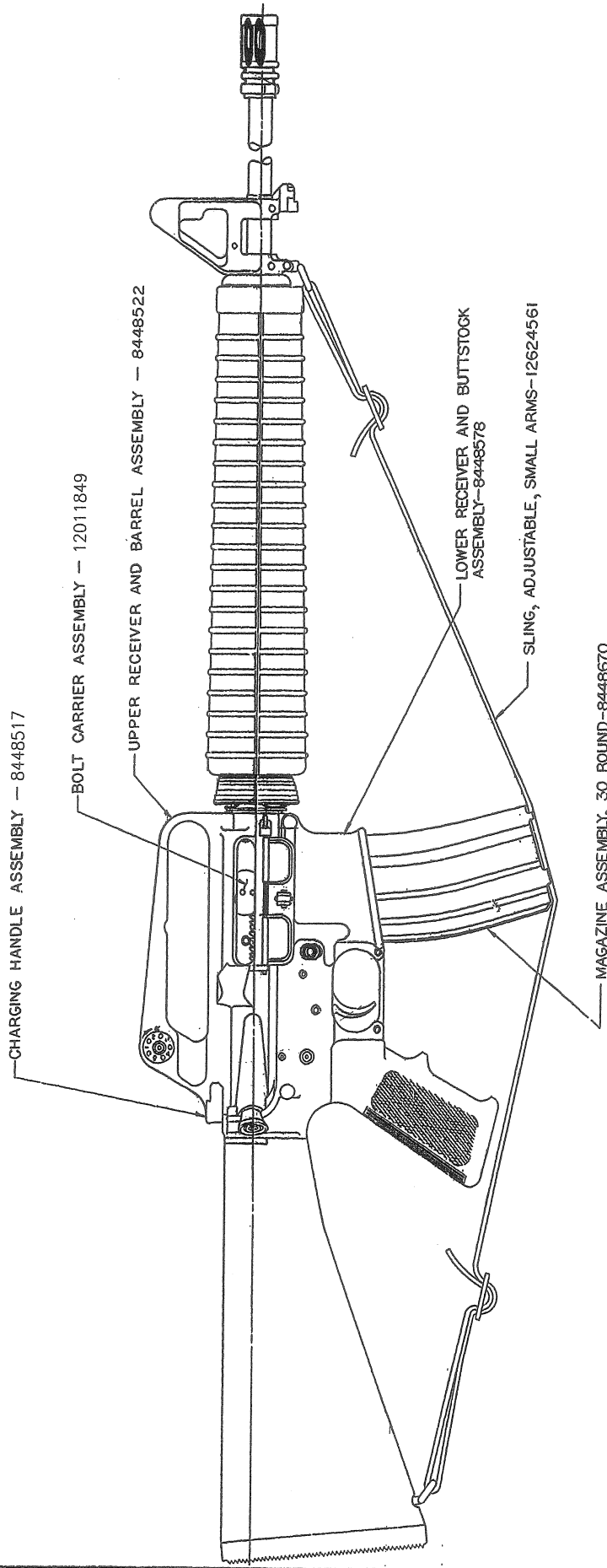


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- NOTES:
1. MIL-R-45587 APPLIES.
 2. FOR INFORMATION ONLY:
DRAWING A8448795 INCLUDES THE SUPPORT EQUIPMENT FOR THE RIFLE, M16A1. THIS EQUIPMENT IS NOT PACKAGED OR INCLUDED WITH THE M16A1 RIFLE, P/N 8448500.



REV	DESCRIPTION	DATE	APPROVAL
1	REDRAWN WITH CHARGES INOR W558004/860204	890215	
2	INOR G2S3057/920716	921030	RR
3	INOR L753059 971016		
4	IN (ECP 1853000 980126)	980313	JB

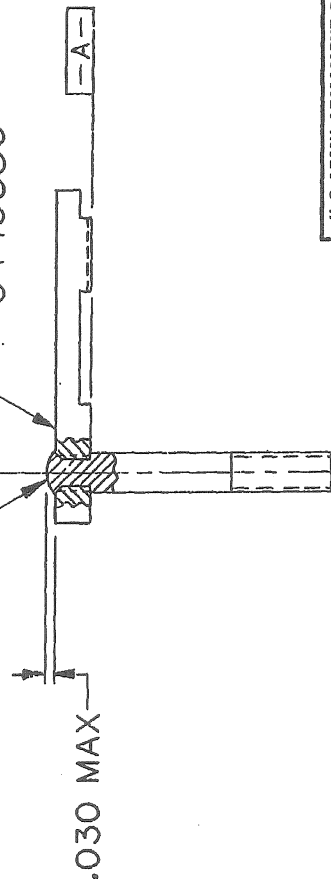
SEE PARTS LIST 8448500		PART NO. 8448500	
DO NOT SCALE DRAWING UNLESS SPECIFICALLY INDICATED BY A NOTE		ORIGINAL DATE OF DRAWING 27 APR 1970	
REVISIONS	REVISIONS	ROCK ISLAND ARSENAL ROCK ISLAND, ILL 61204	
1	1	DATE	DATE
2	2	BY	BY
3	3	CHK	CHK
4	4	APP	APP
5	5	PS	PS
6	6	DB	DB
7	7	THIRD ANGLE PROJECTION	THIRD ANGLE PROJECTION
8	8	APPROVED	APPROVED
9	9	FOR THE DIRECTOR	FOR THE DIRECTOR
10	10	FOR THE DIRECTOR	FOR THE DIRECTOR
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100	100	FOR THE DIRECTOR	FOR THE DIRECTOR

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1. ASSEMBLE 8448639 AND 8448640 USING 15±5 INCH LB OF TORQUE BEFORE SWAGING.

SWAGE TO FORM HEAD AND LOCK ASSEMBLY.
SWAGED HEAD MUST BE SMOOTH AND
SYMMETRICAL

PLATE, MA
8448639



SHAFT, MAGAZINE CATCH - 8448640

LA.004

SEE PL-8448638

MECHANICAL PROPERTIES			
YS	MIN		
YS		9390011	M4
MAX		F9327230	M 231
TEL2		F8448604	M16
RA		F8448578	M16AI
BH		NEXT ASSY	USED ON
RH		APPLICATION	

**DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY
AS DIRECTED BY ASQC-AR OR HIGHER DOD AUTHORITY; 92-06-22.**

CONTRACT NO.	27 APR 1970			
DATE	PREP	C4K	ENGR	SUBMITTED
	B. R. L.	A. H. L.	A. H. L.	A. H. L.
	Q. J. M.	Q. J. M.	Q. J. M.	Q. J. M.

FINAL PROTECTIVE FINISH
5.3.1.2 OF MIL-STD-171

APPROVED *R. P. Gilman*

CATCH, MAGAZINE

SIZE	CODE : DENT NO.	DRAWING NO.
B	19204	8448638

SCALE 2

SHEET OF

SCALE 2

100

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

CODE IDENT NO.

CURRENT

19200

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

CONTRACT NO.

DATE 27 APR 1970

PREP	B. K. L. A. S. L.
CHK	11/11/11

ENGR	<i>D. Smart</i>
	<i>W. J. Smart</i>

SUBMITTED *FD 302*

APPROVED *[Signature]*

R. L. Hansen

14 13 12 11 10 9 8 7 6 5 4 3 2 1

SECTION F-F

SECTION E-E

VIEW A

SCALE: 10/1

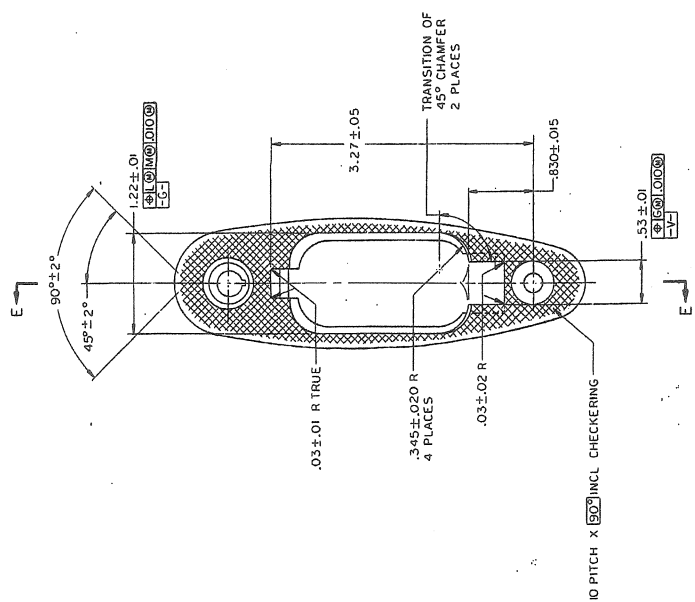
REV 12

934930

15, 2004 11:04 AM

NOTES:--

- 1- SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
- 2- MATERIAL PLASTIC COMPOUND PER ASTM D4086 (PALS. COLOR SHALL BE LUSTERLESS PLAIN AND SMOOTH FINISH) WITH 10% RED-500-00A
- 3- BREAK EDGES .010 ±.005 UNLESS OTHERWISE NOTED.
- 4- FILLET RADI .009 ±.006 UNLESS OTHERWISE NOTED.
- 5- ALL EXPOSED SURFACES ENCLOSED IN AREA F-5 SHALL HAVE A NONREFLECTIVE MATTE SURFACE, OTHER SURFACES OPTIONAL.
- 6- TRANSITION OF ANGLES F-6, F-7 AND F-8 SHALL BE SMOOTHLY BLENDED.
- 7- REMOVE ALL FLASH.
- 8- PART SHALL BE FREE FROM POROSITY, CRACKING, DEFORMATION, AND FLOW AND/OR KNOT MARKS.
- 9 FINISH: 125/ ALL SURFACES UNLESS OTHERWISE NOTED.



