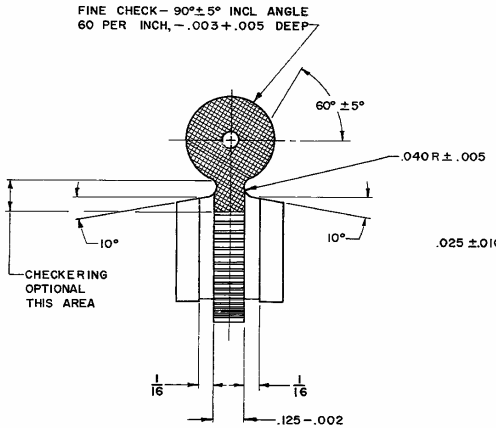
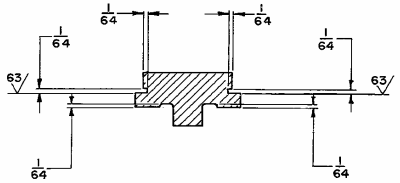
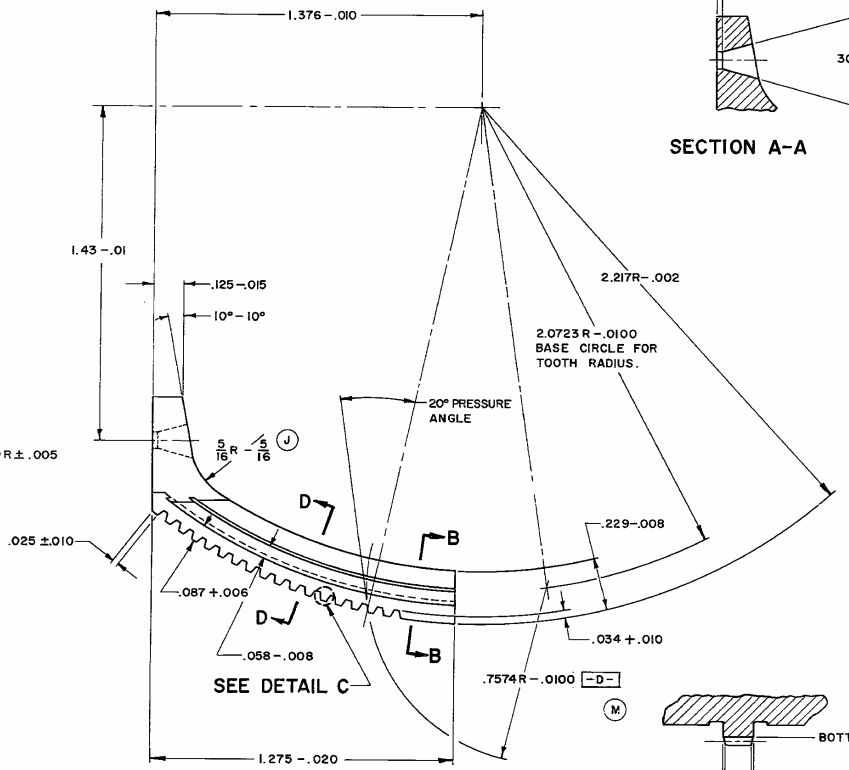
NOTES:

1. FINISH 125 EXCEPT AS NOTED.
2. MATERIAL: STEEL, FED. SPEC QQ-S-637: 1141 FORGING (N1) SPEC MIL-S-46172 ; STEEL TUBING, SEAMLESS, SPEC ASTM A512, A513, A519; 1040 . (K)
3. HEAT TREATMENT: HEAT TO 1525° - 1550°F. OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. (J) (M)
4. ALL CORNERS AND EDGES SHALL BE BROKEN .005 +.010 UNLESS OTHERWISE SPECIFIED. (L)
5. MIL-W-13855 SHALL APPLY.

