

NOTES:

1. EACH RIFLE SHALL WITHSTAND THE FIRING OF ONE GOVERNMENT STANDARD HIGH PRESSURE TEST CARTRIDGE WITHOUT EVIDENCE OF FAILURE. APPLY PROOF MARK TO RIFLES MEETING THIS REQUIREMENT.
2. AFTER COMPLETION OF ALL FIRING TESTS (HIGH PRESSURE RESISTANCE, FUNCTION FIRING, AND TARGETING AND ACCURACY) PER SAPD-260, EACH BOLT AND ROLLER ASSEMBLY C7790186 SHALL BE FREE OF EVIDENCE OF FAILURE AS DETERMINED BY MAGNETIC PARTIAL INSPECTION FOR CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS, IN ACCORDANCE WITH METHOD SPECIFIED ON DRAWING C7790186. APPLY MPI MARK TO ASSEMBLY AS SHOWN ON C7790186 MEETING THIS REQUIREMENT. AFTER CLEANING THE ASSEMBLY THE ROLLER SHALL BE PACKED WITH GREASE CONFORMING TO MIL-G-10924.

THE APERTURE ASSEMBLY PROVIDES 1/2 MINUTE OF ANGLE ELEVATION ADJUSTMENT. THE PEEPHOLE SIZE SHALL BE .0595 DIA.

THE BASE, REAR SIGHT PROVIDES 1/2 MINUTE ANGLE OF WINDAGE ADJUSTMENT. REAR SIGHT MARKINGS MUST BE DISTINCT.

ELEVATING KNOB MUST BE ON 100 METER SETTING WHEN APERTURE IS ELEVATED 8 CLICKS FROM LOWEST POSITION.

KNOBS MUST HAVE FREE MOVEMENT, INDEPENDENT OF EACH OTHER, DEFINITE CLICKING ACTION, AND POSITIVE RETENTION.

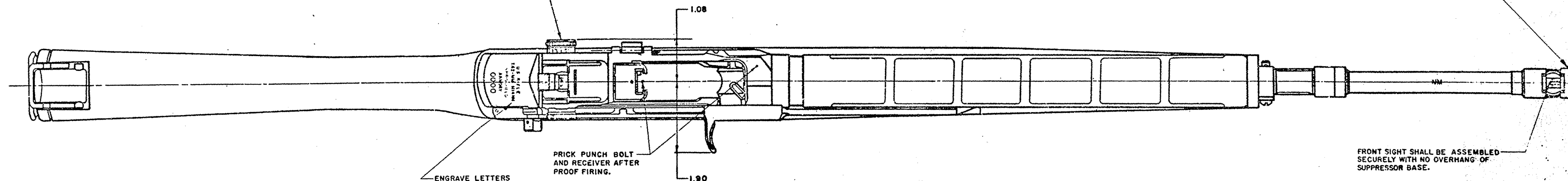
APERTURE ASSEMBLY SHALL OPERATE SMOOTHLY IN BASE, REAR SIGHT WITH NO PERCEPTIBLE SIDE MOVEMENT WHEN SET AT 600 METER SETTING. PREFERENTIAL ASSEMBLY OF APERTURE ASSEMBLY AND BASE, REAR SIGHT SHALL BE EFFECTED AS NECESSARY TO MEET ABOVE REQUIREMENTS.

WHEN NECESSARY EQUAL AMOUNTS OF MATERIAL SHALL BE REMOVED FROM BOTH SIDES OF APERTURE TO OBTAIN THE REQUIRED FIT.

BRIGHT SURFACES RESULTING FROM FITTING THE APERTURE ARE PERMISSIBLE. WHEN APERTURE ASSEMBLY IS ELEVATED TO ITS HIGHEST POSITION AND THUMB PRESSURE IS APPLIED TO BOTTOM OF EYEPIECE IN A VERTICAL PLANE AWAY FROM THE WEAPON, SPRING TENSION OF COVER MUST RETURN THE APERTURE ASSEMBLY TO ITS ORIGINAL POSITION.

SCREW, REAR SIGHT SHALL BE TIGHTENED WITHIN 20 TO 25 INCH LBS. SIGHT MUST BE FREE OF EXCESS OIL.

THE FLASH SUPPRESSOR SHALL BE FASTENED TO THE BARREL WITH NO ROTATIONAL OR LONGITUDINAL MOVEMENT. IN ASSEMBLY THE NUT WITH EVENLY SPACED NOTCHES ROTATED IN A CLOCKWISE DIRECTION SIMULTANEOUSLY AND POSITIONING ONE OF THE NOTCHES AT THE TWELVE O'CLOCK POSITION. THE NUT SHALL NOT BE BACKED OFF TO ALIGN THE NUT SHALL BE LOCKED SECURELY BY THE SET SCREW EITHER GAGE C1015429 OR C1015430 SHALL ENTER THE UP TO THE HANDLE OF THE GAGE AND THE .329 DIA OF IT SHALL NOT TOUCH THE FLASH SUPPRESSOR. GAGE C1015430 BE USED WHEN THE BORE DIA IS .3005 OR SMALLER. GAGE C1015429 SHALL BE USED WHEN THE BORE DIA IS .3006 OR LARGER. FLASH SUPPRESSOR SHALL BE SELECTIVELY ASSEMBLED TO EACH ABOVE REQUIREMENT.

