

NOTES:

1. FINISH 125/
2. ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.

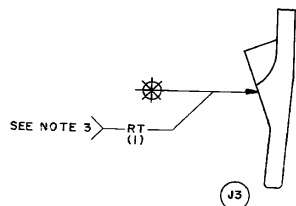
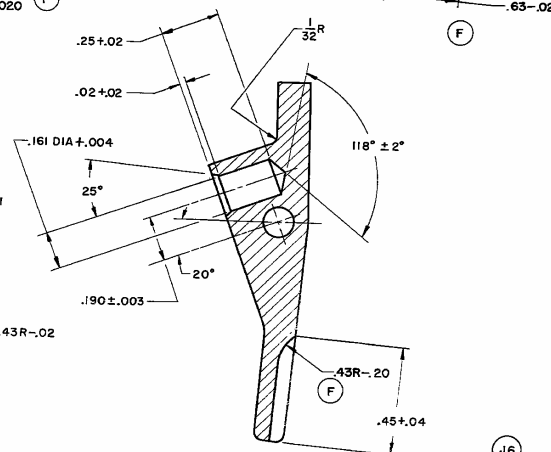
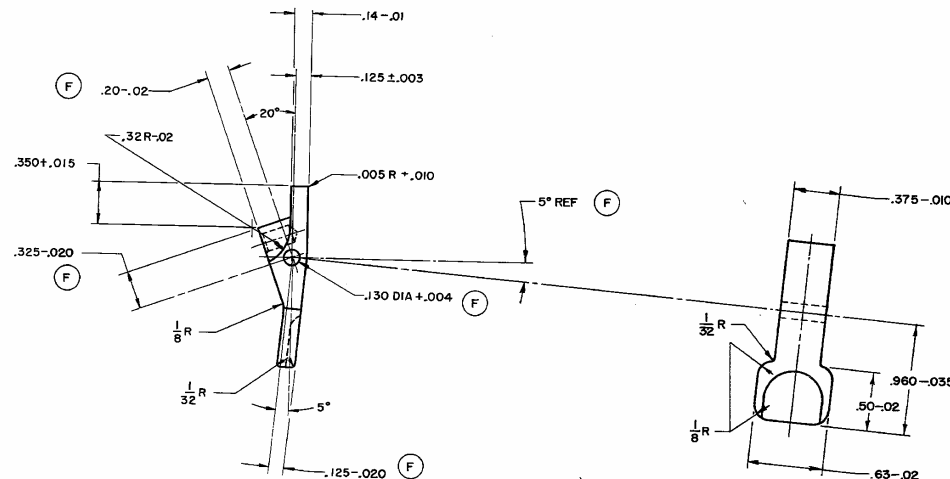
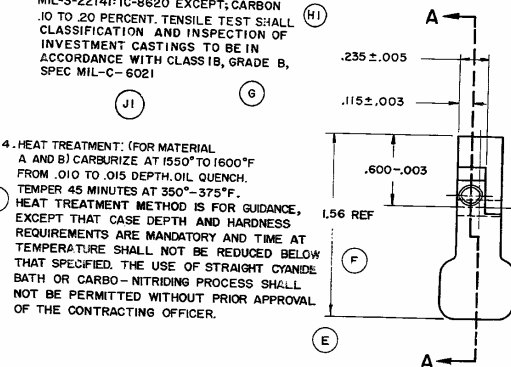
3. MATERIAL:
A - FOR WROUGHT MATERIAL: STEEL, SPEC ASTM A304, A322, A331, 8615.
B - FOR PRECISION CASTING: STEEL, MIL-S-22141; IC-8620 EXCEPT; CARBON .10 TO .20 PERCENT. TENSILE TEST SHALL CLASSIFICATION AND INSPECTION OF INVESTMENT CASTINGS TO BE IN ACCORDANCE WITH CLASS 1B, GRADE B, SPEC MIL-C-6021

4. HEAT TREATMENT: (FOR MATERIAL A AND B) CARBURIZE AT 1550° TO 1600°F FROM .010 TO .015 DEPTH. OIL QUENCH. TEMPER 45 MINUTES AT 350° - 375°F.
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. HARDNESS: ROCKWELL 30N-75 TO 79 OR FILE HARD IN ACCORDANCE WITH MIL-W-13855.

6. MIL-W-13855 SHALL APPLY.

| POSITION NUMBERS | NUMBER OF POSITIONS | NO. OF FILMS | NO OF VIEWS PER FILM | FILM SIZE |
|------------------|---------------------|--------------|----------------------|-----------|
| 1 | 1 | 1 | 120 TO 150 | 14 X 17 |



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

SECTION A-A

SCALE 4/1

CODE IDENT NO.
19200

| PHYSICAL PROPERTIES | APPLICATION |
|---------------------|-----------------------------------|
| ITEM 1 | RIFLE XM21 |
| ITEM 2 | RIFLE M14-NM |
| ITEM 3 | RIFLE, M14 |
| ITEM 4 | C7790196 |
| ITEM 5 | SEE NOTE 3 |
| ITEM 6 | HEAT TREATMENT |
| ITEM 7 | SEE NOTE 4 |
| ITEM 8 | DO NOT |
| ITEM 9 | APPLY PART NO. |
| ITEM 10 | FINAL PROTECTIVE FINISH |
| ITEM 11 | FINISH NO 5.3.1.2 OF MIL-STD -171 |

| | |
|----------------|---|
| | UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES |
| RIFLE XM21 | TOLERANCES ON DECIMALS $\pm .01$ |
| RIFLE M14-NM | ANGLES $\pm 1^\circ$ |
| RIFLE, M14 | FRACTIONS $\pm 1/64$ |
| | MATERIAL |
| | SEE NOTE 3 |
| USED ON | HEAT TREATMENT |
| | SEE NOTE 4 |
| CATION | |
| APPLY PART NO. | FINAL PROTECTIVE FINISH |
| | PHOSPHATE |

CODE IDENT NO. 19200
PART NO. 7267032

| REVISIONS | DATE | APPROVAL |
|-----------|-------------------------|------------|
| M | NOR W852022/79-03-26 | 790401 SAR |
| L | SEE EO HRD 02136 | 790401 SAR |
| K | (1) SEE EO HRD 92078-2 | 251101 SAR |
| J | (1-6) SEE EO-62048 | 11 MAR 68 |
| I | (1-3) SEE EO 542928 | 11 MAR 68 |
| H | SEE EO 542928 | 4 OCT 67 |
| G | SEE EO NO. 542945 | 1 APR 67 |
| F | SEE EO NO. 542945 | 1 APR 67 |
| E | SEE EO NO. 542945 | 1 APR 67 |
| D | REDRAWN AND REVISED WAS | 1 APR 67 |
| C | SEE EO 542945 | 1 APR 67 |
| B | SEE EO 542945 | 1 APR 67 |
| A | SEE EO 542945 | 1 APR 67 |

LATCH,
MAGAZINE

DEPT OF THE ARMY
U.S. ARMY WEAPONS
COMMAND
ROCKISLAND, ILL 61201
7267032

D 7267032

B

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