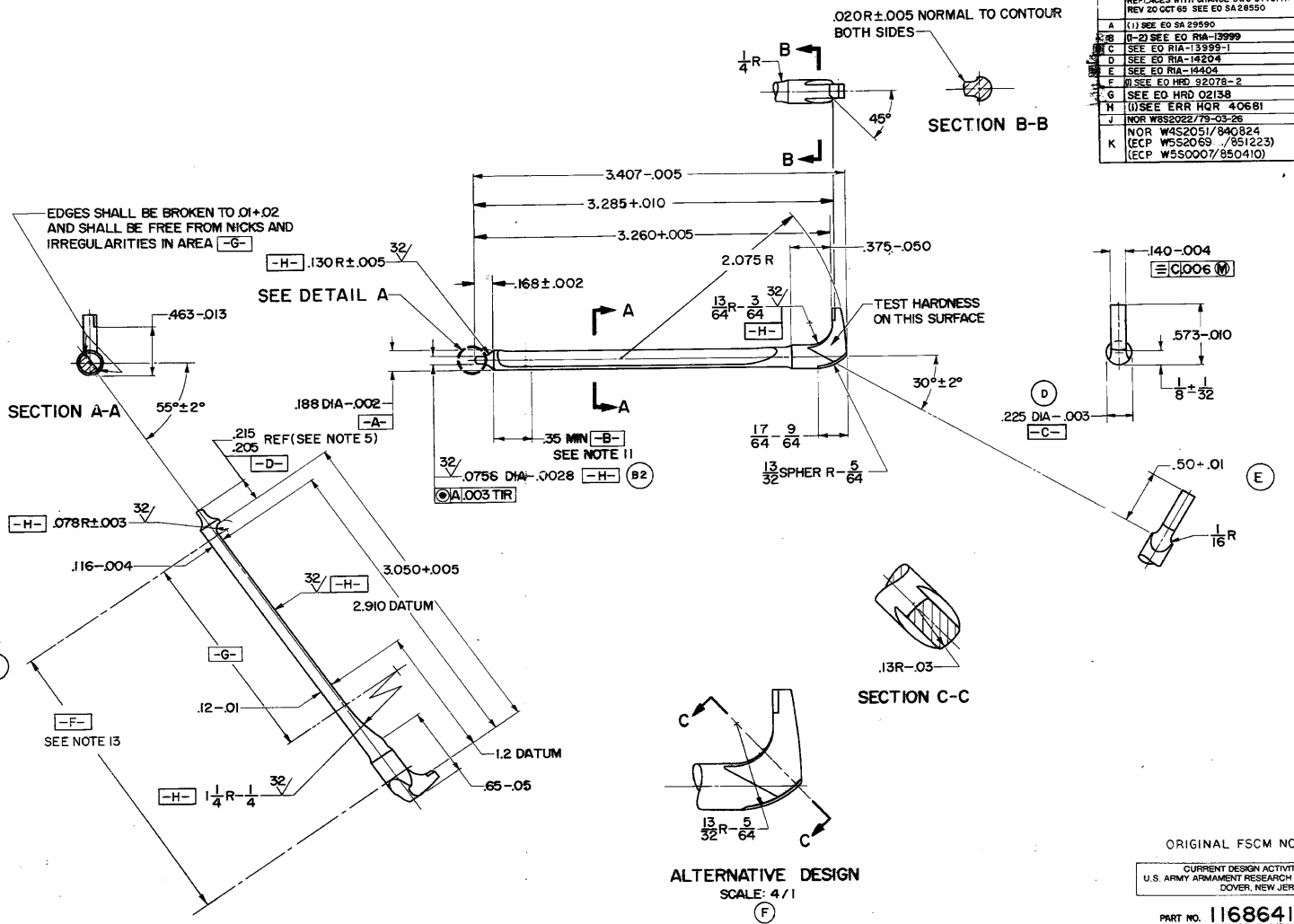
NOTES:

