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INSPECTION STANDARDS

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AND ARMED FORCES**
by

**SOLDIER SYSTEMS PROGRAM LETHALITY
PROJECT TEAM
KD4Q8**

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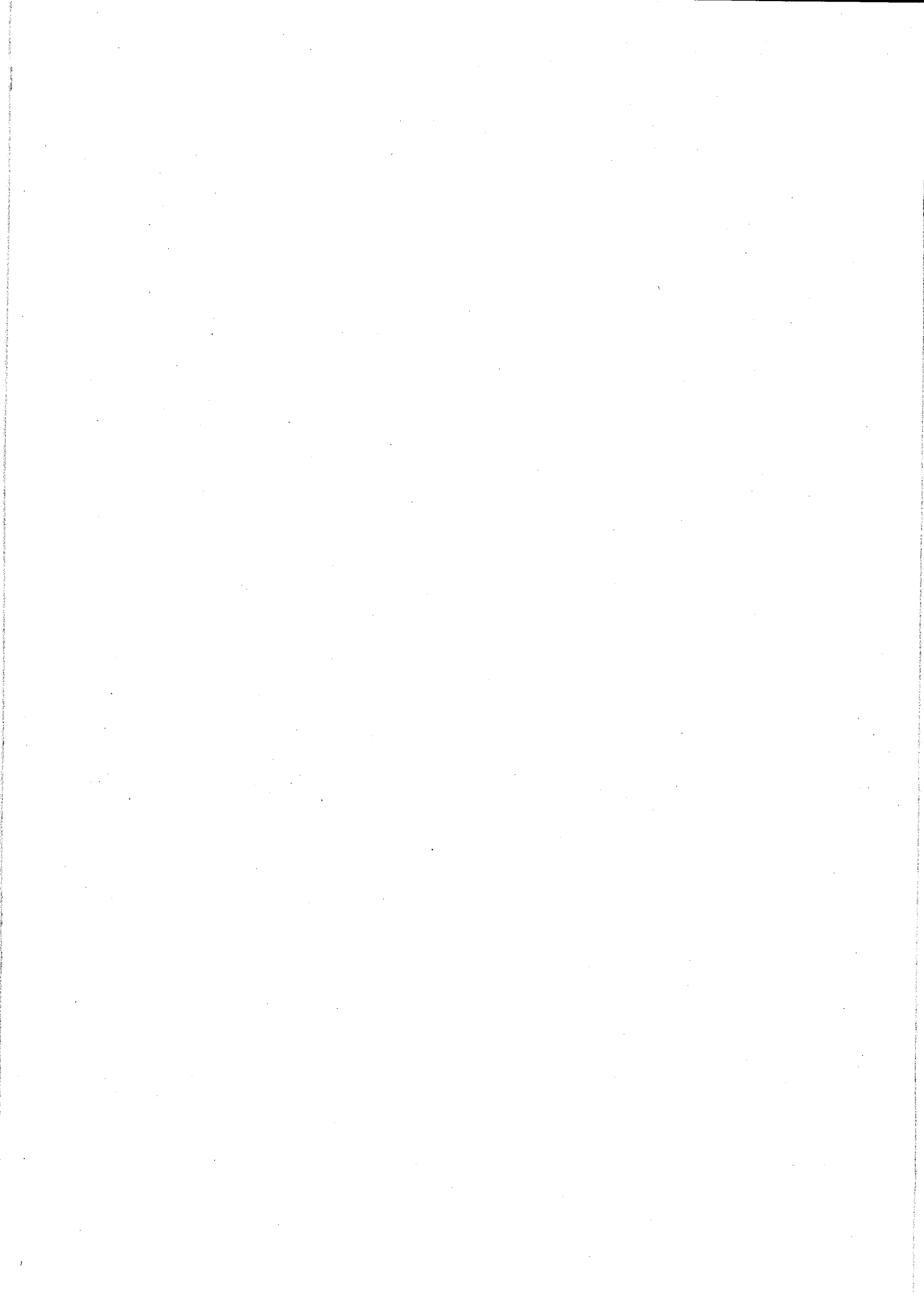


AMENDMENT RECORD

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INSPECTION STANDARDS

Chapter

- 1 General information
- 2 Inspection standards

PREFACE

Sponsor: SSP Lethality
 Project Number: -
 File Ref: -

Publication Authority: SSP Lethality

INTRODUCTION

1 Any comments by service users on this publication should be forwarded through the channels prescribed in Army Equipment Support Publication (AESP) 0100-P-011-013. An AESP Form 10 is provided at the end of this publication; it should be photocopied and used for forwarding comments on this AESP.

