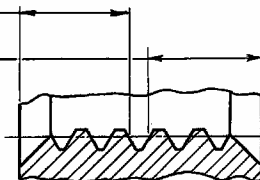


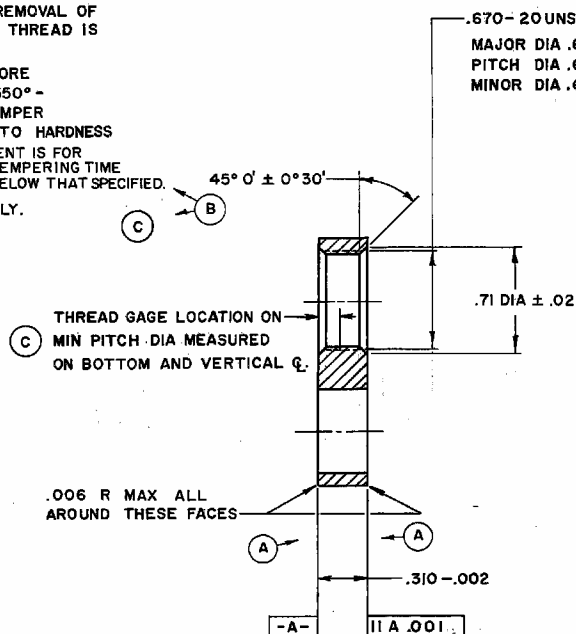
NOTES:

1. FINISH $\sqrt{63}$ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .01+.01 UNLESS OTHERWISE SPECIFIED.
3. REMOVAL OR PARTIAL REMOVAL OF PROTECTIVE FINISH ON THREAD IS PERMISSIBLE.
4. HEAT TREATMENT: BEFORE MACHINING, HEAT TO 1550°-1575°F. OIL QUENCH. TEMPER 45 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. MIL-W-13855 SHALL APPLY.

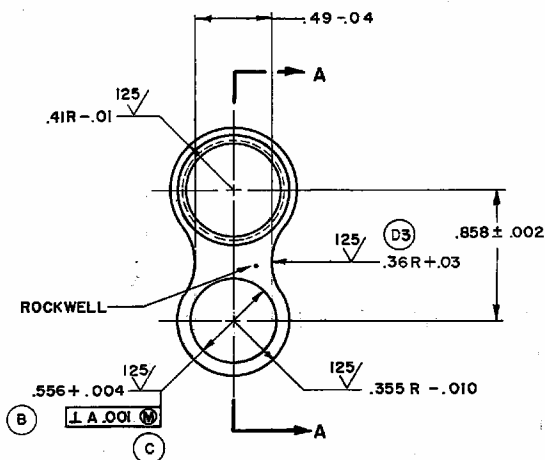
.142 ± .002 LOCATION OF GAGE
SHALL BE WITHIN RESULTANT
DIMENSIONAL LIMITS



PARTIAL SECTION OF .670-20UNS-3B THD.
SCALE: 10/1



SECTION A-A



C7790188

ORIGINAL FSCM NO. 19205

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

J	ECPW5S2069 /851223	860121	10/1
M	NORW4S2051/ 840824	790401	SA 01/10/1
G	SEE EO HRD 02138	790401	SA 01/10/1
F	(1) SEE EO HRD 92078-2	25 JUN 85	SA 01/10/1
E	SEE EO 82048	11 MAR 85	SA 01/10/1
D	(1-3) SEE EO SA 29261	18 MAY 85	SA 01/10/1
C	SEE EO SA 26177	18 MAR 85	SA 01/10/1
B	SEE EO SA 25568	23 DEC 84	SA 01/10/1
A	SEE EO SA 25470	28 DEC 84	SA 01/10/1
SYN	DESCRIPTION	DATE	APPROVAL

PART NO. 7790188

PHYSICAL PROPERTIES	APPLICATION
YP	
TS	J9386974 RIFLE, M14, NM
SLZ	F7267000 RIFLE, M14
RA	
BH	
RH	C28-33
DO NOT	APPLY PART NO.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCES ON DECIMALS

ANGLES FRACTIONS

MATERIAL STEEL, SPEC ASTM A304, A322, A331; 4150

HEAT TREATMENT SEE NOTE 4

FINAL PROTECTIVE FINISH FINISH NO. 3.3.1.2 OF MIL-STD-171

ORIGINAL DATE OF DRAWING 10 JUL 1958

DRAFTSMAN J.E. CHECKER J.K.

TRACER R.J. CHECKER J.K.

ENGINEER J.K. ENGINEER J.K.

SUBMITTED

R.D. Henry ORG CORPS

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE

A.J. Lynch ORG CORPS

LOCK, GAS CYLINDER

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILL 61201

OWC
SIZE
C
7790188
SHEET 1 OF 1

R.M.H.