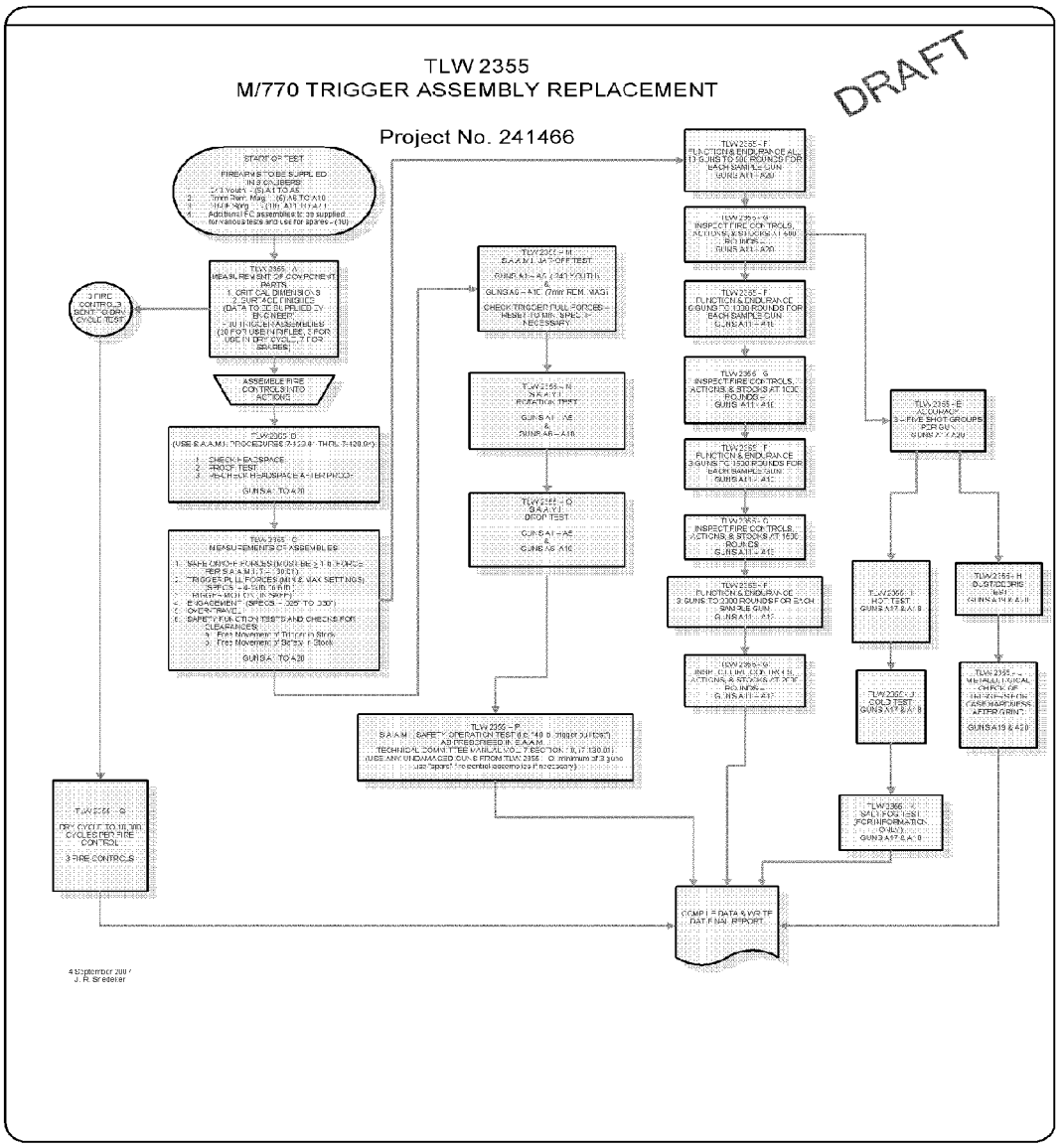
TLW 2355
M/770 TRIGGER ASSEMBLY REPLACEMENT
Project No. 241466
DRAFT
START OF TEST
FIREARMS TO BE SUPPLIED IN 2 CONDITIONS
1. 12 Volt - (5) A1 TO A5
2. 7mm Rem. Mag. - (5) A6 TO A10
3. 30.06 Sprg. - (10) A11 TO A20
4. Additional FC assemblies to be supplied for various uses and use for spares - (10)
TLW 2355 - A
MEASUREMENT OF COMPONENT PARTS
1. CRITICAL DIMENSIONS
2. SURFACE FINISHES
(DATA TO BE SUPPLIED BY ENGINEER)
3. BUILT-IN CLEARANCE VALUES
(DO FOR USE IN RIFLE, C FOR USE IN DRY CYCLE, T FOR SPARES)
ASSEMBLE FIRE CONTROLS INTO ACTIONS
TLW 2355 - B
(USE S.A.A.M. PROCEDURE 241294 - THOL 3-120.01)
