

Franz, Scott

From: Mead, Joseph P.
Sent: Saturday, April 29, 2000 8:13 AM
To: Franz, Scott
Cc: Lewis, Richard
Subject: RE:

Scott,

I cut and pasted this right from the process for you. We did make a change to the process in November 99. We tightened up the engagement tolerance from .015-.02 to .018-.02 new comparator at 50X allows us this control. Raised the lower end of Trigger pull from #3.5 to #4. We use a comparator fixture with all the settings at 50X. If you have any other questions give me a call.

Joe

Adjust Trigger Assembly on Comparator 100%

1. Pick Trigger Sub-Assembly. Position in comparator fixture and clamp:
 - * Housing must properly contact all locators.
 - * Top of Housing must be flat on fixture.
 - * Push with thumb on rear of Trigger (toward left). This seats Trigger firmly against end of Trigger Adjusting Screw.
2. Adjust fixture to locate Sear on "set" line of comparator screen.
3. Adjust Sear/Connector engagement (.018 - .020) to correct comparator screen line by turning Trigger Engagement Screw SLOWLY CLOCKWISE (to reduce engagement).

AFTER CORRECTLY ADJUSTING SEAR/CONNECTOR ENGAGEMENT

4. Hang dead weight roller assembly in radius of trigger.
5. Adjust trigger pull by turning Trigger Adjusting Screw slowly counter-clockwise until Sear just disengages (fires).
Comparator fixture dead weight - 4 lbs.
6. Remove dead weight assembly from Trigger.
7. Hold Trigger in fired position firmly with finger and:
 - * Set OVER-TRAVEL by turning Trigger Stop Screw SLOWLY CLOCKWISE, until Trigger Connector touches correct line in comparator screen.
8. Remove Trigger Sub-Assembly from comparator fixture.
9. Seal all three screws with "Duco" Cement, including screw slots.

-----Original Message-----

From: Franz, Scott
Sent: Friday, April 28, 2000 4:34 PM
To: Mead, Joseph P.
Subject: FW:
Importance: High

Joe,

I probably should of directed this to you first. Could you help me on this?

Thanks,
Scott F.

From: Franz, Scott
Sent: Thursday, April 27, 2000 1:55 PM
To: Lewis, Richard
Importance: High

Rick,

What are our current trigger pull and engagement process specifications for the M/700. Was there a recent change, or is there one in the works? I need these for M/710 reference. While I've got you, congratulations on 30 years. Say hi to the family. Everyone here is doing fine. Kids are driving us crazy with soccer, baseball, school, you name it.

Later,
Scott

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