

	A	B
1	Part Name:	REAR SPACER BLOCK
2	Drawing Num:	301444
3	TLW Number:	241460
4	Revision Level:	
5	Vendor:	
6	Requisition #:	
7	Material:	
8	Hardness:	
9	Metallurgist:	
10	Engineer:	JIM RONKAINEN
11	Inspected by:	JIM RONKAINEN
12	Date:	12/5/2006
13	Reviewed by:	JR
14	Date:	12/6/2006
15		
16		
17		
18		
19	identifier	feature description
20	A	THICKNESS
21	B	Diameter
22	C	Diameter
23	C	Bonus
24	C	Positional Tolerance
25	D	Vert. DISTANCE Hole
26	I	Horiz. DISTANCE Hole
27	E	DISTANCE
28	F	DISTANCE
29	G	DISTANCE
30	H	DISTANCE
31	J	DISTANCE
32	K	DISTANCE
33	L	DISTANCE
34	M	RADIUS
35	N	RADIUS
36	O	RADIUS
37	P	RADIUS
38	Q	RADIUS
39	R	RADIUS
40	S	RADIUS
41	T	DEGREE
42	U	DEGREE
43	V	DEGREE
44	W	DEGREE
45	X	DISTANCE
46	Y	DISTANCE
47	Z	Diameter
48	Z	Diameter
49	Z	Possible Bonus
50	Z	Positional Tolerance
51	AA	Diameter

	C
1	
2	
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6	
7	
8	
9	
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13	
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15	
16	
17	
18	
19	DIM
20	0.1750
21	0.0995
22	0.0995
23	
24	0.0030
25	0.160
26	0.105
27	0.289
28	0.265
29	0.271
30	0.315
31	0.143
32	0.100
33	0.250
34	0.015
35	0.010
36	0.015
37	0.050
38	0.015
39	0.300
40	0.015
41	29.000
42	99.000
43	55.000
44	35.000
45	0.0875
46	0.150
47	0.125
48	0.125
49	
50	0.010
51	0.168

	D	E	F	G	H	I	J	K
1								
2	NOTE- Dimension identifiers will be provided on the prints supplied by engineering & the CAD group.							
3								
4	INSTRUCTIONS:							
5	1. STAMP ALL PARTS WITH AN I.D, NUMBER AND CHANGE I.D. AT TOP OF PAGE CORRESPONDINGLY.							
6	2. TAG PARTS ONLY IF STAMPING IS NOT POSSIBLE.							
7	3. ENTER FEATURE DESCRIPTIONS WHEN POSSIBLE. (OPTIONAL)							
8	4. WHEN COMPLETE, RETURN ALL PARTS TO ENGINEER IN ORIGINAL SHIPPING CARTON (IF POSSIBLE) AND DRAWING WITH IDENTIFIERS.							
9								
10	INSPECTOR NOTES: DIAMETER DIM B AND C ARE + PIN GAGES							
11								
12								
13								
14								
15								
16								
17								
18								
19	plus	minus	1	2	3	4	5	6
20	0.001	0.001	0.1759	0.1760	0.1759	0.1758	0.1758	0.1760
21	0.001	0.001	0.0988	0.0988	0.0988	0.0987	0.0987	0.0987
22	0.001	0.001	0.0988	0.0988	0.0988	0.0987	0.0987	0.0987
23			0.0003	0.0003	0.0003	0.0002	0.0002	0.0002
24	0.000	0.003	IN	IN	IN	IN	IN	IN
25	0.0015	0.0015	0.1600	0.1598	0.1600	0.1600	0.1599	0.1599
26	0.0015	0.0015	0.1049	0.1052	0.1051	0.1048	0.1052	0.1050
27	0.0025	0.0025	0.2892	0.2897	0.2895	0.2892	0.2896	0.2895
28	0.0025	0.0025	0.2652	0.2657	0.2658	0.2655	0.2656	0.2656
29	0.0025	0.0025	0.2713	0.2718	0.2715	0.2711	0.2717	0.2715
30	0.0025	0.0025	0.3153	0.3156	0.3158	0.3156	0.3158	0.3157
31	0.0025	0.0025	0.1435	0.1435	0.1435	0.1433	0.1432	0.1431
32	0.0025	0.0025	0.1002	0.1026	0.1002	0.1005	0.1007	0.1007
33	0.0025	0.0025	0.2503	0.2502	0.2504	0.2508	0.2500	0.2502
34	0.0025	0.0025	0.0209	0.0374	0.0485	0.0441	0.0256	0.0337
35	0.0025	0.0025	0.0103	0.0113	0.0111	0.0112	0.0096	0.0113
36	0.0025	0.0025	0.0130	0.0155	0.0135	0.0150	0.0216	0.0205
37	0.0025	0.0025	0.0491	0.0467	0.0495	0.0498	0.0474	0.0491
38	0.0025	0.0025	0.0172	0.0155	0.0145	0.0172	0.0131	0.0178
39	0.0025	0.0025	0.3005	0.2973	0.2992	0.2977	0.3036	0.3012
40	0.0025	0.0025	0.0155	0.0157	0.0154	0.0171	0.0165	0.0167
41	0.500	0.500	29.0406	29.0234	28.9890	28.8009	29.0584	28.9005
42	0.500	0.500	99.0347	99.0309	98.8927	98.7539	98.8492	98.9018
43	0.500	0.500	55.1037	54.2090	55.2359	54.9017	54.9088	54.7860
44	0.500	0.500	34.9800	35.0526	34.9662	35.0072	34.9958	35.0056
45			0.0900	0.0916	0.0903	0.0886	0.0912	0.0899
46			0.1535	0.1496	0.1478	0.1490	0.1550	0.1495
47			.1255-	.125+	.125+	.1245+	.125+	.125+
48	0.001	0.001	0.1253	0.1252	0.1252	0.1247	0.1252	0.1252
49			0.0013	0.0012	0.0012	0.0007	0.0012	0.0012
50	0.000	0.010	IN	IN	IN	IN	0.0013	IN
51	0.007	0.007	0.1676	0.1682	0.1663	0.1667	0.1656	0.1640