2 AESPs are issued under UK MOD authority and where AESPs specify action is to be taken, the AESP will of itself be sufficient authority for such action and also for the demanding of the necessary stores, subject to the provisions of Para 3 below.

3 The subject matter of this publication may be affected by Defence Instructions and Notices (DINs), Standard Operating Procedures (SOPs) or by local regulations. When any such instruction, order or regulation contradicts any portion of this publication it is to be taken as the overriding authority.

RELATED AND ASSOCIATED PUBLICATIONS**Related publications**

4 The Octad for the subject equipment consists of the publications shown below. All references are prefixed with the first eight digits of this publication. The availability of the publications can be checked by reference to the relevant Group Index (see AESP 0100-A-001-013).

| Category/Sub-category | | | Information Level | | | |
|-----------------------|---|---|--------------------|--------------------------|---------------------------|--------------------------|
| | | | 1 User/Operator | 2 Unit Maintenance | 3 Field Maintenance | 4 Base Maintenance |
| 1 | 0 | Purpose and Planning Information | 101 | 101 | * | * |
| | 1 | Equipment Support Policy Directive | 111 | 111 | * | * |
| 2 | 0 | Operating Information | 201 | 201 | * | * |
| | 1 | Aide Memoire | * | * | * | * |
| | 2 | Training Aids | * | * | * | * |
| 3 | | Technical Description | 201 | 201 | * | * |
| 4 | 1 | Installation Instructions | * | * | * | * |
| | 2 | Preparation for Special Environments | * | * | * | * |
| 5 | 1 | Failure Diagnosis | 201 | 522 | 522 | 522 |
| | 2 | Maintenance Instructions | 201 | 522 | 522 | 522 |
| | 3 | Inspection Standards | * | 532 | 532 | 532 |
| | 4 | Calibration Procedures | * | * | * | * |
| 6 | | Maintenance Schedules | * | * | * | * |
| 7 | 1 | Illustrated Parts Catalogues | 711 | 711 | 711 | 711 |
| | 2 | Commercial Parts Lists | * | * | * | * |
| | 3 | Complete Equipment Schedule, Production | * | * | * | * |
| | 4 | Complete Equipment Schedule, Service Edition (Simple Equipment) | * | * | * | * |
| | 5 | Complete Equipment Schedule, Service Edition (Complex Equipment) | * | * | * | * |
| 8 | 1 | Modification Instructions | * | * | * | * |
| | 2 | General Instructions, Special Technical Instructions and Servicing Instructions | * | * | * | * |
| | 3 | Service Engineered Modification Instructions (RAF only) | * | * | * | * |

*Category/sub-category not published.



Associated publications

5 Reference Title

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|------------|------------|
| [REDACTED] | [REDACTED] |
| [REDACTED] | [REDACTED] |

WARNINGS AND CAUTIONS

WARNING

RISK OF INJURY OR DEATH. NORMAL SAFETY PRECAUTIONS MUST BE OBSERVED BEFORE OPERATION, INSPECTION OR REPAIR OF THIS WEAPON. REFER TO 1005-L-203-201 CHAP 2.

CAUTIONS

NA



LIST OF ABBREVIATIONS

| Abbreviation | Definition |
|--------------|---|
| AESP | Army Equipment Support Publication |
| approx. | approximately |
| AQL | Acceptable Quality Level |
| BR | Beyond Repair |
| Cat | Category |
| Chap | Chapter |
| DIN | Defence Instruction Notice |
| EFR | Equipment Failure Report |
| EMER | Electrical & Mechanical Engineering Regulations |
| in. | Inch(es) |
| lbf | Pound foot |
| max | Maximum |
| min | minimum |
| MOD | Ministry of Defence |
| NATO | North Atlantic Treaty Organisation |
| No. | Number |
| NSN | NATO Stock Number |
| NSP | Normal Safety Precautions |
| Pamp | Pamphlet |
| Para | Paragraph |
| PT | Project Team |
| REME | Royal Electrical and Mechanical Engineers |
| SOP | Standard Operating Procedure |
| SSP | Soldier Systems Programme |

CHAPTER 1

GENERAL INFORMATION

CONTENTS

Para

- 1 Introduction
- 3 Safety precautions
- 4 Frequency of inspection
- 5 Modification and general instructions
- 6 Special tools and gauges
- 7 Protective finish
- 8 Defects
- 9 Proof marks
- 10 Lubrication
- 11 Sentencing
- 12 Principles and practices
- 13 Amendments

INTRODUCTION

- 1 This category details the inspection standards and functional checks to be carried out when the weapon is being inspected at Unit repair (level 2), Field (level 3) and Base (level 4).
- 2 The inspection standards detailed in this publication are to be applied to achieve the minimum Acceptable Quality Level (AQL) to ensure that the weapon will be reliable and safe for its intended role.
- 3 These inspection standards are to be read in conjunction with AESP 1005-L-203-522.

