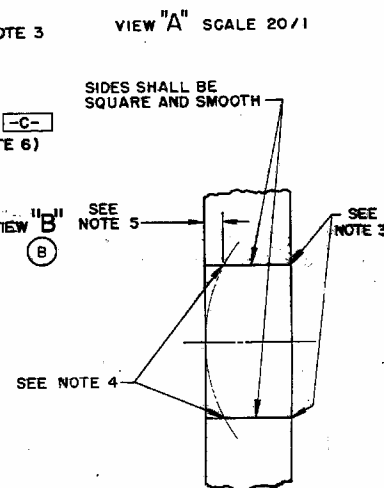
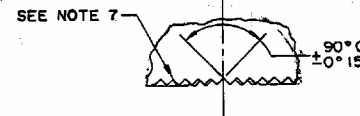
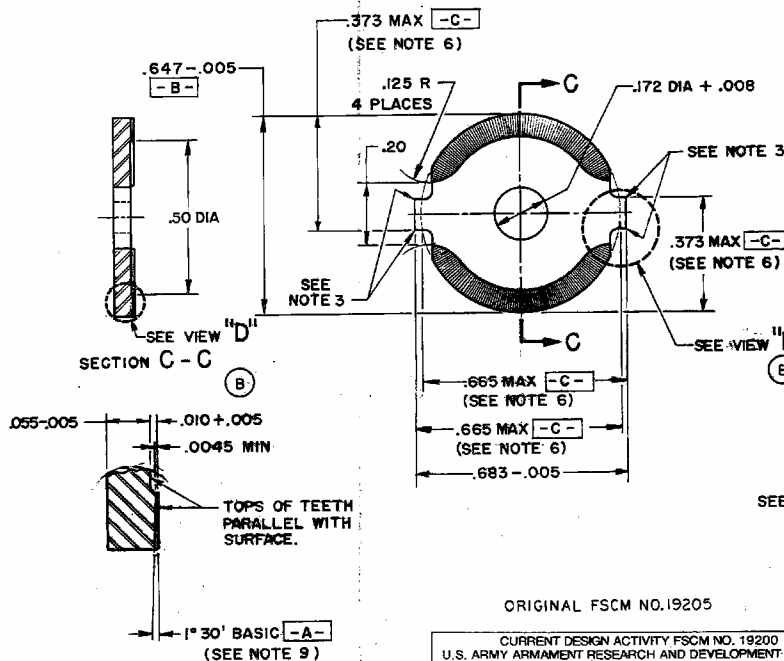
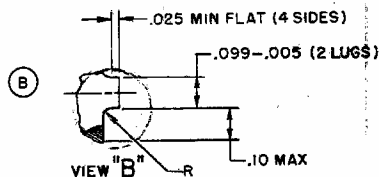


NOTES:

- 1.- FINISH $\sqrt{}$
- 2.- ALL CORNERS AND EDGES SHALL BE FREE FROM BURRS WITH MAX RADIUS OF .005 UNLESS OTHERWISE SPECIFIED.
- 3.- THESE EDGES SHALL BE SHARP TO .010 R MAX AND FREE FROM BURRS.
- 4.- RESULTANT CORNERS SHALL BE WELL DEFINED AND FREE FROM TEARS.
- 5.- .013 MAX DEFORMATION RESULTING FROM PUNCHING AND CONING PERMISSIBLE ONE SURFACE ONLY, EITHER TOP OR BOTTOM.
- 6.- DIMENSIONS LABELED -C- APPLY AT MAX DIA -B-.
- 7.- 100 SERRATIONS IN 360 DEGREES. SERRATIONS SHALL BE RADIAL (CHECK FROM DIM -B-) AND EQUIDISTANT. WHEN SERRATIONS OF ONE DOG ARE MESHED WITH SERRATIONS OF ANOTHER DOG, THE DEPTH OF ENGAGEMENT SHALL BE .004 MIN ALL AROUND THE SERRATED PORTIONS AND DIM -B- OF ONE SHALL BE CONCENTRIC WITH DIM -B- OF THE OTHER WITHIN .003.
- 8.- HEAT TREATMENT: CARBURIZE AT 1550°-1600°F FROM .008 TO .012 DEPTH. OIL QUENCH TEMPER ONE HOUR AT HEAT TO ROCKWELL SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TEMPERING TIME 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.
- 9.- ANGLE -A- SHALL BE ADJUSTED AS NECESSARY TO PROVIDE CRESTS, UNIFORM IN WIDTH FOR THE LENGTH OF THE SERRATIONS.
10. MIL-W-12855 SHALL APPLY.



REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
A	REDRAWN WITH CHANGE, WAS "A" SIZE. SEE EO 5A 27606	7 SEP 65	<i>D. Cole</i>
B	(1-6) SEE EO 82048	11 MAR 68	<i>P. Williams</i>
C	(1) SEE EO HRD 92078-2	25 JUN 69	<i>W. H. Hays</i>
D	SEE EO HRD 02138	71 FEB 25	<i>D. Cole</i>
E	NOR WSS2022/79-03-26	79-04-01	<i>S. A. Cole</i>
F	NORW452051/840824 FCPW52069, /851223)	860121	<i>W. H. Hays</i>

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 10 JUL 58		DEPT OF THE ARMY US ARMY WEAPONS COMMAND ROCK ISLAND, ILL 62206	
YP		RIFLE, M14MM	TOLERANCES ON DECIMALS ± .01	DRAFTSMAN	CHECKER	DOG, INDEXING	
TS	C11010362	RIFLE, M14	FRACTIONS ± ANGLES ±	HWF	RMS		
EL 2		.30R MI.	MATERIAL	TRACER	NWS		
RA		MIC & MID	STEEL, FED SPEC QQ-5-698:	CHECKER	NJA		
BH			CARBON .08 TO .18 %, KILLED	ENGINEER	W. J. Cole		
			HEAT TREATMENT	SUBMITTED			
		NEXT ASSY	USED ON	D. J. Cole			
RH	15N 63-72	APPLICATION		APPROVED		DWG SIZE	
		-APPLY POINT-WELD		R. S. Henry		CODE IDENT NO.	
		SEE NOTE 8				C 19204	
		FINAL PROTECTIVE FINISH				7267097	
		AT ASSEMBLY.				SCALE 4/1 UNIT WT	
						SHEET 1 OF 1	