	L	M	N	O	P	Q	R	S	T	U	V	W	X	Y	Z	AA
1																
2																
3																
4																
5																
6																
7																
8																
9																
10																
11																
12																
13																
14																
15																
16																
17																
18																
19	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22
20	0.1759	0.1757	0.1758	0.1758	0.1760	0.1759	0.1759	0.1759	0.1758	0.1757	0.1759	0.1758	0.1757	0.1759	0.1758	0.1758
21	0.0987	0.0987	0.0987	0.0987	0.0987	0.0987	0.0987	0.0987	0.0987	0.0987	0.0987	0.0988	0.0987	0.0987	0.0988	0.0987
22	0.0987	0.0987	0.0987	0.0987	0.0987	0.0987	0.0987	0.0987	0.0987	0.0987	0.0987	0.0988	0.0987	0.0987	0.0988	0.0987
23	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0002	0.0003	0.0002	0.0002	0.0003	0.0002
24	IN	IN	IN	IN	IN	IN	IN	IN	IN	IN	IN	IN	IN	IN	IN	IN
25	0.1600	0.1600	0.1603	0.1599	0.1599	0.1600	0.1599	0.1604	0.1601	0.1602	0.1599	0.1600	0.1602	0.1601	0.1601	0.1598
26	0.1044	0.1051	0.1050	0.1053	0.1048	0.1048	0.1048	0.1059	0.1046	0.1052	0.1046	0.1048	0.1049	0.1051	0.1056	0.1047
27	0.2910	0.2895	0.2893	0.2893	0.2905	0.2897	0.2908	0.2891	0.2898	0.2894	0.2894	0.2897	0.2894	0.2892	0.2891	0.2897
28	0.2640	0.2654	0.2653	0.2651	0.2637	0.2655	0.2640	0.2663	0.2658	0.2656	0.2654	0.2653	0.2656	0.2651	0.2663	0.2650
29	0.2739	0.2714	0.2715	0.2713	0.2726	0.2717	0.2739	0.2707	0.2720	0.2714	0.2718	0.2716	0.2714	0.2717	0.2710	0.2721
30	0.3134	0.3153	0.3159	0.3161	0.3148	0.3157	0.3135	0.3162	0.3159	0.3161	0.3156	0.3154	0.3158	0.3155	0.3162	0.3154
31	0.1456	0.1431	0.1434	0.1431	0.1447	0.1435	0.1449	0.1425	0.1442	0.1431	0.1434	0.1432	0.1433	0.1435	0.1427	0.1438
32	0.1038	0.1009	0.1005	0.1003	0.1016	0.1005	0.1022	0.0998	0.1016	0.0999	0.0999	0.0999	0.1000	0.1015	0.1010	0.1011
33	0.2511	0.2504	0.2505	0.2504	0.2513	0.2503	0.2505	0.2496	0.2508	0.2503	0.2504	0.2504	0.2504	0.2509	0.2499	0.2506
