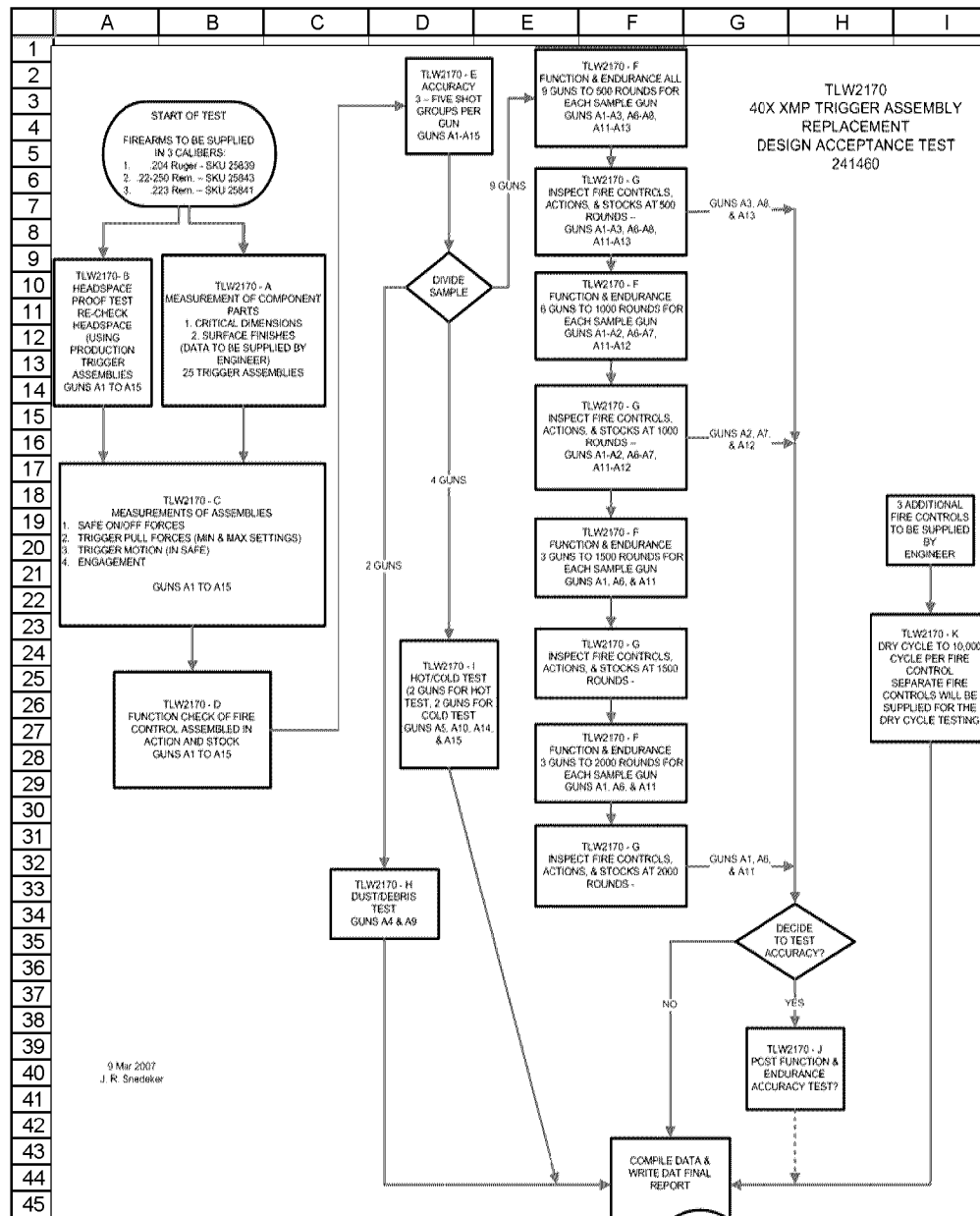
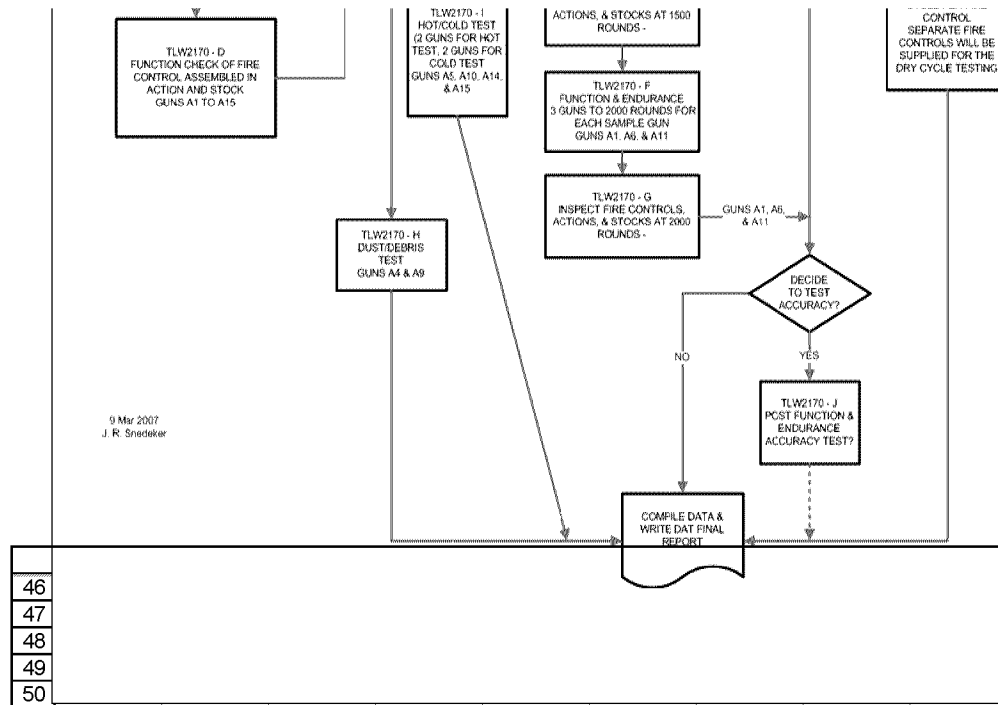