INSERT - 8448657

SEE VIEW B FOR MAX PERMISSIBLE OUT-OF-FLAT OF PLANE ESTABLISHED BY THIS SURFACE

SECTION E-E

REV 12

934930

ARMAMENT RESEARCH & DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PARTS LIST
DOCUMENT/PART NUMBER D 9349119
BUTTSTOCK ASSEMBLY, STOWAGE
CHANGE CONTROL NUMBER W253258

CURRENT FSCM NO. 19200 - ORIGINAL FSCM NO. 19200

AUTHENTICATION- *R. Hall*

END QTY UNIT FSCM PART OR
NO. REQ MEAS NO. IDENTIFYING NO

DRAWING/DOCUMENT SIZE NUMBER NOMENCLATURE OR DOCUMENT TITLE

1 19204 8448652
1 19204 8448653
1 19204 8448655
1 9349120
1 9349121
1 9349130
1 9349130

C 8448652 SWIVEL
C 8448653 HINGE
B 8448655 PIN
D 9349120 SCREW, SWIVEL
J 9349121 BUTTSTOCK
J 9349130 BUTT PLATE ASSEMBLY
C 9349130 DOOR ASSEMBLY, THUMB LATCH

TOTAL NUMBER OF SHEETS 1

REV. DATE 04 SEP 84
REVISION LETTER B
SHEET 1
ORIG. DATE 14 JUN 82

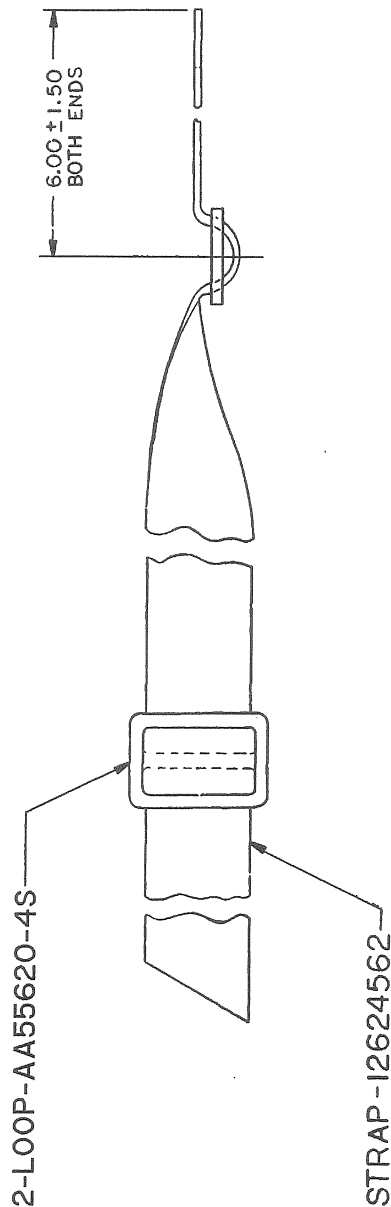
SUP
LST

X
X

AR - AS REQUIRED, ALT - ALTERNATE, OPT - OPTIONAL, SO - SELECTION OPTIONAL

1-MIL-W-13855 APPLIES.

REVISIONS			
SYTM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERRWSS0107	86-01-24	SK
A	NORIGIS451/910429	910605	GHS 5/25/86
B	NORL7S2000 970214	970306	JB

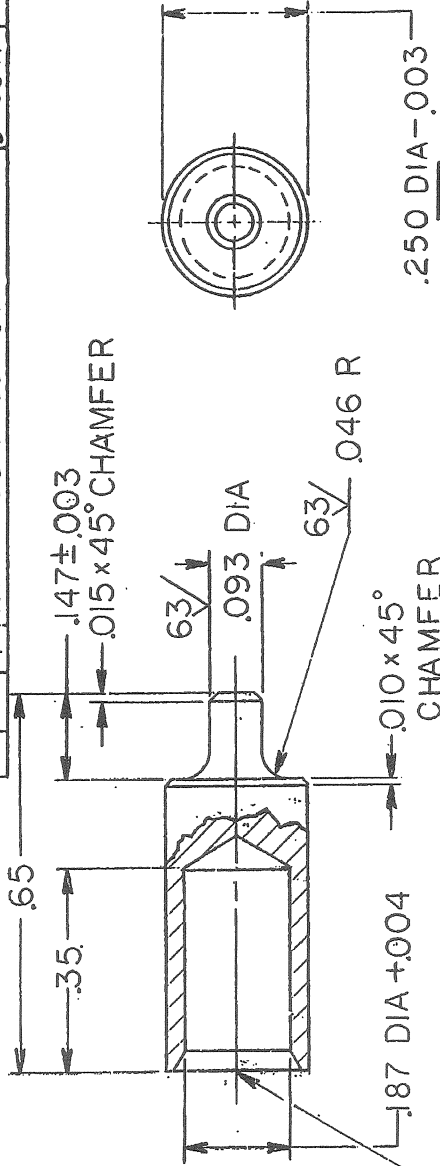
[illegible]

SMCAR FORM 67, 1 FEB 85, REPLACES ARRADCOM FORM 67, AUG 77 WHICH MAY BE USED TO REQUEST EXAMINATION OF THE FOLLOWING:

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- NOTES:-
- 1.- STEEL CMPSN 4130 OR 41L40 ASTM A322 OR ASTM A331
 - 2.- FINISH 125/ EXCEPT AS NOTED.
 - 3.- BREAK ALL SHARP EDGES .010 MAX.
 - 4.- ALL DIAMETERS $\pm .0006$ DIA
 - 5.- MIL-W-13855 APPLIES.

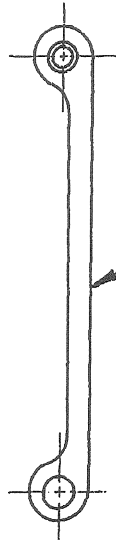


CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

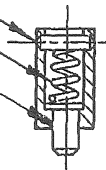
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DATE 27 APR 1970		U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS MIN		TOLERANCES:		PREP	E.C.H.	RETAINER, BUFFER	
YS MAX		ANGLES:		CHK	M.H.T.		
EL2		3 PLACE DECIMALS ± .005		ENGR	J.L.B.		
RA		2 PLACE DECIMALS ± .01		SUBMITTED	F.P. Williams		
BH		MATERIAL	SEE NOTE 1	APPROVED	L.J. Henry		
RH	15N 72.5-76	FINAL PROTECTIVE FINISH	53.12 OF MIL-STD-171				
NEXT ASSY		USED ON					
APPLICATION							
SIZE		B 19204		DRAWING NO.		8448582	
SCALE		5/1		SHEET		OF 1	

[illegible]

L. MIL-W-13855 APPLIES.



GUARD, TRIGGER- 8448588



PLUNGER, TRIGGER GUARD-- 8448589
-SPRING, TRIGGER GUARD-- 8448590
PIN, SPRING--MSI6562-96

CURRENT
CODE IDENT NO.
19200

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
YS				TOLERANCES ARE IN INCHES:
MIN				ANGLES ±
YS		9390011	M4	3 PLACE DECIMALS ±
MAX		F9327230	M231	2 PLACE DECIMALS ±
EL2		C8448605	M16	MATERIAL
RA		C8448605	M16	
BH		C8448579	M16A1	
		NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH
RH		APPLICATION		

CONTRACT NO	DATE 27 APR 1970			
PREP	RAR	G. J. A.		
CHK	WJH	J. S. A.		
ENGR	SUBMITTED			
J. P. Upchurch				
APPROVED	K. J. Harris			

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

TRIGGER GUARD
ASSEMBLY

AWING NO. 8448587

SCALE 2/1

SHEET 1 OF 1

100

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REVISIONS			
MF	ZONE	DESCRIPTION	DATE
B		REPLACES REV A W/ CHANGE SEE ERR HQR 20778	6 OCT 72
C		NOR W230011 / 82-04-13 ECP W230034 / 82-07-15 ECP W353120 / 83-07-07	83-11-04
D		NORGIS2018 91-07-08	91-10-11

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER 0220 ±.0005
COIL DIAMETER (O.D) 180 ±.003
FREE LENGTH 940 REF
TOTAL COILS 14 REF
DIRECTION OF HELIX OPTIONAL
LOAD AT COMPRESSED LENGTH OF .490 30 LB ±.3 LB
LOAD AT COMPRESSED LENGTH OF _____
SPRING RATE _____
SOLID LENGTH 335 MAX
TYPE OF ENDS CLOSED
MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

- WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
- PRECIPITATION HEAT TREAT AFTER FORMING TO COND TN CH900. HOLD AT 900°F ± 10° FOR ONE HOUR. AIR COOL.
- MIL-W-13855 APPLIES.
- BREAK SHARP EDGES .003 ± .012.

