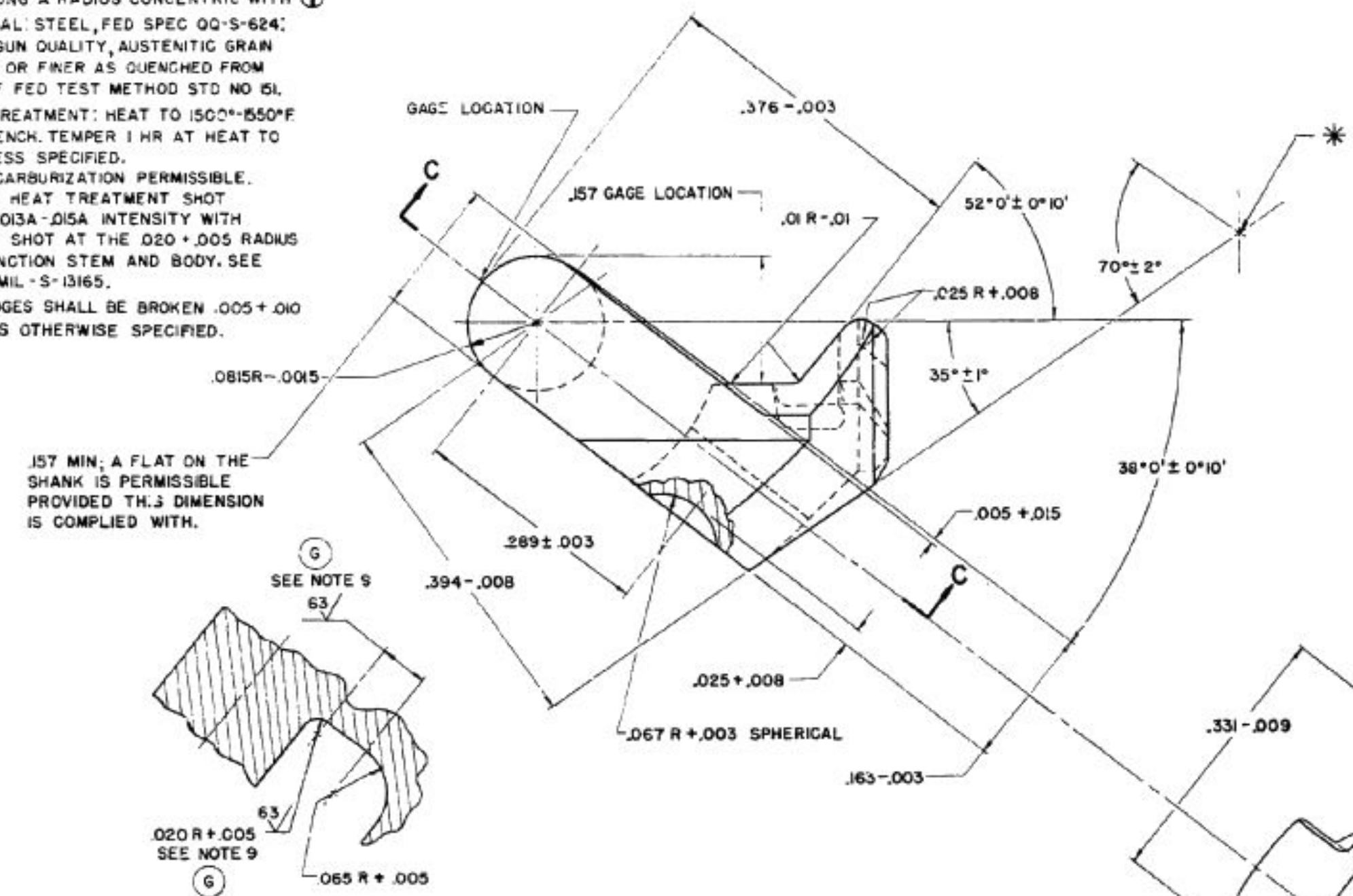