	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P	Q	
1																		
2		Engineer:	Jim Ronkainen			Project #:	241460		TLW #:	2170								
3																		
4		Date Submitted:	3/16/2007			Requested Completion Date:	4/23/2007											
5																		
6		Completion Date																
7		Justification:																
8																		
9		Test Description:	Conduct Design Acceptance Testing on the 40X XMP trigger assembly using the XR100 Targetmaster as the test vehicle.															
10																		
11																		
12																		
13		Test Procedure:	Conduct the DAT per the plan provided by Jim Snedeker.															
14																		
15			SEE FLOW CHART															
16																		
17																		
18																		
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	A	B	C	D	E	F	G	H	I	J	K	L	M	N	O	P	Q							
38																								
39	Special Requirements:																							
40																								
41																								
42																								
43																								
44	Supplies Availability:																							
45																								
46																								
47																								
48																								
49	Results Required:			Formal Report																				
50																								
51	*****This section to be completed by Test Lab Manager*****																							
52																								
53	Assigned To:							Start Date:			3/19/2007													
54																								
55	Assigned Date:			3/16/2007				Completion Date:																
56																								
57	Comments:																							
58																								
59																								
60																								
61																								

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49						
50						
51					Data Only	
52					Formal Report	
53						
54						
55						
56						
57						
58						
59						
60						
61						





	A	B	C	D	E	F	G
1	GUN #	SERIAL #	CALIBER	HEADSPACE	PROOF	HEADSPACE	COMMENTS
2	A-1	7813826	.204 RUGER	GO	SEE NOTE	GO	high pressure - 2 rds. - replaced bolt
3	A-2	7813859	.204 RUGER	GO	SEE NOTE	GO	high pressure -broke extractor- 1 rd.- replaced bolt
4	A-3	7813717	.204 RUGER	GO	SEE NOTE	GO	high pressure - 1 rd.
5	A-4	7815650	.204 RUGER	GO	SEE NOTE	GO	high pressure -broke extractor- 1 rd. - replaced bolt
6	A-5	7824564	.204 RUGER	GO	SEE NOTE	GO	
7							*NOTE* shoot 20 rounds service ammo with lanyard
8							and determine if any pressure issues
9							
10	A-6	7824563	.22-250 REM	min. + .002	OK	min. + .002	
11	A-7	7824516	.22-250 REM	min. + .003	OK	min. + .004	
12	A-8	7824427	.22-250 REM	min. + .002	OK	min. + .003	
13	A-9	7824613	.22-250 REM	min. + .002	OK	min. + .002	
14	A-10	7824432	.22-250 REM	min. + .002	OK	min. + .002	
15							
16							
17	A-11	7814291	.223 REM	min. + .004	OK	min. + .004	
18	A-12	7814769	.223 REM	min. + .007	OK	min. + .007	
19	A-13	7813898	.223 REM	min. + .003	OK	min. + .003	
20	A-14	7814631	.223 REM	min. + .005	OK	min. + .005	
21	A-15	7813470	.223 REM	min. + .004	OK	min. + .004	

