

# NOTES:

1. SPEC MIL-W-13855 AND MIL-R-45979 APPLY.
2. EACH RIFLE SHALL WITHSTAND THE FIRING OF ONE GOVERNMENT STANDARD HIGH PRESSURE TEST CARTRIDGE WITHOUT EVIDENCE OF FAILURE. APPLY PROOF MARK TO RIFLES MEETING THIS REQUIREMENT.
3. AFTER COMPLETION OF ALL FIRING TESTS (HIGH PRESSURE RESISTANCE, FUNCTION FIRING, AND TARGETING AND ACCURACY) FOR MIL-R-45979, EACH BOLT AND ROLLER ASSEMBLY 779086 SHALL BE FREE OF EVIDENCE OF FAILURE AS DETERMINED BY MAGNETIC PARTICLE INSPECTION FOR CRACKS, SEAMS AND OTHER HARMFUL DEFECTS, IN ACCORDANCE WITH METHOD SPECIFIED ON DRAWING 779086. APPLY IMP MARK TO ASSEMBLY AS SHOWN ON 779086 MEETING THIS REQUIREMENT. AFTER CLEANING THE ASSEMBLY THE ROLLER SHALL BE PACKED WITH GREASE CONFORMING TO MIL-G-10924.
4. FOR INFORMATION ONLY: SUPPORT EQUIPMENT IS LISTED ON DWG 12002927. SUPPORT EQUIPMENT IS NOT PACKAGED OR INCLUDED WITH THE RIFLE.

J 86  
SH 1 4  
F 1/2

THE APERTURE ASSEMBLY PROVIDES 1/2 MINUTE OF ANGLE ELEVATION ADJUSTMENT. THE PEEPHOLE SIZE SHALL BE .0595 DIA FOR APERTURE ASST 7791132.

THE BASE, REAR SIGHT PROVIDES 1/2 MINUTE ANGLE OF WINDAGE ADJUSTMENT.

REAR SIGHT MARKINGS MUST BE INSTINCT.

ELEVATING KNOB MUST BE ON 100 METER SETTING WHEN APERTURE IS ELEVATED 8 CLICKS FROM LOWEST POSITION.

KNOBS MUST HAVE FREE MOVEMENT, INDEPENDENT OF EACH OTHER, POSITIVE CLICKING ACTION, AND POSITIVE RETENTION.

APERTURE ASSEMBLY SHALL OPERATE SMOOTHLY IN BASE, REAR SIGHT WITH NO PERCEPTIBLE SIDE MOVEMENT WHEN SET AT 500 METER SETTING.

PREFERENTIAL ASSEMBLY OF APERTURE ASSEMBLY AND BASE, REAR SIGHT SHALL BE EFFECTED AS NECESSARY TO MEET ABOVE REQUIREMENTS.

WHEN NECESSARY EQUAL AMOUNTS OF MATERIAL SHALL BE REMOVED FROM BOTH SIDES OF APERTURE TO OBTAIN THE REQUIRED FIT.

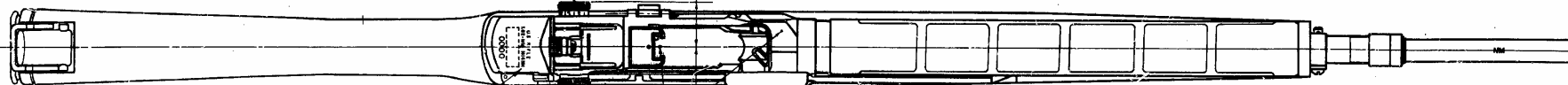
BRIGHT SURFACES RESULTING FROM FITTING THE APERTURE ARE PERMISSIBLE.

WHEN APERTURE ASSEMBLY IS ELEVATED TO ITS HIGHEST POSITION AND THUMB PRESSURE IS APPLIED TO BOTTOM OF EYEPiece IN A VERTICAL PLANE AWAY FROM THE WEAPON, SPRING TENSION OF COVER MUST RETURN THE APERTURE ASSEMBLY TO ITS ORIGINAL POSITION.

SCREW, REAR SIGHT SHALL BE TIGHTENED WITHIN 20 TO 25 INCH LBS.

SIGHT MUST BE FREE OF EXCESS OIL.

THE FLASH SUPPRESSOR SHALL BE FASTENED WITH NO ROTATIONAL OR LONGITUDINAL IN ASSEMBLY. THE NUT SHALL BE EVENLY SPACED IN A CLOCKWISE DIRECTION SH MAXIMUM TIGHTNESS AGAINST FLASH SUPPRESSOR. THE NUT SHALL NOT BE BACKED OFF THE HANDLE OF THE GAGE AND THE FLASH SUPPRESSOR SHALL NOT TOUCH THE FLASH SUPPRESSOR WHEN THE NUT SHALL BE USED WHEN THE BORE DIA IS .30 SUPPRESSOR SHALL BE SELECTIVELY ASS ABOVE REQUIREMENT.

