

NOTES:

1. EACH REPAIR PART BOLT AND ROLLER ASSY SHALL WITHSTAND THE FIRING OF ONE GOVERNMENT STANDARD HIGH PRESSURE TEST CARTRIDGE WITHOUT EVIDENCE OF FAILURE AS DETERMINED BY MAGNETIC PARTICLE INSPECTION FOR CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS, USING A STANDARD 5 TURN MAGNETIZING COIL WITH A CURRENT OF 200 TO 250 AMPERES. APPLY MPI MARK TO ASSY MEETING THIS REQUIREMENT.

2. ROLLER SHALL BE ASSEMBLED TO THE BOLT BY GRADUAL APPLICATION OF FORCE WHILE RING IS COMPRESSED INTO THE GROOVE ON THE BOLT WITH A SUITABLE TOOL. CARE SHALL BE EXERCISED TO PRECLUDE DAMAGE TO THE RING DURING ASSEMBLY OPERATION.

3. AFTER ASSEMBLY, THE ROLLER SHALL ROTATE SMOOTHLY WITHOUT EVIDENCE OF BINDING OR DRAG.

4. MIL-W-13855 SHALL APPLY. (H)

BOLT - 7790185

ROLLER - 7267065

RING - 7267059

APPLY MPI MARK "M" 1/8 HIGH ON UNDERSIDE

PRICK PUNCH AFTER PROOF FIRING (REPAIR PARTS ONLY)

SECTION VIEWS SHOWING ROLLER AND RING POSITION

BEFORE ASSEMBLING RING AND ROLLER, PACK WITH GREASE CONFORMING TO SPEC MIL-G-10924. AFTER MPI, ROLLER SHALL BE REPACKED WITH GREASE CONFORMING TO SPEC MIL-G-10924.

LONGITUDINAL RESIDUAL MAGNETIZATION WITH WET FLUORESCENT SOLUTION. (SEE NOTE 1)

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

CODE IDENT NO. 19205

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FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7790186

PHYSICAL PROPERTIES		RIFLE, M14NM	TOLERANCES ON DECIMALS	ORIGINAL DATE OF DRAWING
TP			ANGLES	10 JUL 58
TS			FRACTIONS	DRAFTSMAN R.E.K. CHECKER
CL 2	C7790187	RIFLE, M14	MATERIAL	TRACER
RA			HEAT TREATMENT	ENGINEERED BY H. H. HENRY
BT			FINAL PROTECTIVE FINISH	SUBMITTED
RM				R. L. Henry ORD CORPS
				APPROVED BY ORDER OF THE CHIEF OF GUN
				4. F. Synch...

REVISIONS	DATE	APPROVED
L	NORG2S2038/921021	921230
K	ECPW552069/1651223	860121
J	NORW452051/840824	790401
H	NORW82022/79-03-26	71FEB25
G	SEE EO HRD 92078-2	25 JUN 80
F	SEE EO RIA-14182	15 MAY 81
E	SEE EO SA 29261	15 MAY 81
D	SEE EO SA 26910	26 AUG 81
C	SEE EO SA 26046	15 FEB 81
B	SEE EO SA 25810	30 SEP 80
A	SEE EO SA 25232	1 SEP 79

BOLT AND ROLLER ASSEMBLY

SPRINGFIELD ARMY	7790186
ENGINEERED BY T. MASS.	C
SCALE 2/1	UNIT WT
RMH	