

1. SPEC MIL-H-38855 AND ANSI Y14.5-1973 APPLY.

2. MATERIAL:-

A- FOR INROUGH MATERIAL:-  
HOT ROLLED ALLOY STEEL BARS, GRADE 4140,  
ASTM A522.

ALTERNATIVE MATERIAL:-  
STEEL BAR ALLOY, COLD-FINISHED, 4140 H,  
ASTM A531.

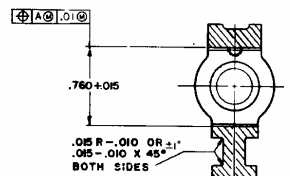
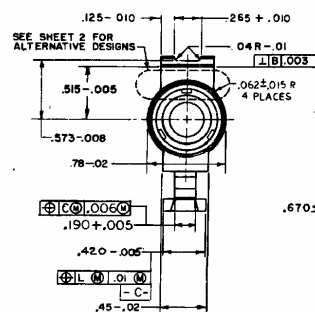
B- FOR PRECISION CASTING:-  
STEEL, 1C-4140, SPEC MIL-S-22141 EXCEPT  
CARBON .43 TO .53 PERCENT. TENSILE TEST  
SHALL NOT APPLY. CLASSIFICATION AND INSPECTION  
REQUIREMENTS CASTING TO BE IN ACCORDANCE  
WITH CLASS 2, GRADE A, EXCEPT CROSS MATCHING  
AREA TO BE CLASS 1, GRADE A, SPEC MIL-C-5021  
(SEE SHEET 2).

3- HEAT TREATMENT (FOR MATERIALS A AND B):  
BEFORE MACHINING, HEAT AT 1550°F TO 1750°F. OIL  
QUENCH. THEN SOAK 15 MINUTES AT 1750°F.  
SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE  
EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED  
BELOW THAT SPECIFIED.

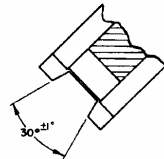
4. FINISH 125/ ALL OVER.

5. ALL EDGES SHALL BE BURNED .005 + .010 UNLESS OTHER  
SPECIFIED.

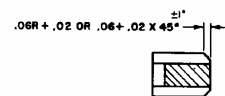
6. ☐ ESTABLISHED BY ☐ IN ☐  
7. ☐ (TOP SLOT) SHALL BE IN ALIGNMENT WITH ☐  
(TOP SPINE) WITHIN .02.



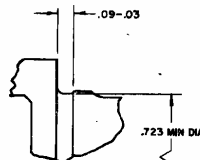
**SECTION D-D**



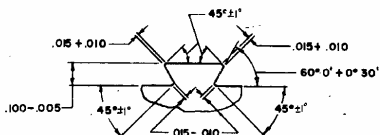
**PARTIAL SECTION K-K**  
**SCALE 4/1**



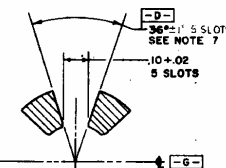
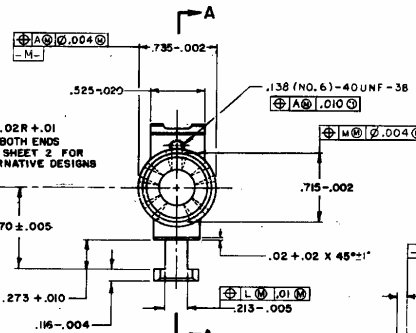
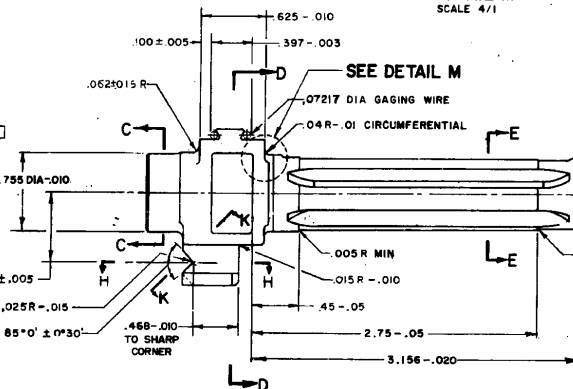
**SECTION H-H**



