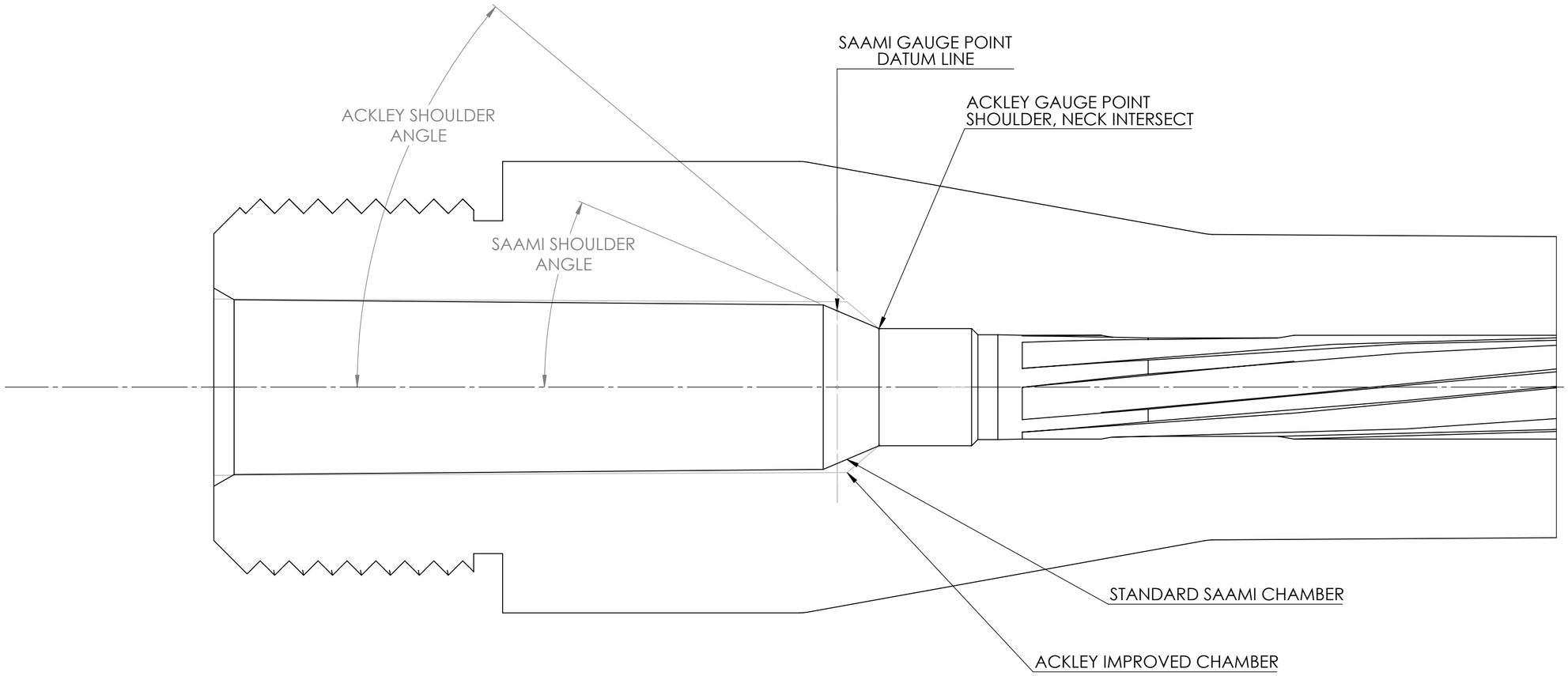
ACKLEY IMPROVED HEADSPACE



Ackley's method was simple, he used a headspace gauge .004" shorter than the SAAMI minimum chamber as a GO Gauge. The shoulder angle on the gauge was still the same as the parent chamber. Ackley used the shoulder and neck junction as his gauging point not the datum line of the SAAMI chamber. So the SAAMI GO dimension becomes the NO-GO dimension for Ackley's improved chambers, and the chamber Go minimum was .004 shorter. This shorter headspace assured that the SAAMI spec cartridges would be held tight between the breach and the junction of the neck and shoulder of the chamber during fire forming. This is called the crush fit in Mr Ackley book.

UNLESS OTHERWISE SPECIFIED:		NAME	DATE
DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONAL ± 1/16 ANGULAR: MACH ± 1/4 DEG TWO PLACE DECIMAL ± .010 THREE PLACE DECIMAL ± .005 FOUR PLACE DECIMAL ± .0005	DRAWN	BBAILEY	
	CHECKED		
	ENG APPR.		
	MFG APPR.		
	Q.A.		
INTERPRET GEOMETRIC TOLERANCING PER: ANSI			
MATERIAL			
FINISH			
DO NOT SCALE DRAWING			

PACIFIC TOOL AND GAUGE

TITLE: ACKLEY INFORMATION SHEET

SIZE	DWG. NO.	REV
C	PTG-10131	
SCALE: 1:2	WEIGHT:	SHEET 1 OF 1