1. FINISH 63 EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. STEEL, ~~CMPSN 8640~~ OR 8645 OR 8740 SPHEROIDIZED; SPEC ASTM A304, A322, A331; AUSTENITE GRAIN SIZE 7 OR FINER.
4. HEAT TREATMENT: BEFORE CHROMIUM PLATING HEAT AT 1500°F TO 1550°F. OIL QUENCH. TEMPER 1 HOUR AT HEAT TO HARDNESS SPECIFIED. NO DECARBURIZATION PERMISSIBLE.
5. AREA [-D-] SHALL BE BUFFED BEFORE AND AFTER CHROMIUM PLATING.
6. FIRING PIN SHALL BE FREE FROM BURRS, PITS, ETC. PRIOR TO CHROMIUM PLATING.
7. STRAIGHTENING AFTER CHROMIUM PLATING IS NOT PERMISSIBLE.
8. AFTER CHROMIUM PLATING, FIRING PIN SHALL BE BAKED AT 375°F FOR 3 HRS MIN.
9. DIMENSIONS APPLY AFTER CHROMIUM PLATING.
10. DIA [-A-] FOR LENGTH [-B-] AND DIA [-C-] TO BE ON A COMMON CENTER. THE SECTION BETWEEN SHALL NOT BE MORE THAN .003 ECCENTRIC (.006 TIR)
11. REMOVE LATERAL & CIRCUMFERENTIAL LINES FROM SURFACES [-H-] BEFORE CHROMIUM PLATING.
12. CHROMIUM PLATING DISCOLORATION OR LACK OF CHROMIUM PLATING RESULTING FROM ELECTRODE CONTACT, NOT TO EXCEED .125 MAX LENGTH IS PERMISSIBLE IN AREA [-F-]. (A1)
13. THICKNESS OF CHROMIUM PLATING SHALL BE .0002 TO .0004 ON BODY, BUT MAY BE .0002 TO .0008 ON .168 TIP LENGTH (DETAIL A), AND END AREA WITHIN 17/64 LENGTH. (B1) (C)
14. MIL-W-13855 SHALL APPLY.

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
	REPLACES WITH CHANGE DWG D7791417 REV 20 OCT 65 SEE EO SA26550		
A	(1) SEE EO SA 29590	23 AUG 66	
B	(1-2) SEE EO RIA-13999	2-16-67	
C	SEE EO RIA-13999-1	4-6-67	
D	SEE EO RIA-14204	6-26-67	
E	SEE EO RIA-14404	9-18-67	
F	(1) SEE EO HRD 92078-2	25 JUN 69	
G	SEE EO HRD 02138	71 FEB 25	
H	(1) SEE ERR HQR 40681	10 FEB 75	
J	NOR W8S2022/79-03-26	79-04-01	
K	NOR W4S2051/840824 (ECP W5S2069 /851223) (ECP W5S0007/850410)	860121	



ORIGINAL FSCM NO. 19205

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

PART NO. 11686413

MECHANICAL PROPERTIES			
YP			
TS			
EL 2			
RA			
BH			
RH	C43 TO 48		

C7790187	RIFLE, M14	
	RIFLE, M14A1	
	RIFLE, M14NM	

NEXT ASSY | USED ON
APPLICATION
~~REPLY PART NO.~~

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ± .01 FRACTIONS ± 1/64 ANGLES ± 1°
MATERIAL SEE NOTE 3
HEAT TREATMENT SEE NOTE 4
FINAL PROTECTIVE FINISH FINISH 1.2.2 OF MIL-STD-171

ORIGINAL DATE OF DRAWING 20 OCT 65
DRAFTSMAN DSK CHECKER
TRACER DSK CHECKER
ENGINEER ENGINEER
SUBMITTED R.S. Henry
APPROVED J.A. Leuckhoven

~~DEPT OF THE ARMY~~
~~ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201~~

PIN, FIRING

DWG SIZE ~~FSCM NO.~~ 19200 11686413
D
SCALE 2/1 UNIT WT SHEET 1 OF 1

SWESP FORM NO. 1178-1
20 MAR 64 REV.