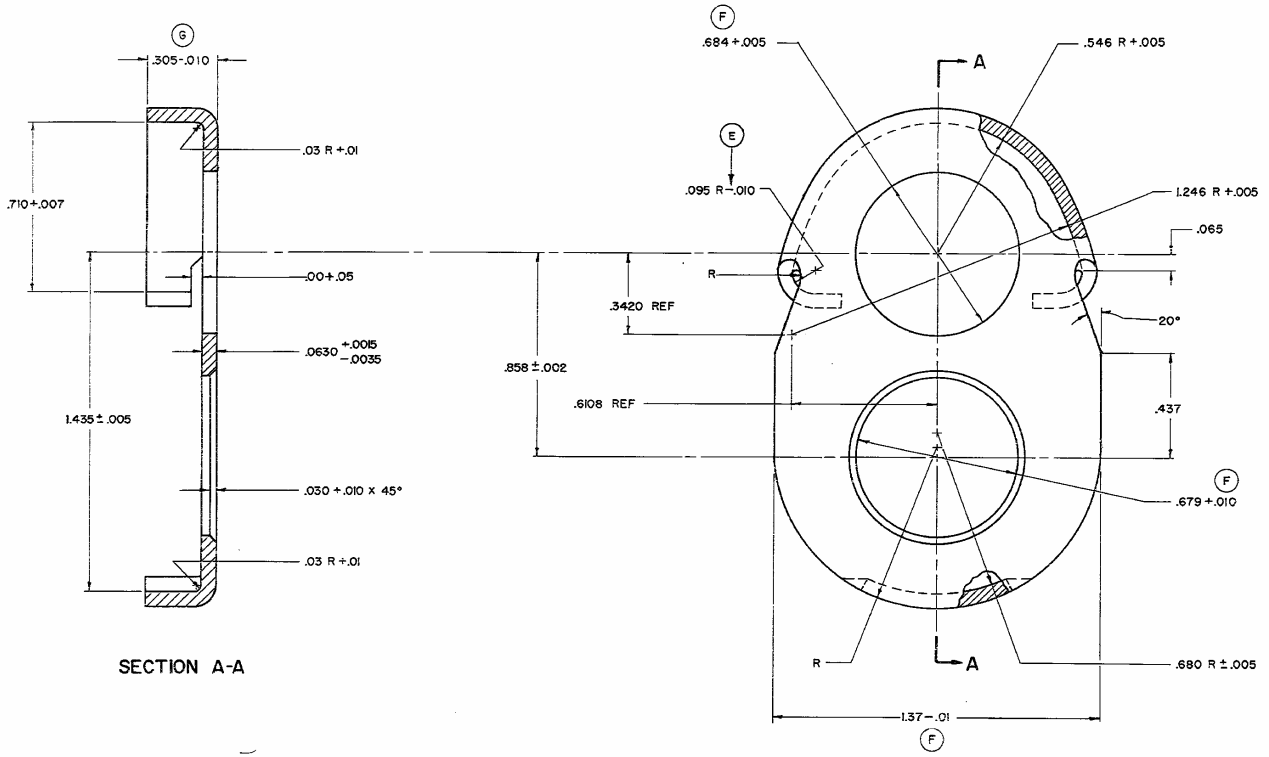
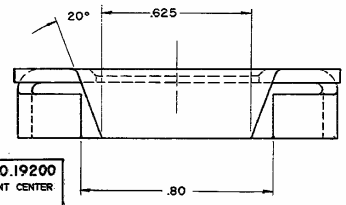
NOTES:

1. FINISH 125/ ALL OVER. (M)
2. ALL EDGES SHALL BE BROKEN .005 +.010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, SPEC QQ-S-700: (M) GRADE 1035,1050; DRAWING QUALITY. (G)
4. HEAT TREATMENT:
   - FOR 1035, 1050; HEAT AT 1525°F TO 1550°F. OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO ROCKWELL C30-35.
   - FOR .17/.24 CARBON STEEL; CARBURIZE AT 1575°F TO 1600°F FROM .005 TO .008 DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350°F TO 425°F: FILE HARD.

   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 PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. MIL-W-13855 SHALL APPLY. (J3) (L)



D7267001



(J1)

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

ORIGINAL DESIGN ACTIVITY FSCM NO.19205

(H1) ~~CODE IDENT NO. 19204~~

PART NO. 7267001

SYM	DESCRIPTION	DATE	APPROVAL
R	NOR W4S2051/840824	860121	MR
P	NORW2S2025 22/84 0210	84-04-20	
N	NOR W8S2022/79-03-26	79-04-01	S.A.
M	(3) SEE ERR HQR 40681	10 FEB75	
L	SEE EO HRD 02138	71 FEB25	
K	(1) SEE EO HRD 92078-2	25 JUN69	
J	(1-3) SEE EO 82048	11 MAR68	
H	(1-2) SEE EO SA29261	18 MAY66	
G3	SEE EO SA 26457	11 MAR63	
F3	SEE EO SA 25156	1 JUN 59	
E	SEE EO SA 24763	12 SEP 58	
D	REDRAWN AND REVISED SEE EO SA24529	10 JUL 58	
C		1 DEC54	

REVISIONS

(J2) (H2) (K) (G) (L) (M)

PHYSICAL PROPERTIES			
YP			
TS			
EL 2		F7267000	RIFLE, M14
PA			
BH		NEXT ASSY	USED ON
	SEE NOTE 4 & 5	APPLICATION	
	FILEHARD	DO NOT	APPLY PART NO.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±.01 ANGLES ±3° FRACTIONS
MATERIAL SEE NOTE 3
HEAT TREATMENT SEE NOTE 4
FINAL PROTECTIVE FINISH FINISH NO. 5.3.1.2 OF MIL-STD-171

ORIGINAL DATE OF DRAWING 17 SEP 1954
DRAFTSMAN AUA CHECKER
TRACER CHECKER
ENGINEER ENGINEER
SUBMITTED R.S. Henry ORD CORPS
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE ORD CORPS

BAND, FRONT

~~DEPT OF THE ARMY~~
~~ROCK ISLAND ARSENAL~~
~~ROCK ISLAND, ILL 61202~~

DWG SIZE D 7267001

SCALE 4/1 UNIT WT SHEET 1 OF 1