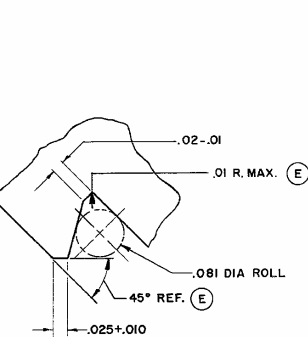
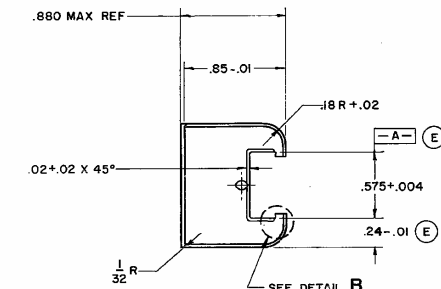


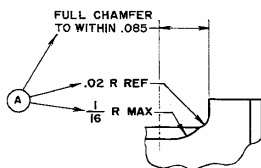
- NOTES:
- FINISH 125/
  - ALL EDGES SHALL BE BROKEN .005+0.010 UNLESS OTHERWISE SPECIFIED.
  - MATERIALS:  
A- FOR WROUGHT MATERIAL:  
STEEL, SPEC ASTM A304 (E) (G2)  
A322, A331: 4140, 8620,  
4140 RESULPHURIZED  
(SULPHUR .05 TO .09%) OR 4140  
LEADED (LEAD .15 TO .35%).  
B- FOR PRECISION CASTING:  
STEEL, MIL-S-22411: 1C-8620.  
TENSILE TEST SHALL NOT APPLY.
  - CLASSIFICATION AND INSPECTION OF  
INVESTMENT CASTINGS TO BE IN  
ACCORDANCE WITH CLASS 4, GRADE B,  
MIL-STD-2175.
  - HEAT TREATMENT: FOR MATERIAL  
4140 (A) HEAT AT 1575° TO 1600° F.  
IN NEUTRAL SALT BATH. QUENCH  
IN CIRCULATING OIL. TEMPER 30  
MIN. AT HEAT TO ROCKWELL C40-45.  
FOR MATERIAL 8620 (A & B):  
CARBURIZE AT 1575° TO 1600° F.  
FROM .005 TO .008 DEPTH. QUENCH  
IN CIRCULATING OIL. TEMPER  
30 MIN. AT 375° F. HARDNESS:  
FILE HARD. HEAT TREATMENT METHOD  
IS FOR GUIDANCE EXCEPT THAT CASE  
DEPTH AND HARDNESS REQUIREMENTS  
ARE MANDATORY AND TIME AT TEM-  
PERATURE SHALL NOT BE REDUCED  
BELOW THAT SPECIFIED. THE USE OF  
STRAIGHT CYANIDE BATH OR CARBO-  
NITRIDING PROCESSES SHALL NOT BE  
PERMITTED WITHOUT PRIOR APPROVAL  
OF THE CONTRACTING OFFICER.
  - MIL-W-13855 SHALL APPLY.
  - FINAL PROTECTIVE FINISH: (H2)  
FINISH 5.3.12 OR 5.3.2.2  
OF MIL-STD-171.



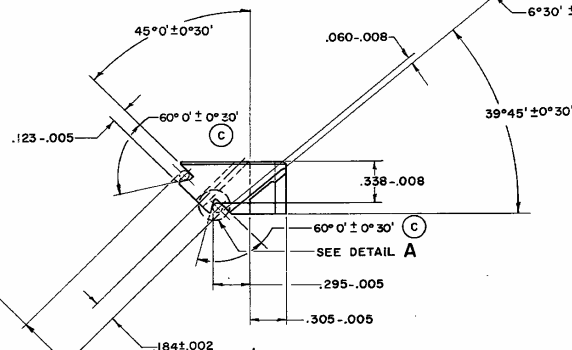
DETAIL A  
(BOTH SIDES)  
SCALE 10/1



DETAIL B  
(BOTH CORNERS)  
SCALE 10/1



467-.003 MEASURED AT B-B  
474-.003 MEASURED AT C-C



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

ORIGINAL FSCM NO. 19205

PART NO. 7790184

PHYSICAL PROPERTIES	TOLERANCES ON DIMENSIONS	ORIGINAL DATE OF DRAWING
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