

1. FINISH 125/ ALL OVER. (G) (B2)
2. ALL EDGES SHALL BE BROKEN
.005 +.010 UNLESS OTHERWISE
SPECIFIED.
3. C-H- ESTABLISHED BY -A- AND (A)
-F-

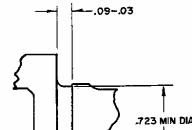
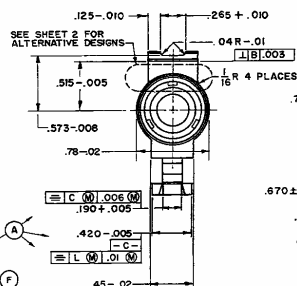
4. MATERIAL:
A FOR WROUGHT MATERIAL:
STEEL, SPEC ASTM A304, A322, A331, 4140;
B FOR PRECISION CASTING:
STEEL, MIL-S-22141; 1C-4140 EXCEPT;
CARBON, A2 TO .55 PERCENT. TENSILE
TEST SHALL NOT APPLY.
CLASSIFICATION AND INSPECTION OF
INVESTMENT CASTINGS TO BE IN
ACCORDANCE WITH CLASS 2, GRADE A
EXCEPT CROSS SECTIONAL AREA TO BE
CLASS 1, GRADE A, SPEC MIL-C-6021.
(SEE SHEET 2)

5. HEAT TREATMENT (FOR MATERIALS A & B): BEFORE MACHINING, HEAT AT 1550°F. TO 1575°F. OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. (A)

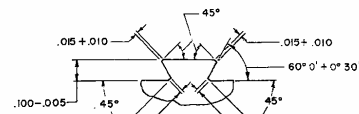
6. -D- (TOP SLOT) SHALL BE IN ALIGNMENT WITH E (TOP SPLINE) WITHIN 2°. (SEE SH1, C-3)

7. MIL-W-13855 SHALL APPLY.

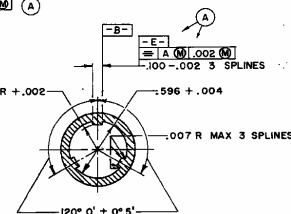
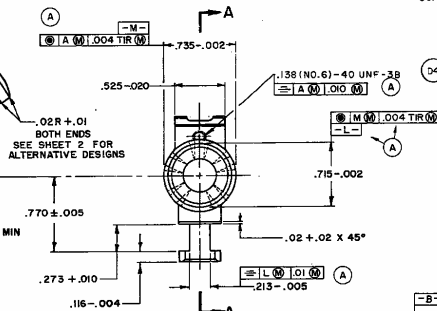
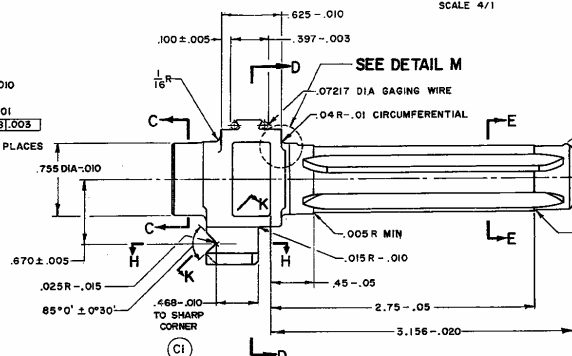
7. MIL-W-13855 SHALL APPLY



DETAIL M
SCALE 4/1

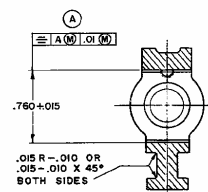


DOVETAIL CHAMFERS
SCALE 4/1

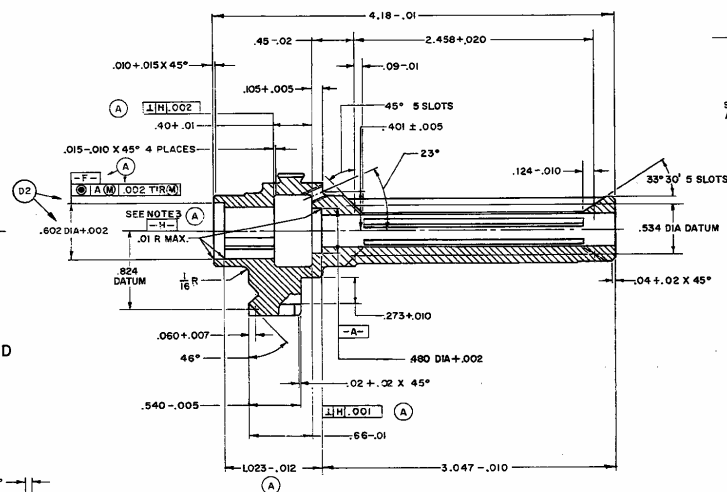


SECTION C - C

SEE SHEET 2 FOR ALTERNATIVE DESIGN

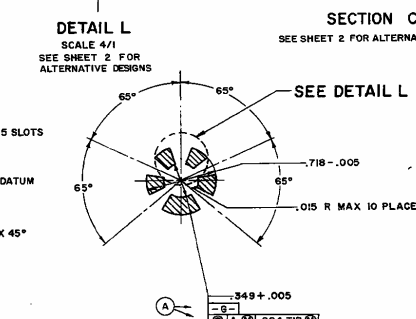


SECTION D-D



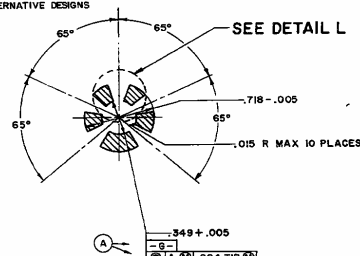
SECTION A-A

SEE SHEET 2 FOR ALTERNATIVE DESIGNS

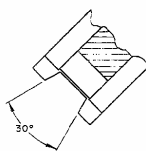


DETAIL L

SCALE 4/1
SEE SHEET 2 FOR
ALTERNATIVE DESIGNS



SECTION E-E



PARTIAL SECTION K-K
SCALE 4/1



SECTION H-H

ORIGINAL DESIGN ACTIVITY FSCM NO.19205
CURRENT DESIGN ACTIVITY FSCM NO.19200
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER NEW JERSEY 07801

CODE IDENT NO. 19204
PART NO. 7791053

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SUPPRESSOR,
FLASH

REVISES	
DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 62201	
DWG SIZE F	7791053 SHEET 1 OF 2