NOTES:

1. MIL-W-13855 SHALL APPLY.
2. FINISH 125/ EXCEPT AS NOTED.
3. MATERIAL: STEEL, SPEC ASTM A304, A322, A331, 8620H, EXCEPT RESULPHURIZED (SULPHUR .035 TO .050%) GUN QUALITY. HARDENABILITY OF STEEL SHALL BE CONTROLLED, AS REQUIRED, TO SUIT MANUFACTURER'S HEAT TREATMENT PROCESS AND ASSURE THAT SPECIFIED MANDATORY PHYSICAL PROPERTIES ARE MET. GRAIN SIZE 7 OR FINER.
4. HEAT TREATMENT: RECOMMENDED PROCESS: NORMALIZE BEFORE MACHINING, (OIL QUENCHING FOLLOWED BY TEMPERING AT NOT LESS THAN 450°F MAY BE USED IN LIEU OF AIR COOLING). CARBURIZE AT 1550°F TO 1600°F TO SPECIFIED CASE DEPTH. OIL QUENCH FROM 1550°F TO 1600°F. TEMPER TO HARDNESS SPECIFIED.
   (J) MANDATORY REQUIREMENTS:
   a. NORMALIZE BEFORE MACHINING.
   b. CARBURIZE TO CASE DEPTH .012 TO .018.
   c. TEMPER ONE HOUR MINIMUM AT 350°F TO 450°F.
   d. CORE, ROCKWELL HARDNESS C28 TO C42. SURFACE, ROCKWELL HARDNESS D61 TO D71 OR (REFEREE METHOD) 30N-79 MINIMUM ON A PROPERLY PREPARED SURFACE.
   e. MICROSTRUCTURE OF CORE SHALL NOT CONTAIN MORE THAN 10% FREE FERRITE AFTER HEAT TREATMENT.
   f. THE USE OF A STRAIGHT CYANIDE BATH OR GAS PROCESSES SHALL NOT BE PERMITTED.
5. UNLESS OTHERWISE SPECIFIED:
   a. ALL EXPOSED EXTERIOR EDGES AND CORNERS SHALL BE BROKEN .015 ± 015;
   b. ALL INTERIOR CORNERS SHALL BE ROUNDED WITH A FILLET OF .005 R+.010.
   c. ALL OTHER EDGES AND CORNERS SHALL BE BROKEN .005 ± .010.
6. DIM Ⓜ APPLIES TO LENGTH ⊕
   ℄ ⊕ ESTABLISHED BY BARREL THREAD MINOR DIA .918 +.004 AND BOLT HOLE DIA .730 +.005 AT BRIDGE.
7. FACES OF LOCKING LUGS SHALL BE PERPENDICULAR WITHIN .0005 WITH CENTERLINE ⊕ (SEE NOTE 7.) (GAGING SHALL BE DONE RADIALLY.)
8. AFTER HEAT TREATMENT, EACH RECEIVER SHALL BE FREE FROM CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS AS DETERMINED BY MAGNETIC PARTICLE INSPECTION USING A STANDARD 5 TURN MAGNETIZING COIL WITH A CURRENT OF 400 TO 500 AMPERES. (J) (L)

SECTION C-C

SECTION AK-AK

SECTION D-D (K)

VIEW A

VIEW A

SECTION AJ-AJ (B)

VIEW G

VIEW G
SCALE 4/1

ORIGINAL DESIGN ACTIVITY FSCM NO. 19205

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

CODE IDENT NO. 19200

PART NO. 7790189

RECEIVER

SCALE 2/1

UNIT WT.

PHYSICAL PROPERTIES		
YP		
YS		
EL 2		
RA		
BH		
RF		
SEE NOTE 4		

	F779363	RIFLE, M14NM
	F7790191	RIFLE, M 14
NEXT ASSY		USED ON
APPLICATION		
DO	PER MIL-STD-100 AS SPECIFIED	

FINISH MIL-F-7179 (ORDNANCE)

TOLERANCES ON DECIMALS ± .01, ANGLES ± 1°, FRACTIONS ± 1/64

MATERIAL: SEE NOTE 3

HEAT TREATMENT: SEE NOTE 4

FINAL PROTECTIVE FINISH: FINISH MIL-F-7179 (ORDNANCE)

ORIGINAL DATE: 10 JUL 58

DRAWN: R.M.H. CHECKED: O.H.L.

TRACED: CHECKED:

ENGINEER: ENGINEER:

SUBMITTED: R. J. Henry ORD CORPS

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: O.H. Lund ORD CORPS

V	NORWESTRY 17723-A NOR WS62051/PH10524 ECP WS32072/B3115	86012	NR
U	NOR WS32022/79-03-26	79-04	SA
T	10SEE ERR HQR 40681	10FEB79	SC
S	SEE EO HRD 02138	9FEB78	
R	(1) SEE EO HRD 92076-2	25JUN68	
P	0-21SEE EO 82048	11 MAR68	
N	(1-2) SEE EO SA 28261	18MAR66	
M	SEE EO SA26742	9 NOV65	
L	SEE EO SA26270	29OCT65	
K	SEE EO SA25269	7APR65	
J	SEE EO SA2616	24AUG61	
H	SEE EO SA2616-45	15 FEB 61	
G	SEE EO SA 25585	25DEC60	
F	SEE EO SA 25596	1DEC 60	
E	SEE EO SA 25575	30SEP60	
D	SEE EO SA 25456	15JAN60	
C	SEE EO SA 25811 9	30JUN59	
B	SEE EO SA 25160	11APR59	
A	SEE EO SA 24764	23OCT58	

SYM	DESCRIPTION	DATE	APPROVED
	REVISIONS		
	DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILLINOIS 61201		

SIZE F | CAGE CODE 19200 | 7790189 | SHEET OF 4

V	V	V	V
SHEET 1	SHEET 2	SHEET 3	SHEET 4

REVISION STATUS OF SHEETS

F7790189

R.M.H.