ASSEMBLY AND INSPECTION PROCEDURE
MOHAWK 600 TRIGGER ASSEMBLY

1. Clean and prime Trigger Engagement Screw hole. (see figure 1)

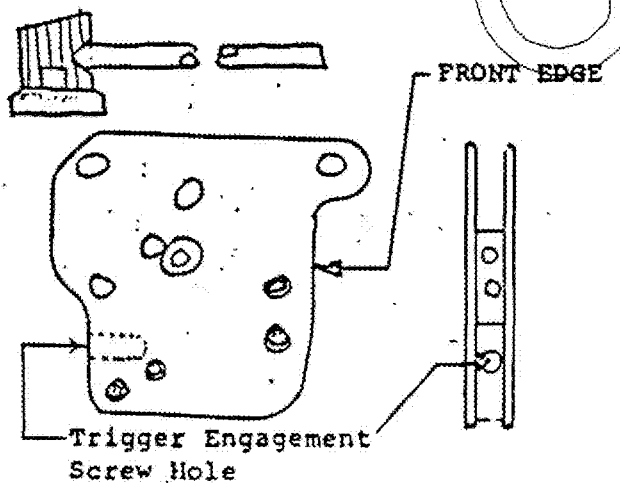
   a. Position Housing on its front edge.

   b. Air clean Trigger Engagement Screw hole and Housing.

   c. Spray Trigger Engagement Screw hole with "Locquic Primer T" (Aerosol can). Housing must air dry (no hose) at least five minutes after spraying before they are used.

   d. To Trigger Sub-Assembly -

NOTE: USE RED PLASTIC VALVE-FINGERPIECE AND PLASTIC TUBE FROM CAN OF "INHIBISOL" ON CAN OF "LOCQUIC".



(figure 1)

2. Inspect Connectors 100% and smooth top. Scrap all defectives.

Note: Do all elements 100%.

a. Inspect long inside connector surface and inside surface of long (top) leg for flatness. Hold connector against flatness block with light finger pressure.

- If no light shows between back and long leg of connector and block surface, then connector is passed (see Figure 2).
- If light gap shows, measure gap with .004 shim. If gap accepts shim without moving connector, then reject connector (see Figure 3).
- Reject connector if it rocks on flatness block at all (see Figure 4).
- Front edge of long (top) leg must be square with shoulder on flatness block (see Figure 5).

