

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:

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 -	Test Results Required: Formal Report: Data Only: XX
Facility Requirements - metrology	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	Test Assigned To: Jeff Wade
Completion Date: 4/23/03	Assignment Date: 04/23/03
Report Date:	

ET19965

PROJECT # 241375				4/23/2003	
TLW 1116E					
EET FLUTED FIRING PIN					
FIRING PIN HEAD TO SEAR ENGAGEMENT					
DONE BY JEFF WADE & STEVE WADE					
USED PIN GAGES C10+					
				PIN	
GUN #	SERIAL #	CALIBER	SEAR	GAUGE	ENGAGEMENT
A1	F6214003	.300 WIN MAG	0.0825	0.040	0.0425
A2	F6214034	.300 WIN MAG	0.0840	0.038	0.0460
A3	F6256782	.308 WIN	0.0835	0.036	0.0475
A4	F6258005	.308 WIN	0.0780	0.037	0.0410
A5	F6212462	.300 WIN MAG	0.0815	0.038	0.0435
A6	F6210119	.300 WIN MAG	0.0810	0.034	0.0470
A7	F6248456	.308 WIN	0.0775	0.043	0.0345
A8	F6247847	.308 WIN	0.0800	0.031	0.0490
A9	7780924	.308 WIN	0.0800	0.044	0.0360
A10	7780597	.308 WIN	0.0810	0.029	0.0520
A11	7780771	.308 WIN	0.0790	0.032	0.0470
A12	7780569	.308 WIN	0.0795	0.043	0.0365

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