

PROCESS RECORD ASSEMBLY SHEETS

DATE AND REASON FOR REVISIONS 1/16/59 - Revised process - Q.M. - 253552 -
 6/5/63 - Add N/T22 - C.M. - 256008
 1/9/67 - Rev. Act. P. - Miller - 257220

DESCRIPTIVE INFORMATION

1. Pick Action from truck, position and clamp in vise.
2. Pick Trigger Assembly.
3. Insert Trigger Assembly into Receiver. (Must fit freely).
 a. File slot if necessary.
4. Pick Sear Pin and start. Drive in flush with inside of Bolt Stop cut.
5. Pick Bolt Stop Spring and position in Receiver.
6. Pick Bolt Stop and position in Receiver.
 a. Must fit freely, file slot if necessary.
7. Pick Bolt Stop Pin, position and drive in.
8. Stroke Bolt Stop Pin and Sear Pin.
9. Pick Firing Pin Assembly, inspect, point not marred, Bolt Flng color O.K. No rust, or sludge.
10. Assemble to Bolt Group and remove "U" washer.
11. Check Firing Pin protrusion.
12. Insert Bolt into Action and lock down.
13. Try Safety.
 a. Must be clearance between Sear and Trigger Connector with Safety on.

EQUIPMENT - TOOLS & GAGES

No Sear, Safety Can bind in Housing.
 File tight - Tester 3-00652

Protrusion gauge 3-10-52009

NOTE: Only correct components of good color, not broken or deformed should be used.

OPERATION DESCRIPTION

QCC No
 STD HRC
 STD No
 EFF DATE

Final Assembly - N/T22-T22
 N/T22 ADL

PART No
 Q-

FIRST NAME Final Assembly COOLANT SEE UP WORK No T21 - T22 - T22 ADL 173
 DEPT No 54 PAGE 1 OF 3

PROCESS RECORD - ASSEMBLY SHEETS

DATE OF ORDER FOR RECORD 1/16/72 - Revised process - 0-6-111111

NO. OF SHEETS - 1200

NAME OF SHEET - 1 - Drawing - 11729

Drawings furnished from _____

Drawings furnished to _____

11. Adjust Trigger pull (6 to 6 lbs.) and make two Trigger Adjustment Surveys.
12. Drill six adjusting screws (3/64") into "Trigger" screws.
13. Finish correct shoulder flat, inspect for color, no rust.
14. Assemble Machine flat to Action.
15. a. 200 Chi. only assemble screw.
16. Finish correct frame.
17. a. Support for steel plates, were fitted to check. Grip holder previously installed and square.
18. b. Steel frame fitted, four (four) steel pins were all the way around slot. In frame .002 inch opening to base, slide (finger tool) across slot, inspect body, bases on four main slides. Of the thickness of steel plate and steel holder.
19. Inspect base on Action.
20. Finish Trigger Action Frame. Support for color and rust, position to check. (1/72 - 72 = 720 mil)
21. Finish Trigger screw, inspect for no carry edges, color, more or pink and position to check.

Trigger Pull action

1172997

Plant Assembly

(1/72) 1200-720 AS

Plant Assembly

PT. 10

72 - 720 - 720 mil

172

1172997

[illegible]

[illegible][illegible]