CURRENT DESIGN ACTIVITY
FSCM NO. 19200

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

PART NO. 8448583

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DATE 27 APR 70		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS MIN		TOLERANCES:		PREP	P. Vernon	CHK	8. Outman	SPRING	
YS MAX		ANGLES ±		ENGR	Dr. Elise L. Buntin	SUBMITTED		BUFFER RETAINER	
EL 2		3 PLACE DECIMALS ±.005		SEE NOTE 1		APPROVED		SIZE CODE IDENT NO. DRAWING NO.	
RA		2 PLACE DECIMALS ±		5.4.1 OF MIL-STD-171		NEXT ASSY		B 19204 8448583	
BH		MATERIAL		FINAL PROTECTIVE FINISH		USED ON		SCALE	
RH	15N 84.5 MIN	APPLICATION		5.4.1 OF MIL-STD-171		APPLICATION		SHEET 1 OF 1	

5

4

3

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1

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		C	REPLACES REV B W/CHANGE SEE ERR HQR 20778	6 OCT 72	RB
		D	NORW2S0045 82-07-29	830203	RB
		E	NORW2S0011 / 82-04-13 (ECPW3S3120 / 83-07-07)	83-11-04	RB
		F	NOR G8S2005 / 880310	880927	OKETT
		G	NOR G1S2018 / 910708	911011	RR

NOTES:

1. WIRE, STEEL, CARBON,
SPRING, MUSIC,
ASTM -A228.

2. STRESS RELIEVE: HOLD AT
475°F ± 25° FOR 30 MINUTES.
AIR COOL.

3. MIL-W-13855 APPLIES.

4. BREAK SHARP EDGES
.003 ± .012.

WIRE DIAMETER

COIL DIAMETER (OD)

FREE LENGTH AFTER SETTING

TOTAL COILS

DIRECTION OF HELIX

LOAD AT COMPRESSED LENGTH OF .630

LOAD AT COMPRESSED LENGTH OF

SPRING RATE

SOLID LENGTH

TYPE OF ENDS

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572.
EXCEPT PARAGRAPH 3.4.3 SHALL NOT APPLY.

SPRING, HELICAL, COMPRESSION

0400 ± .0005

41

1.13 REF

9 REF

OPTIONAL

4.0 LB ± .4 LB

405 MAX

OPEN

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-3000

PART NO. 8448540

CONTRACT NO.
DATE 27 APR 70

PREP
CHK
ENGR
SUBMITTED

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ± .005
3 PLACE DECIMALS ± .01
2 PLACE DECIMALS ± .01
MATERIAL
SEE NOTE 1

9390029
D8448523
NEXT ASSY

MECHANICAL PROPERTIES
YS
MIN
YS
MAX
EL 2
RA
BH
RH

APPLICATION

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING, PLUNGER

SIZE
B
CODE IDENT NO.
19204
DRAWING NO.
8448540

SCALE
NONE

SHEET
1 OF 1

AMSWE Form 403B, 29 Jul 69

October 15, 2004 10:54 AM

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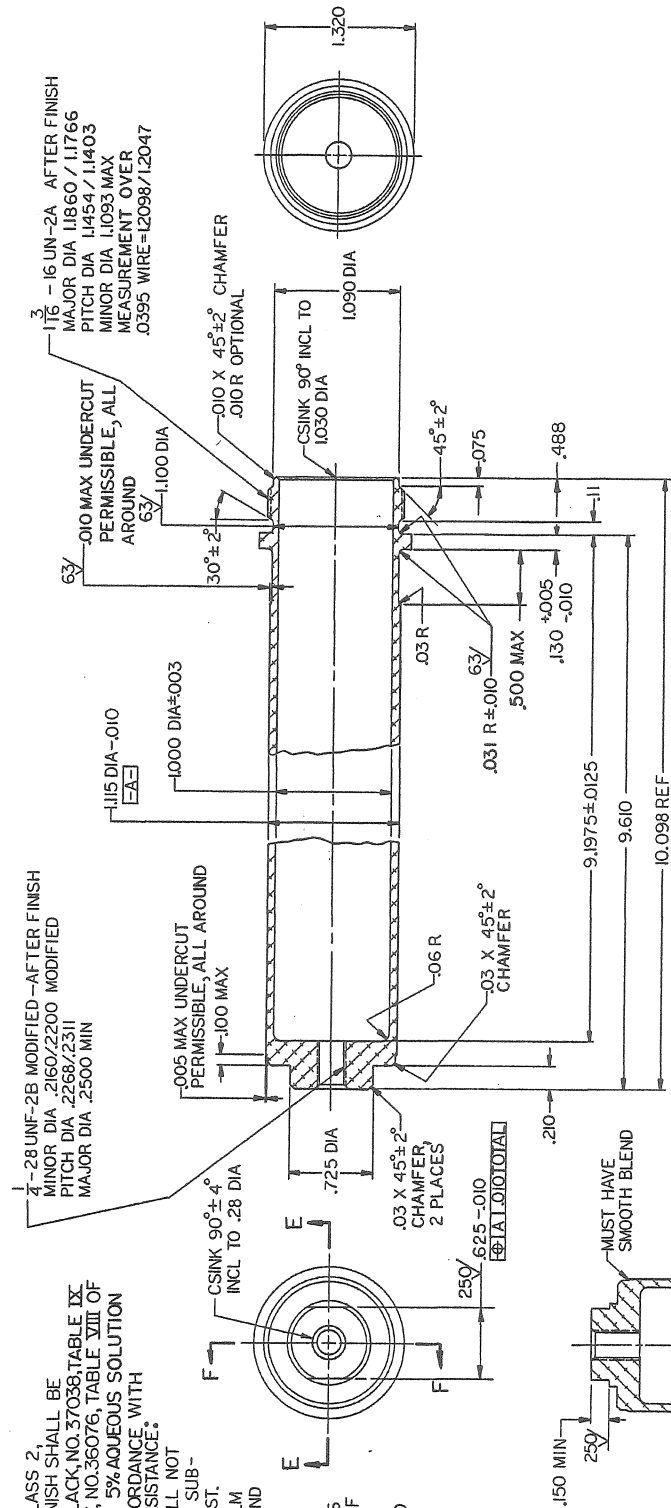
1. FINISH 125/EXCEPT AS NOTED.

3 ALL DIAMETERS TO BE A Q 10 DIA.

5 FINISH MIL-A-8625, TYPE III, CLASS 2, FILM THICKNESS .0010-.0020. FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL WITH 5% AQUEOUS SOLUTION OF SODIUM DICHROMATE IN ACCORDANCE WITH PARAGRAPH 3.8.2 ABRASION RESISTANCE.

5. MASK THREADS, APPLY DRY FILM LUBRICANT TO BOTH INTERIOR AND EXTERIOR. 0002/0005

2. BREAK SHARP EDGES .005 + .010
UNLESS OTHERWISE SPECIFIED.



SECTION F-F

MECHANICAL PROPERTIES		UNIFORM STRAIN RATE IN INCHES PER MINUTE		CONTRACT NO.		FEDERAL BUREAU OF INVESTIGATION	
YS	MIN	TENSILE STRENGTH		DATE		DEPT. OF THE ARMY	
YS	MAX	TENSILE STRENGTH		27 APR 1970		HQ. 1ST INFANTRY DIV.	
EL	MIN	2 PLATE DEFORMALS : 5005				ROCK ISLAND, ILLINOIS, 11221	
EL	MAX	2 PLATE DEFORMALS : 501					
EA		MATERIAL		PREPARED BY			
EA		ALUMINUM ALLOY,		CHECKED BY			
EA		EXTRUDED ALLOY 7075		ENGINEERED BY			
EA		TEMPER T6,		SUMMITTED BY			
EA		ASTM B 221		DATE TESTED		NO. DRAWING NO.	
BH		FINAL PROTECTIVE FINISH		APPROVED BY		SCALE	
BH		SEE NOTES 5 & 6		P. H. HARRIS		12204	
BH		NEXT ASY. USED ON				8448581	
BH		APPLICATION				SHEET	
BH						OF	

AMSWE Form 403D, 29 Jul 69

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NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH) COLD DRAWN, ASTM A313.