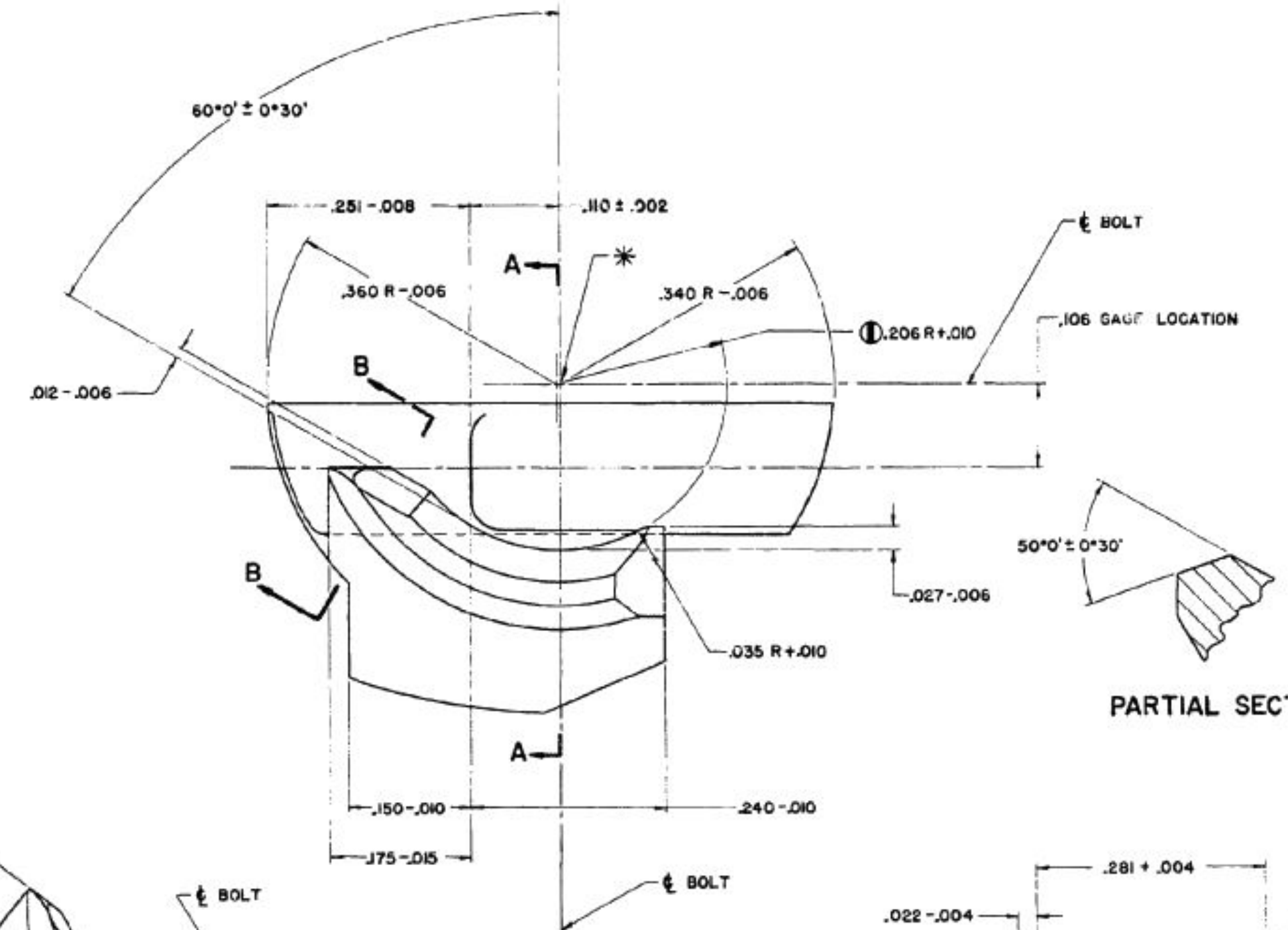


