

710, 270 TRAIL & PILOT SERIES- A

PRELIMINARY MEASUREMENTS & CHECKS

PROOF TEST & MAGNAFLUX COMPLETED AT MAYFIELD

TEST LAB TRACKING NUMBER- TLW0407

GUN ID #	SERIAL NUMBER	HEADSPACE REM. SPEC GAUGES	FIRING PIN INDENT V/ COPPER CRUSHERS				SEAR TO TRIGGER ENGAGEMENT				SEAR LIFT				TRIGGER PULL WITH SP	
			TLW0407H GUNS A11-A20				TLW0407J out of stock @ 20X, ALL GUNS				TLW0300I out of stock @ 20X, ALL GUNS				TLW0407J IN STOCK, ALL	
			1	2	3	AVERAGE	1	2	3	AVERAGE	1	2	3	AVERAGE	1	2
A-1	7100	MIN.+.00					0.0246	0.0251	0.0244	0.0247	0.0163	0.0156	0.0162	0.0161	4	4.25
A-2	7100	MIN.+.00					0.0294	0.0301	0.0297	0.0297	0.0155	0.0148	0.0159	0.0154	4.25	4.25
A-3	7100	MIN.+.00					0.0277	0.0269	0.0268	0.0271	0.0148	0.0152	0.0146	0.0149	4.5	4
A-4	7100	MIN.+.00					0.0271	0.0277	0.0272	0.0273	0.0163	0.0155	0.0169	0.0162	4.25	4.25
A-5	7100	MIN.+.00					0.0253	0.0249	0.0252	0.0251	0.0152	0.0146	0.0143	0.0147	4.5	4.5
A-6	7100	MIN.+.00					0.0258	0.0252	0.0258	0.0256	0.0169	0.0167	0.0168	0.0168	5	5.25
A-7	7100	MIN.+.00					0.0277	0.0286	0.0286	0.0283	0.0142	0.0146	0.0141	0.0143	4.75	4.75
A-8	7100	MIN.+.00					0.0288	0.0271	0.0269	0.0269	0.0153	0.0162	0.0156	0.0157	4.5	4.25
A-9	7100	MIN.+.00					0.0239	0.0241	0.0242	0.0241	0.0138	0.0136	0.0135	0.0136	5.25	4.75
A-10	7100	MIN.+.00					0.0252	0.0249	0.0251	0.0251	0.0162	0.0159	0.0164	0.0162	4	4.5
A-11	7100	MIN.+.00	0.016	0.017	0.016	0.0163	0.0286	0.0258	0.026	0.0261	0.0155	0.0161	0.0164	0.0160	3.75	4.25
A-12	7100	MIN.+.00	0.017	0.017	0.017	0.0170	0.0271	0.0268	0.0275	0.0271	0.0164	0.017	0.0183	0.0166	4.25	4.75
A-13	7100	MIN.+.00	0.018	0.018	0.018	0.0180	0.0301	0.0299	0.0303	0.0301	0.017	0.0171	0.017	0.0170	4	4
A-14	7100	MIN.+.00	0.016	0.016	0.016	0.0160	0.0269	0.0271	0.0278	0.0273	0.0161	0.0162	0.0157	0.0160	4.25	4.75
A-15	7100	MIN.+.00	0.017	0.016	0.016	0.0163	0.0252	0.0242	0.0244	0.0246	0.0146	0.015	0.0141	0.0146	4	4
A-16	7100	MIN.+.00	0.018	0.017	0.018	0.0177	0.0264	0.0262	0.026	0.0262	0.0172	0.0181	0.0177	0.0177	4.25	4.5
A-17	7100	MIN.+.00	0.018	0.017	0.017	0.0173	0.0291	0.0267	0.0295	0.0291	0.0159	0.0161	0.016	0.0160	4.25	4
A-18	7100	MIN.+.00	0.017	0.017	0.016	0.0167	0.0263	0.0262	0.0268	0.0264	0.0149	0.0151	0.0152	0.0151	4	4
A-19	7100	MIN.+.00	0.018	0.018	0.018	0.0180	0.0306	0.0317	0.0309	0.0311	0.0169	0.0166	0.0168	0.0168	4.25	4.5
A-20	7100	MIN.+.00	0.018	0.017	0.017	0.0173	0.0301	0.0297	0.0299	0.0299	0.0158	0.0161	0.016	0.0160	5	5
A-21	7100	MIN.+.00					0.0302	0.0299	0.0306	0.0302	0.0135	0.0134	0.013	0.0133	4.5	4.75
A-22	7100	MIN.+.00					0.0286	0.028	0.0287	0.0284	0.0158	0.0158	0.0161	0.0159	4.25	4.75
A-23	7100	MIN.+.00					0.0301	0.0299	0.0307	0.0302	0.0149	0.0144	0.0147	0.0147	4	3.75
A-24	7100	MIN.+.00					0.0289	0.0297	0.0293	0.0293	0.0142	0.0144	0.0141	0.0142	4	5
A-25	7100	MIN.+.00					0.0301	0.0306	0.0309	0.0305	0.0133	0.0141	0.0137	0.0137	4.5	4
A-26	7100	MIN.+.00					0.0273	0.0274	0.0272	0.0273	0.0175	0.0182	0.0186	0.0181	4.25	4.5
A-27	7100	MIN.+.00					0.0282	0.0269	0.0281	0.0264	0.0155	0.0161	0.0157	0.0158	4	4.75
A-28	7100	MIN.+.00					0.0315	0.0317	0.0301	0.0311	0.0183	0.0174	0.0171	0.0176	4	4
A-29	7100	MIN.+.00					0.0299	0.0297	0.0299	0.0298	0.0185	0.0179	0.0182	0.0182	5	4.75
A-30	7100	MIN.+.00					0.0286	0.0279	0.0284	0.0283	0.0167	0.0166	0.0167	0.0167	4	4
TEST AVERAGE			0.0171				TEST AVERAGE 0.02780				TEST AVERAGE 0.0164				TES	
SAAMI MIN. = .017							SPEC. = .020 TO .025				SPEC. = .006 TO .018				SPEC. = 4.0	

