

Trigger Pull Audit Plan

- Verify calibration of the Dvorak TriggerScan per the User Manual's procedure. *(DONE)*
- Verify calibration of the production spring scale prior to starting the audit and as needed during the course of the audit.

Trigger Pull Measurement Process

1. Unpack guns from multi-packs one gun at a time.
2. Have no more than two guns unpacked at any one time to minimize the possibility of parts getting lost or mixed up.
3. ***Handle the guns with extreme care as they are salable product and will be returned to the warehouse after completion of the trigger pull force audit.***
4. Assemble the gun's bolt to the action. After verifying the action is clear of ammunition, manually verify trigger function by dry firing the rifle several times in a safe direction.
5. Record the appropriate information for the gun on the datasheet (SKU, S/N, etc.) prior to conducting any testing.
6. Mount the gun securely in a non-marring gun vise or cradle.
7. Measure and record trigger pull of the gun with the spring scale per the current production process indicated in the process records. *This measurement will be made by someone from Ilion using a production spring scale from Ilion.*
8. Carefully remove the gun from the gun vise or cradle.
9. Carefully disassemble the action from the stock setting aside the stock and trigger guard components so that they will not be damaged.
10. Mount the action in the Dvorak TriggerScan fixture with the barrel bracket tight against the front surface of the V-block and with the top clamp's hold down screw tip approximately aligned with the rearmost scope plug screw on the front receiver bridge. Ensure the trigger's shoe is centered on the V-roller on the TriggerScan arm so that both sides of the roller's V contact the trigger and then tighten the clamping screw. ***Make sure the clamp's screw does not contact the top of the receiver or it may mar it.*** When properly secured in the TriggerScan fixture, the action cannot move with respect to the fixture.