NOTES:

1. FINISH 125 EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. STEEL, GRADE 8645H (GUN QUALITY), ASTM A304. AUSTENITE GRAIN SIZE 7 OR FINER.
4. HEAT TREATMENT:
   a. NORMALIZE BEFORE MACHINING.
   b. HEAT TO 1575° TO 1600° F. OIL QUENCH. TEMPER ALL OVER FOR 90 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
   c. DECARBURIZATION SHALL NOT EXCEED .001 (TOTAL AND PARTIAL) IN AREAS -D-. (SEE SHEET 1, ZONES B-8 & E-6; SEE SHEET 2, ZONES D-4 & D-5).
5. ROCKWELL HARDNESS: HANDLE AND END OF TUBE C40 TO 46.
6. -B- INDICATES MEASURMENT ON PITCH CIRCLE. (SEE ZONES D-4, E-4, & E-5)
7. GAGE LOCATIONS FOR CHECKING HOLE CONCENTRICITY. (SEE ZONES A-1 & B-3).
8. ADJUST AS NECESSARY BENDING HANDLE AT -C- FOR PROPER FIT WITH GAGE F7796726. (SEE ZONES D-3, C-7 & E-7). ADJUSTMENT OF ROD(S) TO FIT GAGE MAY RESULT IN SOME SLIGHT DIMENSIONAL CHANGES. THIS CONDITION IS PERMISSIBLE AND SHALL NOT BE CAUSE FOR REJECTION.
9. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171

10. MIL-W-13855 SHALL APPLY.

REVISION STATUS OF SHEETS

SHEET 1	SHEET 2	SHEET 3
U	L2	U

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
H		19 APR 62	
J	REVISED AND REDRAWN SEE EO SA 29577	11 MAR 63	
K	(1-3) SEE EO SA 29261	15 MAY 66	
L	(1-3) SEE EO 82048	11 MAR 68	
M	(1-2) SEE EO HRD 82272	7 OCT 68	
N	(1) SEE EO HRD 92078-2	25 JUN 69	
P	SEE EO HRD 92138	7 FEB 25	
R	(2) SEE ERR HQR 40681	HQREB 75	
S	ERR WSS2022/79-13626	79-04-01	
U	NOR WSS2051/840824 ECP WSS2069 /851223 ECP W3S2027/850808	860121	

5.584+.010
LEAD OF HELIX-1 TURN IN 5.000 BASIC
63 FINISH ON SURFACE OF CAM
SEE NOTE 4c -D-
5.017+.010 -B-
.025+.012
.33-.01
SEE NOTE 8
℄ OF -A-
.5135 DATUM -B-
.005+.010
.18+.01
45°±2°
45°±2°
45°
.625 R
.60
.83-.05
.075+.020
.23+.01
.25 R
.03 R+.05
4.326-.010 -B-
4.926+.010
.045 R-.035
THESE EDGES SHALL BE BROKEN .005+.040
SEE NOTE 8 -C-
6.452+.025
6.526 MAX TO APEX OF DRILL POINT
.077 DIA+.006
A.01 TIR
1/32 + 1/32 X 45°

2 1/2
.33+.03
SEE NOTE 8
.27-.01
.000±.003
.225-.030
.01 R+.03
.60-.02
3/64 R
.62 R
.45
1/8 R
.14+.01
1 7/16 DIA-3/8
30°±5°
20°
.03 R+.05
SEE DETAIL A
.51 R
1/32 R
.080 R±.005
.18-.01
.195-.010
F
F
1 DIA-1/4
20°
63 FINISH FOR 4.58 MIN
.01 R+.01 OR .01+.01 X 45°
.590 DIA-.004 -A-
.01-.02
1/2-1/16
.005 R+.040
6.452+.025

170° MAX
.400 DATUM
170° MIN
.046 MAX .466 DIA MIN FOR THIS DISTANCE
ALTERNATIVE DESIGN

SEE NOTE 4c -D-
1/16 R+1/16
.320-.003
63
.000 R+.005
3/8
45°
.35-.01
.465-.010
.155-.010
63
1.00 R-.02
1.00 R-.02
5/32 R-1/32
45°±5°
.97-.01
.165-.020
.05 R+.01
.J5 DATUM
45°
.002+.005
1 1/4 DIA+1/8
.058-.003
20°
.44±.02
.005±.005
A
A
.315-.015
.39+.02
2 1/8-1/8
4.436-.010
6.28-.01
.02 R+.01 THROUGHOUT CONTOUR
.000+.007
VIEW A-A

.03 R+.05
2.500 DATUM GAGE LOCATION SEE NOTE 7
1/4 DATUM
.420-.015
45°
A.004 TIR
15°
30°
C
C
.505 DIA+.010
.0176 MAX
3/8 DATUM
63
A.008 TIR
1/8 DATUM GAGE LOCATION SEE NOTE 7
11.090-.005
FINISH AFTER HEAT TREATMENT

3/64
45°±2°
DETAIL A
OPTIONAL METHOD

ORIGINAL DESIGN ACTIVITY FSCM NO. 19205

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

PART NO. 7267064

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

ROD, OPERATING

MECHANICAL PROPERTIES		
YP		
TS	#9386974	RIFLE, M14-NM
EL 2	F 7267000	RIFLE, M14
RA	NEXT ASSY	USED ON
BH	APPLICATION	
RH	SEE NOTE 5	DO NOT APPLY PART NO.
	DO	AS SPECIFIED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ± .01
FRACTIONS ± 1/64 ANGLES ± 1°
MATERIAL SEE NOTE 3
HEAT TREATMENT SEE NOTE 4
FINAL PROTECTIVE FINISH SEE NOTE 9

ORIGINAL DATE OF DRAWING 17 SEP 54
DRAFTSMAN C.L.B. CHECKER E.F.K.
TRACER CHECKER
ENGINEER ENGINEER
SUBMITTED ORD CORPS
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE ORD CORPS

DRAWING NUMBER 7267064 DWG SIZE F
SCALE 2/1 UNIT WT SHEET 1 OF 3