Flatness Block: C-44520

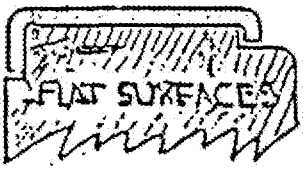


Fig. 2. GOOD

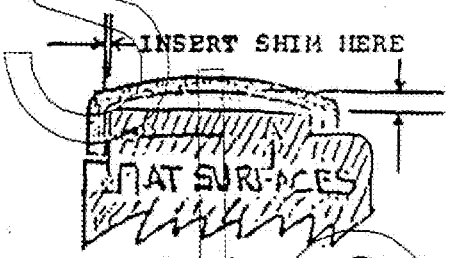


Fig. 3. TEST LIGHT GAP WITH SHIM

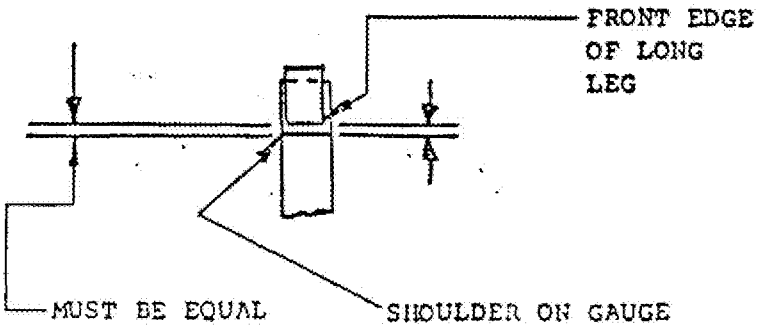


Fig. 5

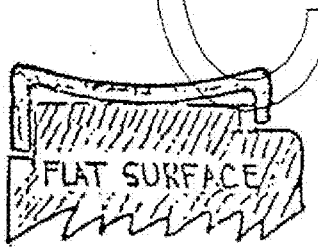


Fig. 4. REJECT

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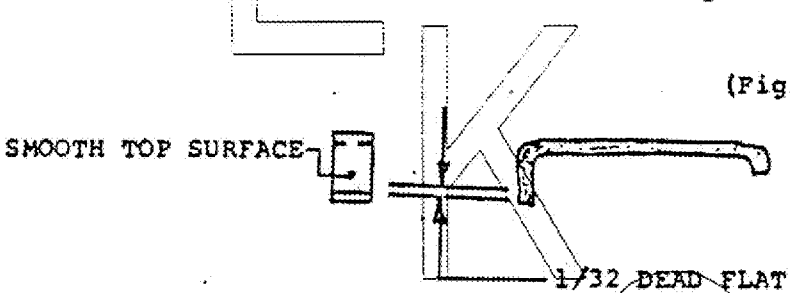
b. Check connector for maximum width over full length. Reject parts over 0.172. Use receiving gauge C-44522.

c. Smooth top surface of long leg of connector. Use crocus cloth. Surface must be: (see Figure 6)

- Smooth
- Burr-free
- Dead flat with 1/32" of end

Check for smoothness and burrs with tip of finger.

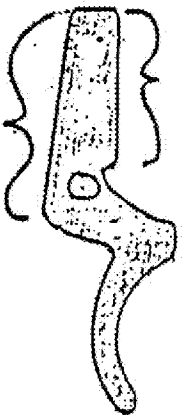
(Fig. 6)



3. Inspect Trigger

a. Inspect Trigger for: (See Figure 7)

- Good black color
- No bleed-out
- No burrs on sides



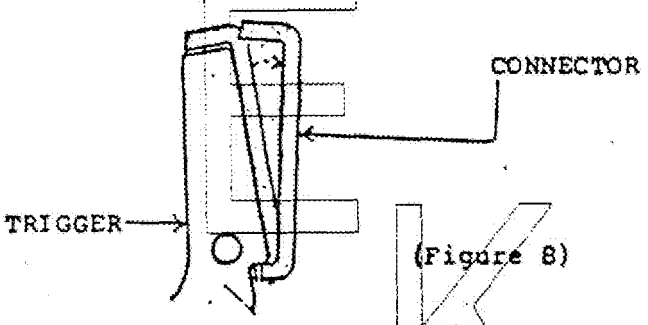
NO BURRS - BOTH SIDES

(Fig. 7)

4. Check Connector to Trigger Fit - 100%

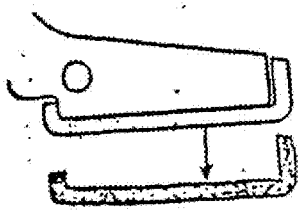
a. Fit passed connector to passed trigger and check for minimum working clearance (slipfit).

. Connector must rotate freely around bottom (short) leg without binding on top of trigger (see Figure 8).



(Figure 8)

. Connector must fall off trigger when trigger is held horizontally (see Figure 9).



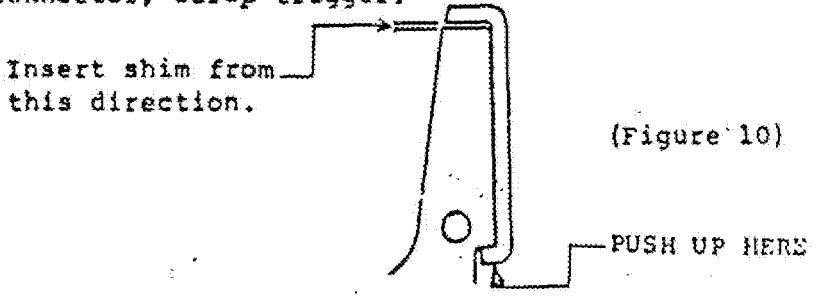
(Figure 9)

. File bottom notch on trigger only if required to remove bind. Filed surface must be flat and square with sides of trigger. Use filing fixture D-44521.

b. With same trigger and connector, check for maximum working clearance (see Figure 10).

. Push connector tight to trigger at bottom.

. Insert shim stock in clearance from front to back. .006 shim must not go. If shim goes without moving connector, scrap trigger.



(Figure 10)

5. Assemble Trigger Sub-Assembly - Stage I

a. Inspect Housing

. Good Black color.

. No bleedout.

