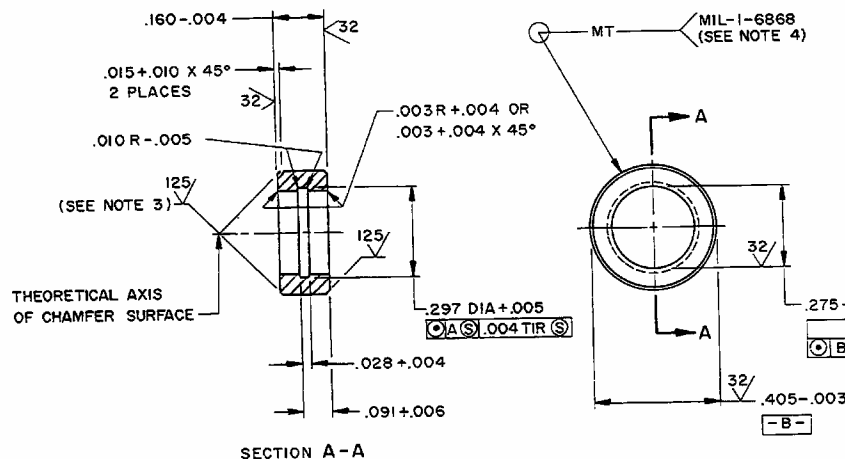


WHEN GOVERNMENT DRAWINGS SPECIFY A FINISH, IT IS TO BE USED FOR ANY RELATED PARTS. IF A FINISH IS SPECIFIED FOR A PART, IT IS TO BE USED FOR ANY RELATED PARTS. IF A FINISH IS SPECIFIED FOR A PART, IT IS TO BE USED FOR ANY RELATED PARTS.

#### NOTES:

1. FINISH  $\nabla 63$  EXCEPT AS NOTED.
2. HEAT TREATMENT: HEAT AT 1550°F TO 1575°F IN A NEUTRAL ATMOSPHERE. QUENCH IN BRINE. IMMEDIATELY AFTER QUENCHING, TEMPER ONE HOUR AT 275°F MINIMUM. FINISH MACHINE AFTER INITIAL TEMPERING, THEN RE-TEMPER AT 300°F FOR TWO HOURS. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT HARDNESS AND TEMPERING TIMES AND TEMPERATURES SPECIFIED ARE MANDATORY. NO CARBURIZATION OR DECARBURIZATION PERMISSIBLE.
3. SURFACE PATTERN LAY OF BOTH CHAMFERS ON DIA  $\nabla 8$  SHALL BE APPROXIMATELY CONCENTRIC TO THE THEORETICAL AXIS OF THE CHAMFER SURFACE.
4. AFTER HEAT TREATMENT, ROLLERS SHALL BE FREE FROM CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS AS DETERMINED BY MAGNETIC PARTICLE INSPECTION USING CIRCULAR AND LONGITUDINAL MAGNETIZATION, CONTINUOUS WET METHOD AT 450 TO 500 AMPS.
5. MIL-W-13855 SHALL APPLY.



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
E		11 MAR 63	
F	REDRAWN AND REVISED		
G	SEE EO SA 26910	26 AUG 63	
H	(1) SEE EO SA 29261	18 MAY 66	
I	SEE EO 82048	11 MAR 68	
J	SEE EO HRD 92078-2	25 JUN 69	
K	SEE EO HRD 02138	7 FEB 75	
L	NOR WBS2022/79-03-26	79-04-01	
M	NORW4S2051/840824 (ECPW5S2069 / 851223)	860121	
N	NORG2S2038/921021 (ECPG2S2042/ 921021)	921230	RR

ORIGINAL FSCM NO. 19205

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

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MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 17 SEP 54		SPRINGFIELD ARMOERY U.S. ARMY WEAPONS COMMAND	
YP		TOLERANCES ON DECIMALS $\pm .01$		DRAFTSMAN G.V.S.	CHECKER R.H.S.	ROLLER, BOLT	
TS		FRACTIONS $\pm$ ANGLES $\pm 1^\circ$		TRACER B.T.	CHECKER EPS		
EL 2		MATERIAL TOOL STEEL, ALLOY ASTM A681, TYPE S2		ENGINEER	ENGINEER		
RA		HEAT TREATMENT SEE NOTE 2		SUBMITTED			
BH		NEXT ASSY USED ON	FINAL PROTECTIVE FINISH NONE	APPROVED		DWG SIZE 7267065	
RH	45N64-67	DO NOT APPLY PART NO		SCALE 4/1		UNIT WT	SHEET 1 OF 1
AS SPECIFIED				PDC			