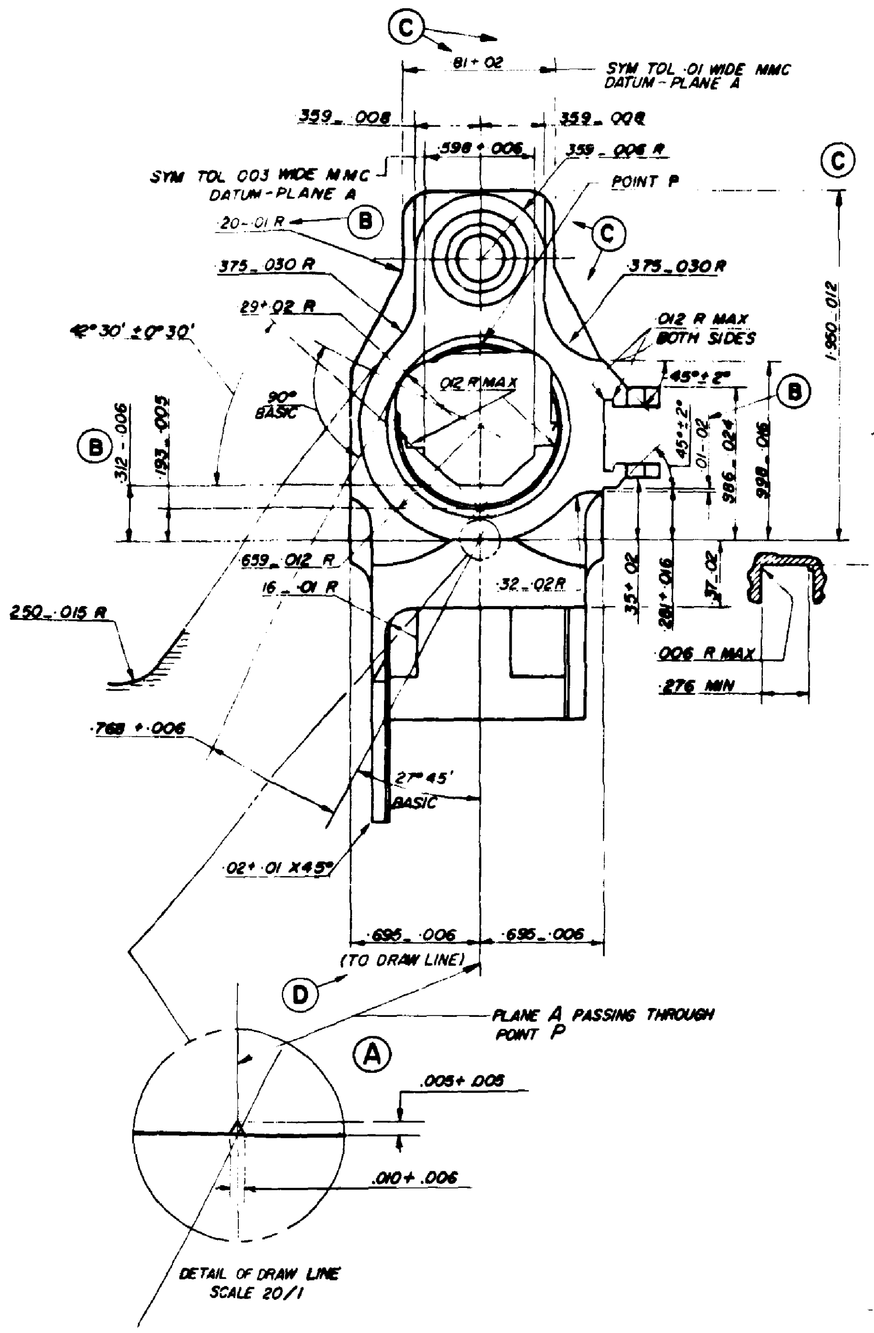
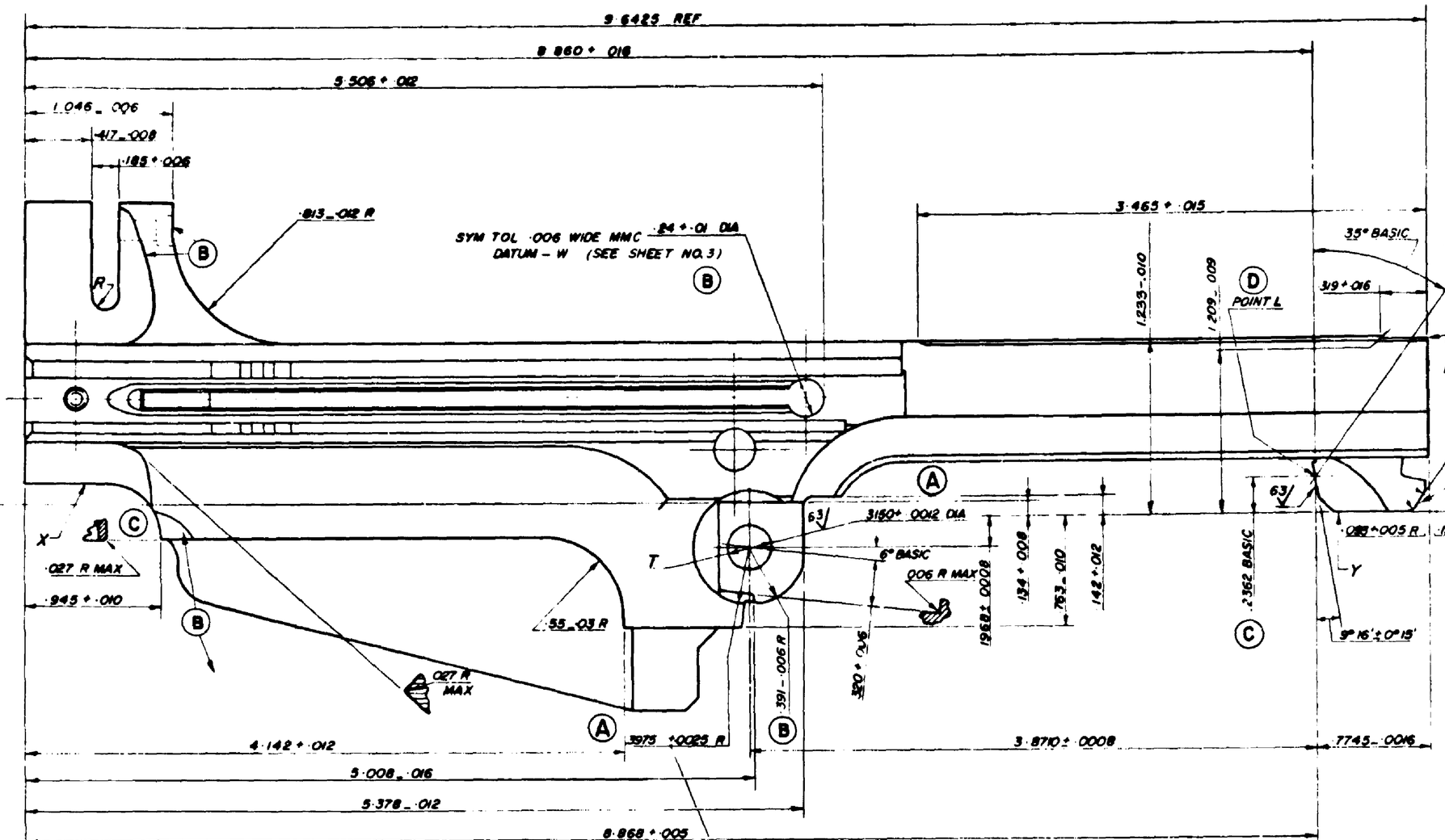