. Check inside Housing for burrs at the Sear Pin Holes.

b. Position Trigger in Housing and install Trigger Pin. Use pin holder drive punch A-35645.

. Pin must be flush to Housing on right side.

. Trigger must rotate freely in Housing without bind. Grip Trigger and rotate Housing around Pin.

c. Install -

. Same Connector as fitted to above Trigger.

. Trigger stop screw - one turn (thread) above flush with hole.

. Trigger adjusting screw - flush with hole.

. Trigger Spring.

. Trigger Engagement Screw - flush with holes.

d. Install -

. Sear Spring

. Correct Sear using two dummy Pins (A-51468). Sear must be flat, not bowed (visually check). Sear must have dimple (see Figure 11).

(Figure 11)

CORRECT SEAR - PART #91470 HAS A RECESSED DIMPLE ON RIGHT SIDE. DO NOT SUBSTITUTE.

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6. Adjust Trigger Sub-Assembly on Comparator 100%.

a. Pick Trigger Sub-Assembly and position in comparator fixture and clamp.

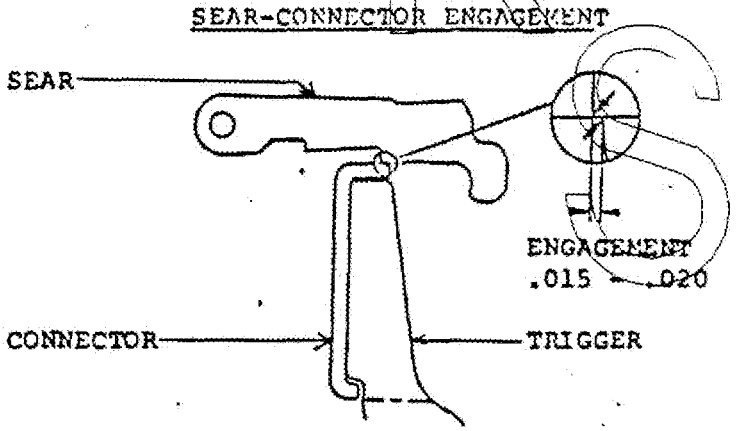
(~~Comparator fixture~~ E-42271)
(Comparator ~~screen~~ A-600-CL25)

. Houning ~~must properly~~ contact all locators.

. Top of Housing must be flat on fixture.

b. Adjust fixture to locate Sear on "set" line of comparator screen.

c. Adjust Sear-Connector engagement (.015 - .020) to correct comparator screen line by turning Trigger Engagement Screw slowly clockwise (to reduce engagement) (see Figure 12).



(Figure 12)

After correctly adjusting Sear-Connector engagement -

d. Hang dead weight assembly to end of Trigger (Comparator fixture dead weight 2¼ lbs. M600 only).

e. Adjust Trigger pull by turning Trigger Adjusting Screw counter-clockwise slowly until Sear just disengages (fires).

f. Readjust fixture to locate Sear on "set" line of comparator screen.

g. Remove dead weight assembly from Trigger.

h. Hold Trigger in fired position firmly with finger.

- Set over-travel by turning Trigger stop screw clockwise until Trigger Connector touches correct line on comparator screen.

i. Remove Trigger Sub-Assembly from comparator fixture.

j. Seal all three screws with Duco cement.

7. Assemble Trigger Assembly - Stage Two.

a. Pick correctly adjusted Trigger Sub-Assembly.

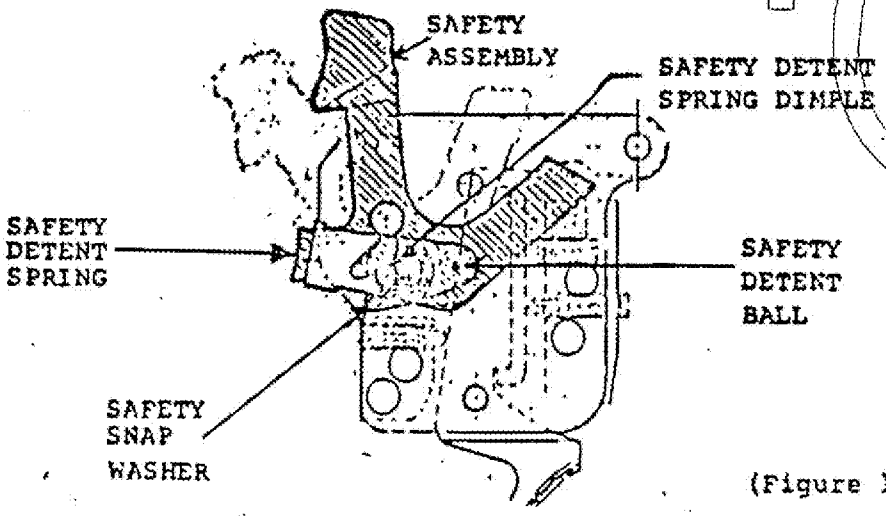
b. Assemble (see Figure 13).

