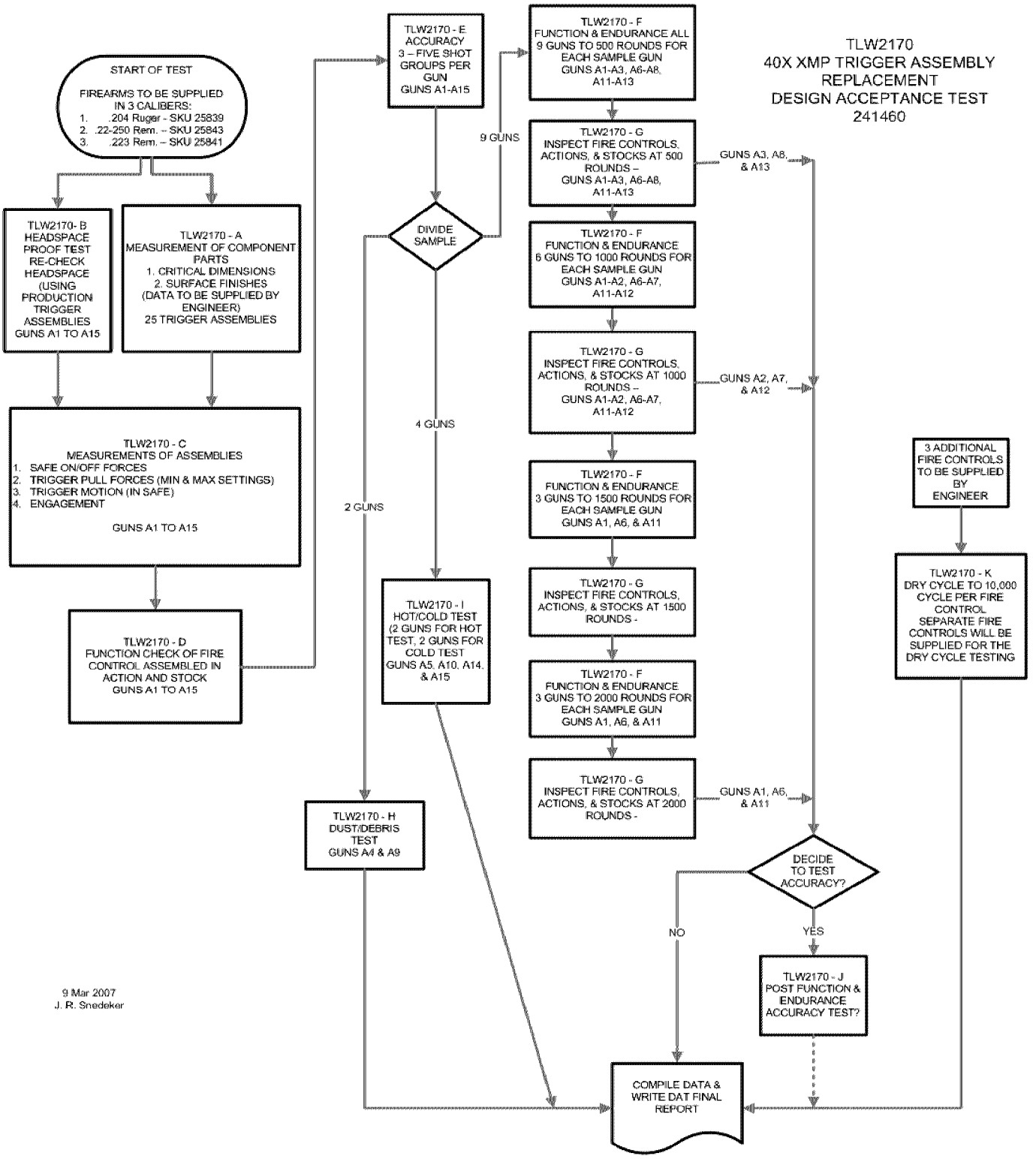
TLW2170
40X XMP TRIGGER ASSEMBLY
REPLACEMENT
DESIGN ACCEPTANCE TEST
241460
START OF TEST
FIREARMS TO BE SUPPLIED IN 3 CALIBERS:
1. .204 Ruger - SKU 25839
2. .22-250 Rem. – SKU 25843
3. .223 Rem. – SKU 25841
TLW2170- B HEADSPACE PROOF TEST RE-CHECK HEADSPACE (USING PRODUCTION TRIGGER ASSEMBLIES GUNS A1 TO A15
TLW2170 - A MEASUREMENT OF COMPONENT PARTS
1. CRITICAL DIMENSIONS
2. SURFACE FINISHES
(DATA TO BE SUPPLIED BY ENGINEER)
25 TRIGGER ASSEMBLIES
TLW2170 - C MEASUREMENTS OF ASSEMBLIES
1. SAFE ON/OFF FORCES
2. TRIGGER PULL FORCES (MIN & MAX SETTINGS)
3. TRIGGER MOTION (IN SAFE)
4. ENGAGEMENT
GUNS A1 TO A15
TLW2170 - D FUNCTION CHECK OF FIRE CONTROL ASSEMBLED IN ACTION AND STOCK
GUNS A1 TO A15
TLW2170 - E ACCURACY
3 – FIVE SHOT GROUPS PER GUN
GUNS A1-A15
DIVIDE SAMPLE
9 GUNS
4 GUNS
2 GUNS
TLW2170 - I HOT/COLD TEST (2 GUNS FOR HOT TEST, 2 GUNS FOR COLD TEST
GUNS A5, A10, A14, & A15
TLW2170 - H DUST/DEBRIS TEST
GUNS A4 & A9
TLW2170 - F FUNCTION & ENDURANCE ALL
9 GUNS TO 500 ROUNDS FOR EACH SAMPLE GUN
GUNS A1-A3, A6-A8, A11-A13
TLW2170 - G INSPECT FIRE CONTROLS, ACTIONS, & STOCKS AT 500 ROUNDS –
GUNS A1-A3, A6-A8, A11-A13
GUNS A3, A8, & A13
TLW2170 - F FUNCTION & ENDURANCE
6 GUNS TO 1000 ROUNDS FOR EACH SAMPLE GUN
GUNS A1-A2, A6-A7, A11-A12
TLW2170 - G INSPECT FIRE CONTROLS, ACTIONS, & STOCKS AT 1000 ROUNDS –
GUNS A1-A2, A6-A7, A11-A12
GUNS A2, A7, & A12
TLW2170 - F FUNCTION & ENDURANCE
3 GUNS TO 1500 ROUNDS FOR EACH SAMPLE GUN
GUNS A1, A6, & A11
TLW2170 - G INSPECT FIRE CONTROLS, ACTIONS, & STOCKS AT 1500 ROUNDS -
TLW2170 - F FUNCTION & ENDURANCE
3 GUNS TO 2000 ROUNDS FOR EACH SAMPLE GUN
GUNS A1, A6, & A11
TLW2170 - G INSPECT FIRE CONTROLS, ACTIONS, & STOCKS AT 2000 ROUNDS -
GUNS A1, A6, & A11
3 ADDITIONAL FIRE CONTROLS TO BE SUPPLIED BY ENGINEER
TLW2170 - K DRY CYCLE TO 10,000 CYCLE PER FIRE CONTROL
SEPARATE FIRE CONTROLS WILL BE SUPPLIED FOR THE DRY CYCLE TESTING
DECIDE TO TEST ACCURACY?
NO
YES
TLW2170 - J POST FUNCTION & ENDURANCE ACCURACY TEST?
COMPILE DATA & WRITE DAT FINAL REPORT
9 Mar 2007
J. R. Snedeker