34	0.0267	0.0320	0.0554	0.0267	0.0166	0.0296	0.0228	0.0212	0.0220	0.0366	0.0291	0.0207	0.0221	0.0535	0.0255	0.0220
35	0.0122	0.0091	0.0131	0.0137	0.0137	0.0204	0.0117	0.0144	0.0124	0.0134	0.0125	0.0086	0.0092	0.0110	0.0101	0.0131
36	0.0160	0.0147	0.0133	0.0174	0.0133	0.0124	0.0156	0.0146	0.0138	0.0177	0.0110	0.0241	0.0180	0.0132	0.0187	0.0155
37	0.0479	0.0482	0.0523	0.0508	0.0499	0.0465	0.0518	0.0496	0.0491	0.0483	0.0494	0.0493	0.0511	0.0479	0.0473	0.0502
38	0.0165	0.0155	0.0141	0.0147	0.0170	0.0163	0.0180	0.0146	0.0166	0.0165	0.0141	0.0145	0.0172	0.0156	0.0162	0.0153
39	0.2985	0.2997	0.3009	0.2947	0.2980	0.3010	0.2998	0.2959	0.2981	0.3014	0.2999	0.3024	0.2995	0.2977	0.3000	0.2979
40	0.0155	0.0155	0.0160	0.0150	0.0150	0.0150	0.0161	0.0197	0.0159	0.0163	0.0166	0.0183	0.0160	0.0175	0.0149	0.0166
41	28.9450	29.1149	28.9458	28.9665	28.8417	28.9537	28.6441	29.0223	28.9996	28.9640	29.0565	29.0858	29.1641	28.8050	28.9466	28.8989
42	98.9899	98.9123	99.0270	98.8229	98.8872	99.0575	99.0000	98.9656	98.9585	98.9070	98.9638	99.0447	98.9745	98.9110	98.8437	98.8596
43	54.7517	54.8293	54.9627	54.8212	55.1165	55.1132	55.1868	54.9972	54.7830	55.1768	55.3207	55.3413	55.1173	54.7679	54.5130	55.0137
44	34.9204	34.9973	34.8150	35.0858	34.8906	34.3976	34.5354	34.8833	34.6575	35.0120	34.8213	35.0058	34.9396	34.7329	34.7213	34.7830
45	0.0909	0.0887	0.0910	0.0894	0.0894	0.0924	0.0891	0.0892	0.0889	0.0898	0.0918	0.0897	0.0912	0.0912	0.0911	0.0882
46	0.1487	0.1501	0.1558	0.1472	0.1489	0.1476	0.1513	0.1524	0.1490	0.1478	0.1527	0.1486	0.1502	0.1579	0.1539	0.1528
47	.125+	.125+	.125+	.125+	.1245+	.125+	.125+	.1255-	.125-	.125+	.125+	.125+	.125+	.125-	.125-	.125+
48	0.1252	0.1252	0.1252	0.1252	0.1247	0.1252	0.1252	0.1253	0.1248	0.1252	0.1252	0.1252	0.1252	0.1252	0.1248	0.1252
49	0.0012	0.0012	0.0012	0.0012	0.0007	0.0012	0.0012	0.0013	0.0008	0.0012	0.0012	0.0012	0.0012	0.0008	0.0008	0.0012
50	IN	IN	0.0024	IN	IN	IN	IN	IN	IN	IN	IN	IN	IN	0.0067	IN	IN
51	0.1627	0.1699	0.1622	0.1604	0.1600	0.1640	0.1694	0.1637	0.1774	0.1649	0.1628	0.1653	0.1725	0.1643	0.1624	0.1673