		BLUE INDICATES BELOW SPEC RED INDICATES ABOVE SPEC													
RING SCALE		TRIGGER PULL WITH SPRING SCALE				SAFE ON FORCES				SAFE OFF FORCES					
L GUNS	LBS.	TLW0407J OUT OF STOCK, ALL GUNS				LBS.	TLW0407K GUNS A11-A20				LBS.	TLW0407K GUNS A11-A20			
	3 AVERAGE	1	2	3	AVERAGE	1	2	3	AVERAGE	1	2	3	AVERAGE		
4.25	4.17	4.5	4.25	4.5	4.42				#DIV/0!				#DIV/0!		
4.25	4.25	4	4	4.25	4.08				#DIV/0!				#DIV/0!		
4.5	4.33	4.25	4.5	4.25	4.33				#DIV/0!				#DIV/0!		
4.5	4.33	4.5	4.5	4.5	4.50				#DIV/0!				#DIV/0!		
4.25	4.42	4.25	4.5	4.25	4.33				#DIV/0!				#DIV/0!		
5	5.08	5.5	5.25	5	5.25				#DIV/0!				#DIV/0!		
5	4.83	4.75	5	4.75	4.83				#DIV/0!				#DIV/0!		
4.5	4.42	4.5	4.25	4.5	4.42				#DIV/0!				#DIV/0!		
4.5	4.83	4.75	5.5	4.5	4.92				#DIV/0!				#DIV/0!		
4.75	4.42	4.5	4.25	4.25	4.33				#DIV/0!				#DIV/0!		
4.25	4.08	4	4.25	4.25	4.17	4.76	5.25	5.46	5.16	3.46	3.24	3.5	3.4		
4.5	4.50	4.5	4.5	4.5	4.50	5.1	5.28	5.44	5.27	3.65	3.66	3.62	3.6		
3.75	3.92	4	4.5	4	4.17	6.76	6.42	6.36	6.62	3.34	3.36	3.4	3.3		
4.5	4.50	4.5	4.5	4.75	4.58	5.04	5.56	5.18	5.26	3.36	3.36	3.4	3.3		
4.25	4.08	4.25	4	4.5	4.26	6.42	6.72	6.36	6.50	3.66	3.26	3.64	3.5		
4.25	4.33	4.5	5	4.5	4.67	6.26	6.1	6.24	6.20	2.42	2.66	2.72	2.6		
4	4.08	4.5	4	4	4.17	6.6	6.66	6.94	6.73	3.94	3.26	3.62	3.6		
4	4.00	4	4.5	4.25	4.25	7.24	6.96	6.78	6.99	2.96	2.96	3.04	2.9		
4.75	4.50	4.25	4.25	4.25	4.25	6.48	5.6	5.52	5.87	3.42	3.24	3.04	3.2		
5.25	5.08	5.5	5	4.75	5.08	6.72	6.79	6.88	6.80	3.5	2.88	3.46	3.2		
4.5	4.58	5.25	5.5	5	5.25				#DIV/0!				#DIV/0!		
4.5	4.50	4	4.5	4.5	4.33				#DIV/0!				#DIV/0!		
3.75	3.83	4	3.75	4.25	4.00				#DIV/0!				#DIV/0!		
4.5	4.50	5	5.25	4.75	5.00				#DIV/0!				#DIV/0!		
4.25	4.25	5	5	4.75	4.92				#DIV/0!				#DIV/0!		
4.5	4.42	4	4.25	5	4.42				#DIV/0!				#DIV/0!		
4.5	4.42	4.5	4.5	4.75	4.58				#DIV/0!				#DIV/0!		
4	4.00	4	4.5	4	4.17				#DIV/0!				#DIV/0!		
4.5	4.75	4.75	4.5	4.5	4.58				#DIV/0!				#DIV/0!		
4.5	4.17	4.5	4.5	4.25	4.42				#DIV/0!				#DIV/0!		
TEST AVERAGE	4.39	TEST AVERAGE				4.51	TEST AVERAGE				TEST AVERAGE				
TO 5.5 LBS.		SPEC.= 4.0 TO 5.5					SAAMI MIN.= 1 LB.				SAAMI MIN.= 1 LB.				

