	A	B	C	D	E	F	G	H	I	J
1		**A**	**A**	**A**	**C**	**E**	**A**	**B**	**B**	**D**
2	Housing #	Engagement Screw Hole Gage Pin Diameter	Engagement Screw Hole Gage Pin Diameter	Engagement Screw Hole Diameter	Engagement Screw Hole Vertical Position	Engagement Screw Hole Lateral Position	Engagement Screw Hole Position	Trigger Pull Screw Hole Gage Pin Diameter	Trigger Pull Screw Hole Gage Pin Diameter	Trigger Pull Screw Hole Vertical Position
3	Method	Gage Pin	Gage Pin	MV	MV	MV	Calculated	Gage Pin	Gage Pin	MV
4	Nominal		0.120	0.120	0.925	0.1475	0.006		0.120	0.835
5	Plus		0.001	0.001	0.003	0.003	0.000		0.001	0.003
6	Minus		0.001	0.001	0.003	0.003	0.006		0.001	0.003
7	1	.120+	0.1202	0.1209	0.9251	0.1449	0.0053	.119+	0.1192	0.8334
8	2	.120+	0.1202	0.1209	0.9225	0.1455	**0.0065**	.1195+	0.1197	***0.8291***
9	3	.120+	0.1202	0.1205	0.9248	0.1464	0.0022	.119+	0.1192	***0.8307***
10	4	.120+	0.1202	0.1209	0.9233	0.1470	0.0036	.119+	0.1192	***0.8263***
11	5	.120+	0.1202	0.1206	0.9238	0.1480	0.0027	.119+	0.1192	***0.8317***
12	6	.120+	0.1202	0.1206	0.9232	0.1449	**0.0064**	.119+	0.1192	***0.8294***
13	7	.120+	0.1202	0.1204	0.9243	0.1461	0.0032	.119+	0.1192	0.8326
14	8	.120+	0.1202	0.1208	0.9244	0.1448	0.0055	.119+	0.1192	0.8320
15	9	.120+	0.1202	0.1201	0.9237	0.1474	0.0025	.119+	0.1192	***0.8309***
16	10	.120+	0.1202	0.1205	0.9237	0.1474	0.0026	.119+	0.1192	0.8328
17	11	.120+	0.1202	0.1206	0.9222	0.1463	**0.0060**	.119+	0.1192	***0.8304***
18	12									
19	13	.120+	0.1202	0.1204	0.9243	0.1447	0.0059	.119+	0.1192	***0.8316***
20	14	.120+	0.1202	0.1205	0.9225	0.1463	0.0055	.119+	0.1192	0.8324
21	15	.120+	0.1202	0.1204	0.9244	0.1492	0.0035	.119+	0.1192	0.8325
22	16	.120+	0.1202	0.1208	0.9225	***0.1438***	**0.0090**	.119+	0.1192	0.8352
23	17	.120+	0.1202	0.1205	0.9233	0.1446	**0.0066**	.119+	0.1192	***0.8293***
24	18	.120+	0.1202	0.1206	0.9243	0.1457	0.0039	.119+	0.1192	***0.8319***
25	19	.120+	0.1202	0.1205	0.9242	0.1474	0.0016	.119+	0.1192	***0.8293***
26	20	.120+	0.1202	0.1207	0.9242	0.1461	0.0033	.119+	0.1192	***0.8317***
27	21	.120+	0.1202	0.1204	0.9237	0.1461	0.0038	.119+	0.1192	0.8322
28	22	.120+	0.1202	0.1207	0.9238	0.1471	0.0026	.119+	0.1192	0.8377
29	23	.120+	0.1202	0.1208	0.9241	***0.1444***	**0.0064**	.119+	0.1192	***0.8316***
30	24	.120+	0.1202	0.1208	0.9240	0.1455	0.0045	.119+	0.1192	***0.8311***
31	25	.120+	0.1202	0.1209	0.9243	0.1454	0.0044	.119+	0.1192	0.8321
32	Average		0.1202	0.1206	0.9238	0.1460	0.0045		0.1192	0.8316
33	SD		0.0000	0.0002	0.0008	0.0013	0.0018		0.0001	0.0022
34	MAX		0.1202	0.1209	0.9251	0.1492	0.0090		0.1197	0.8377
35	MIN		0.1202	0.1201	0.9222	0.1438	0.0016		0.1192	0.8263
36	Range		0.0000	0.0009	0.0029	0.0054	0.0074		0.0005	0.0114
37										
38		**OHL**	= over high limit							
39		***ULL***	= under low limit							
40										
41										
42										