	AB	AC	AD	AE	AF	AG	AH	AI	AJ	AK	AL
1											
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6											
7											
8											
9											
10											
11											
12											
13											
14											
15											
16											
17											
18											
19	23	24	25	AVG	STDEV	Method					
20	0.1759	0.1758	0.1758	0.1758	0.0001	MIC					
21	0.0987	0.0987	0.0987	0.0987	0.0000	PIN					
22	0.0987	0.0987	0.0987	0.0987	0.0000	PIN					
23	0.0002	0.0002	0.0002	0.0002	0.0000	Calculated					
24	IN	IN	IN			Calculated					
25	0.1602	0.1602	0.1600	0.1600	0.0001	MV					
26	0.1045	0.1048	0.1051	0.1050	0.0003	MV					
27	0.2905	0.2892	0.2894	0.2896	0.0005	MV					
28	0.2644	0.2651	0.2651	0.2653	0.0007	MV					
29	0.2732	0.2712	0.2715	0.2718	0.0008	MV					
30	0.3136	0.3154	0.3156	0.3154	0.0008	MV					
31	0.1447	0.1432	0.1436	0.1436	0.0007	MV					
32	0.1023	0.1001	0.0999	0.1009	0.0010	MV					
33	0.2505	0.2504	0.2504	0.2504	0.0003	MV					
34	0.0601	0.0204	0.0286	0.0313	0.0122	MV					
35	0.0124	0.0118	0.0120	0.0120	0.0023	MV					
36	0.0163	0.0105	0.0155	0.0156	0.0032	MV					
37	0.0526	0.0502	0.0495	0.0493	0.0016	MV					
38	0.0150	0.0139	0.0122	0.0156	0.0015	MV					
39	0.2973	0.2997	0.3003	0.2993	0.0020	MV					
40	0.0157	0.0166	0.0147	0.0161	0.0011	MV					
41	28.9820	29.2668	29.1004	28.9815	0.1278	MV					
42	99.0814	98.9795	98.9802	98.9460	0.0826	MV					
43	55.1390	55.0341	55.2298	54.9744	0.2583	MV					
44	34.7131	34.8139	34.8978	34.8652	0.1682	MV					
45	0.0896	0.0922	0.0896	0.0902	0.0012	MV					
46	0.1497	0.1551	0.1545	0.1511	0.0030	MV					
47	.125-	.125+	.125-			PIN					
48	0.1248	0.1252	0.1248	0.1251	0.0002	PIN					
49	0.0008	0.0012	0.0008			Calculated					
50	IN	0.0026	IN			Calculated					
51	0.1620	0.1636	0.1682	0.1657	0.0039	MV					

