

1. FINISH 125/ EXCEPT AS NOTED.
2. ALL EDGES AND CORNERS SHALL BE BROKEN .005+-.010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, SPEC ASTM A304, A322, A331; 8620 EXCEPT; SULPHUR .035-.050 (RESULPHURIZED), AUSTENITIC GRAIN SIZE 5 OR FINER.

4. HEAT TREATMENT: NORMALIZE BEFORE MACHINING. CARBURIZE AT 1600°F \pm 25°F FROM .008 TO .012 DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350°F TO 375°F. HEAT TREATMENT METHOD 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 PROCESSES SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.

5. LINE -F- PASSES THROUGH THE THEORETICAL APEX FORMED BY SURFACES -J- AND -K-.

6. MIL-W-13855 SHALL APPLY.

7. FINAL PROTECTIVE FINISH:- FINISH 5.3.1.2
OR 5.3.2.2 OF MIL-STD-171 LIGHT
GRITBLAST PERMISSIBLE

VERTICAL C'S OF HOLES A
SHALL COINCIDE WITHIN .003-

.080 +.015

.120 ±.004

.02 R-02 —

.04

DETAIL B
SCALE 10/1

- THIS CORNER SHALL
BE SHARP AND SMOOTH
BOTH SIDES

THESE SURFACES SHALL BE
IN ALIGNMENT WITH EACH
OTHER WITHIN .002, WITHIN
DIMENSIONAL LIMITS, AND
90°0' ± 0°10' FROM
SURFACE - E -

THIS SURFACE SHALL
BE SMOOTH, FLAT AND
90° 0' ± 0° 10' FROM C [-]

SECTION A-A

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

ORIGINAL FSCM NO.19205

CODE IDENT NO. ~~19204~~
PART NO. 5546020

PHYSICAL PROPERTIES		(H) (E)		PART NO. 5546	
72	07267090	RIFLE,M16	USE OR DISPOSE (SEE INSTRUCTIONS) USE OR DISPOSE		ORIGINAL DATE 2 AUG 37
73		RIFLE,M16,M4M	TOLERANCES UNLESS OTHERWISE SPECIFIED		COORDINATOR
74			ANGLE 1/2" 1/4" 1/8" 1/16"		DESIGNER
75	53460626	RIFLE,M16,M4M	NATURAL		CHUCKER 222
76			SEE NOTE 3		TRACER 2-9-2
77			HEAT TREATMENT		FINISHER
78			SEE NOTE 4		SUBMITTER
79			APPLICATION		<i>R.D. Henry</i>
80	DO NOT	APPLY PARTS	IMMEDIATE PROTECTIVE FINISH		APPROVED BY ORS AND CORP
81	SEE NOTE 6	FILE HARD	SEE NOTE 7		CHG 222

[illegible]

TRIGGER

D5546020