1. CHECK HAZSPACE
2. PROOF TEST
3. RECHECK HAZSPACE AFTER PROOF
GUNS A1 TO A10
TLW 2355 - C
MEASUREMENTS OF ASSEMBLIES
1. SAFE ORDER FORCES (MUST BE ≥ 1 lb. FORCE PER S.A.A.M. TC - 3001)
2. TRIGGER PULL FORCES (MIN & MAX SETTINGS) (SPECS - 4-5 lbs. & 8 lb.)
MINIMUM CLEARANCE
3. ENGAGEMENT (SPECS - 325 TO 330°)
4. OVER-TRAVEL
5. SAFETY FUNCTION TESTS AND CHECKS FOR CLEARANCES
a. Free Movement of Trigger in Slots
b. Free Movement of Sear in Stock
GUNS A1 TO A20
3 FIRE CONTROLS SENT TO DRY CYCLE TEST
TLW 2355 - D
DRY CYCLE TO 10,000 CYCLES FIRE CONTROL
3 FIRE CONTROLS
TLW 2355 - H
S.A.A.M. DROP TEST
GUNS A1 - A5
&
GUNS A6 - A10
TLW 2355 - N
S.A.A.M. ROTATION TEST
GUNS A1 - A5
&
GUNS A6 - A10
TLW 2355 - O
S.A.A.M. DROP TEST
GUNS A1 - A5
&
GUNS A6 - A10
TLW 2355 - P
S.A.A.M. SAFETY OPERATION TEST (6 x 140 lb. trigger pull forces)
AS PRESCRIBED IN S.A.A.M. TECHNICAL COMMITTEE MANUAL VOL. 7 SECTION 7, 17 130.01
(USE ANY UNDAMAGED GUNS FROM TLW 2355 - O minimum of 3 guns use "spare" recovered assemblies if necessary)
TLW 2355 - F
FUNCTION & ENDURANCE ALL 13 GUNS TO 500 ROUNDS FOR EACH SAMPLE GUN
GUNS A11 - A20
TLW 2355 - G
INSPECT FIRE CONTROLS, ACTIONS, & STOCKS AT 500 RD. INTS.
GUNS A11 - A20
TLW 2355 - F
FUNCTION & ENDURANCE 3 GUNS TO 1000 ROUNDS FOR EACH SAMPLE GUN
GUNS A11 - A13
TLW 2355 - G
INSPECT FIRE CONTROLS, ACTIONS, & STOCKS AT 1000 ROUNDS
GUNS A11 - A13
TLW 2355 - F
FUNCTION & ENDURANCE 3 GUNS TO 1500 ROUNDS FOR EACH SAMPLE GUN
GUNS A11 - A13
TLW 2355 - G
INSPECT FIRE CONTROLS, ACTIONS, & STOCKS AT 1500 ROUNDS
GUNS A11 - A13
TLW 2355 - F
FUNCTION & ENDURANCE 3 GUNS TO 2000 ROUNDS FOR EACH SAMPLE GUN
GUNS A11 - A13
TLW 2355 - G
INSPECT FIRE CONTROLS, ACTIONS, & STOCKS AT 2000 RD. INTS.
GUNS A11 - A13
TLW 2355 - E
ACCURACY
3 - FIVE SHOT GROUPS PER GUN
GUNS A11 - A20
TLW 2355 - I
HOT TEST
GUNS A17 & A18
TLW 2355 - J
COLD TEST
GUNS A17 & A18
TLW 2355 - H
DUST SCORE TEST
GUNS A19 & A20
TLW 2355 - K
METALLURGICAL CHECK OF INTERNAL CASE HARDENING AFTER GRINT
GUNS A19 & A20
TLW 2355 - K
MALFUNCTION TEST (FOR INFORMATION ONLY)
GUNS A17 & A18
COMPILE DATA & WRITE DATA FINAL REPORT
4 September 2007
J. R. Stredeler