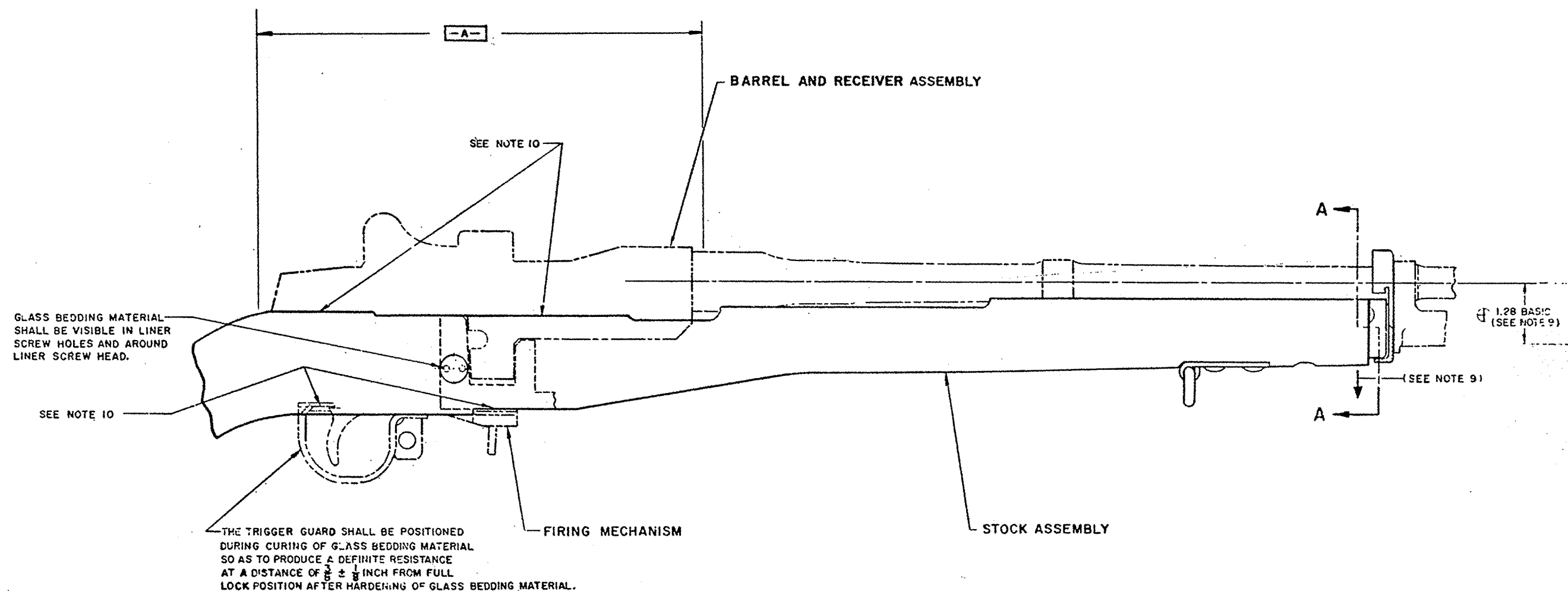


- NOTES:
- CHEMICALS AND SOURCES OF SUPPLY.  
EPON RESIN NO.820—SHELL CHEMICAL CORP., NY, N.Y.  
VERSAMID POLYAMIDE RESIN NO.140—CHEMICAL DIV OF GENERAL MILLS, KANKAKEE, ILL.  
DIETHYLENETRIAMINE (TECH GRADE)—MATHESON COLEMAN & BELL, EAST RUTHERFORD, N.J.  
MILLED FIBERGLASS (1/32" LENGTH)—FIBERGLASS DIV OF FERRO CORP, NASHVILLE, TENN.  
SUBSTITUTE MATERIALS SHALL NOT BE USED WITHOUT APPROVAL BY SPRINGFIELD ARMOY.
  - FORMULATION OF GLASS BEDDING MATERIAL (PARTS BY WEIGHT)  
EPON RESIN NO.820 — 75 PARTS  
VERSAMID NO.140 — 25 PARTS  
DIETHYLENETRIAMINE — 6 PARTS  
MILLED FIBERGLASS — 27 PARTS  
NOTE THE ABOVE FORMULATION AFTER MIXING WILL GIVE A SERVICEABLE POT LIFE UP TO 90 MINUTES OR LONGER AT AMBIENT TEMPERATURES PROVIDED THE MIXTURE IS SPREAD THINLY ON A FLAT HARD SURFACE (THIS WILL REDUCE EXOTHERM WHICH SHORTENS POT LIFE).
  - STOCKS SHALL BE ALLOWED TO DRY AFTER FINAL PROTECTIVE FINISH (CHINAWOOD OIL) FOR A MINIMUM 7 DAY PERIOD PRIOR TO APPLYING GLASS BEDDING MATERIAL.
  - THE STOCK ASSEMBLY AND FIRING MECHANISM OF EACH WEAPON SHALL BE IDENTIFIED BY MARKING OR STAMPING IN A SUITABLE INTERIOR SURFACE WITH THE LAST 4 DIGITS OF THE SERIAL NUMBER OF MATING RECEIVER (BARREL AND RECEIVER ASSEMBLY). THESE ASSEMBLIES SHALL NOT BE INTERCHANGED AFTER COMPLETION OF GLASS BEDDING.
  - ALL METALLIC COMPONENTS AND/OR ASSEMBLIES WITHIN AREA A COMING IN CONTACT WITH GLASS BEDDING MATERIAL SHALL BE DEGREASED.
  - ALL METALLIC AREAS OF RIFLE ACTION ASSEMBLY WITHIN AREA A SHALL BE PROTECTED FROM BONDING BY GLASS BEDDING MATERIAL BY APPLYING, EITHER BY BRUSHING OR DIPPING, TWO COATS OF MOLD RELEASE COMPOUND. SOURCE OF SUPPLY:  
RAM CHEMICALS, INCORPORATED, 210 EAST ALONDRA BOULEVARD  
GARDENA, CALIFORNIA — GARAN NO.225  
A SUBSTITUTE MATERIAL SHALL NOT BE USED WITHOUT APPROVAL BY SPRINGFIELD ARMOY.
