

NOTES:
 1. FINISH 125 EXCEPT AS NOTED.
 2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
 3. STEEL, CMPSN 8645, OR 8740 SPEC ASTM A304, A302, A331, GRAIN SIZE 7 OR FINER.

4. HEAT TREATMENT: HEAT TO 1500° TO 1550° F. OIL QUENCH, TEMPER 1 HOUR AT HEAT TO HARDNESS SPECIFIED. NO DECARBURIZATION PERMISSIBLE. AFTER HEAT TREATMENT SHOT PEEN .013A-.015A INTENSITY WITH NO.170 SHOT AT THE .020+.005 RADIUS AT JUNCTION STEM AND BODY. SEE SPEC MIL-S-13165. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

5. [A] ALONG A RADIUS CONCENTRIC WITH [B].
 6. [C] LOCATION OF 70° CONE CENTER.
 7. FINISH REQUIREMENTS SPECIFIED FOR THESE TWO SURFACES SHALL APPLY BEFORE SHOT PEENING. SEE SECTION C-C.

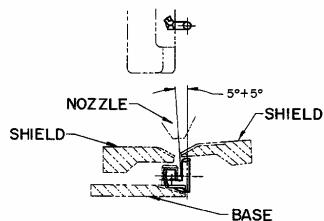
8. [D] SHALL APPLY WITHIN [E] AND ABOVE DATUM LINE [F]. DIMENSION [D] IS DEPICTED AT AN EXTREME MISMATCH CONDITION TO ILLUSTRATE ITS TERMINAL RADI. A MISMATCH IN THE OPPOSITE DIRECTION IS ALSO PERMISSIBLE.

9. .157 DATUM GAGE LOCATION [P] & DATUM LINE [K] WHICH IS TANGENT TO [C] PRESCRIBE ORIENTATION OF COMPONENT SUCH THAT THE LOCATION OF OTHER DIMENSIONAL FEATURES IS ESTABLISHED (SEE ZONE E-61).

10. FINAL PROTECTIVE FINISH: FINISH 5.3.12 OF MIL-STD-171.

11. MIL-W-13885 SHALL APPLY.

THESE EDGES, ON BOTH SIDES, SHALL BE BROKEN .005R+.010 AND SHALL BE SMOOTH, FREE OF BURRS AND TOOL MARKS. (TO PREVENT START OF A FRACTURE)

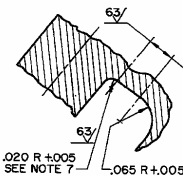
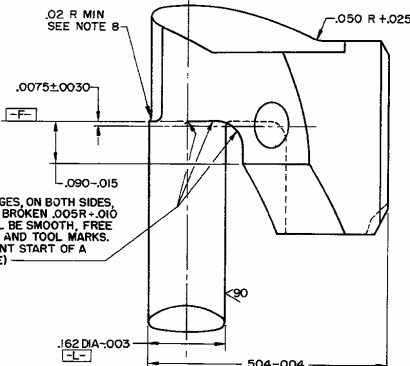
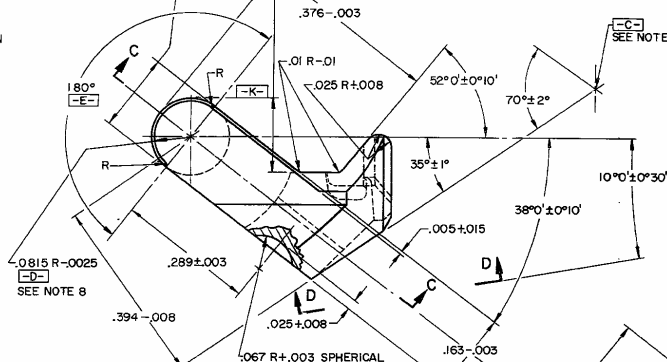


VIEW OF SHOT PEENING .020 R+.005 AFTER HEAT TREATMENT

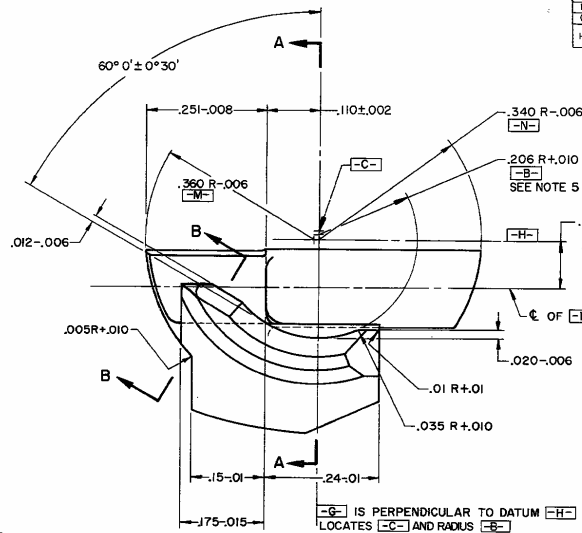
.157 MIN; A FLAT ON THE SHANK IS PERMISSIBLE PROVIDED THIS DIMENSION IS COMPLIED WITH

.157 DATUM GAGE LOCATION [P] SEE NOTE 9

[C] SEE NOTE 6



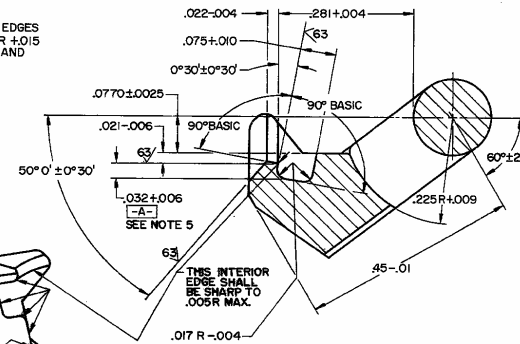
PARTIAL SECTION C-C



EXTERIOR CORNERS AND EDGES SHALL BE BROKEN .005 R+.015 AND SHALL BE SMOOTH AND FREE FROM BURRS

THIS EDGE SHALL BE BROKEN .005 R+.010, FLUSH OR BELOW SURFACE [J] AND SHALL BE BLENDED INTO THE .065 R+.005. (SEE PARTIAL SECTION C-C)

[G] IS PERPENDICULAR TO DATUM [H] LOCATES [C] AND RADIUS [B]



SECTION A-A

ORIGINAL DESIGN ACTIVITY FROM 1920'S
 CURRENT DESIGN ACTIVITY FROM NO. 12000
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
 COVER NEW JERSEY 07801

MECHANICAL PROPERTIES		RIFLE, M14-NM		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE 11 MAR 63		PART NO. 7791578	
YP	C7790187	RIFLE, M14		TOLERANCES ON DECIMALS		DRAWN BY 7791578		CHECKED BY 7791578	
TS	D5546023	30R MI, MIC		FRACTIONS		TRACER 7791578		CHECKER EPS	
EL 2		B WID		MATERIAL		SEE NOTE 3			
RA				ANGLES		SEE NOTE 4			
SH		NEXT ASBY USED ON		APPLICATION		HEAT TREATMENT		APPROVED BY ORDER OF THE	
RH	C 40-43	DO NOT		APPLY PART NO		FINAL PROTECTIVE FINISH		SCALE 10/1 UNIT WT. A	

EXTRACTOR

7791578

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