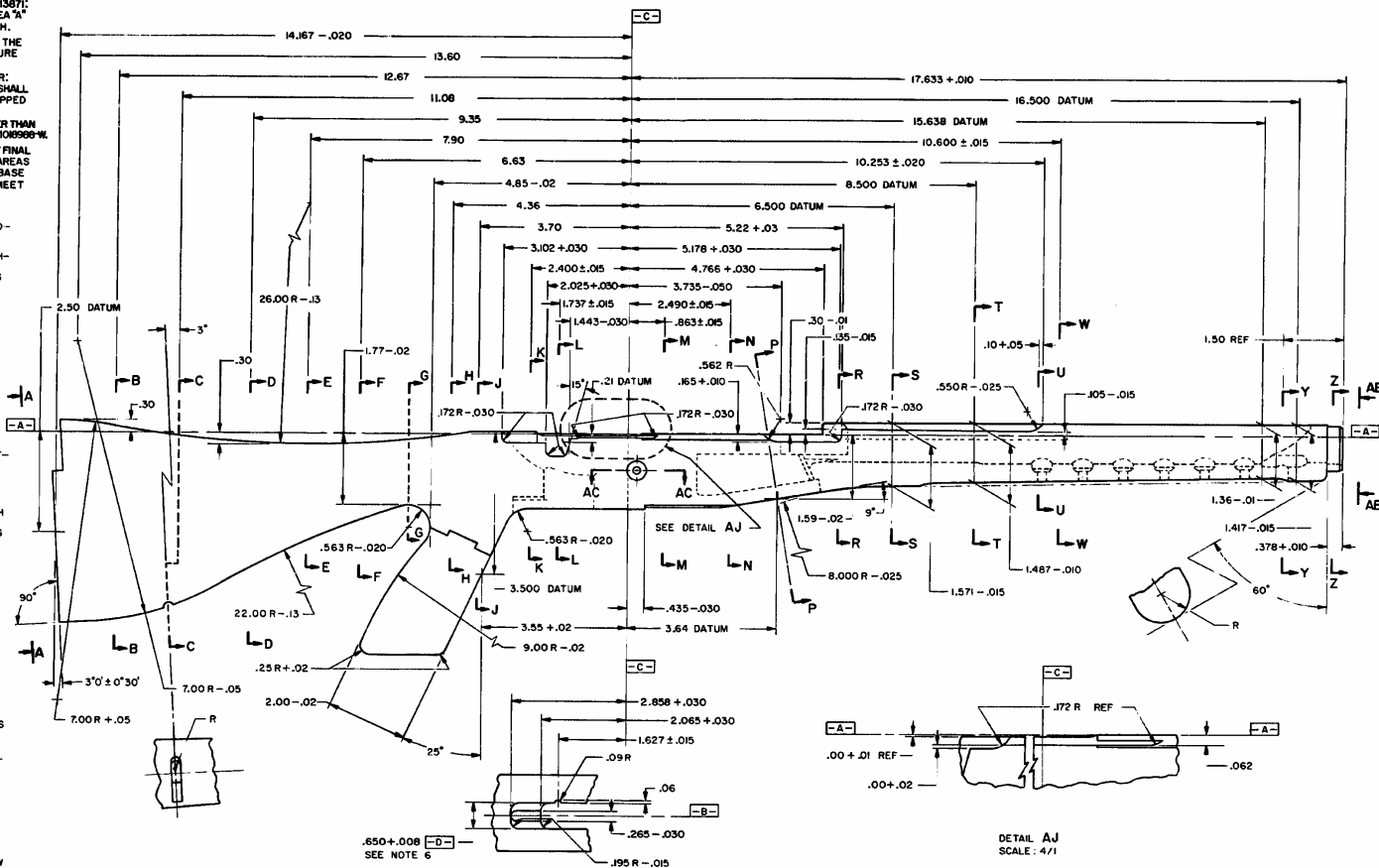


NOTES:

1. UNLESS OTHERWISE SPECIFIED, CORNERS AND EDGES SHALL BE BROKEN .01 MAX AND FILLETS SHALL BE .01 R MAX.
2. MATERIAL: WOOD SPEC MIL-W-13871; TYPE (NATURAL) CRITICAL AREA "A" (FILL) SHALL BE 25 1/2 INCH.
3. ALL DIMENSIONS APPLY WHEN THE STOCK HAS 6% TO 8% MOISTURE CONTENT.
4. PROTECTIVE FINISH AND COLOR: A. FINAL PROTECTIVE FINISH SHALL BE NO. 29.7 OF MIL-STD-171 (DIPPED MINIMUM OF 3 MINUTES). B. NO AREAS SHALL BE LIGHTER THAN COMPARISON COLOR GAGE NO. 1009888-W. C. PRIOR TO APPLICATION OF FINAL PROTECTIVE FINISH, LIGHT AREAS SHALL BE STAINED (SPIRIT BASE STAIN) AS NECESSARY TO MEET COLOR REQUIREMENT.
5. AFTER APPLICATION OF PROTECTIVE FINISH STOCKS SHALL BE FREE FROM CROCK, SPOTS, GLOSSY PATCHES, LIGHT STREAKS, RUNS, CONTACT MARKS, STICKINESS AND CRAZING. EXTERIOR STOCK CONTOURS SHALL BE SMOOTH AND EXHIBIT NO BUILD-UP OR RAISED GRAIN.
6. DIMENSIONS \boxed{D} SHOWN ON SHEET 1 ZONE A-6 AND SHEET 2 ZONE D-5 ARE IDENTICAL DIMENSIONS.
7. .00+.01 MISMATCH PERMISSIBLE BETWEEN RADIUS \boxed{H} , SHEET 2 ZONE A-3, AND PLANE \boxed{G} , SHEET 2 ZONE B-3.
8. JOINT BETWEEN HANDGrip AND STOCK MAY BE ADJUSTED WITHIN AREA \boxed{K} , SHEET 2 ZONE C-7.
9. DOWEL, BIRCH, MAPLE, OR WALNUT, SPIRAL GROOVED, APPROX 1/4 INCH PITCH WITH TWO LONGITUDINAL GROOVES 180° APART, .50 DIA X 5.5 LONG SHALL BE FITTED INTO DIA \boxed{F} . DOWEL SHALL BE FINISHED FLUSH WITH BOTTOM SURFACE \boxed{J} .
10. ADHESIVE SHALL CONFORM TO FED. SPEC MM-M-A-181. APPLICATION OF ADHESIVE SHALL BE IN ACCORDANCE WITH MANUFACTURERS SPECIFICATIONS.
11. DATUM PLANE \boxed{A} ESTABLISHED AT INTERSECTIONS OF DIMENSION \boxed{E} AND ANGLE \boxed{L} (SEE SECTION M-M, SHEET 3 ZONE C-3) EXTENDS FROM BUTT END TO MUZZLE END OF STOCK.
12. DATUM PLANE \boxed{B} IS ESTABLISHED BY CENTERLINE OF DIMENSION \boxed{M} (VIEW AB-AB SHEET 3 ZONE A-6) AND CENTERLINE OF DIMENSION \boxed{E} (SHEET 2 ZONE E-4) AND EXTENDS TO BUTT END OF STOCK.
13. VIEW A-A AND SECTIONS B-B THRU B-D, SECTION Z-Z, VIEW AB-AB AND SECTIONS AE-AE THRU AH-AH ARE SYMMETRICAL ABOUT \boxed{B} .
14. DATUM LINE \boxed{P} ORIGINATES AT THE INTERSECTION OF DATUM LINE \boxed{A} AND SURFACE \boxed{N} AND IS PERPENDICULAR TO SURFACE \boxed{R} .



REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
1	REPLACES WITH CHANGE NO. 1779821 150 9 APR 66 SEE E.O. 1158943		

PART NO. 11686526			
U.S. ARMY SPRINGFIELD ARMOY SPRINGFIELD, MASS. 01101			
STOCK, GUN, SHOULDER			
DATE SENT NO. 19205 F	DATE SENT NO. 11686526		
REASON (U)	REASON (U)		

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			ORIGINAL DATE 8 APR 66	
TY	F11686527	RIFLE	M44E2	TOLERANCES ON DIMENSIONS	± .01	DATE OF DRAWING
TR				FINISHES	AS SHOWN	MAKER
CL				MATERIAL	SEE NOTE 2	REVIEWER
PL	SEE ENGINEERING RECORDS			HEAT TREATMENT	SEE NOTE 4	APPROVER
BN	HEAT TREATMENT			FINAL PROTECTIVE FINISH	SEE NOTE 4	
PH	APPROX. 100-100					