	A	B	C	D	E	F	G	H	I	J
1		SAFETY OFF TO ON FORCE					SAFETY ON TO OFF FORCE			
2	GUN #	1	2	3	AVG.		1	2	3	AVG.
3	A-1	2.485	2.460	2.450	2.465		3.710	3.730	3.700	3.713
4	A-2	2.390	2.395	2.385	2.390		3.175	3.150	3.160	3.162
5	A-3	2.145	2.120	2.135	2.133		2.800	2.815	2.790	2.802
6	A-4	2.805	2.825	2.815	2.815		2.815	3.800	3.795	3.803
7	A-5	2.515	2.510	2.520	2.515		3.490	3.445	3.495	3.477
8										
9	A-6	2.405	2.445	2.445	2.432		3.355	3.385	3.365	3.368
10	A-7	2.450	2.400	2.425	2.425		3.110	3.120	3.150	3.127
11	A-8	2.440	2.470	2.490	2.467		3.160	3.195	3.140	3.165
12	A-9	2.580	2.530	2.550	2.553		3.210	3.165	3.235	3.203
13	A-10	2.465	2.430	2.420	2.438		3.185	3.155	3.125	3.155
14										
15	A-11	2.450	2.440	2.455	2.448		3.335	3.415	3.385	3.378
16	A-12	2.810	2.805	2.795	2.803		3.430	3.375	3.415	3.407
17	A-13	2.935	2.935	2.895	2.922		3.805	3.815	3.810	3.810
18	A-14	2.480	2.465	2.455	2.467		3.500	3.475	3.420	3.465
19	A-15	2.515	2.515	2.450	2.493		3.470	3.445	3.415	3.443
20	A-12 (XMP19)	2.325	2.270	2.275	2.290		2.880	2.870	2.900	2.883

	A	B	C	D
1	Date:	23-Mar-07		
2	Shooter:	J. Sims		
3	Note: All shots were recorded @ 100yds. (3-5shot groups), utilized Leupold 16 X Mark 4 scope, shot from bench.			
4				
5	Ammo type: 22-250= R22501			
6		223= R223R1		
7		.204 RUGER = PRA204B		
8				
9				Caliber
10		Gun #	A-1	.204 RUGER
11			A-2	.204 RUGER
12			A-3	.204 RUGER
13			A-4	.204 RUGER
14			A-5	.204 RUGER
15				
16			A-6	22-250
17			A-7	22-250
18			A-8	22-250
19			A-9	22-250
20			A-10	22-250
21				
22			A-11	223
23			A-12	223
24			A-13	223
25			A-14	223
26			A-15	223
27				

	E	F	G	H	I
1					
2					
3					
4					
5					
6					
7					
8					
9	Grp. 1	Grp. 2	Grp. 3	Avg.	
10	1.65	1.5	1.25	1.467	
11	0.95	1.45	0.75	1.05	
12	1.7	2	1.85	1.85	
13	0.6	1.7	0.75	1.017	
14	3.85	2.6	2	2.817	
15				1.64	Avg.
16	1.1	1.2	1.7	1.333	
17	1.15	1.05	1.35	1.183	
18	1.7	1.2	1	1.3	
19	1.05	1.45	1.3	1.267	
20	0.85	1.4	1.1	1.117	
21				1.24	Avg.
22	1.65	0.85	1.65	1.383	
23	1.35	1.1	1.55	1.333	
24	1.5	1.25	1.05	1.267	
25	0.8	1.4	1.55	1.25	
26	1.6	1.4	0.75	1.25	
27				1.2966	Avg.

