

**Project Name: 710 Short Action**  
**Project Number: 241429**  
**R&D Engineer(s): Vincent Norton, Will B James**

**Revised: 5/13/05**  
**Marketing Manager: John Trull**  
**Plant Contact: K. D. Lance**

**Status:**

- Changes to the M710 long action for a short action with a current receiver include: magazine box, follower, follower spacer, and box bottom.
- Currently we have 2 different designs to accommodate the fire control options: 1) new short receiver insert to accept SPL fire control or the current 700 fire control, 2) Current M710 short receiver insert with current M710 fire control.
- Adding the SPL Fire Control adds additional components to the M710 such as a new receiver insert and fire control support bracket. The stock will require a modification around safety arm for clearance.
- SLS prototypes of the magazine spacer, follower, and box bottom have been received. A prototype tool was used to make the magazine boxes.
- Three short action M710's were built and 200 rds place each prototype. The magazine box was modified and retested with no malfunctions.
- SLS of the SPL fire control short receiver inserts was received. Will need to modify the current fire control support bracket to adapt to the SPL fire control.
- Tooling cost for the receiver insert (SPL) \$52K. One quote for magazine box was received at \$82K and 22 weeks lead time.

**Issues:**

- 1) Will combine DAT and T&P using production magazine tooling. If the SPL short receiver insert is used a new Receiver Insert tool will be required prior to DAT build.
- 2) Assuming Ilion can supply all of 710 fire Controls (60K per year) what is the ramp up schedule for 710 long and short actions?

**Action Items:**

Action Item	Status	Responsible	Date
1. Build 3 Test barrels ((1) 243 & (2) 308)	Complete	Mayfield	2/18/05
2. Machined One Piece Receivers (2)	Complete	R&D	2/16/05
3. Build guns for EET	Complete	R&D/Mayfield	2/22/05
4. Receive barrel components (reamers, etc)	In process	Mayfield	5/20/05
5. Cost of "SPL" Short Receiver Insert tool	In Process	Mayfield	5/15/05
6. EET Test	Complete	R&D	4/1/05
7. Ramp-up timeline for new SPL	In process	Ilion	4/30/05
8. Capital Request for magazine & SPL Insert		Mayfield	5/17/05
9. Capital approval			5/31/05

**Schedule / Key Milestones:**

Milestone	Current Date
First Prototype	1/20/05
EET	4/22/05
DAT / T&P	11/30/05
Warehouse Position	12/29/05