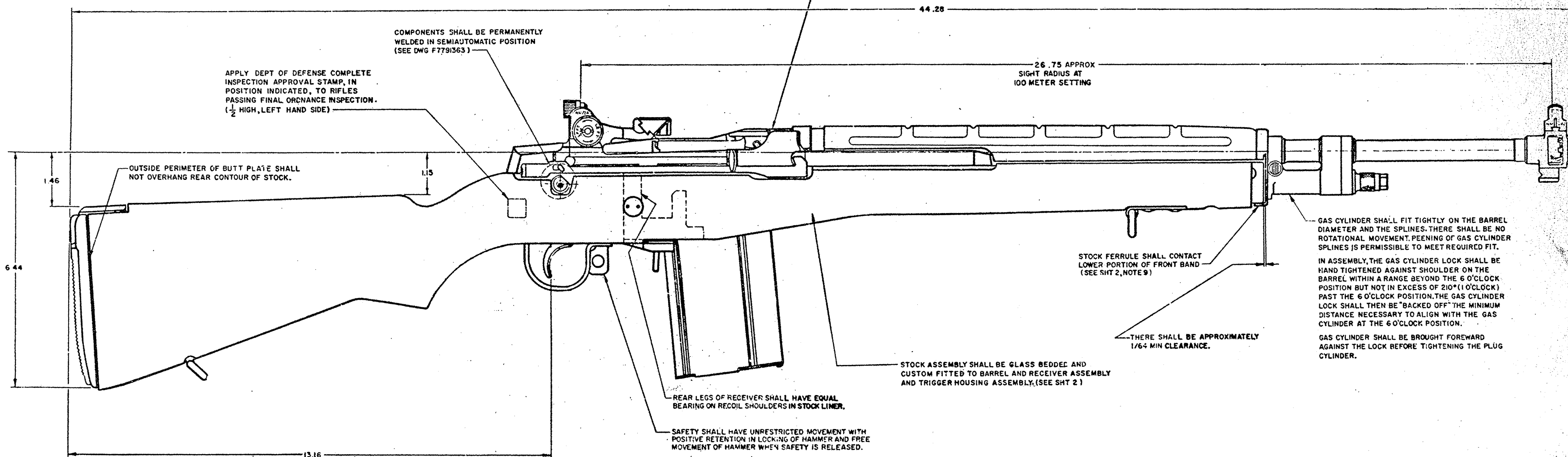


FRONT SIGHT SHALL BE ASSEMBLED SECURELY WITH NO OVERHANG OF SUPPRESSOR BASE.

WITH THE FIRING MECHANISM, STOCK ASSEMBLY, OPERATING ROD SPRING AND SPRING GUIDE DISASSEMBLED FROM THE RIFLE, AND WITH THE MUZZLE RAISED TO AN ANGLE OF APPROXIMATELY 60° FROM THE HORIZONTAL, THE BOLT, WITH OPERATING ROD ASSEMBLED, SHALL OPEN FULLY WITHOUT ANY MANUAL ASSISTANCE. WHEN THE MUZZLE IS LOWERED TO AN ANGLE OF APPROXIMATELY 60° FROM THE HORIZONTAL, THE BOLT, WITH OPERATING ROD ASSEMBLED, SHALL CLOSE FULLY WITHOUT ANY MANUAL ASSISTANCE.

ENGRAVE LETTERS "NM" 1/16 HIGH PER MIL-STD-130

AFTER PROOF FIRING, THE HEADSPACE AT 400 DATUM DIA, WITH COMPONENT BOLT, SHALL BE FROM 1.6355 MIN TO 1.6385 MAX.



APPLY DEPT OF DEFENSE COMPLETE INSPECTION APPROVAL STAMP, IN POSITION INDICATED, TO RIFLES PASSING FINAL ORDNANCE INSPECTION. (1/2 HIGH, LEFT HAND SIDE)

COMPONENTS SHALL BE PERMANENTLY WELDED IN SEMIAUTOMATIC POSITION (SEE DWG F7791363)

26.75 APPROX SIGHT RADIUS AT 100 METER SETTING

OUTSIDE PERIMETER OF BUTT PLATE SHALL NOT OVERHANG REAR CONTOUR OF STOCK.

STOCK FERRULE SHALL CONTACT LOWER PORTION OF FRONT BAND (SEE SHT 2, NOTE 9)

THERE SHALL BE APPROXIMATELY 1/64 MIN CLEARANCE.

STOCK ASSEMBLY SHALL BE GLASS BEDDED AND CUSTOM FITTED TO BARREL AND RECEIVER ASSEMBLY (SEE SHT 2)

REAR LEGS OF RECEIVER SHALL HAVE EQUAL BEARING ON RECOIL SHOULDERS IN STOCK LINER.

SAFETY SHALL HAVE UNRESTRICTED MOVEMENT WITH POSITIVE RETENTION IN LOCKING OF HAMMER AND FREE MOVEMENT OF HAMMER WHEN SAFETY IS RELEASED.

GAS CYLINDER SHALL FIT TIGHTLY ON THE BARREL DIAMETER AND THE SPLINES. THERE SHALL BE NO ROTATIONAL MOVEMENT. PEENING OF GAS CYLINDER SPLINES IS PERMISSIBLE TO MEET REQUIRED FIT.

IN ASSEMBLY, THE GAS CYLINDER LOCK SHALL BE HAND TIGHTENED AGAINST SHOULDER ON THE BARREL WITHIN A RANGE BEYOND THE 6 O'CLOCK POSITION BUT NOT IN EXCESS OF 210° (1 O'CLOCK) PAST THE 6 O'CLOCK POSITION. THE GAS CYLINDER LOCK SHALL THEN BE "BACKED OFF" THE MINIMUM DISTANCE NECESSARY TO ALIGN WITH THE GAS CYLINDER AT THE 6 O'CLOCK POSITION.

GAS CYLINDER SHALL BE BROUGHT FORWARD AGAINST THE LOCK BEFORE TIGHTENING THE PLUG CYLINDER.

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