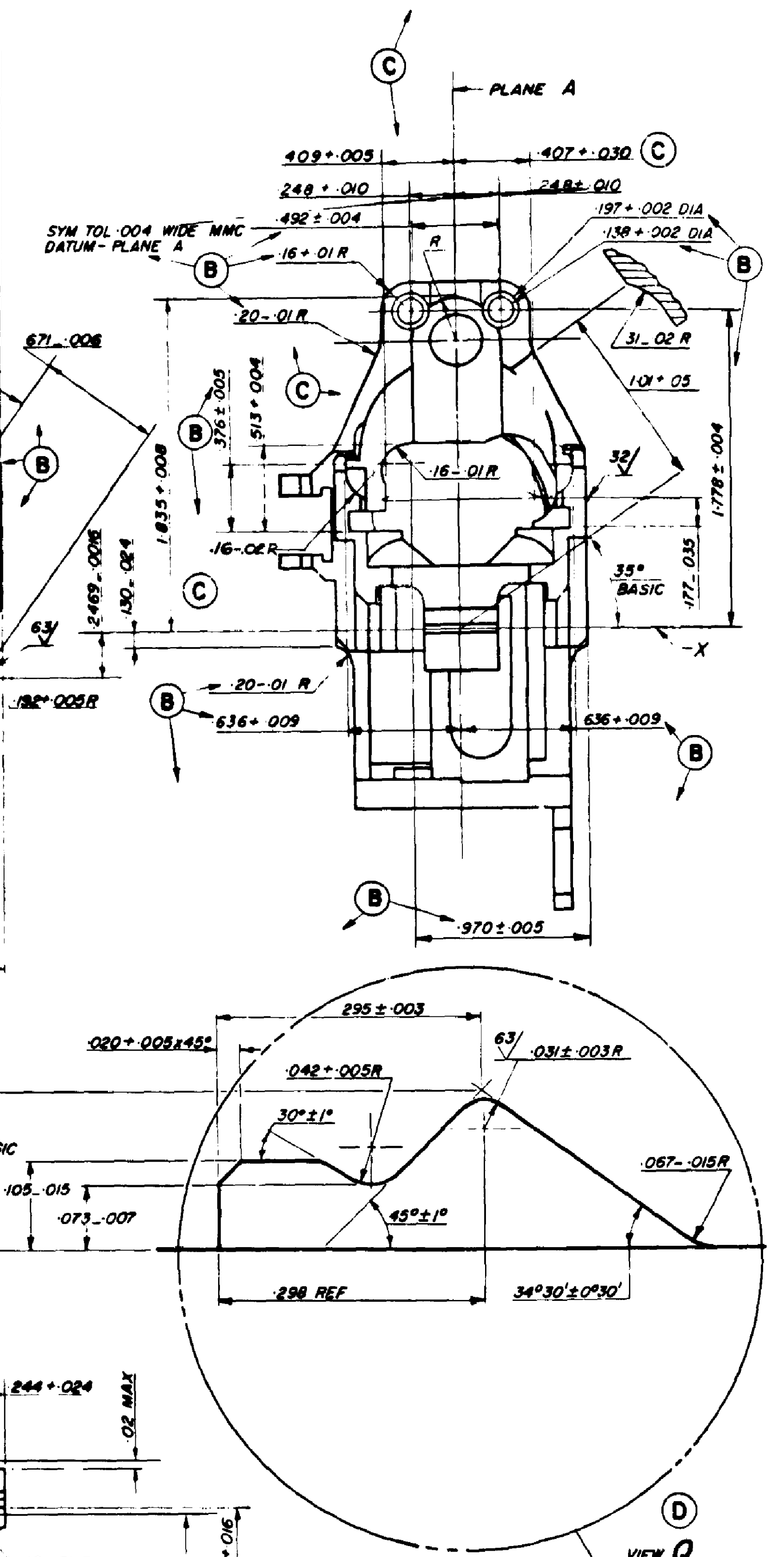
