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Remington Arms Company Inc.
RESEARCH & DEVELOPMENT TECHNICAL CENTER
315 WEST RING ROAD
ELIZABETHTOWN, KY 42701

- 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.

TLW0407N – 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.
- Lightly depress the sear until contact with the trigger is felt and hold in place.
- Indicate to the top of the rear portion of the sear and record the measurement.
- Reinstall the bolt assembly and close over an empty chamber.
- Use pin gauges to measure the gap between the receiver insert and the bottom of the firing pin head, record the gap width.
- Subtract the gap width from the indicated measurement and record as the firing pin to sear engagement.

Data Required:

J.R. Snedeker

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