SAFETY PRECAUTIONS

- 4 Before commencing work on the weapon, make sure it is unloaded and safe to handle by carrying out the safety precautions detailed in AESP 1005-L-203-201 Chapter 2.

FREQUENCY OF INSPECTION

- 5 Inspection of the weapon is to be carried out in accordance with AESP 1000-A-003-013 Chapter 5 or where any of the following occur:
 - 5.1 The weapon is reported by the user as having a fault or failing to function correctly.
 - 5.2 The weapon is subject to an ammunition incident or performance failure.

MODIFICATION AND GENERAL INSTRUCTIONS

- 6 The inspector is to be aware of all Modification Instructions and General Instructions.
 - 6.1 The inspector is to ensure that where applicable, all immediate modifications have been carried out. Equipment with immediate modifications outstanding are to be sentenced unserviceable until the modification is completed.
 - 6.2 Routine modifications and general instructions are to be completed, unless the instruction contains a note, stipulating during repair or during overhaul only.

SPECIAL TOOLS AND GAUGES

7 The special tools and gauges required by Armourers for the inspection and repair of this weapon are detailed in AESP 1005-L-203-522 Chapter 1.

PROTECTIVE FINISH

8 Details on types of finish, paints and protection of individual components by weapon type are given in AESP 1000-A-003-013 Chapter 9.

DEFECTS

9 Where, during inspection, a weapon or ancillary is found to be in an unserviceable condition due to deterioration in storage, the effects of fatigue stress, faulty design, material, or manufacture, an Equipment Failure Report (EFR) - AFG 8267 is to be completed and distributed as laid down in JSP 886.

PROOF MARKS

10 The barrel, body and bolt assembly of this weapon are subject to the stress created by firing and as such must exhibit a valid proof mark. AESP 1000-A-003-013, Chap 11 contains further details of proof requirements and acceptable proof marks.

LUBRICATION

11 Subsequent to repair, all metal to wood contact points of this rifle are to be lightly protected by coating with grease XG 276. Further information on lubricants and preservatives is detailed in AESP 1000-A-003-013 Chapter 3.

SENTENCING

12 After inspection, the condition of the equipment is to be given by the standard series of sentencing symbols laid down in AESP 1000-A-003-013.

PRINCIPLES AND PRACTICES

13 The general principles and practices when inspecting light weapons and their associated stores are detailed in AESP 1000-A-003-013 Chapter 4.

AMENDMENTS

14 The inspector is responsible for notifying the SSP PT Abbey Wood of any aspect of these inspection standards that are wrong, confusing or cannot be achieved. Suggested amendments to this publication are to be submitted in accordance with AESP 0100-P-011-013 using AESP Form 10 provided at the end of this document.

CHAPTER 2

INSPECTION STANDARDS

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Para

- 1 Introduction (WARNING)
- 3 Use of inspection tables

Table

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INTRODUCTION

WARNING

RISK OF INJURY OR DEATH. NORMAL SAFETY PRECAUTIONS MUST BE OBSERVED BEFORE OPERATION, INSPECTION OR REPAIR OF THIS WEAPON. REFER TO 1005-L-203-201 CHAP 2.

- 1 The inspection data contained in this chapter is to be applied at all levels.
- 2 These inspection standards detail the minimum quality standards to be achieved when inspecting and testing the equipment listed.

USE OF INSPECTION TABLES

3 The features to be inspected are set out in a logical order to minimise inspection time and avoid repetitive inspection:

- 3.1 Column 1 gives the table serial number.
- 3.2 Column 2 gives the feature to be inspected.
- 3.3 Column 3 gives the minimum acceptable quality level applied to the feature.
- 3.4 Column 4 details any relevant remarks.
- 3.5 Column 5 gives the sentencing symbol to be used at Level 2. When inspecting the weapon at Level 3 and 4 the symbols are to be taken as 'Y' or 'Z'. Where at Level 4 the weapon cannot be repaired to meet the standard laid down in this publication, it is to be sentenced Beyond Repair (BR).