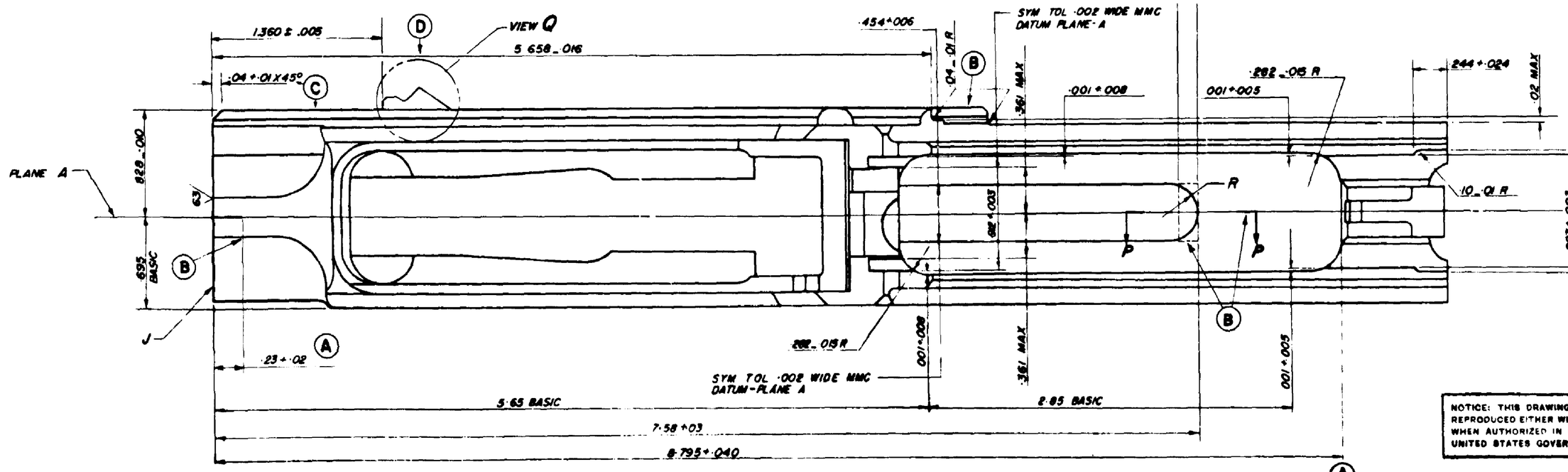
BEST AVAILABLE COPY