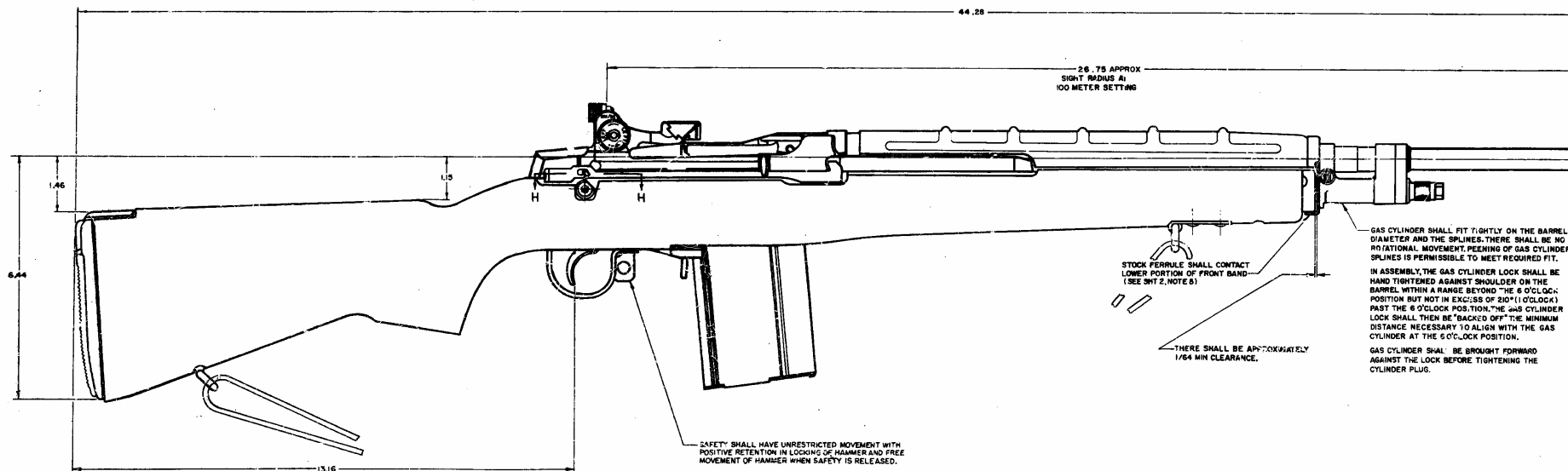


ENGRAVE LETTERS  
"NM" 1/16 HIGH PER  
MIL-STD-130

WICK PUNCH BOLT  
AND RECEIVER AFTER  
PROOF FIRING.

WITH THE FIRING MECHANISM, STOCK ASSEMBLY, OPERATING ROD SPRING AND SPRING GUIDE DISASSEMBLED FROM THE RIFLE, AND WITH THE MUZZLE RAISED TO AN ANGLE OF APPROXIMATELY 90° FROM THE HORIZONTAL, THE BOLT, WITH OPERATING ROD ASSEMBLED, SHALL OPEN FULLY WITHOUT ANY MANUAL ASSISTANCE. WHEN THE MUZZLE IS LOWERED TO AN ANGLE OF APPROXIMATELY 90° FROM THE HORIZONTAL, THE BOLT, WITH OPERATING ROD ASSEMBLED, SHALL CLOSE FULLY WITHOUT ANY MANUAL ASSISTANCE.

FRONT SIGHT SHALL BE ASSEMBLED—  
SECURELY WITH NO OVERHANG OF  
SUPPRESSOR BASE.



26.75 APPROX  
SIGHT RADIUS AT  
100 METER SETTING

STOCK FERRULE SHALL CONTACT  
LOWER PORTION OF FRONT BAND  
(SEE DWT 2, NOTE 8)

THERE SHALL BE APPROXIMATELY  
1/64 MIN CLEARANCE.

SAFETY SHALL HAVE UNRESTRICTED MOVEMENT WITH  
POSITIVE RETENTION IN LOCKING OF HAMMER AND FREE  
MOVEMENT OF HAMMER WHEN SAFETY IS RELEASED.

GAS CYLINDER SHALL FIT TIGHTLY ON THE BARREL DIAMETER AND THE SPLINES. THERE SHALL BE NO ROTATIONAL MOVEMENT. PEENING OF GAS CYLINDER SPLINES IS PERMISSIBLE TO MEET REQUIRED FIT.

IN ASSEMBLY, THE GAS CYLINDER LOCK SHALL BE HAND TIGHTENED AGAINST SHOULDER ON THE BARREL WITHIN A RANGE BEYOND THE 6 O'CLOCK POSITION BUT NOT IN EXCESS OF 210° (1 O'CLOCK) FIRST THE 6 O'CLOCK POSITION. THE GAS CYLINDER LOCK SHALL THEN BE "BACKED OFF" THE MINIMUM DISTANCE NECESSARY TO ALIGN WITH THE GAS CYLINDER AT THE 5 O'CLOCK POSITION.

GAS CYLINDER SHALL BE BROUGHT FORWARD AGAINST THE LOCK BEFORE TIGHTENING THE CYLINDER PLUG.

MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF REVISION	
TP	13	TP	13	DATE	REVISION
ES	13	ES	13	DATE	REVISION
EC	13	EC	13	DATE	REVISION
SA	13	SA	13	DATE	REVISION
SH	13	SH	13	DATE	REVISION
RV	13	RV	13	DATE	REVISION
APPLICATION		USED ON		APPROVED	
9386973		MIL-R-45979		APPROVED	
NEXT ASSY		USED ON		APPROVED	