

DRAWING SIZE F

## NOTES:

1. UNLESS OTHERWISE SPECIFIED ALL EDGES SHALL BE BROKEN .015+.015.

## 2. MATERIAL:

A. PLASTIC (PREMIX MOULDING COMPOUND) MIL-P-43043 COLOR: FED STD NO. 595 BROWN 3002S.  
B. 16 STRANDS OF PREIMPREGNATED CONTINUOUS ROVING "K" FILAMENT (50 END EQUIVALENT) WITH INSOLUBLE SILANE SIZING SHALL BE PLACED BETWEEN DIMENSIONS DEFINED BY E-1 WITHIN EACH MOLDED SHELL. DISTRIBUTION OF MOLDED STRANDS SHALL RESULT IN A DOWNWARD FILAMENT SPREAD FROM TOP SURFACE E-2.

C. ADHESIVE MIL-P-52194.  
D. PLASTIC MATERIAL (FOAM IN PLACE), MIL-P-21929, CLASS 2.

3. FINAL PROTECTIVE FINISH: EXCEPT INTERNAL AREA DEFINED BY E-3.

A. PRIMER MIL-P-23377, TYPE II TWO COATS, COLOR: FED STD NO. 595, 3002S, DARK GREEN.

B. TOP COAT: MIL-C-83295, COLOR: FED STD NO. 595, 3002S, BROWN.

4. SHELLS LH AND RH PINS AND PLATE SHALL BE PERMANENTLY ASSEMBLED BY BONDING WITH ADHESIVE (SEE NOTE 2). ADHESIVE SHALL BE APPLIED TO ALL JOINT SURFACES, REINFORCING PIN HOLES AND PLATE CAVITIES.