	A	B
52	BB	DEPTH
53	CC	DEGREE
54	DD	DEGREE
55	EE	OVERLAY@20X (profile)
56	Z	Diameter
57	AA to Z	Eccentricity
58		
59		
60		
61		OHL
62		ULL
63		
64		
65		
66		
67		

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

R 2193520

	C
52	0.380
53	35.000
54	60.000
55	
56	0.125
57	
58	
59	
60	All items inside this box are for informational purposes only. Acceptance or rejection of the parts are based solely up conformance of the parts to the profile tolerance evaluated with the comparator screen.
61	= over high limit
62	= under low limit
63	
64	
65	
66	
67	

	D	E	F	G	H	I	J	K
52	0.010	0.010	0.3770	0.3750	0.3740	0.3790	0.3790	0.3790
53	0.500	0.500	35.3105	35.5678	35.2443	35.1813	35.0056	35.2754
54			n/a	n/a	n/a	n/a	n/a	n/a
55			OK	OK	OK	OK	OK	OK
56	0.001	0.001	0.1254	0.1251	0.1264	0.1253	0.1258	0.1253
57			0.0018	0.0029	0.0012	0.0005	0.0018	0.0022
58								
59								
60								
61								
62								
63								
64								
65								
66								
67								



	L	M	N	O	P	Q	R	S	T	U	V	W	X	Y	Z	AA
52	0.3740	0.3730	0.3740	0.3790	0.3700	0.3830	0.3770	0.3810	0.3750	0.3850	0.3760	0.3830	0.3700	0.3720	0.3780	0.3800
53	34.8335	35.1537	35.2188	34.0312	35.0773	35.2270	35.5458	35.2667	35.3084	35.1552	35.3174	35.1249	35.1489	35.3722	35.5233	34.0960
54	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
55	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
56	0.1250	0.1252	0.1251	0.1253	0.1247	0.1255	0.1248	0.1260	0.1255	0.1247	0.1255	0.1253	0.1256	0.1250	0.1253	0.1253
57	0.0018	0.0013	0.0022	0.0053	0.0024	0.0033	0.0025	0.0009	0.0012	0.0015	0.0020	0.0017	0.0021	0.0024	0.0030	0.0020
58																
59																
60																
61																
62																
63																
64																
65																
66																
67																

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
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R 2193523

	AB	AC	AD	AE	AF	AG	AH	AI	AJ	AK	AL
52	0.3720	0.3800	0.3750	0.3768	0.0040	HG					
53	35.2363	36.1118	35.6872	35.2008	0.4230	MV					
54	n/a	n/a	n/a								
55	OK	OK	OK			OVERLAY					
56	0.1253	0.1256	0.1250	0.1253	0.0004	MV					
57	0.0011	0.0035	0.0023	0.0021	0.0010	MV					
58											
59											
60											
61											
62											
63											
64											
65											
66											
67											

Cell: F21

Comment: Jim Ronkainen:
was .0987 on MicroVu

Cell: G21

Comment: Jim Ronkainen:
was .0986 on MicroVu

Cell: H21

Comment: Jim Ronkainen:
was .0979 on MicroVu

Cell: I21

Comment: Jim Ronkainen:
was .0981 on MicroVu

Cell: J21

Comment: Jim Ronkainen:
was .0982 on MV

Cell: K21

Comment: Jim Ronkainen:
was .0984 on MV

Cell: L21

Comment: Jim Ronkainen:
was .0973 on MV

Cell: M21

Comment: Jim Ronkainen:
was .0983 on MV

Cell: N21

Comment: Jim Ronkainen:
was .0980 on MV

Cell: O21

Comment: Jim Ronkainen:
was .0981 on MV

Cell: P21

Comment: Jim Ronkainen:
.0979 on MV

Cell: Q21

Comment: Jim Ronkainen:
was .0984 on MV

Cell: R21

Comment: Jim Ronkainen:
.0979 on MV

Cell: S21

**CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON**

R 2193525

Comment: Jim Ronkainen:
.0969 on MV

Cell: T21
Comment: Jim Ronkainen:
.0974 in MV

Cell: U21
Comment: Jim Ronkainen:
.0982 on MV

Cell: V21
Comment: Jim Ronkainen:
.0983 on MV

Cell: W21
Comment: Jim Ronkainen:
.0986 in MV

Cell: X21
Comment: Jim Ronkainen:
.0983 on MV

Cell: Y21
Comment: Jim Ronkainen:
.0975 on MV

Cell: Z21
Comment: Jim Ronkainen:
.0971 on MV

Cell: AA21
Comment: Jim Ronkainen:
.0981 on MV

Cell: AB21
Comment: Jim Ronkainen:
.0983 on MV

Cell: AC21
Comment: Jim Ronkainen:
.0984 on MV

Cell: AD21
Comment: Jim Ronkainen:
.0984 on MV

Cell: F22
Comment: Jim Ronkainen:
was .0984 on MicroVu

Cell: G22
Comment: Jim Ronkainen:

