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- Lower the gauge until it just touches the magazine follower, approximately in the middle location both side to side and front to rear.
- Zero force gauge again if necessary.
- Lower the gauge 0.200" and take the spring force measurements.
- Lower the gauge another 1.0".
- Take the force measurement at this depressed location of the spring.
- Repeat procedure two additional trials for each box.
- Average the 3 trials for each box and at each measurement location.

**Data Required:**

- Force Measurements taken on each trial per box at each of the measurement locations.
- The Average Force measurement per box.
- The serial number of the Chatillion Digital Force Gauge used for the procedure.

**TLW0300N – Measure Firing Pin Head / Sear Engagement:**

The vertical engagement of the contact between the firing pin head and sear will be measured. The minimum vertical engagement to be .049".

**Method:**

- Use digital height gauge and one-tenth dial indicator attachment.
- Visually check to ensure the firearm is unloaded.
- Clamp firearm in portable vise and set on top of granite table.
- Remove the bolt assembly.
- Place the safety in the "Fire" position.
- Use a small bubble level to level the top of the receiver relative to the granite table.
- Zero indicator on the receiver insert just rearward of the sear.

J.R.Snedeker

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