- Safety Assembly.
- Safety Detent Ball.
- Safety Detent Spring.
- Safety Pivot Pin.
- Safety Snap Washer.

Make sure that:

- Safety Snap Washer is completely contained within Safety Pivot Pin groove.

- Raised dimple on Safety Detent Spring is at left end of opening at closed end of Safety Snap Washer.



(Figure 13)

8. Lubricate Connector and Sear with "Molykote" dry powder.

   a. Pick Trigger Assembly.

   b. Apply small amount of "Molykote" powder to Sear-Connector engagement surfaces through engagement view hole. (Use dry type "Molykote" powder and squeeze container - eyedropper).

9. Function check completed Trigger Assembly 100%.

   a. Put safety in "off safe" position and check for:

      . Trigger Retraction - pull Trigger and release - Trigger and Connector must return freely to original position with spring force.

      . Sear freedom - pull Trigger and hold - depress Sear fully and release. Sear must move freely in Housing without binding. It must return fully upward under Sear Spring force.

      . Operation of Safe - push Safety thumb piece fully forward beyond detent position. Safety must spring - return rearward to detent position.

      . Push Safety thumbpiece fully rearward beyond detent position. Safety must spring - return forward to detent position.

      . Move Safety from "on safe" to "off safe" position and back twice. Safety must spring forward into "off safe" detent when pushed slightly to rear of detent position. There must be no hangup or hesitation between detent positions. Bolt lock arm must work freely on Housing.

10. Mark correctly assembled and checked Trigger Assembly with Assembler's identification. (See Figure 14)

    a. Locate Trigger Assembly in stamping fixture.

    b. Stamp lower left front corner, as shown in Figure 14, with correct assembler identification. Use 1/16" size character.

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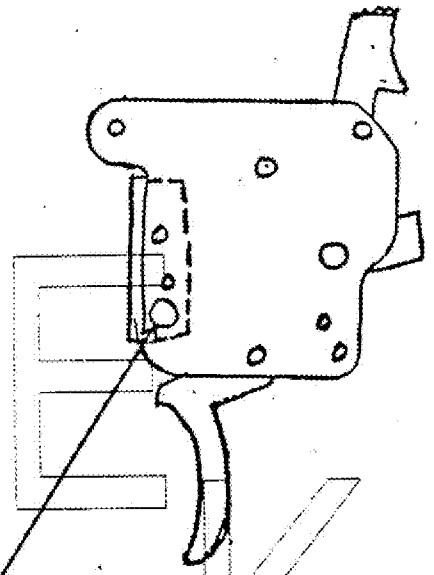


(Figure 14)

STAMP HERE. MARK MUST BE ON HOUSING WHERE FULLY SUPPORTED BY SPACER BLOCK.

11. Check for Sear Lift 100%.

    a. Pick Trigger Assembly and position in gage and clamp (Gage #D-42614).

    b. With Safety in "off safe" position, move dial indicator into position and set dial to "0".

    c. Move Safety to "on safe" position.

        . Dial indicator must read .008" or greater.

        . Reject Trigger Assembly if less than .008".

    d. Move Safety to forward-most "null location."

        . Dial indicator must read .008" or greater.

        . Reject Trigger Assembly if less than .008".

    e. Move Safety to "on safe" position and remove Trigger Assembly from gage. Reposition Slave Pins in Sear Pin holes.

12. Check Sear-Connector Clearance 100%

    a. Move Safety to "null location." Insert the blade of a small screwdriver in the Housing just ahead of the Trigger

and push the Connector upward toward the Sear. CAUTION: Be sure to push on the Connector and not the Spacer Block.

