

PROCESS RECORD ASSEMBLY SHEETS

DATE AND REASON FOR REVISIONS 1/16/59 - Revised process - Q.M. - 253512 -
 6/15/61 - J.M. W.T.O. - C.M. - 256088
 7/9/62 - J.M. W.T.O. - C.M. - 257220

DESCRIPTIVE INFORMATION

1. Pick Action from truck, position and clamp in vice.
2. Pick Trigger Assembly.
3. Insert Trigger Assembly into Receiver. (Must fit freely).
4. Pick Bolt Stop Pin and start. Drive in flush with inside of Bolt Stop cut.
5. Pick Bolt Stop Spring and position in Receiver.
6. Pick Bolt Stop and position in Receiver.
7. Pick Bolt Stop Pin, position and drive in.
8. Pick Bolt Stop Pin and Sear Pin.
9. Pick Piling Pin Assembly, inspect, point not marred, Bolt Plug color O.K. No rust, or sludge.
10. Assemble to Bolt Group and remove "U" washer.
11. Check Piling Pin protrusion.
12. Insert Bolt into Action and lock down.
13. Try Safety.

a. Must be clearance between Sear and Trigger Connector with Safety on.

EQUIPMENT-TOOLS & GAGES

No Sear, Safety Can bind to Bowling.
 Pins tight - Tester 3-20652

Protrusion gauge 3-10-52009

NOTE: Only correct components of good color, Not broke or deformed should be used.

OPERATION DESCRIPTION

Final Assembly - M/T21-T22
 M/T00 ADL

QCC No
 STD - P&C
 STD No
 EFF DATE

PART No
 DA

FIRST NAME Final Assembly

COOLING

SET UP

MODEL No T21 - T22 - T00 ADL - 173

DATE 6/15/61

[illegible]

