

Test Lab Work Request Form

Date Submitted: 3-3-03	Tracking #: TLW 1116E
Project #: 241375	Engineer: J. Ronkainen
Test Objective: Measure the firing pin head to sear engagement of the EET fluted firing pin assemblies on their respective test actions.	
Test Description: Direct measurement of the firing pin head to sear engagement is not possible on the Model 700 or Model Seven. To measure the engagement, use the following procedure: <ol style="list-style-type: none"> 1. With the bolt removed, mount the action in a V-block so that the centerline of the barrel is held horizontal and the trigger assembly is in a vertical plane with the trigger pointing down. 2. Check the firing pin head clearance slot for horizontal runout (level) from front to rear and adjust the action as necessary to make this feature horizontal. Zero a dial indicator on the bottom of the clearance slot on the end nearest the trigger assembly mounting slot. 3. With the safety in the FIRE position, slide the action so that the point of the dial indicator comes to rest on the sear just ahead of the firing pin head engagement surface. Push the indicator down with your finger until the sear comes to rest on top of the trigger connector and record the measurement. 4. Remove the action from the V-block and reinstall the bolt. After checking the action to make sure it is not loaded, close the bolt on an empty chamber with the safety in the FIRE position. Using a gage pin, measure the gap between the firing pin head clearance slot and the bottom of the firing pin head. Record the size of the largest pin that can slide all of the way across the width of the firing pin head clearance slot with minimal finger pressure (make sure to include the + or - designation on the pin in the recorded measurement). 5. Subtracting the pin diameter from the dial indicator measurement in step 3 yields the firing pin head to sear engagement measurement for the action. 	
Resource Usage: Manpower Requirements – Facility Requirements – metrology	Test Results Required: Formal Report: Data Only: XX Requested Completion Date:
Required Materials/Parts/Equipment (include quantities): 12 EET Test guns dial base gage gage pins	
Test Parts Availability Date:	
Start Date: 4-23-03 Completion Date: 4-23-03 4-23-03 Report Date:	Test Assigned To: Jeff Wade Assignment Date: 04/23/03

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	SEAR	PIN GAUGE	GAGES USED C10+
A1	.0825	.0400	.0425 4-23-03
A2	.0840	.0380	.0460 JW & SW
A3	.0835	.0360	.0475
A4	.0780	.0370	.0410
A5	.0815	.0380	.0435
A6	.0810	.0340	.0470
A7	.0775	.0430	.0345
A8	.0800	.0310	.0490
A9	.0800	.0440	.0360
A10	.0810	.0290	.0520
A11	.0790	.0320	.0470
A12	.0795	.0430	.0345

A1 300 W 20 MAC
 A2 11 11 11
 A3 308 W 12
 A4 11 11
 A5 300 11 MAC
 A6 11 11 11
 A7 308 11
 A8 11 11
 A9 11 11
 A10 11 11
 A11 11 11
 A12 11 11

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