5. DATUM E-1 IS ESTABLISHED BY CENTRELINE OF E-2 (SH 5, ZONE C4) AND E-3 (SH 1, ZONE C3).

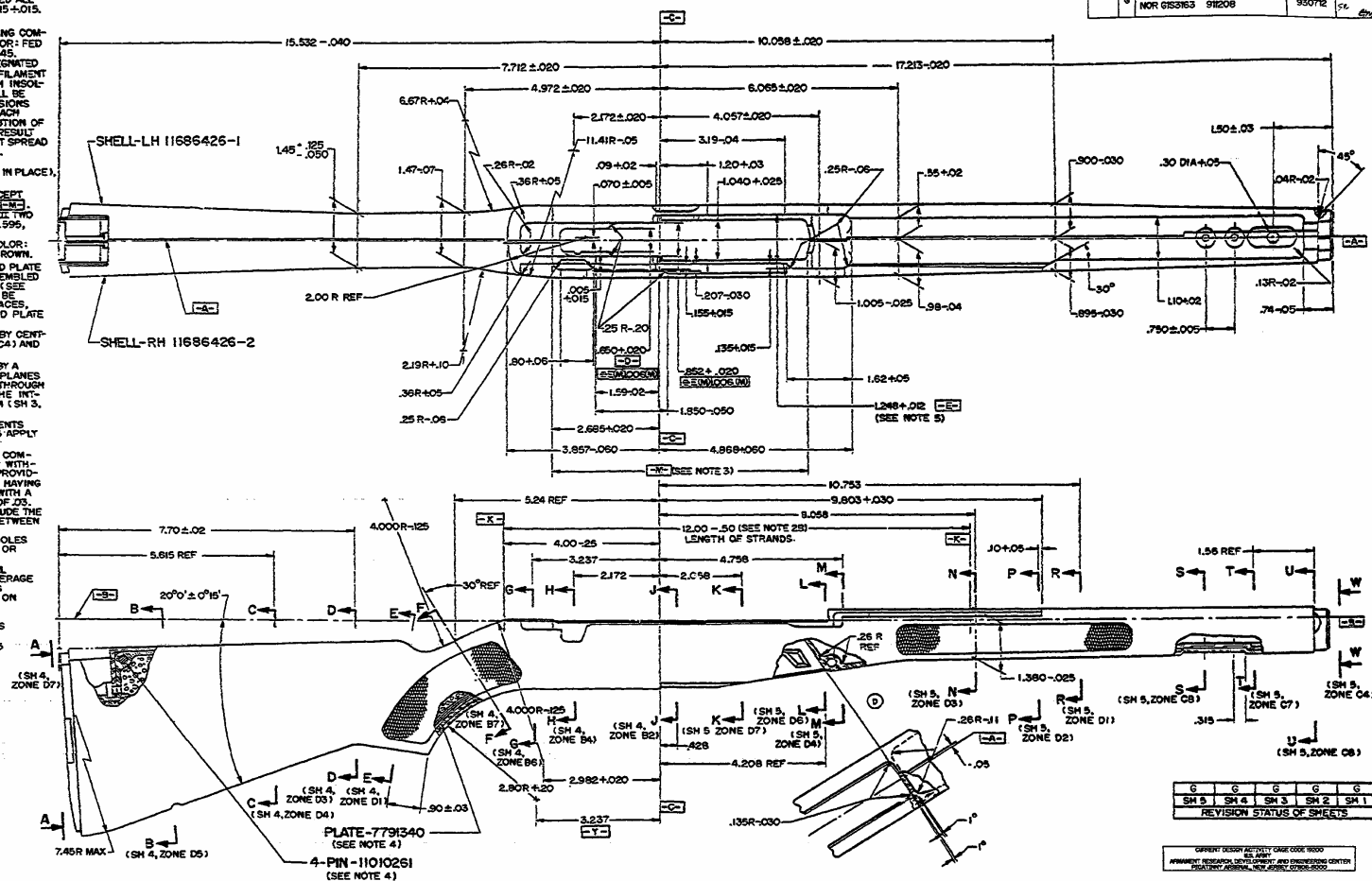
6. DATUM E-2 IS ESTABLISHED BY A PLANE AT RIGHT ANGLES TO PLANES E-3 AND E-4 AND PASSING THROUGH THE 3" BASIC SURFACE AT THE INTERSECTIONS OF .8955 DATUM (SH 3, ZONE D4).

7. DIMENSIONS AND REQUIREMENTS SHOWN ON SHEETS 1 THRU 5 APPLY TO COMPLETED STOCK.

8. THE BUTT CAVITY SHALL BE COMPLETELY FILLED WITH FOAM WITHIN LIMITS OF E-3 AND BE PROVIDED WITH ACCESSORY HOLES HAVING A HARD, SMOOTH SURFACE WITH A MINIMUM SKIN THICKNESS OF .03. THIS THICKNESS SHALL INCLUDE THE ENTIRE DENSITY GRADIENT BETWEEN MASS AND HARD SURFACE. THERE SHALL BE NO BLOWHOLES EITHER IN THE SKIN ITSELF OR ADJACENT TO THE SKIN.

9. HARDNESS: HARDNESS SHALL BE BRINELL 50 MINIMUM AVERAGE OF SIX READINGS. HARDNESS READINGS SHALL BE TAKEN ON RIGHT AND LEFT HAND STOCK SHELLS PRIOR TO ASSEMBLY WITHIN 24 HOURS AFTER MOLDING.

10. MIL-W-13855 AND ANSI Y14.5 APPLY.



REV	DATE	DESCRIPTION
G	930712	REDRAWN WITH CHANGE NOR 653163 91208

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FOR LIST OF PARTS SEE ENGINEERING PARTS LIST 11686426

PART NO. 11686426

PERC MECHANICAL PROPERTIES 11686426 RIFLE, M16 NEXT ASSY USED ON APPLICATION		DO NOT SCALE DRAWING DIMENSIONS SHOWN 3/16" ± .010 ANGLES 1° THIRD ANGLE PROJECTION SPRINGFIELD ARMOY, SPRINGFIELD, MA STOCK GUN SHOULDER (PREMIX) F 19205 11686426 17/1	
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