2. PRECIPITATION HEAT TREAT
AFTER FORMING TO COND'TN
CH900. HOLD AT 900°F ±10°
FOR 1 HOUR. AIR COOL

3. MIL-W-13855 APPLIES.
4. BRAKE SHARP EDGES .003+-.012.

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER:

COIL DIAMETER (O.D.)

FREE LENGTH

TOTAL COILS

DIRECTION OF HELIX

LOAD AT COMPRESSED LENGTH OF 470

LOAD AT COMPRESSED LENGTH OF

SPRING RATE —

SOLID LENGTH

TYPE OF ENDS

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

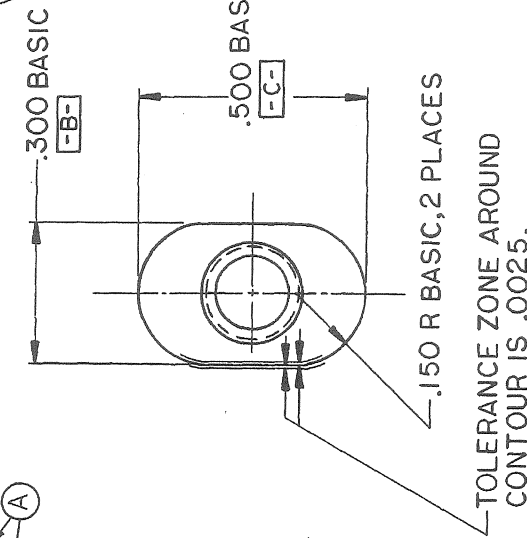
[illegible]

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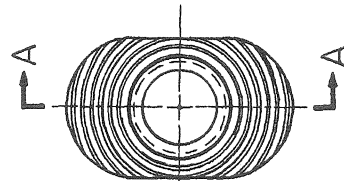
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NOTE:

1. FINISH 125/.
2. ALL DIMENSIONS APPLY BEFORE FINISH.
3. FINISH: MIL-A-8625, TYPE 3, CLASS 2, FILM THICKNESS .0010 $\pm$.0002. FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE XVII OF FED-STD-595, AND SEAL.
4. MIL-W-13855 APPLIES.



SECTION A-A



(3) $60^\circ \pm 2^\circ$ INCL X .040 PITCH REF. CIRCULAR SERRATIONS. .005 (APPROX) FLATS ON CREST AND ROOT

(A)

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES	
YS MIN		ANGLES $\pm$	3 PLACE DECIMALS $\pm$.005
YS MAX		2 PLACE DECIMALS $\pm$.01	
EL 2		MATERIAL	
RA		ALUMINUM ALY	
BH		7075 - T6,	
RH		ASTM B221	
		9390011	M4
		9349100	M16A2
		F9237230	M231
		F8448604	M16
		F8448578	M16A1
		NEXT ASSY	USED ON
		APPLICATION	
		SEE NOTE 3	

DATE	27 APR 1970
PREPARED	W. A. G. St.
CHECKED	W. A. G. St.
ENGINEER	W. A. G. St.
SUBMITTED	W. A. G. St.
APPROVED	R. S. Henry

CONTRACT NO	
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND	DOVER, NEW JERSEY 07801
DEPT OF THE ARMY	U.S. ARMY WEAPONS COMMAND
	ROCK ISLAND, ILLINOIS, 61201

SIZE	C
CODE IDENT NO	19204
DRAWING NO.	8448636
SCALE	5/1
SHEET	OF
CDI	

BUTTON,
MAGAZINE RELEASE

19200

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

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

DATE 27 APR 1970

PREPARED W. A. G. St.

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DOVER, NEW JERSEY 07801

DEPT OF THE ARMY

U.S. ARMY WEAPONS COMMAND

ROCK ISLAND, ILLINOIS, 61201

QUALITY ASSURANCE PROVISIONS (QAP) - (CONTINUATION SHEET) (DARCOM-R 702-10)

3. NOTICE: RESTRICTED AS TO USE AND DISCLOSURE (see page 1)

PART III. INSPECTION REQUIREMENTS

TABLE I. CLASSIFICATION OF QUALITY CONFORMANCE CHARACTERISTICS

100% examination shall be performed for critical characteristics unless otherwise stated. Examination for major and minor characteristics shall be performed in accordance with the classification of quality conformance characteristics contained herein. Inspection Level II shall be used and individual AQL's applied in accordance with MIL-STD-105.

<u>CLASS</u>	<u>CHARACTERISTIC</u>	<u>AQL or 100%</u>	<u>INSPECTION METHOD</u>
<u>CRITICAL:</u>	None defined		
<u>MAJOR:</u>			
101.	.590 Length	0.65	SMTE
102.	.460 Width	0.65	SMTE
<u>MINOR:</u>			
201.	Hardness	1.5	SMTE
202.	.116 Height .279R (ref)	1.5	SMTE
203.	.010 Maximum mismatch .125R (4 places)	1.5	Visual
204.	AA63 Surface roughness	1.5	ANSI-B36.1
205.	Defective protective coating	1.5	Visual
206.	Workmanship (See MIL-W-63150)	2.5	Visual

PART IV. CERTIFICATION PROVISIONS

The certification provisions of MIL-W-63150 for Certificate of conformance shall apply. Certification of Conformance are required for the following:

<u>NUMBER</u>	<u>CHARACTERISTIC</u>	<u>TEST DATA TO COMPLY WITH</u>
301	Material	Dwg. 8448536, Note 1
302	Phosphate Coating	DOD-P-16232
303.	Supplementary Oil	MIL-L-3150 & FED-STD-791

PART V. TEST METHODS AND PROCEDURES

None Required

					ORIG CODE IDENT 19204	CAGE CODE 19200
16.	REVISION SYMBOL AND DATE	E841126	F880218	G920910		10. QAP NO. 8448536
						14. PAGE NO. 3

QUALITY ASSURANCE PROVISIONS (QAP) - (CONTINUATION SHEET)

(DARCOM-R 702-10)

3. NOTICE: RESTRICTED AS TO USE AND DISCLOSURE (see page 1)

SPECIFICATIONS

MIL-L-3150	Lubricating Oil, Preservative, Medium
DOD-P-16232	Phosphate Coatings, Heavy, Manganese or Zinc Base (For Ferrous Metals)
MIL-W-63150	Weapons and Support Material, Standard Quality Assurance Provisions
ANSI-B46.1	Surface Texture (Surface Roughness, Waviness & Lay)

PART II. QUALITY PROVISIONS

1. Responsibility for Inspection. Unless otherwise specified in the contract, the contractor is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract, the contractor may use his own or any other facilities suitable for the performance of the inspection requirements specified herein, unless disapproved by the Government. The Government reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure supplies and services conform to prescribed requirements.

2. First Article Inspection.

2.1 Submission. Unless otherwise specified in the contract, a first article sample consisting of five (5) QAP items shall be submitted for inspection, testing and approval in accordance with the terms of the contract. As determined by the Government, the sample items may be subjected to any or all of the examinations and tests specified in this QAP and be inspected for compliance with any of the requirements.

2.2 Rejection. If any sample item fails to comply with any of the applicable requirements, the first article sample shall be rejected. The Government reserves the right to terminate inspection upon any failure to comply with any of the requirements.

3. Quality Conformance Inspection.

3.1 Quality Conformance Inspection shall consist of inspection of all characteristics contained in Part III "Inspection Requirements" and Part IV "Certification Provisions" of this QAP.

3.1.1 All other quality characteristics not specifically listed herein are subject to inspection under the contractor's quality or inspection system.

				ORIG CODE IDENT 19204		CAGE CODE 19200		
16.	REVISION SYMBOL AND DATE	E841126	G920910					
								10. QAP NO. 8448536
								14. PAGE NO. 2

QUALITY ASSURANCE PROVISIONS (QAP) (DARCOM-R 702-10)

1. COMMAND AGENCY:

U.S. ARMY ARMAMENT, RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, N.J. 07806-5000

2. THESE QAP'S FORM PART OF DRAWING/SPECIFICATION

8448536

AS SPECIFIED IN THE CONTRACT.

INSPECTION SHALL BE CONDUCTED AS SPECIFIED HEREIN AND IN ACCORDANCE WITH REFERENCED DOCUMENTS.

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Unless otherwise specified herein or in the contract, the provisions of MIL-W-63150 shall apply and are made part of this detail QAP.

