to support this testing is about 18,000 rounds split evenly amongst the three calibers. The main reason for the majority of this testing is due to the integration of the SPL fire control.

Any questions or comments are always welcomed.

Scott Franz

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Snedeker, Jim

**From:** Franz, Scott  
**Sent:** Wednesday, June 29, 2005 10:24 AM  
**To:** Bristol II, Ronald H; Diaz, Danny; Lance, Kevin D.  
**Cc:** Millner, Tommy; Campbell, Don H.; Trull, John; Norton, Vince; Snedeker, Jim; Reesor, Phillip K.  
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  - SAMMI Test
  - Remington Test
  - Dynamic Dust & Debris
- SAAMI Jar-Off, Rotation, Drop Tests (3 Guns/Caliber)
- Extended Function & Endurance
  - 500 rds/Gun (5 Guns/Caliber)

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- o 1,000 rds/Gun (2 Guns/Caliber)
- o 2,000 rds/Gun (1 Gun/Caliber)

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Scott Franz

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Clean & Inspect at 500 Rd Level  
A4 TO A10  
A14 TO A20  
A24 TO A30

TLW 1800L  
Extended  
Function &  
Endurance  
Test -  
501 - 1000 Rd.  
A4 TO A6  
A14 TO A16  
A24 TO A26

TLW 1800K  
Clean & Inspect at 1000 Rd Level  
A4 TO A6  
A14 TO A16  
A24 TO A26

TLW 1800M  
Endurance Test -  
1001 to 4000  
Rds.  
Please Note:  
Clean & Inspect Rifle Every 500 Rds.  
A5, A15, & A25

TLW 1800K  
Clean & Inspect at 4000  
Rd. Level  
A5, A15, & A25

3000 rds

3000 rds

2 ea → 1000

3000 rds

1 ea to 2000 - 3000 rds

Endurance

30 Guns (10 ea)	200 rds/Gun	6,000
15 Guns (5 ea)	500 rds/Gun	7,500
6 Guns (2 ea)	1000 rds	6,000
3 Guns (1 ea)	2000 rds	3,000
		3,000
		15,000 rds
		18,000

ET34771

**Snedeker, Jim**

**From:** Franz, Scott  
**Sent:** Monday, June 27, 2005 8:37 AM  
**To:** Snedeker, Jim  
**Subject:** Re: M/710 Short Action

Jim,

The following data was included in Mayfield's CAR for this product. Take a look, and then based on what is different in this new version put together what you think is a reasonable combined DAT/T&P test. Looking for a rough outline only then you and I can sit down to discuss. By tomorrow afternoon would be great. Then I'll have time to respond to Ron by Wednesday.

Thanks,  
Scott

Ammunition:	.308	5,000 rds.	\$1,128.00
	.243	5,000 rds.	\$1,128.00
	7mm-08	5,000 rds.	\$1,128.00
			<b>\$3,384.00</b>

Barrel Process Development:			
	.308	100 pcs.	\$2,000.00
	.243	100 pcs.	\$2,000.00
	7mm-08	100 pcs.	\$2,000.00
			<b>\$6,000.00</b>

Finished Guns:			
	.308	50 units	\$7,000.00
	.243	50 units	\$7,000.00
	7mm-08	50 units	\$7,000.00
			<b>\$21,000.00</b>

Scott Franz  
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**Remington Arms Co. Inc.**  
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6/27/2005

ET34772