



Standard Inventory Item  
**244 Ack Imp**

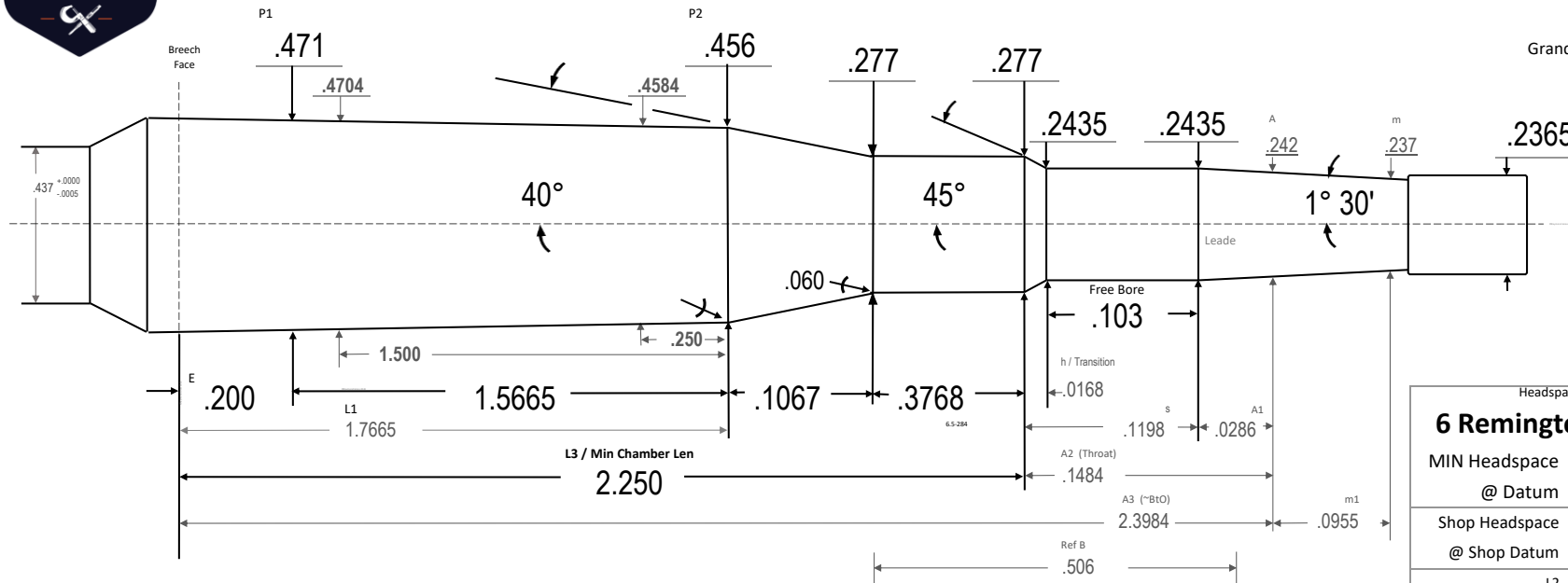
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**Manson Reamers**

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8200 Embury Rd  
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Headspace Gage:	
<b>6 Remington ACK GO</b>	
MIN Headspace	1.8732
@ Datum	.2770
Shop Headspace	1.7767
@ Shop Datum	.3750
L2	1.8731 65
A3+m1	2.4938 71
Body TPI	.0095 75
Breech Face Dia	.4729 15
~Chamber Vol in <sup>3</sup>	.3108 06
Drawn:	Ray Gross
SD	2024.06.08
Template PTL	V10.4 24.06.08
Dia Tolerance	+.001/-0.000
Length Tolerance	+.005/-0.000
Angle Tolerance	+/- 15'
Use Reamer Blank	243 AI
Print is not to scale	

Ackley Improved version of 6mm Rem. Base diameter is slightly tightened. Free bore length remains the same as 6 Rem, but lead angle is changed to 1.5 degree (from 3 deg). Throat will be longer than needed for most 6mm/.243 bullets with the exception of some of the heavier (105+gr) hunting type bullets. Will shoot any traditionally loaded 6 Rem bullets as well as a standard 6 Rem would. Throat can be shortened to suit.

Uses 6 Rem ACK GO as GO gage and standard 6 Rem GO gage as NO GO

Design revised and updated 8/15/2022

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