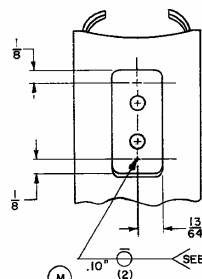


NOTES:

1. WELD SHALL WITHSTAND PEEL TEST PER PAR 7.3.3.1 OF MIL-W-12332 EXCEPT THAT IN LIEU OF MINIMUM BUTTON DIA REQUIREMENT THE WELD SHALL BE SATISFACTORY IF THE PEEL TEST CAUSES TEARING OF THE THINNER BASE METAL AROUND THE PERIPHERY OF THE WELD.
2. HEAT TREATMENT: HEAT TO 1525°-1550° F. QUENCH IN CIRCULATING OIL. TEMPER 45 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
3. LOCATION AND SIZE OF BUTTONS ON PLATE AND HOLES IN TUBE SHALL BE ADJUSTED TO MEET ASSY REQUIREMENTS AND SHALL NOT INTERFERE WITH WELDING REQUIREMENTS. SEE ALTERNATIVE DESIGNS IN ZONES B-2 AND A-6.
4. FINAL PROTECTIVE FINISH: 5.3.1.2. OR 5.3.2.2. OF MIL-STD-171.
5. MIL-W-13855 SHALL APPLY.

PLATE-7790198

TUBE-7790181



ALTERNATIVE METHOD

THIS SURFACE SHALL BE FREE OF WELD PROTRUSIONS

.100 DIA ROLL DATUM

1.5095-.0100 FROM HIGHEST LIP

SEE NOTE 1

3.100 ±.025

6.000 DATUM

10" (5)

1/8

1/8

1/8

1/8

1/8

1/8

1/8

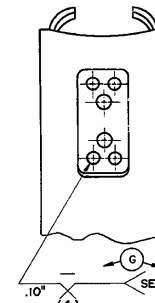
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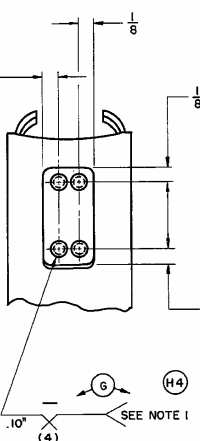
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ALTERNATIVE METHOD



ALTERNATIVE DESIGN (SEE NOTE 3)



D7790197

BUTTONS SHALL NOT PROTRUDE BEYOND INNER SURFACE OF TUBE.

ORIGINAL FSCM NO. 19205

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

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7790197

PART NO. 7790197

PHYSICAL PROPERTIES	APPLICATION	HEAT TREATMENT	FINAL PROTECTIVE FINISH
1. RIFLE M14NM	DO NOT	SEE NOTE 2	SEE NOTE 4
2. RIFLE M14	APPLY PART NO.		
3. A71-76			

ORIGINAL DATE OF DRAWING 12 JUN 1958	TRACER C. MC	CHECKER J.K.
ENGINEER J.P.	CHECKER J.K.	
SUBMITTED		
APPROVED BY JONES OF THE		
OF THE		

REVISIONS	DATE	APPROVAL
1. TUBE ASSY, MAGAZINE		
2. 7790197		
3. 7790197		
4. 7790197		
5. 7790197		
6. 7790197		
7. 7790197		
8. 7790197		
9. 7790197		
10. 7790197		

SCALE 2/1 UNIT WT RMH