	A	B	C	D	E	F
1	TLW2170-H					
2	DYNAMIC SAND AND DUST TEST					
3	BY; Jeff Wade & Steve Wade					
4	4/4/2007					
5						
6	GUNS					
7	A-4 .204 RUGER		primed case test	passed	20 rounds live fire test	passed
8	A-9 .22-250		primed case test	passed	20 rounds live fire test	passed
9						
10	85 psi line pressure		0 weight of debris after test			

	A	B	C
1	Part Name:	Primary Trigger Pull Spring	
2	Drawing Num:	301427	
3	TLW Number:	241460	
4	Revision Level:	A	
5	Vendor:	Industrial Spring of St Louis	
6	Requisition #:		
7	Material:	Music Wire	
8	Hardness:		
9	Metallurgist:		
10	Engineer:	JIM RONKAINEN	
11	Inspected by:	Ronkainen	
12	Date:	12/7/2006	
13	Reviewed by:	JR	
14	Date:	12/11/2006	
15			
16			
17			
18			
19	<u>identifier</u>	<u>feature description</u>	<u>DIM</u>
20	A	OD	0.115
21	B	Wire Diameter	0.0160
22	C	Free Length	0.240
23	D	L1@.220	0.400
24	E	L2@.185	1.000
25	F	Wind Direction	LH
26	G	Ends	C&G
27			
28			OHL
29			ULL

	D	E
1		
2	NOTE- Dimension identifiers will be provided on the prints supplied by engineering & the CAD group.	
3		
4	INSTRUCTIONS:	
5	1. DO NOT STAMP PARTS WITH AN I.D, NUMBER.	
6	2. SEPARATE NON-CONFORMING PARTS.	
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: Parts not individually bagged or identified for traceability after measurement.	
11		
12		
13		
14		
15		
16		
17		
18		
19	plus	minus
20	0.005	0.005
21	0.001	0.001
22		MIN
23	0.040	0.040
24	0.100	0.100
25		
26		
27		
28	=Over High Limit	
29	=Under Low Limit	

	F	G	H	I	J	K	L	M	N	O	P	Q	R	S	T
1															
2															
3															
4															
5															
6															
7															
8															
9															
10															
11															
12															
13															
14															
15															
16															
17															
18															
19	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
20	0.1180	0.1180	0.1180	0.1180	0.1180	0.1180	0.1180	0.1180	0.1180	0.1180	0.1180	0.1180	0.1180	0.1180	0.1170
21	0.0159	0.0159	0.0159	0.0160	0.0159	0.0160	0.0159	0.0158	0.0158	0.0159	0.0158	0.0158	0.0157	0.0158	0.0159
22	0.2585	0.2530	0.2558	0.2497	0.2469	0.2457	0.2507	0.2495	0.2520	0.2637	0.2495	0.2466	0.2542	0.2560	0.2479
23	0.370	0.435	0.425	0.365	0.420	0.420	0.440	0.410	0.375	0.435	0.415	0.375	0.365	0.395	0.375
24	0.905	0.935	0.925	0.900	0.940	0.905	0.950	0.915	0.930	0.935	0.910	0.910	0.910	0.920	0.915
25	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
26	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK
27															
28															
29															

	U	V	W	X	Y	Z	AA	AB	AC	AD	AE	AF	AG	AH	AI
1															
2															
3															
4															
5															
6															
7															
8															
9															
10															
11															
12															
13															
14															
15															
16															
17															
18															
19	16	17	18	19	20	21	22	23	24	25	26	27	28	29	AVG
20	0.1180	0.1180	0.1180	0.1180	0.1175	0.1180	0.1180	0.1180	0.1180	0.1175	0.1180	0.1180	0.1180	0.1180	0.1179
21	0.0158	0.0157	0.0158	0.0159	0.0160	0.0159	0.0157	0.0160	0.0158	0.0158	0.0159	0.0159	0.0158	0.0157	0.0158
22	0.2574	0.2484	0.2601	0.2566	0.2546	0.2472	0.2501	0.2579	0.2552	0.2506	0.2520	0.2496	0.2472	0.2484	0.2527
23	0.400	0.375	0.365	0.410	0.385	0.375	0.415	0.385	0.380	0.420	0.375	0.380	0.385	0.405	0.397
24	0.920	0.900	0.920	0.920	0.905	0.915	0.935	0.910	0.900	0.930	0.915	0.900	0.920	0.940	0.9184
25	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	
26	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	OK	
27															
28															
29															

	AJ	AK	AL	AM	AN	AO	AP
1							
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3							
4							
5							
6							
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10							
11							
12							
13							
14							
15							
16							
17							
18							
19	<u>STDEV</u>	<u>Method</u>					
20	0.0002	Mic					
21	0.0001	MV					
22	0.0046	MV					
23	0.024	Chatillon					
24	0.0138	Chatillon					
25		Visual					
26		Visual					
27							
28							
29							

	B	C	D	E	F	G
2						
3						
4						
5	301427 - Primary Trigger Pull Spring NR markup for inspection.pdf					
6						
7						