  - FILL THE ROUTED AREAS OF STOCK WITH GLASS BEDDING MATERIAL TO INSURE THAT THE IMBEDDED AREAS ARE COMPLETELY COVERED PROVIDING EXCESS MATERIAL TO INSURE COMPLETE SURFACE BEDDING.  
ASSEMBLE, BED AND BOND LINER ASSEMBLY, STOCK AND SCREWS, STOCK LINER TO STOCK WITH GLASS BEDDING MATERIAL (DO NOT APPLY MOLD RELEASE COMPOUND TO LINER AND SCREWS) ALLOWING FOR FINAL TIGHTENING OF SCREWS AFTER COMPLETE RIFLE ACTION HAS BEEN ADJUSTED.  
IMMEDIATELY FOLLOWING THE ABOVE PROCEDURE, THE RIFLE ACTION (BARREL AND RECEIVER ASSEMBLY AND FIRING MECHANISM) SHALL BE BEDDED TO THE STOCK AND THE RECEIVER LEGS ALIGNED WITH STOCK LINER RECOIL SURFACES (SEE ZONE 3A, SHEET 1). ADJUST THE TRIGGER GUARD (FIRING MECHANISM) TO OBTAIN THE REQUIRED TENSION (SEE ZONE 4B).  
ALLOW THE BEDDED RIFLE ACTION TO DRY A MINIMUM OF 8 HOURS.
  - ON COMPLETION OF GLASS BEDDING ALL EXCESS MATERIAL IN SOFT STATE AROUND PERIPHERY OF MATING COMPONENTS OR ASSEMBLIES SHALL BE REMOVED. NO REMOVAL OF GLASS BEDDING MATERIAL IS PERMITTED (AFTER IT SOLIDIFIES) CONTAINING THE MOLDED IMPRESSIONS OF THE RECEIVER AND TRIGGER HOUSING (FIRING MECHANISM) BEDDING SURFACES.
  - ASSEMBLIES SHALL BE ADJUSTED SO THAT THE STOCK EXERTS A 1 TO 15 LB MAX LOAD ON BAND IN DIRECTION SHOWN AFTER HARDENING OF GLASS BEDDING MATERIAL.
  - 0.015 MAXIMUM BUILDUP OF GLASS BEDDING MATERIAL PERMISSIBLE ON UPPER AND LOWER BEDDING SURFACES OF STOCK.
  - QUALIFICATION OF + REQUIREMENTS SHALL BE MAINTAINED DURING CURING OF GLASS BEDDING MATERIAL WITH BARREL AND RECEIVER ASSEMBLY, STOCK ASSEMBLY AND FIRING MECHANISM AS SHOWN.



CODE IDENT A

PART NO

F 1 / 2

J-7790476  
SH-245

| DATE      | BY | REVISION | DESCRIPTION | APPROVED |
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| 10 APR 59 | 1  |          | REVISION    |          |
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| 10 APR 59 | 10 |          | REVISION    |          |

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