- 7- HEAT TREATMENT METHOD (SEE NOTE 5) IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 8- FINISH NO. 53.1 OF MIL-STD-171 EXCEPT MIL-P-16232 WITH MIL-L-644 SUPPLEMENTARY OIL TREATMENT SHALL APPLY IN LIEU OF MIL-C-12968. PREPRODUCTION APPROVAL, WEIGHT OF COATING AND SALT SPRAY EXPOSURE TIME PER MIL-P-16232 SHALL NOT APPLY. SALT SPRAY EXPOSURE TIME PRIOR TO SUPPLEMENTARY TREATMENT SHALL BE ONE HOUR.
- 9- FINISH REQUIREMENTS SPECIFIED FOR THESE TWO SURFACES SHALL APPLY BEFORE SHOT PEENING.

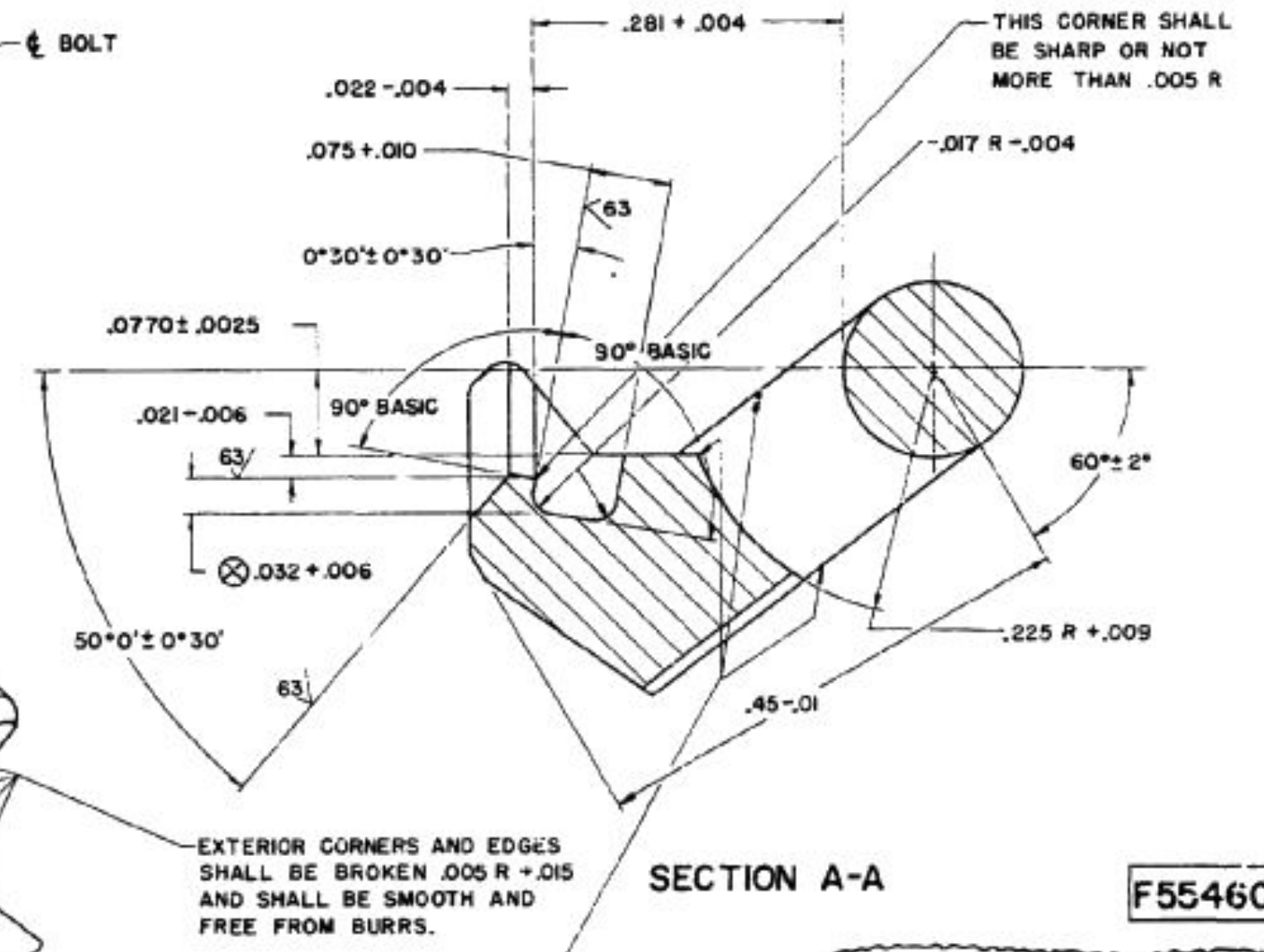
- NOTES:
- 1- FINISH $\sqrt{125}$ EXCEPT AS NOTED.
 - 2- * LOCATION OF 70° CONE CENTER.
 - 3- * ALONG A RADIUS CONCENTRIC WITH ①
 - 4- MATERIAL: STEEL, FED SPEC QQ-S-624; 8645, GUN QUALITY, AUSTENITIC GRAIN SIZE 7 OR FINER AS QUENCHED FROM 1550° F FED TEST METHOD STD NO 61.
 - 5- HEAT TREATMENT: HEAT TO 1500°-1550° F OIL QUENCH. TEMPER 1 HR AT HEAT TO HARDNESS SPECIFIED. NO DECARBURIZATION PERMISSIBLE. AFTER HEAT TREATMENT SHOT PEEN .013A-.015A INTENSITY WITH NO. 170 SHOT AT THE .020 ± .005 RADIUS AT JUNCTION STEM AND BODY. SEE SPEC MIL-S-13165.
 - 6- ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.



