

NOTES:

1. FINISH YES EXCEPT AS NOTED.  
2. ALL EDGES SHALL BE BROKEN .005±.010 UNLESS OTHERWISE SPECIFIED.

3. HOLE [A] TO BE STRAIGHT, SMOOTH, AND FREE OF BURRS, RIDGES AND OTHER PROCESSING DEFECTS.

4. A TWO DIA CONCENTRIC PLUG HAVING DIAMETERS OF .4998 AND .404 AND HAVING A FLAT .151 FROM E OF .404 DIA SHALL PASS THROUGH "O" SHAPED OPENING. LENGTH OF .4998 DIA SHALL BE .1875 MIN.

5. MATERIAL: CORROSION RESISTING STEEL, STAINLESS, TYPE 416, CONDITION A, ASTM A 582 EXCEPT: COPPER .50 MAX, CHROMIUM 12.00-13.50, PHOSPHORUS .04 MAX. MUST BE WORKABLE TO MINIMUM OF Rc 36 WHEN AIRCOOLED FROM 1800°-1850° F.

6. HEAT TREATMENT: BEFORE MACHINING, HEAT TO 1800°-1850° F. AIR COOL. TEMPER ONE HOUR AT HEAT TO BRINELL SPECIFIED. HEAT TREATMENT IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

7. FINAL PROTECTIVE FINISH: FINISH NO 3.3.2 OR 3.3.3 OF MIL-STD-111 WITH SUPPLEMENTARY PRESERVATIVE CONFORMING TO VV-L-800.

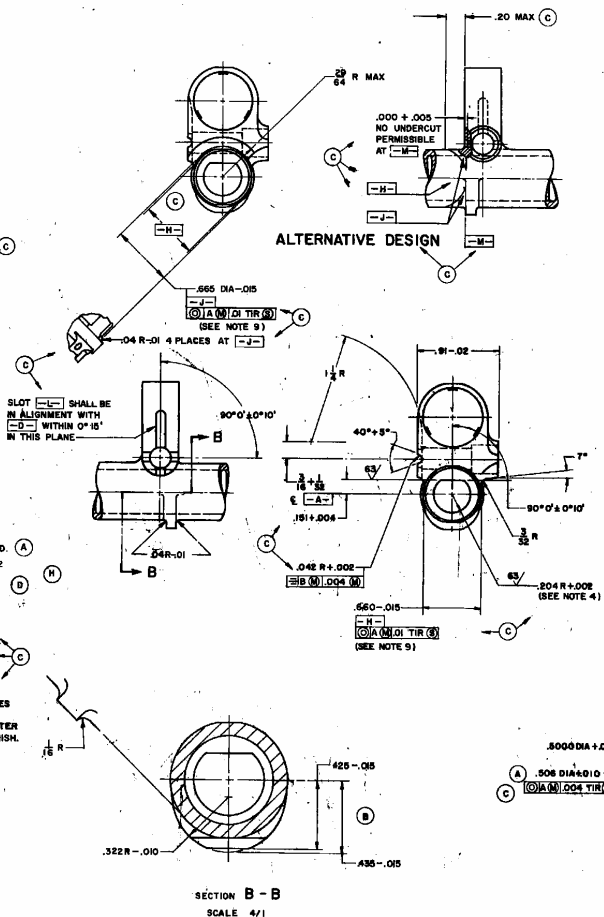
8. [E] IS ESTABLISHED BY A LINE THROUGH THE CENTERS OF HOLES [A] AND [C].

9. NO PORTION OF [E] SHALL FALL BELOW [H] REGARDLESS OF THE SIZES OF BOTH FEATURES AND THEIR CONCENTRICITY REQUIREMENTS RELATIVE TO [E].

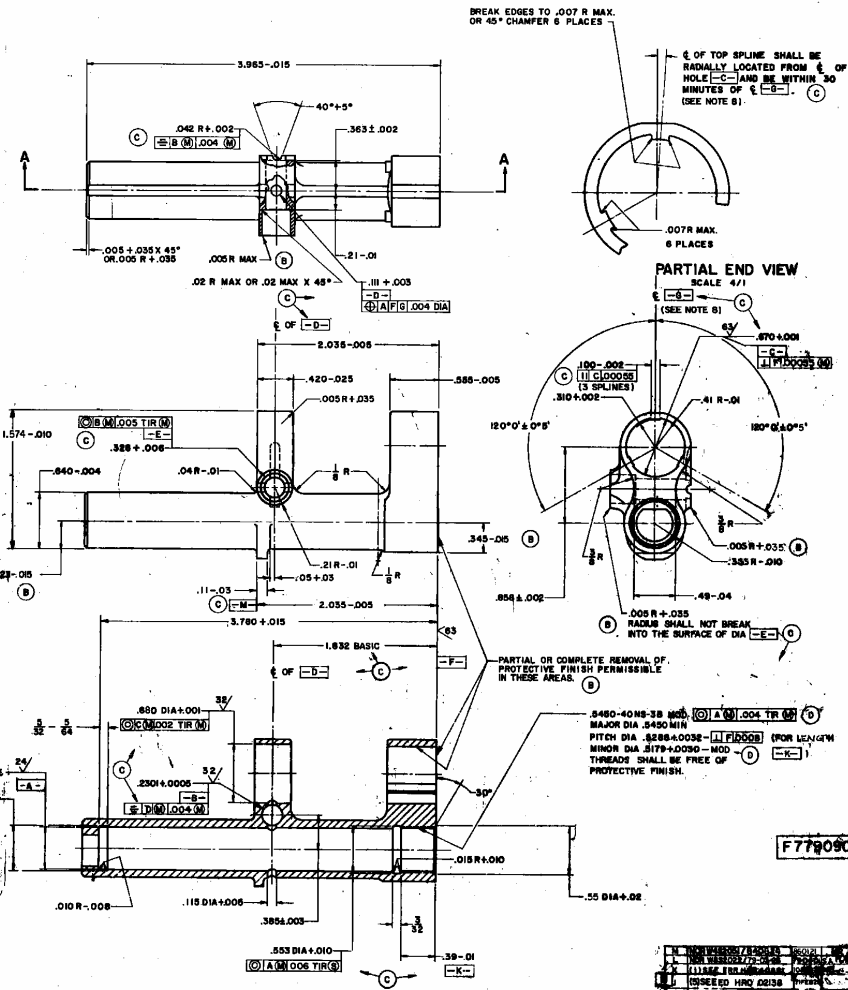
10. UNLESS OTHERWISE SPECIFIED, SURFACES REQUIRING 32 AND FINER ROUGHNESS HENRY RATING MAY BE PROCESSED AFTER APPLICATION OF FINAL PROTECTIVE FINISH. BRIGHT AREAS RESULTING FROM SUCH PROCESSING ARE PERMISSIBLE.

11. MIL-W-13855 SHALL APPLY.

ALTERNATIVE DESIGN



SECTION B-B  
SCALE 4/1



SECTION A-A

ORIGINAL DESIGN ACTIVITY FSCM NO. 19203

CURRENT DESIGN ACTIVITY FROM NO. 19203  
U.S. ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER  
DOWNEY, NEW JERSEY 07801

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