

7-50.02

SAAMI TECHNICAL COMMITTEE MANUAL

ISSUED 10-5-78

VOLUME VII, CENTERFIRE RIFLE

REVISED 2-27-79FIRING-PIN INDENT MEASUREMENT PROCEDUREEQUIPMENT

1. Copper Crusher Cylinder (See data sheet 7-50.04.)
2. Dial Indicator graduated in .0005 inches (.01) mounted on stand with adjustable platen or dial.
3. Indicator Point (stylus) with point radius not larger than .010" (.03).
4. Crusher Holder for the caliber for which firearm is chambered. (See data sheets 7-50.05, 7-50.06, 7-50.07, 7-50.08.)

OPERATION

1. Clean firearms chambers of all residue or lubrication.
2. Adjust dial indicator platen for "0" or known reading on height of a copper crusher cylinder. Remove burrs from crusher as necessary to obtain valid "0" setting.
3. Insert crusher cylinder, for which dial indicator has been set, in crusher holder and insert assembly in chamber.
4. Close firearm and pull trigger with muzzle inclined downward.
5. Open firearm and remove crusher holder and crusher cylinder.
6. Place crusher under dial with indicator point (stylus) in firing-pin indent. Shift crusher cylinder to obtain largest dial reading.
7. Read firing-pin indent from indicator dial to nearest .0005" (.01).

COMMENTS

This method of measurement is designed to include shortening of the crusher as well as the indent depth in the measurement. The removal of burrs from the crusher and provision of a flat smooth seat in the crusher holder recess are important to obtain consistent and accurate readings.

NOTE: (XX.XX) = Millimeters

7-50.03

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REVISED

FIRING-PIN INDENT

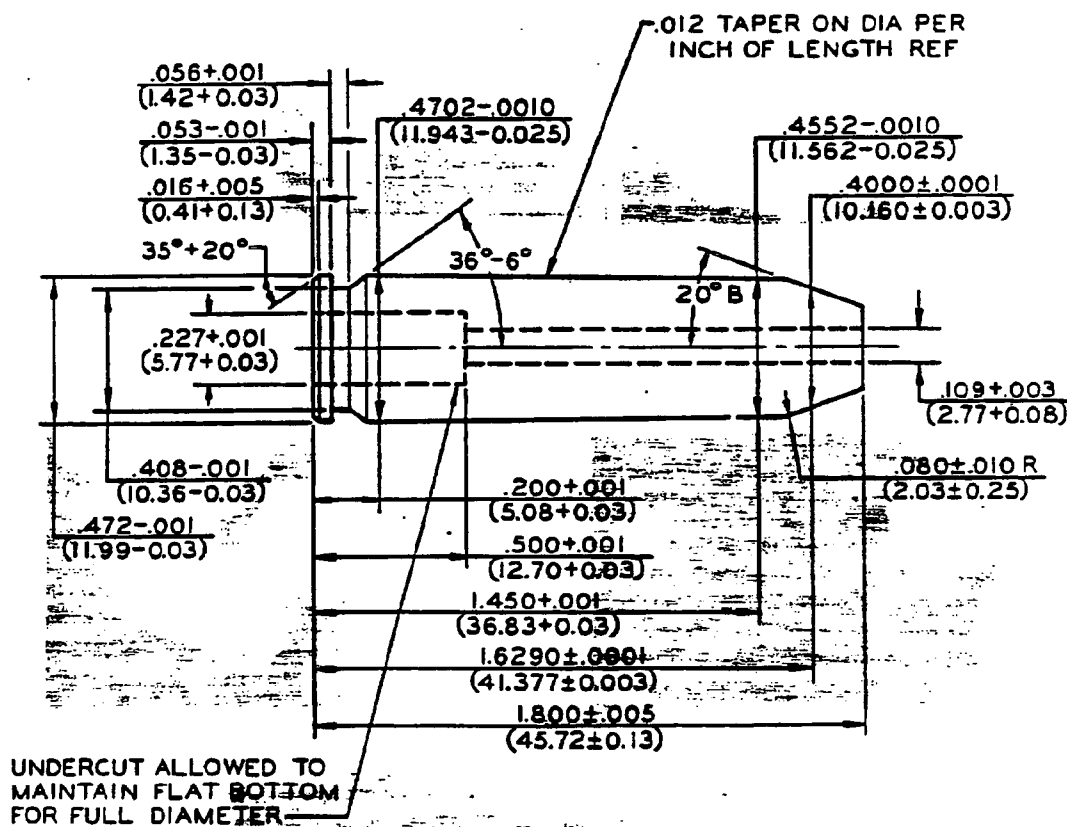
If the major variables of headspace, temperature and eccentricity of blow are considered, minimum indents in centerfire rifles with a .060" (1.52) to .080" (2.03) diameter approximately hemispherical firing-pin, should be .017" (0.43) in order to insure against misfires chargeable to the firearm when measured as per procedure shown on sheet 7-50.02.



NOTE: (XX.XX) = Millimeters

VOLUME VII, CENTERFIRE RIFLE

CENTERFIRE RIFLE
FIRING PIN INDENT FIXTURE
RIMLESS (TYPICAL)
(308 WINCHESTER SHOWN)

**NOTES**

1. USE COPPER CRUSHER SHOWN ON SHEET 7-20.04
2. HARDEN AND GRIND
3. B = BASIC
4. (XX.XX) = MILLIMETERS

REV. DATE	APPROVED DATE	REVISION DESCRIPTION	FIRING PIN INDENT FIXTURE RIMLESS (TYPICAL)
			DRAWN <i>E. G. R.</i> APPROVED <i>10-5-78</i>
			S - A - A - M - I