PART I. LIST OF APPLICABLE DOCUMENTS**DRAWINGS**

B8448536

Spring, Rear Sight

STANDARDS

MIL-STD-105

Sampling Procedures and Tables for Inspection by Attributes

FED-STD-791

Lubricants, Liquid Fuels & Related Products, Methods of Testing

DISTRIBUTION STATEMENT F. Further distribution only as directed by ASQNC-AR or higher DoD authority 92-06-22.

REVISIONS

4. RELEASE NUMBER	50625	W2S0015	G7S3140	W6S0120					
5. DATE	750430	841126	880218	920910					
4. RELEASE NUMBER									
5. DATE									
REVISION STATUS OF SHEETS	6. REVISION	G	G	G					
	7. SHEET	1	2	3					
	6. REVISION								
	7. SHEET								
8. QAP FOR:	Spring, Rear Sight - used on M16/M16A1 Rifle				ORIG CODE IDENT 19204		CAGE CODE 19200		
9. SUBMITTED BY	<i>FJZ</i>				10. QAP NO.: 8448536				
11. DATE: 700528	12. APPROVED: <i>R. Lee</i>		13. RELEASE NO. 05105		14. PAGE NO.: 1		15. NO. OF PAGES: 3		

DARCOM FORM 2484-R-E

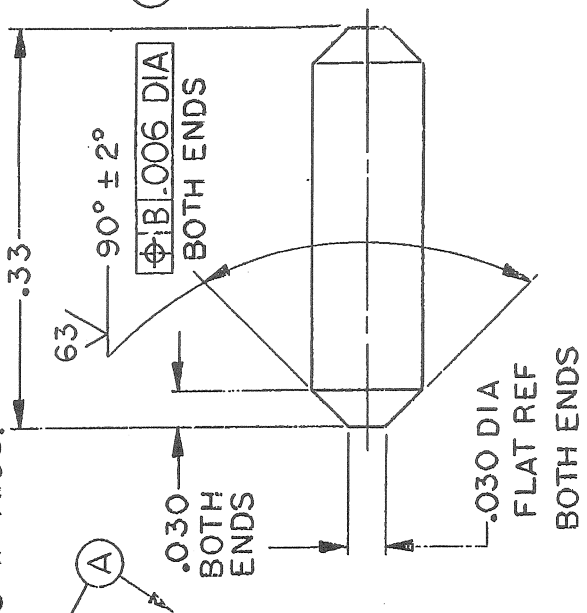
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7. HEAT TREATMENT:
QUENCH AND TEMPER
TO HARDNESS SPECIFIED.
8. MIL-W-13855 APPLIES.

NOTES:

1. STEEL, CMPSN 1012 THRU 1018 OR 1212, 1213, 1215, 1216, ASTM A108.
2. FINISH 125/ EXCEPT AS NOTED.
3. BREAK SHARP EDGES .005 MAX.
4. FINISH 11.2.1 OF MIL-STD-171, DO NOT BAKE FOR EMBRITTLEMENT RELIEF.
5. CARBURIZE TO .010/.015 TOTAL CASE DEPTH.
6. ALL DIMENSIONS APPLY AFTER FINISH. (A)



REVISIONS		
MR	ZONE	LTR
REDRAWN FROM COLT'S DRAWING		
C61698 REVISION B		
A	(4) SEE EO HRD 02197-3	15 JUL 70
B	(2) SEE ERR HQR 20778	6 OCT 72
C	NOR W9S2009 80-02-13	80-05-16
D	NORGOS3002/90-01-31	90-04-19
E	NORGOS2018/ 91-07-08	91-10-11
F	NOR G2S3112/921217	930224
G	NOR G4S3064 940620	940727

CURRENT DESIGN ACTIVITY CAGE CODE 19200
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

CONTRACT NO		DATE 27 APR 1970		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
PREP	CHK	ENGR	SUBMITTED	DETENT, TAKEDOWN PIN	
9390011	M4	F9327230	M23i	SIZE	CODE IDENT NO
F8448604	M16	F8448578	M16A1	B	19204
NEXT ASSY				SCALE	10/1
APPLICATION				SHEET	1 OF 1
MECHANICAL PROPERTIES				DRAWING NO	
YS	MIN	MAX	EL 2	8448585	
9390011	M4	F9327230	M23i		
F8448604	M16	F8448578	M16A1		
RH				15N 89-91	
USED ON					
APPLICATION					

PARTS LIST
DOCUMENT/PART NUMBER PL-8448638
CATCH. MAGAZINE B 8448638
CHANGE CONTROL NUMBER 76V0018

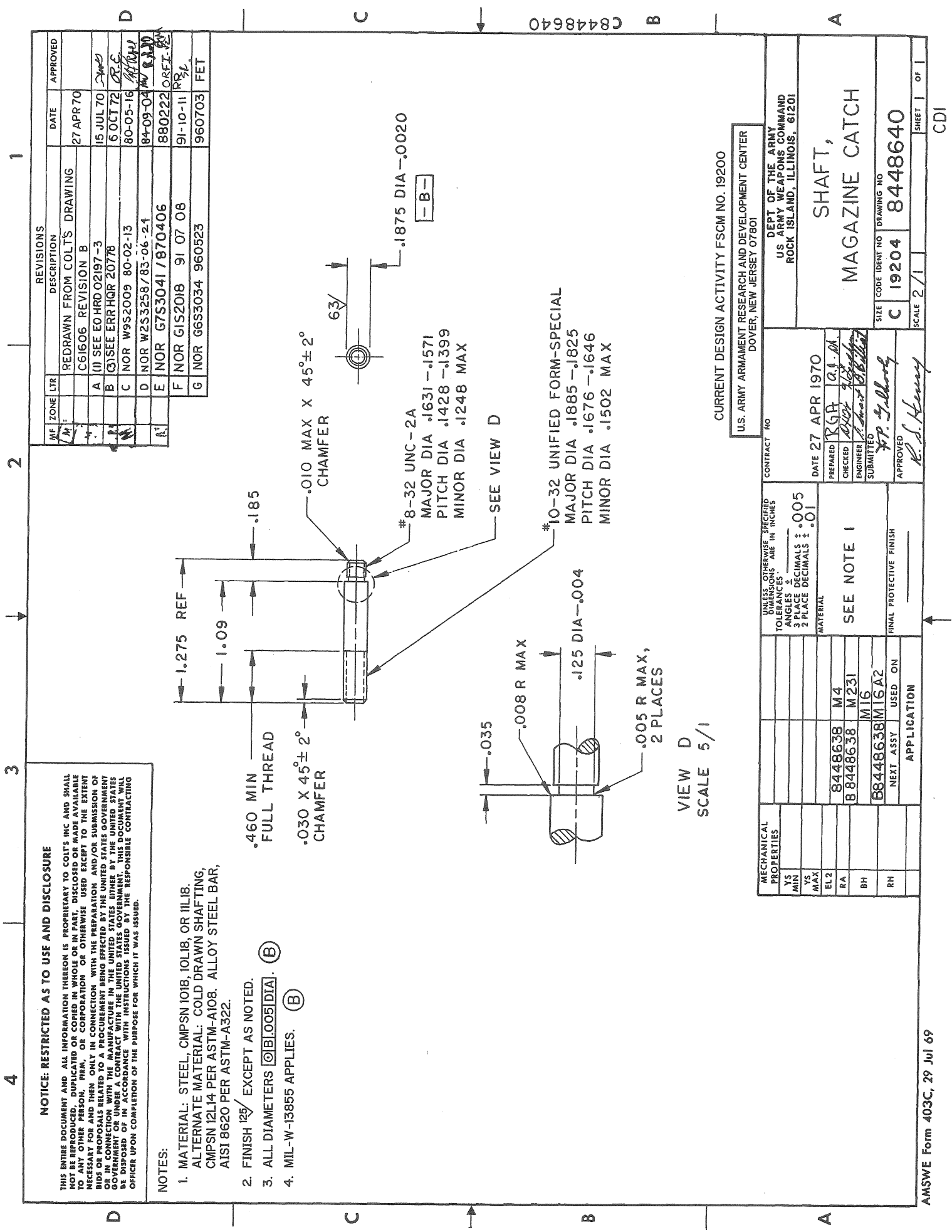
ROCK ISLAND ARSENAL
ROCK ISLAND IL
AUTHENTICATION- CODE ID 19204

REV. DATE 16 APR 76
REVISION LETTER A
SHEET 1
ORIG. DATE 27 APR 70

FND QTY	UNIT CODE	PART OR IDENTIFYING NO.	DRAWING/DOCUMENT SIZE	NOMENCLATURE OR DOCUMENT TITLE	SUP
1	8448639	C 8448639		PLATE, MAGAZINE CATCH	LST
1	8448640	C 8448640		SHAFT, MAGAZINE CATCH	

TOTAL NUMBER OF SHEETS 1

AR - AS REQUIRED, ALT - ALTERNATE, OPT - OPTIONAL, SO - SELECTION OPTIONAL



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NOTES:

1. MATERIAL: STEEL, CMPSN 1018, 1018, OR 1118.
ALTERNATE MATERIAL: COLD DRAWN SHAFING,
CMPSN 12L14 PER ASTM-A108. ALLOY STEEL BAR,
AISI 8620 PER ASTM-A322.
2. FINISH ¹²⁵ EXCEPT AS NOTED.
3. ALL DIAMETERS $\varnothing$ B.005 DIA. B.
4. MIL-W-13855 APPLIES. B.