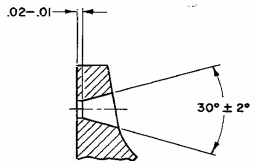


SECTION B-B

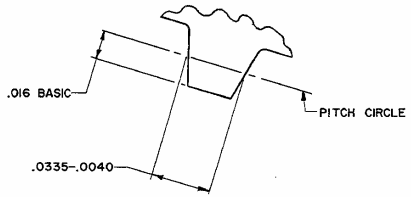




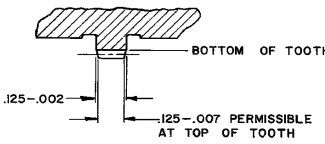
CUT 17 SPACES — MODIFIED -D- (M)
NUTTALL 20 DEGREE STUB TEETH
220 TEETH IN COMPLETE CIRCLE
50 PER INCH .0628 CIRCULAR PITCH. 2.200 PITCH RADIUS
ACCUMULATED BUILDUP OF TOLERANCE IN CIRCULAR PITCH SHALL NOT EXCEED .005 IN 7 TEETH.



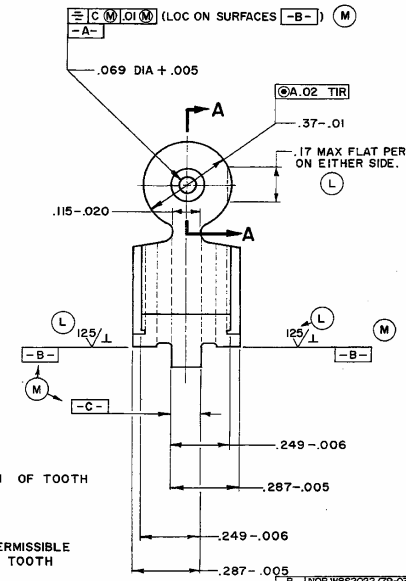
SECTION A-A



DETAIL C
SCALE 30/1



SECTION D-D



D6008868

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
R	NOR W8S2022/79-03-26	79-04-01	SA
P	SEE EO 82048	11MAR68	
N	(J-3) SEE EO SA 29262	16MAY66	
M_2	SEE EO SA 26952	12AUG63	
L_4	SEE EO. SA 25877	23DEC60	
K_1	SEE EO. SA 25524	15JAN60	
J 2	SEE EO. SA 24633	12NOV58	
H	REDRAWN AND REVISED	6JUL 58	
	SEE EO SA24529		
G		25JAN56	

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19200 (P)
~~CODE IDENT NO. 19204~~
(N2) PART NO. 6008868

PHYSICAL PROPERTIES			
TE		F7267000	RIFLE, M14
TS		F7265700	.30R - MID
EL 2		F7265699	.30R - MIC
RA		F7265698	.30R - MI
BH		NEXT ASSY	USED ON
RH	C40 - 45	APPLICATION	
		DO NOT	APPLY PART NO.
		~~SO~~	~~AS SPECIFIED~~

(N3) (L) (M)

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ANGLES ± 1° FRACTIONS ± .01
MATERIAL SEE NOTE 2
HEAT TREATMENT SEE NOTE 3
FINAL PROTECTIVE FINISH FINISH 5.3.1.2 OF MIL-STD-171

ORIGINAL DATE OF DRAWING 2 AUG 37
DRAFTSMAN L.J.L. CHECKER
TRACER J.S.K. CHECKER
ENGINEER R.M.H. ENGINEER
SUBMITTED R. L. Henry ORD CORPS
APPROVED BY CHIEF OF ORDNANCE H. F. Lynch ORD CORPS

APERTURE

~~DEPT OF THE ARMY~~
~~ROCK ISLAND ARSENAL~~
~~ROCK ISLAND, ILL 61201~~

DWG SIZE D | 6008868 | SHEET 1 OF 1

SCALE 4/1 | UNIT WT .02

R.M.H