

1-SPEC MIL-W-13855 AND ANSI Y14.5-1973 APPLY.

2-MATERIAL:-

9352725-1, STAINLESS STEEL, TYPE 631, (SOLUTION ANNEALED), ASTM-A564.
9352725-2, STAINLESS STEEL, TYPE 631, ASTM-A693.

3-HEAT TREATMENT:-

A - HARDEN : 1400°F FOR 90 MIN. AIR COOL.

B- TEMPER: 1050°F FOR 90 MIN. AIR COOL.

C- HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT

THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

4-FINISH 125/ EXCEPT AS NOTED.

5-PROTECTIVE FINISH:-FINISH 3.3.2 OR 3.3.3 OF MIL-STD-171
WITH SUPPLEMENTARY PRESERVATIVE CONFORMING TO VV-L-800.

6-ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.

7-HOLE ☐A- TO BE STRAIGHT, SMOOTH, AND FREE OF BURRS, RIDGES,
AND OTHER PROCESSING DEFECTS.

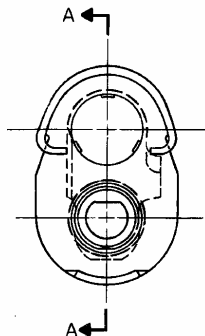
8-A TWO DIA CONCENTRIC PLUG HAVING DIAMETERS OF .4998 AND .404 AND HAVING A FLAT .151 FROM C OF .404 DIA SHALL PASS THROUGH "D" SHAPED OPENING. LENGTH OF .4998 DIA SHALL BE 1.878 MIN.

9-~~2~~ **[G]** IS ESTABLISHED BY A LINE THROUGH THE CENTERS OF HOLES **[A]** AND **[C]**.

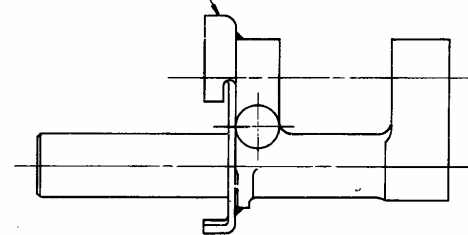
IC-NO PORTION OF J SHALL FALL BELOW H REGARDLESS OF THE SIZES OF BOTH FEATURES AND THEIR CONCENTRICITY REQUIREMENTS RELATIVE TO A.

11- UNLESS OTHERWISE SPECIFIED, SURFACES REQUIRING 32 AND FINER ROUGHNESS HEIGHT RATING MAY BE PROCESSED AFTER APPLICATION OF FINAL PROTECTIVE FINISH. BRIGHT AREAS RESULTING FROM SUCH PROCESSING ARE PERMISSIBLE.

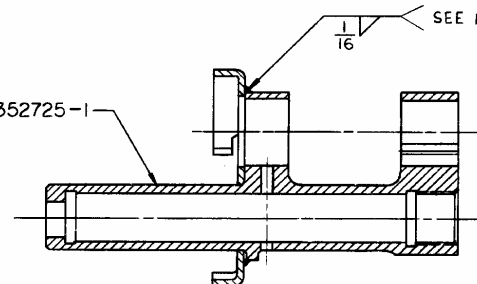
12 - WELD IN ACCORDANCE WITH SPEC MIL-W-8611



BAND, FRONT-9352725-2-



SEE NOTE 12



SECTION A-A

A	A	A
SH 3	SH 2	SH 1
REVISION STATUS OF SHEET		

SEE SEPARATE PARTS LIST 9352725

PART NO. 9352725

		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING 82-06-01		U S ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES ON DIMENSIONS FRACTIONS = 1/32" ANGLES = 1°		DRAFTSMAN ENGR ENGR		CHECKER ENGR ENGR	
J9386974		RIFLE, M16A1				1		CYLINDER VALVE AND BAND ASSEMBLY	
NEXT ADO		USED ON		RH C-36-40		SIZE F		FSCM NO. 19200	
APPLICATION						1		9352725	
						2/1		UNITS WGT	
								UNITS L OF	