REVISIONS

REV	ZONE	LTR	DESCRIPTION	DATE	APPROVED
1			REDRAWN FROM COLT'S DRAWING	27 APR 70	
2			C61606 REVISION B		
3			A (I) SEE EDRD 02197-3	15 JUL 70	
4			B (3) SEE ERR HQR 20778	6 OCT 72	
5			C NOR W9S2009 80-02-13	80-05-16	
6			D NOR W2S3258/83-06-24	84-09-04	
7			E NOR G7S3041/870406	880222	
8			F NOR GIS2018 91 07 08	91-10-11	
9			G NOR G6S3034 960523	960703	

CURRENT DESIGN ACTIVITY FSCM NO. 19200

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

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES DECIMALS ± .005 2 PLACE DECIMALS ± .01		CONTRACT NO	
YS MIN		SEE NOTE 1		DATE 27 APR 1970	
YS MAX				PREPARED RGH G.A. DA	
EL2				CHECKED RGH G.A. DA	
RA				ENGINEER RGH G.A. DA	
BH				SUBMITTED RGH G.A. DA	
RH				APPROVED R.S. Henry	
APPLICATION		NEXT ASSY USED ON		SIZE CODE IDENT NO DRAWING NO	
				C 19204 8448640	
				SCALE 2/1	
				SHEET 1 OF 1	

SHAFT,
MAGAZINE CATCH

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

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NOTES:

1. FINISH $\sqrt{125}$ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005 + .005 EXCEPT AS NOTED.
3. CARBURIZE .010 TO .015 TOTAL CASE DEPTH.
4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
5. MIL-W-13855 APPLIES. 
6. MATERIAL: STEEL, CMPSN 1018, PER ASTM-A108. ALTERNATE MATERIAL: STEEL, AISI 8620 PER ASTM-A322 OR ASTM-A505.

90° C SINK TO .180 DIA +.005
ONE SIDE ONLY

TAP THRU 8-32 UNC-2B THREAD
MINOR DIA .130 / .139

PITCH DIA .1437/.1475

MAJOR DIA .1640 MIN	≡ A .005 TOTAL
---------------------	----------------

①

-050, 2 PLACES

SHARP CORNER-

916 .816 .295

1.460

FULL R. BOTH ENDS

$$63 \sqrt{24c + 001}$$

-A-

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING C
PICATINNY ARSENAL, NEW JERSEY 07806-5000

CONTRACT NO.

DATE 27 APR 1970

RED PGD OK #

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RED *W. S. S. S.*

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1990

3407747 A 6

OVER

11

E. A. Kelms

AMSWE Form 403C, 29 Jul 69

October 15, 2004 11:17 AM

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DIRECTOR, ARMY RESEARCH AND DEVELOPMENT CENTER, FORT MONROE, VA 23060-0001.

NOTES: -

1 - SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

2 - MATERIAL: -

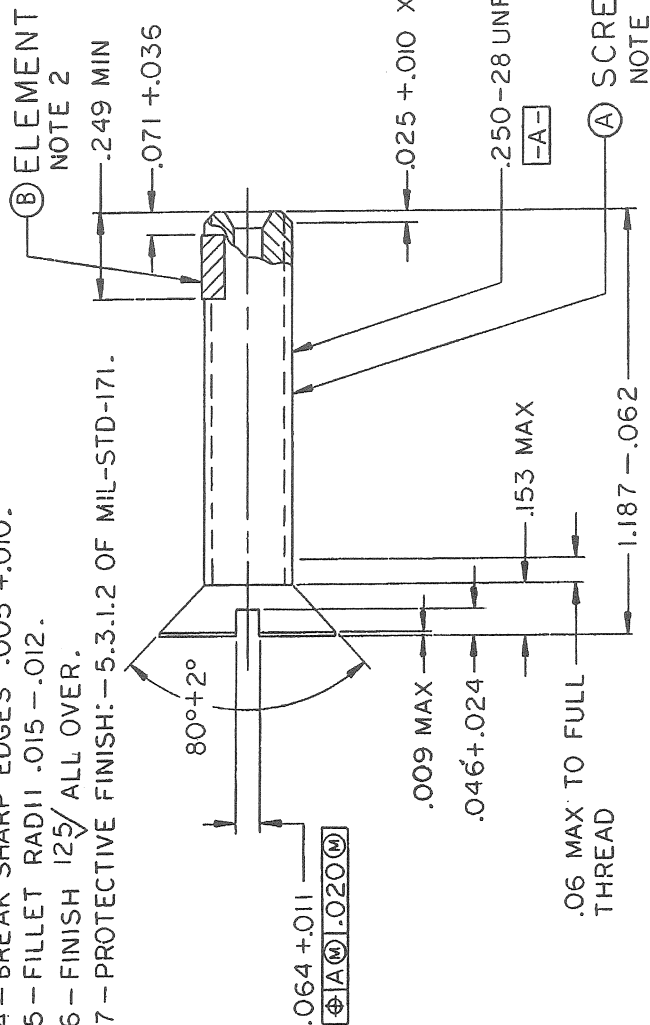
A. SCREW - STEEL WIRE OR ROD, CMPSN 1010 THRU
1018 OR 1018, SPEC. ASTM A108.B. ELEMENT - MUST MEET THE PERFORMANCE REQUIREMENTS
OF MIL-F-18240 CONFIGURATION A OR B PATCH. LOCATION
OF ELEMENT SHALL BE WITHIN THE DIMENSIONAL
LIMITATIONS OF STANDARD MS15981.3 - COVERAGE OF ELEMENT TO BE 90° MIN OF THREADED DIA.
RANDOM RADIAL LOCATION OF ELEMENT.

4 - BREAK SHARP EDGES .005 +.010.

5 - FILLET RADIUS .015 -.012.

6 - FINISH 125/ ALL OVER.

7 - PROTECTIVE FINISH: -5.3.1.2 OF MIL-STD-171.



PART NO. 9349128

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

SCREW, BUTT CAP

SIZE FSCM NO. 9349128

SCALE 4/1 UNIT WT.

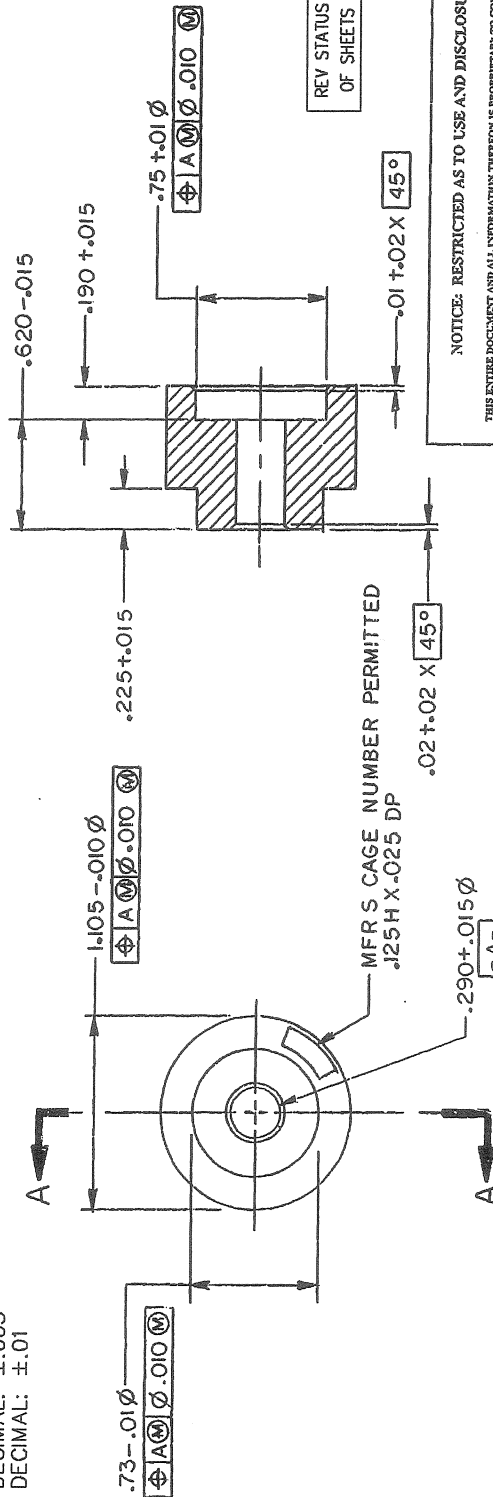
SHEET 1 OF 1

ORIGINAL DATE OF DRAWING 82-06-09	DRAFTSMAN E J Z	CHECKER A B
DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ENGR A B	ENGR A B
TOLERANCES ON DECIMALS ± FRACTIONS ±	ENGR A B	ENGR A B
MECHANICAL PROPERTIES	ENGR A B	ENGR A B
YF	ENGR A B	ENGR A B
TS	ENGR A B	ENGR A B
ELZ	ENGR A B	ENGR A B
BA	ENGR A B	ENGR A B
BH	ENGR A B	ENGR A B
RH	ENGR A B	ENGR A B
8448578 M16A1	ENGR A B	ENGR A B
8448604 M16	ENGR A B	ENGR A B
9349100 M16A2	ENGR A B	ENGR A B
NEXT ASSY	ENGR A B	ENGR A B
USED ON	ENGR A B	ENGR A B
APPLICATION	ENGR A B	ENGR A B