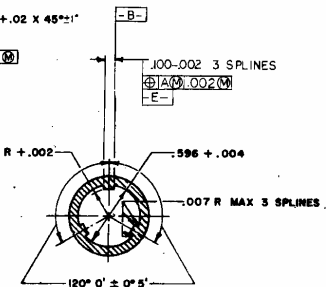
**DETAIL M**  
**SCALE 4/1**



**DOVETAIL CHAMFERS**  
SCALE 4/1

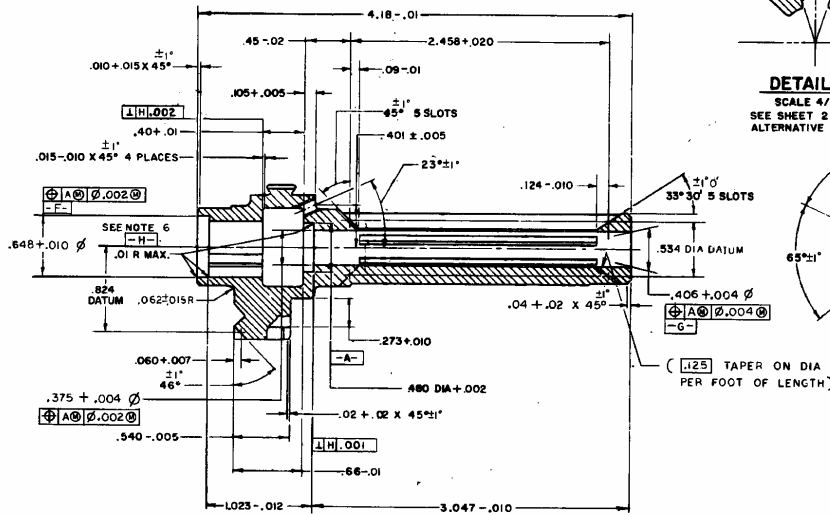


DETAIL L



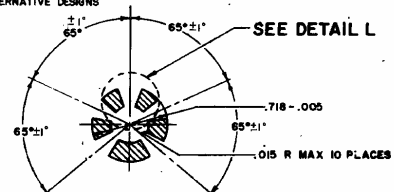
SECTION C - C

**SEE SHEET 2 FOR ALTERNATIVE DESIGN**



SECTION A-A

SEE SHEET 2 FOR ALTERNATIVE DESIGNS



SECTION E-E

| REVISIONS |  |         |           |
|-----------|--|---------|-----------|
| SYM       | DESCRIPTION                                | DATE    | APPROVAL  |
| XC        |  |         |           |
| -         | PRODUCTION RELEASE<br>ERR W25 2025         | 8404 20 | <i>mm</i> |
| A         | NOR W452051/840824<br>ECP W552069/84512231 | 860121  | <i>mm</i> |

|             |  |                       |  |  |  |                                      |  |  |  |
|-------------|--|-----------------------|--|--|--|--------------------------------------|--|--|--|
|             |  | MECHANICAL PROPERTIES |  | DO NOT SCALE DRAWING                                   |  | ORIGINAL DATE OF DRAWING<br>82-06-07 |  | 93362718<br>U S ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER<br>DOWRY, NEW JERSEY 07001 |  |
|             |  | VP                    |  | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES |  | DRAFTSMAN                            |  | CHECKER  |  |
|             |  | VS                    |  | TOLERANCES ON DECIMALS - .01                           |  | ENGR                                 |  | SUPPRESSOR, FLASH<br>9352718   |  |
|             |  | FLD                   |  | FRACTIONS - 1/32 ANGLES - 1°                           |  | ENGR                                 |  | SIZE F<br>FSCM NO. 19200<br>9352718  |  |
| Y 93362718  |  | RIFLE, M14 MM         |  | FINAL PROTECTIVE FINISH                                |  | S. J. [Signature]<br>[Signature]     |  | SCALE 2/1 UNIT WT<br>SHEET 1 OF 2  |  |
| NEXT ASSY   |  | USED ON               |  | OR 5.3.1.2 OF MIL-STD-171                              |  |                                      |  |  |  |
| APPLICATION |  | RH 9329-36            |  |  |  |                                      |  |  |  |