	K	L	M
1	**B**	**F**	**B**
2	Trigger Pull Screw Hole Diameter	Trigger Pull Screw Hole Lateral Position	Trigger Pull Screw Hole Position
3	MV	MV	Calculated
4	0.120	0.1475	0.006
5	0.001	0.003	0.000
6	0.001	0.003	0.006
7	0.1204	0.1451	0.0057
8	0.1209	***0.1432***	**0.0146**
9	0.1205	0.1468	**0.0087**
10	0.1204	0.1476	**0.0174**
11	0.1201	0.1464	**0.0069**
12	0.1202	0.1450	**0.0123**
13	0.1206	0.1459	0.0058
14	0.1202	***0.1434***	**0.0102**
15	0.1201	0.1472	**0.0082**
16	0.1210	0.1472	0.0044
17	0.1201	0.1464	**0.0096**
18			
19	0.1203	0.1452	**0.0082**
20	0.1201	0.1465	0.0056
21	0.1209	0.1465	0.0053
22	0.1202	0.1461	0.0028
23	0.1199	0.1472	**0.0115**
24	0.1202	0.1457	**0.0071**
25	0.1210	***0.1442***	**0.0132**
26	0.1205	0.1476	**0.0066**
27	0.1209	0.1454	**0.0070**
28	0.1203	0.1464	0.0057
29	0.1208	0.1457	**0.0077**
30	0.1210	0.1473	**0.0079**
31	0.1201	0.1458	0.0035
32	0.1204	0.1460	0.0082
33	0.0003	0.0012	0.0036
34	0.1210	0.1476	0.0174
35	0.1199	0.1432	0.0028
36	0.0010	0.0044	0.0146
37			
38			
39			
40			
41			
42			

	A	B		D	E	F	G	H	I	J
43										
44			E:\Solidworks Files\ XR100 SPL Trigger A							
45										
46										

Cell: D2
Comment: Jim Ronkainen:
For reference only.

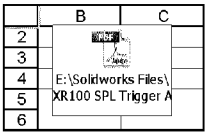
Cell: G2
Comment: Jim Ronkainen:
Hole was drilled and tapped on production fixture. Dimensional results will be fed back to production. Use parts as-is and note any unusual behavior.

Cell: J2
Comment: Jim Ronkainen:
Vertical position of this hole is not critical to function. The slight increase in the trigger spring's moment arm with respect to the trigger pivot is insignificant and can be dialed out with the adjustment of the trigger pull force. Its is OK to use the parts as-is.

Cell: M2
Comment: Jim Ronkainen:
Hole was drilled and tapped on production fixture. Dimensional results will be fed back to production. Most variation is in the vertical direction, which is of no consequence. Use parts as-is and note any unusual behavior.

Cell: L8
Comment: Jim Ronkainen:
This part has the worst deviation of all the parts. The Solidworks layout shows that there is still more than 0.0135" clearance between the major diameter of the screw and the side plate under worst case conditions. All parts are OK to use as-is.

Cell: A18
Comment: Jim Ronkainen:
The trigger houing using rear spacer number 12 was lost in Ilion during processing.


B
C
2
3
4
5
6
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XR100 SPL Trigger A