NOTES:-

- 1- SPEC MIL-W-13855 AND ANSI Y14.5-1973 APPLY.
- 2- MATERIAL: PLASTIC COMPOUND PER ASTM D-4066, PAI62.
- 3- COLOR: NATURAL
- 4- BREAK SHARP EDGES .010 ±.005 UNLESS NOTED
- 5- REMOVE ALL FLASH, ON PLASTIC PARTS ONLY.
- 6- PART SHALL BE FREE FROM POROSITY, CRACKING, DEFORMATION OR KNIT MARKS, ON PLASTIC PARTS ONLY.
- 7-
- 8- FINISH 125/ ALL SURFACES.
- 9- ALTERNATE MATERIAL: ALUMINUM ALLOY 2024-T351 SPEC QQ-A-225/6, ALTERNATE ALLOYS, 2017-T451 SPEC QQ-A-225/5, OR 6061-T651 SPEC QQ-A-225/8.
- 10- PROTECTIVE FINISH FOR ALTERNATE MATERIAL: MIL-A-8625, TYPE III CLASS 2, FILM THICKNESS .0010 ±.0002, SEALED.
- 11- DIMENSIONS SHOWN ARE BEFORE FINAL PROTECTIVE FINISH, ON ALUMINUM PARTS ONLY.
- 12- SEE SHEET 2 OF 2 FOR ALTERNATE PLASTIC MOLDED CONFIGURATION.
- 13- TOLERANCE UNLESS OTHERWISE SPECIFIED:
 - 3 PLACE DECIMAL: ±.005
 - 2 PLACE DECIMAL: ±.01

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
	PRODUCT BASELINE ERR 67S9452	88-01-19	
A	NOR 68S2004/880329	881007	
B	NOR 68S3107 881021	890221	
C	ERR 29Z1148J (ECP 69S3019/890421) (ECP 69S3031/890523)	890912	
D	NOR 69S2030/89-06-21	90-02-09	
E	NOR 61S3077/910626	910820	
F	NOR 62S3084/920924	921105	
G	NOR 62S2052/921217	930225	
H	NOR 66S9003/960722	961113	



REV	STATUS	REV	H	H
SH	1	1	2	2

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DISTRIBUTION STATEMENT F
DISTRIBUTION IS AUTHORIZED TO DOD AGENCIES AND DOD QUALIFIED
US ORDNANCE CONTRACTORS. FURTHER DISSEMINATION ONLY AS DI-
RECTED BY COMMANDER ARDEC ATTN: SMCAR-ESWROCK ISLAND
ASOCC-AR THIS DETERMINATION WAS MADE ON 91-10-25

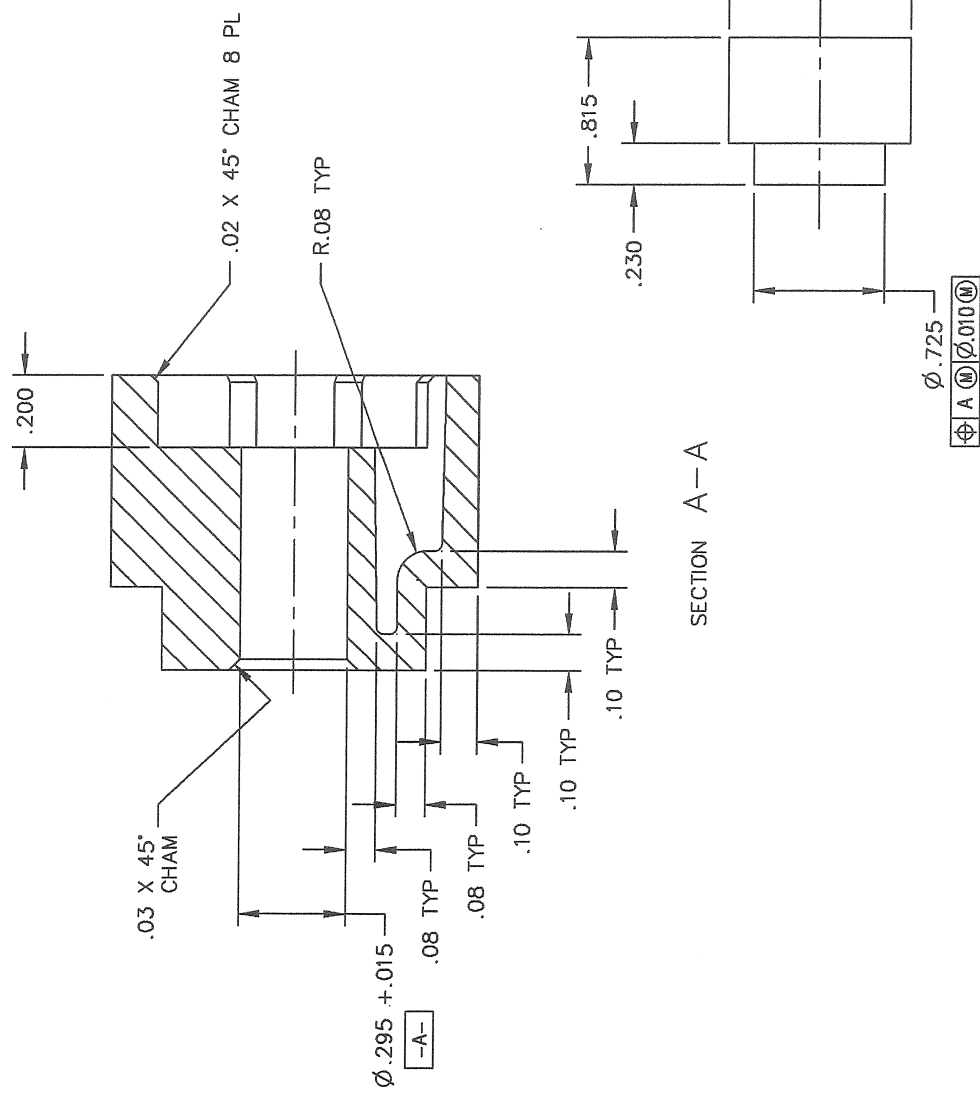
PART NO. 12597640

DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 88-01-19	U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER DOVER, NEW JERSEY 07801-8001	
MECHANICAL PROPERTIES		DRAFTSMAN J. BRENNAN	CHECKER ENGR	ENGR
YP		ENGR	ENGR	ENGR
TS		ENGR	ENGR	ENGR
EL2		ENGR	ENGR	ENGR
RA		ENGR	ENGR	ENGR
BH		ENGR	ENGR	ENGR
RH		ENGR	ENGR	ENGR
TOLERANCES ON DECIMALS ±		THIRD ANGLE PROJECTION		
FRACTIONS ±		ANGLES ±		
12556127 M16A1		NEXT ASSY USED ON		
9349100 M16A2		APPLICATION		
SIZE FSCN NO. C19200		SCALE 2/1 UNIT WT.		
PART NO. 12597640		SPACER, BUTT CAP		
SHEET 1 OF 2		SHEET 1 OF 2		