		FIRING PIN HEAD TO SEAR ENGAGEMENT, TLW0407M, ALL GUNS		ISS FUNCTION TEST, TLW0407P
MAGAZINE SPRING FORCE		BOLT STOP & RELEASE FUNCTION TEST		
TLW0407M, GUNS A11-A20	measurement method	TLW0407O, GUNS A11-A20		GUNS A11-A20
WITH TEST STAND	produces a dimension range	STOP FUNCTION	RELEASE DETENT	PASS/ FAIL
	.064 .075			
	.069 .080			
	.063 .074			
	.067 .078			
	.067 .078			
	.068 .079			
	.071 .062			
	.072 .083			
	.068 .079			
	.068 .079			
	.066 .076	PASS	4.21	
	.066 .077	PASS	4.62	
	.066 .077	PASS	5.22	
	.066 .077	PASS	4.64	
	.067 .076	PASS	4.66	
	.068 .079	PASS	4.71	
	.067 .078	PASS	5.18	
	.068 .080	PASS	4.64	
	.067 .078	PASS	4.61	
	.065 .076	PASS	4.58	
	.067 .078			
	.068 .079			
	.068 .079			
	.067 .078			
	.069 .080			
	.061 .073			
	.067 .079			
	.066 .077			
	.069 .080			
	.070 .081			