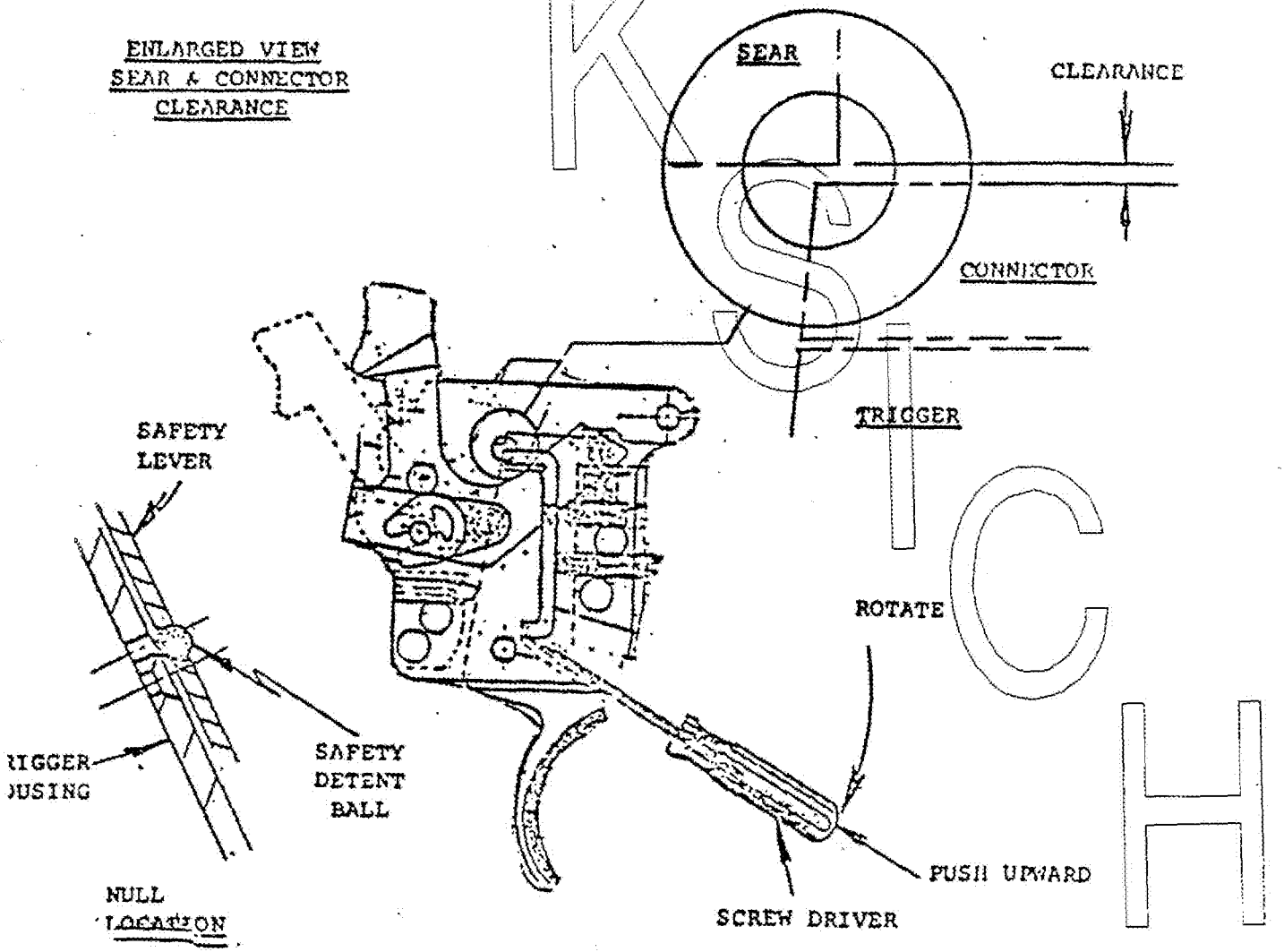
b. While pushing downward on the Sear and pushing upward on the Connector, use the screwdriver to rotate the Trigger front to rear (see Figure 15).

. Through the inspection hole in the Housing, clearance must be observed between the Sear and Connector.

. Connector must freely return under Sear when Trigger is released.

. Reject for no clearance or if Connector catches on Sear.

c. Stamp "V" on Trigger left side, just below Housing on Assemblies which have passed steps 11 and 12.



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