(A)

HEAT TREATMENT FOR BODY-A:
WHEN USING STEEL FS8740, FS8742, FS8747:
BEFORE MACHINING, HEAT AT 1640-1665°F. COOL IN AIR. HEAT AT 1540-1565°F FOR 30 MINUTES AT HEAT. QUENCH IN CIRCULATING OIL. TEMPER 90 MINUTES AT HEAT TO HARDNESS SPECIFIED.

WHEN USING STEEL FS4140:
BEFORE MACHINING, HEAT AT 1675-1700°F. COOL IN STILL AIR. HEAT AT 1600-1625°F FOR 30 MINUTES AT HEAT. QUENCH IN CIRCULATING OIL. TEMPER 90 MINUTES AT HEAT TO HARDNESS SPECIFIED.

MATERIAL FOR BODY-A:
STEEL, FED. SPEC QQ-S-624; FS8740, FS8742, FS8747, FS4140

EDGES BROKEN .005 +.010

125/ ALL OVER EXCEPT AS NOTED (C)

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

E	SUPERSEDED BY F7268260 28SEP54		
	W/C 28 SEP 56		
D 3	SEE ECO 23080	28SEP54	
C1	SEE ECO 22519	19MAY55	
B 18	SEE ECO 22111	14MAR55	
A7	SEE ECO 22038	14JAN55	
SYM	DESCRIPTION	DATE	APPROVAL

REVISIONS

DWG B7266102 APPLIES (A) PART NO. 7267490

PHYSICAL PROPERTIES	
TOLERANCES ON DECIMALS / ANGLES / FRACTIONS	
MATERIAL	SEE NOTE
HEAT TREATMENT	SEE NOTE
FINAL PROTECTIVE FINISH	SEE SHEET 1
F7267487 NEXT ASSY	RIFLE, CAL .30, T48 USED ON
APPLICATION	
DO NOT APPLY PART NO.	
DO AS SPECIFIED	
SYM C25-30	BODY-A

ORIGINAL DATE OF DRAWING 7 DEC 54
DRAFTSMAN RO CHECKER
TRACER RJK CHECKER WSS
ENGINEER FJ AM ENGINEER
SUBMITTED H. F. Lynch ORD CORPS
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE LT COL ORD CORPS

RECEIVER
(DETAILS)

SCALE 2/1 UNIT WT

SPRINGFIELD ARMORY
ORDNANCE CORPS
DEPT OF THE ARMY

DWG SIZE F 7267490 SHEET 2 OF 5

REF: DAD150-3933 CAL5209