

151 Assemble Trigger Assembly - Stage One - Inspect
Connector, Trigger, & Connector to Trigger Fit

Step	Operation / Step Description
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*** See Sketch ***

Assemble Trigger Assembly - Stage One

Inspect Connector 100%, inspect Trigger 100% and check Connector to Trigger fit 100%.

NOTE: Do all elements 100%

1. Inspect long inside Connector surface, and inside surface of long (top) leg for flatness.

Hold Connector against flatness block with light finger pressure.

* If no light shows between inside surfaces of back and long leg of Connector and block surface, Connector is good.

(See Figure #1)

* If light gap shows, measure gap with a .006 shim. If gap accepts shim without moving Connector - Reject Connector. (See Fig. #2)

* Note : .006 Shim - Make new shim as required

* If Connector rocks on flatness block - reject Connector. (See Fig. #3)

* Front edge of long (top) leg, must be square with shoulder of flatness block. (See Fig. #4)

2. Check Connectors

Surface must be:

- * Smooth
- * Burr - Free at top and bottom corners and hole.
- * Dead flat within 1/32" (Minimum of end.

Check for burrs and smoothness with fingertip.

3. INSPECT TRIGGER.

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Trigger Must Have:

- * Uniform Metallic Satin Finish and Color.
- * No bleed out (white material on surface)
- * No burrs
- * No cracks or damage at pivot hole.

4. Fit passed Connector to passed Trigger and check for MIN. WORKING CLEARANCE. (Slip Fit)

- * Connector must rotate freely around bottom (short) leg, without binding on top of Trigger.

* Ref. Sketch # 151-2

- * If additional clearance is needed, file bottom notch on Trigger. Filed surface must be FLAT and SQUARE with sides of trigger. Use filing fixture only. DO NOT FILE FREE HAND.

5. With the same Trigger and Connector, check for Max. Working clearance:

- * Push Connector tight to Trigger at bottom, and hold it parallel to sides of Trigger.

- * Insert shim stock in clearance from back to front.

* .006 shim MUST NOT GO

- * If shim enters without moving Connector SCRAP TRIGGER.

- * Keep trigger and connector together in container ready for Stage Two.

* Ref. Sketch 151-3

Tool Number	Tooling Description
D-44608	File Fixture
C-44604	Flatness Block

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