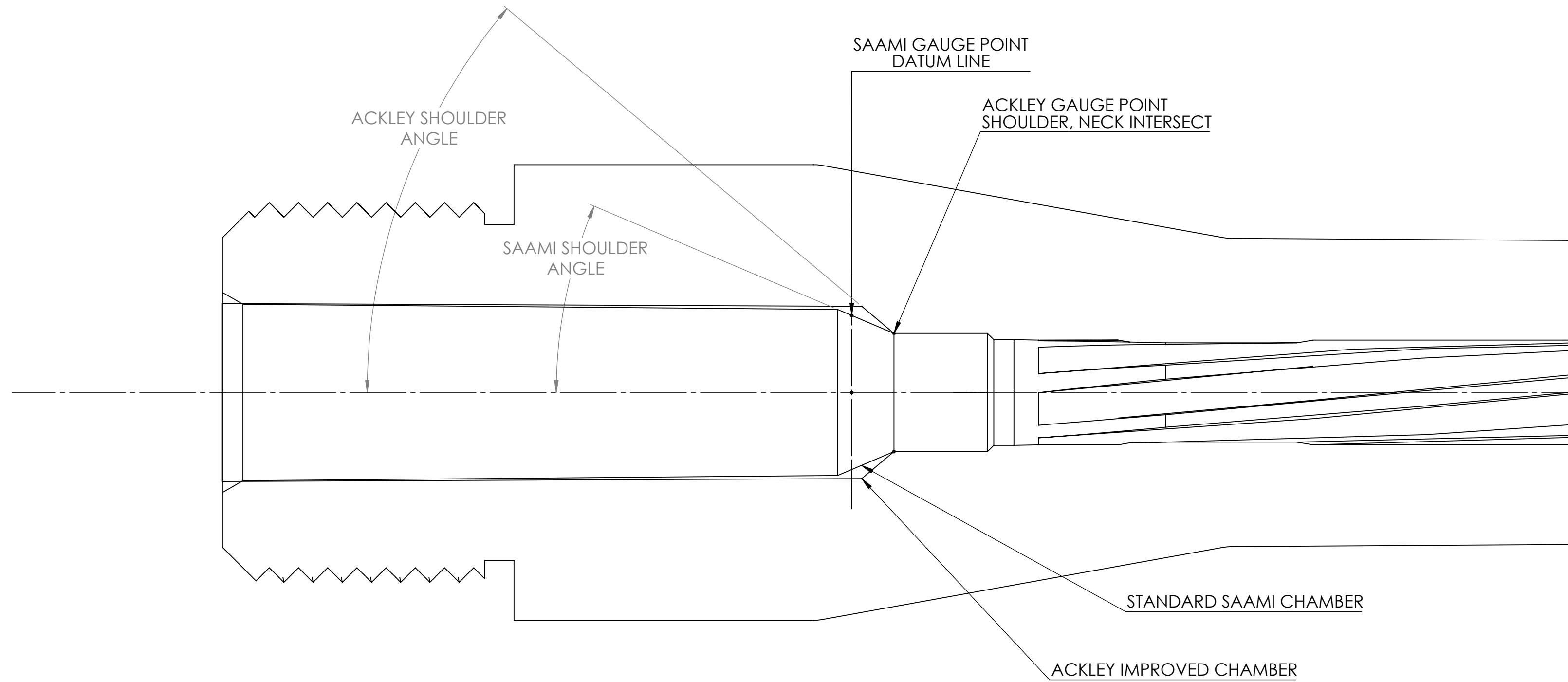


# ACKLEY IMPROVED HEADSPACE



**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.**



**PROPRIETARY AND CONFIDENTIAL**  
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UNLESS OTHERWISE SPECIFIED: 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	NAME	DATE
INTERPRET GEOMETRIC TOLERANCING PER: ANSI	CHECKED	BBAILEY	
MATERIAL	ENG APPR.		
FINISH	MFG APPR.		
DO NOT SCALE DRAWING	Q.A.		

<b>PACIFIC TOOL AND GAUGE</b>		
TITLE: <b>ACKLEY INFORMATION SHEET</b>		
SIZE <b>C</b>	DWG. NO. <b>PTG-10131</b>	REV
SCALE: 1:2	WEIGHT:	SHEET 1 OF 1