was .0986 on MicroVu

Cell: H22

Comment: Jim Ronkainen:
was .0980 on MicroVu

Cell: I22

Comment: Jim Ronkainen:
was .0979 on MicroVu

Cell: J22

Comment: Jim Ronkainen:
was .0980 on MV

Cell: K22

Comment: Jim Ronkainen:
was .0982 on MV

Cell: L22

Comment: Jim Ronkainen:
was .0977 on MV

Cell: M22

Comment: Jim Ronkainen:
was .0983 on MV

Cell: N22

Comment: Jim Ronkainen:
was .0982 on MV

Cell: O22

Comment: Jim Ronkainen:
was .0978 on MV

Cell: P22

Comment: Jim Ronkainen:
was .0975 on MV

Cell: Q22

Comment: Jim Ronkainen:
was .0983 on MV

Cell: R22

Comment: Jim Ronkainen:
.0980 on MV

Cell: S22

Comment: Jim Ronkainen:
.0981 on MV

Cell: T22

Comment: Jim Ronkainen:
.0980 on MV

CONFIDENTIAL-SUBJECT TO PROTECTIVE ORDER
KINZER V. REMINGTON

R 2193527

Cell: U22
Comment: Jim Ronkainen:
.0982 on MV

Cell: V22
Comment: Jim Ronkainen:
.0981 on MV

Cell: W22
Comment: Jim Ronkainen:
.0984 on MV

Cell: X22
Comment: Jim Ronkainen:
.0983 on MV

Cell: Y22
Comment: Jim Ronkainen:
.0977 on MV

Cell: Z22
Comment: Jim Ronkainen:
.0977 on MV

Cell: AA22
Comment: Jim Ronkainen:
.0980 on MV

Cell: AB22
Comment: Jim Ronkainen:
.0981 on MV

Cell: AC22
Comment: Jim Ronkainen:
.0985 on MV

Cell: AD22
Comment: Jim Ronkainen:
.0984 on MV

Cell: A27
Comment: Jim Ronkainen:
For information only - profile tolerance on part periphery governs dimensional acceptability of parts

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Cell: A44

Comment: Jim Ronkainen:

For information only - profile tolerance on part periphery governs dimensional acceptability of parts

Cell: A46

Comment: Jim Ronkainen:

Method used to measure this dimension is not repeatable - very sensitive to pin fit in hole. Measurement of position was done to the exterior of gage pin where small variations in the angle will cause wide variations in the measured position.

Cell: J50

Comment: Jim Ronkainen:

Most of the variation in position is front-to-back, not side-to-side. OK to use as-is. Note any functional issues on data sheets.

Cell: N50

Comment: Jim Ronkainen:

Most of the variation in position is front-to-back, not side-to-side. OK to use as-is. Note any functional issues on data sheets.

Cell: Y50

Comment: Jim Ronkainen:

Most of the variation in position is front-to-back, not side-to-side. OK to use as-is. Note any functional issues on data sheets.

Cell: AC50

Comment: Jim Ronkainen:

Most of the variation in position is front-to-back, not side-to-side. OK to use as-is. Note any functional issues on data sheets.

Cell: A51

Comment: Jim Ronkainen:

Most parts were running below spec - parts were tried parts as-is and modified as necessary where any issues arose. Original specification for c'sink diameter (.175 +/- .005) was modified to .168 +/- .007.

Cell: O51

Comment: Jim Ronkainen:

Dimension is below specification, but does not impede function. Use as-is and note any unusual performance.

Cell: P51

Comment: Jim Ronkainen:

Dimension is below specification, but does not impede function. Use as-is and note any unusual performance.

Cell: T51

Comment: Jim Ronkainen:

originally measured at .1597, but caused hitch in trigger pull. C'sink was increased and hitch went away. Dimension is now above specification, but does not impede function. Use as-is and note any unusual performance.

Cell: A52

Comment: Jim Ronkainen:

Nominal value for hole depth increased and tolerance increased as well. Adjustment screw will accommodate increased hole depth.

Cell: A53

Comment: Jim Ronkainen:

Accurate measurement of angle is difficult due to short length of datum edge. Parts ok to use as-is and any issues that arise will be addressed.

Cell: A56

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R 2193530

Comment: Jim Ronkainen:

Pin gage is the method of record for determining hole diameter, not MicroVu. See dimension Z above.

Cell: B57

Comment: Jim Ronkainen:

for informational purposes only

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KINZER V. REMINGTON

R 2193531

	A	B	C
1		 E:\Solidworks Files\ XR100 SPL Trigger A	
2			
3			
4			
5			
6			
7			
8	View with Adobe Acrobat to properly show highlighting.		