TABLE 1 WEAPON ASSEMBLED

| Serial (1) | Feature (2) | Acceptable Quality Level (AQL) (3) | Remarks (4) | Cond Code (5) |
|---------------|---------------------------|---|---|------------------|
| 1 | Safety | Carry out normal safety precautions (NSPs). | AESP 1005-L-203-201 refers. | X |
| 2 | Registered serial numbers | Numbers on the body, bolt and fore-end must agree and be legible. | | X |
| 3 | Proof marks | Body, barrel and bolt and/or bolt head must bear a valid and legible proof mark. | AESP 1000-A-003-013 refers. | X |
| 4 | Protective finish | 4.1 Unit/Field - No more than 50% of the exposed metal area is to be devoid of phosphate and paint. | Unit - Protection and appearance is to be maintained by patch painting. | X |
| | | 4.2 Base - Weapons subject to programme load are to have 100% protective finish. | Field/Base - Protection and appearance is to be maintained by rustproofing. | Z |
| 5 | Fore-end | 5.1 Must have an overall smooth finish and be free from splits and damage. | | X |
| | | 5.2 Maximum number of four patches. | All repair levels. | X |
| | | 5.3 Must be a reasonable colour match to the butt and handguard. | | X |
| | | 5.4. Filling/stopping must not exceed 0.25 in. diameter. Splits are to be glued and pegged. | | X |
| | | 5.5 Patches must not exceed 3.0 in. in length. | | X |
| | | 5.6 Must be correctly fitted. | AESP 1005-L-203-522 refers. | X |
| | | 5.7 Weight to lift barrel from front bearing: Min: 3.0-lbf. Max: 4.5-lbf. | Trigger tester held at 90° to bore axis. | X |
| | | 5.8 Clearance fore-end to butt socket: Max: 0.030 in. | | X |

continued

TABLE 1 WEAPON ASSEMBLED (continued)

| Serial (1) | Feature (2) | Acceptable Quality Level (AQL) (3) | Remarks (4) | Cond Code (5) |
|---------------|--|---|--|------------------------------|
| 6 | Handguard | 6.1 Must not be split, bowed or damaged. 6.2 Edges are to be flush to the fore-end. 6.3 Must not be loose. | | X X X |
| 7 | Ring, retaining handguard | Must not be fractured or distorted. Must retain handguard securely. | Use of card packing strips is permissible. | X |
| 8 | Front band | 8.1 Must retain handguard securely while allowing rotation of the sling swivel. 8.2 Band should be flush or below flush with the surrounding woodwork. | | X X |
| 9 | Butt | 9.1 Must be tight in the butt socket and in line with the bore axis. 9.2 Must not be split or damaged. 9.3 Screws for the butt plate and rear swivel must be free from damage and must not slip. 9.4 Clearance, butt shoulder to body socket. Min. 0.005 in. Max 0.040 in. | | X X X X |
| 10 | Sling swivels. (front, rear & trigger guard) | 10.1 Must not be distorted. 10.2 Loop must be secure on its link. 10.3 Must rotate freely. | | X X X |

continued

TABLE 1 WEAPON ASSEMBLED (continued)

| Serial (1) | Feature (2) | Acceptable Quality Level (AQL) (3) | Remarks (4) | Cond Code (5) |
|---------------|---------------------|---|-----------------------------|------------------------------|
| 11 | Butt plate | 11.1 Must not be perished, damaged or distorted. 11.2 Should be a reasonable fit to the surface of the butt. | | X X |
| 12 | Backsight assembly | 12.1 Must operate smoothly on its axis pin, without sideplay or slackness. 12.2 Plunger and spring must hold sight in vertical and horizontal positions. 12.3 Range scale to be legible and scale face polished. 12.4 Leaf must not be damaged, cracked or distorted and must operate smoothly over the range scale using the adjusting screw. 12.5 Adjusting screw must not be worn or distorted and is to be retained in each position by the plunger and spring. | | X X X X |
| 13 | Protector foresight | 13.1 Must be secure and free from cracks, burrs and distortion. 13.2 Retaining screw must not be damaged or stripped. | | X X |
| 14 | Foresight | Must be secure within its dovetail seating. | | X |
| 15 | Trigger guard | Must not be distorted or damaged. | | X |
| 16 | Action of bolt | 16.1 Unlocking of the bolt from the fired position must be smooth. 16.2 Sear must not foul the resistance lug of the bolt during operation. 16.3 Cocking piece must not foul its channel in the body or the spindle of the locking bolt. | AESP 1005-L-203-522 refers. | X Y X |

continued