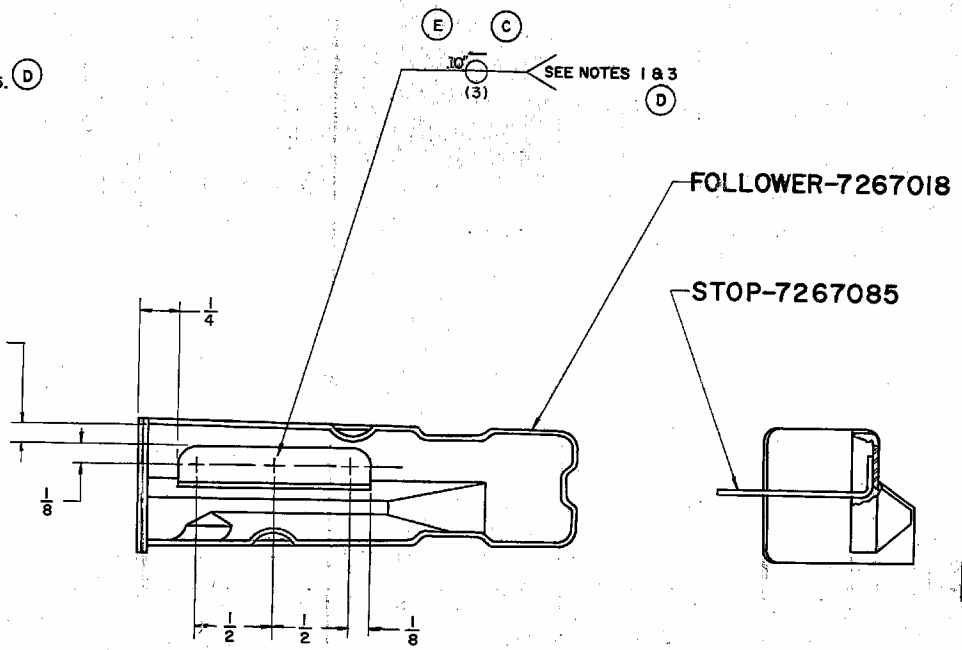
NOTES:

1. ALTERNATIVE TYPE WELD: PROJECTION. PROJECTIONS SHALL BE FORMED ON STOP-7267085. (D)
2. HEAT TREATMENT: CARBURIZE AT 1575°-1600°F FROM .005 TO .008 DEPTH. OIL QUENCH, TEMPER 30 MINUTES AT 375°F TO HARDNESS SPECIFIED.
3. WELD SHALL WITHSTAND PEEL TEST PER MIL-W-12332, EXCEPT THAT IN LIEU OF MINIMUM BUTTON DIAMETER REQUIREMENT THE WELD SHALL BE SATISFACTORY IF THE PEEL TEST CAUSES TEARING OF THE BASE METAL AROUND THE PERIPHERY OF THE WELD.
4. HEAT TREATMENT METHOD (SEE NOTE 2) IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER. (D) (J)
5. MIL-W-13855 SHALL APPLY.
6. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171. (G1) (L)



C7267019

ORIGINAL FSCM NO. 19205

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

REVISIONS			
STA	DESCRIPTION	DATE	APPROVED
N	ECPW5S2069 /851223 NORW4S2051/840824	860121	
M	NOR WBS2022/79-03-26	79-0490	SA01/11
L	(1) SEE ERR HQR 40681	10 FEB 75	
K	SEE EO HQR 10609	71MAY29	
J	SEE EO HRD 02138	71FEB 25	
H	(1) SEE EO HRD 92078-2	25JUN69	
G	(1-2) SEE EO 82048	11MAR68	
F	(1) SEE EO SA 29261	18MAY66	
E2	SEE EO SA 26221	11 MAR66	
D4	SEE EO SA 25971	23DEC65	
C	SEE EO SA 24863	23OCT56	
B	REDRAWN AND REVISED	12JUN56	
	SEE EO SA 24622		
A		10JAN55	

(J) (H) (F1) (G2)

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7267019 (D) (E)

~~CODE IDENT NO. 19204~~ PART NO. 7267019

PHYSICAL PROPERTIES			
.XX			
.X3		RIFLE, M14NM	
.X2	D7790183	RIFLE, M14	
RR			
RH	NEXT ASSY	USED ON	
RH	APPLICATION		
RH	SEE NOTE 5	DO NOT APPLY PART NO.	
	FILE HARD	DO	

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ± .01
ANGLES ± 1/64
MATERIAL
HEAT TREATMENT SEE NOTE 2 & 4
FINAL PROTECTIVE FINISH: SEE NOTE 6

ORIGINAL DATE OF DRAWING 18 OCT 1954
DRAFTSMAN D.F.B. CHECKER J.K.
TRACER G.M. CHECKER J.K.
ENGINEER ENGINEER
SUBMITTED R.S. Henry ORD CORPS
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE H.F. Lynch ORD CORPS

FOLLOWER ASSY, MAGAZINE

DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND ILL
SIZE 7267019
C
SCALE 2/1 UNIT WT.
SHEET 1 OF 1
RMA