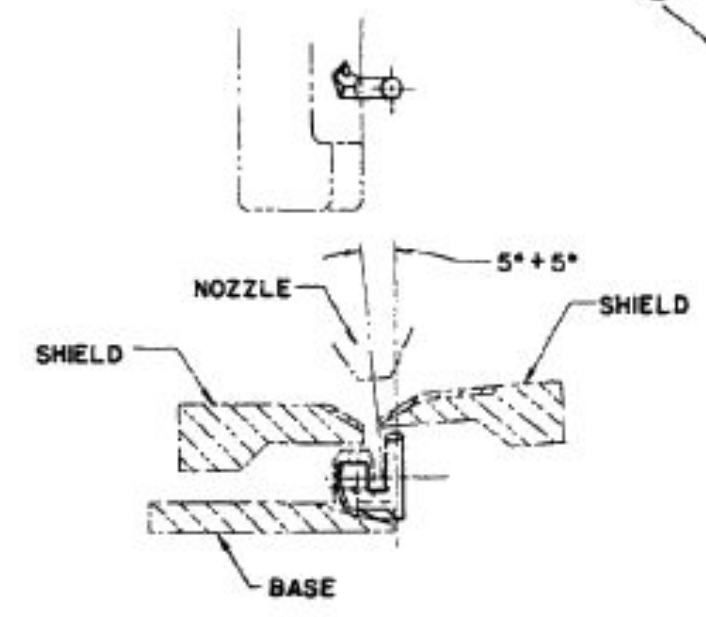
PARTIAL SECTION C-C



PARTIAL SECTION B-B



SECTION A-A



VIEW OF SHOT PEENING .020 R ± .005 AFTER HEAT TREATMENT

EXTERIOR CORNERS AND EDGES SHALL BE BROKEN .005 R ± .015 AND SHALL BE SMOOTH AND FREE FROM BURRS.

REMOVE SHARP RAGGED EDGE ALONG THESE CORNERS TO A SMOOTH RADIUS OF .005 R ± .010 TO PREVENT THE START OF A FRACTURE.

FOR NEW DESIGN WORK AND PROCUREMENT USE PART NO. 7791578

PHYSICAL PROPERTIES		C7790187 RIFLE M14 D7313189 30R M1 MIC B MID SEE ENGRG RECORDS		TOLERANCES UNLESS OTHERWISE SPECIFIED ARE IN INCHES DECIMALS FRACTIONS		ORIGINAL DATE 2 AUG 37	
MATERIAL		SEE NOTE 4		HEAT TREATMENT		SEE NOTE 5 & 7	
APPLICATION		DO NOT APPLY PART NO.		FINAL PROTECTIVE FINISH		SEE NOTE 8	
APPROVED BY		R. J. Henry		APPROVED BY		R. J. Henry	
DATE		2 JAN 50		DATE		2 JAN 50	
BY		R. J. Henry		BY		R. J. Henry	
FOR NEW DESIGN WORK AND PROCUREMENT USE PART NO. 7791578		F5546003		SCALE 10/1		UNIT WT A	
SPRINGFIELD ARMORY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD 1, MASS.		F5546003		SHEET 1 OF 1		R.M.	