

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-A3.
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|TLW0175AP1|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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