SMCAR FORM 67, 1 JUN 86(TEMP) REPLACES SMCAR FORM 67, 1 FEB 85.
WHICH MAY BE USED UNTIL EXHAUSTED

4 3 2 1

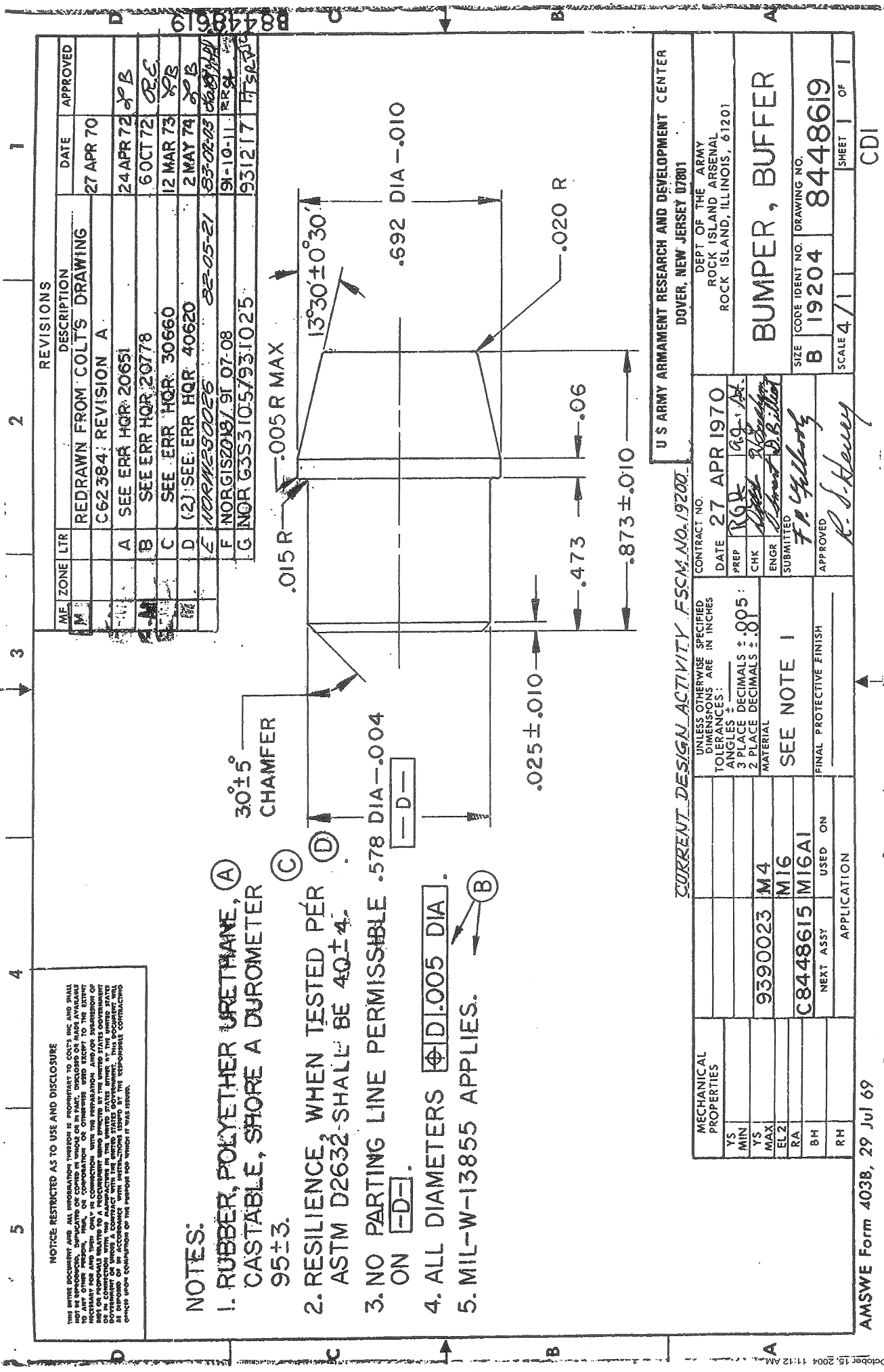
REVISIONS		
SYM	DESCRIPTION	DATE
H	THIS SHEET ADDED NOR C6S9003/960722	961113
		MG



ALTERNATE PLASTIC MOLDED CONFIGURATION

PART NO. I2597640	
U.S. ARMY ARMAMENT RESEARCH DEVELOPMENT AND ENGINEERING CENTER DOVER, NEW JERSEY 07802-6001	
SPACER, BUTTCAP	
SIZE	FSCN NO.
C 19200	I2597640
SCALE 2/1	UNIT WT.
SHEET 2 OF 2	

DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON DECIMALS 2 PL ± .01 FRACTIONS 3 PL ± .005 ANGLES ± THIRD ANGLE PROJECTION	
ORIGINAL DATE OF DRAWING 96-11-13	
DRAFTSMAN E.J.L.	CHECKER M.G.
ENGR	ENGR
ENGR	ENGR

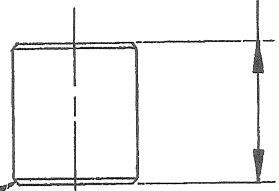


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- NOTES:
- STEEL, CMPSN 1013, 1015, 1213 OR 1215, ASTM A108
 - FINISH 125/ EXCEPT AS NOTED.
 - MIL-W-13855 APPLIES.

.015 X 45° ± 2° CHAMFER BOTH ENDS



	.005
	.005

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING	27 APR 70	
			B62342 REVISION B		
		A	SEE ERR HQR 20778	6 OCT 72	RE
		B	NOR W952009-80-02-13	80-05-16	RE
		C	ERR Z921182AU (ECP G8S3115 881109)	10-03-24	RE
		D	NOR G1S2018 91 07 08	91-10-11	RE
		E	NOR G3S3118 931130	940317	RE

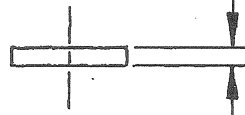
DISTRIBUTION STATEMENT F
DISTRIBUTION IS AUTHORIZED TO DOD AGENCIES AND DOD QUALIFIED US ORDNANCE CONTRACTORS. FURTHER DISSEMINATION ONLY AS DIRECTED BY COMMANDER ARDEC ATTN: SMCAR-FSM, PICATINNY ARSENAL, NJ 07805-5000. THIS TECHNICAL DATA PACKAGE CONTAINS SENSITIVE TECHNOLOGY ON A NEW WEAPON SYSTEM. THIS DETERMINATION WAS MADE ON JULY 1987.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801
CURRENT
CODE IDENT NO.
19200

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO		DEPT OF THE ARMY	
YS	MIN	TOLERANCES ARE IN INCHES		DATE 27 APR 1970		US ARMY WEAPONS COMMAND	
YS	MAX	ANGLES : .005		PREP R6D		FOCK ISLAND, ILLINOIS, 61201	
EL2	RA	3 PLACE DECIMALS : .005		CHK		WEIGHT, BUFFER	
RA	RA	2 PLACE DECIMALS : .005		ENGR		SIZE CODE IDENT NO. DRAWING NO.	
BH	BH	MATERIAL		SUBMITTED		B 19204 8448617	
RH	RH	SEE NOTE 1		APPROVED		SCALE 2/1	
APPLICATION		FINAL PROTECTIVE FINISH		R. J. Henry		SHEET 1 OF 1	
NEXT ASSY		MIL-STD-171				CDI	

[illegible]

1. MATERIAL:- RUBBER, SYNTHETIC, CLASS I, GRADE 70, SPEC MIL-R-6855. VALCANIZED RUBBER SHALL NOT INITIATE CORROSION UPON THE METALS THAT IT COMES INTO CONTACT.



-540 DIA-.020

[illegible]

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

DISC. BUFFER

SIZE	CODE IDENT NO.	DRAWING NO.
------	----------------	-------------

SCALE 2	1	SHEET	OF
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150

NOTES:

2.FINISH 125.
3.FILLET RADIUS TO BE .03.

5. ALL DIAMETERS TO BE Ø18.010 D

6. ALL DIMENSIONS APPLY BEFORE FINISH.

7: FINISH- MIL-A-8625, TYPE III, CLASS I, SEALED, 8
FILM THICKNESS .0010 ± .0002.
8 MIL-W-13855 APPLIES.

VIEW B
SCALE 10/1 ©

3 FLATS, EQUALLY-
SPACED WITHIN ±10°

⑤ .068 DIA +0.020, .030 DEEP -
CENTER PERMISSIBLE

.165 DIA MAX DRILL POINT
PERMISSIBLE AT $118^{\circ} \pm 4^{\circ}$ INCL ANGLE

71.005
71.005

SECTION A-A:

CURRENT DESIGN ACTIVITY TSCM NO. 19208
 • U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER

COVER, NEW JERSEY 171001

DEPT OF THE ARMY.
U.S. ARMY WEAPONS COMMAND.
ROCK ISLAND, ILLINOIS. 61201

100-44388-148 2

BODY: BUFFER

1975

SIZE	CODE	IDENT NO.	DISCOUNT NO.
1	2	3	4
5	6	7	8
9	10	11	12
13	14	15	16
17	18	19	20
21	22	23	24
25	26	27	28
29	30	31	32
33	34	35	36
37	38	39	40
41	42	43	44
45	46	47	48
49	50	51	52
53	54	55	56
57	58	59	60
61	62	63	64
65	66	67	68
69	70	71	72
73	74	75	76
77	78	79	80
81	82	83	84
85	86	87	88
89	90	91	92
93	94	95	96
97	98	99	100

D	19204	8448616
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SCALE 2/1 SHEET 1 OF 1



5

4

3

2

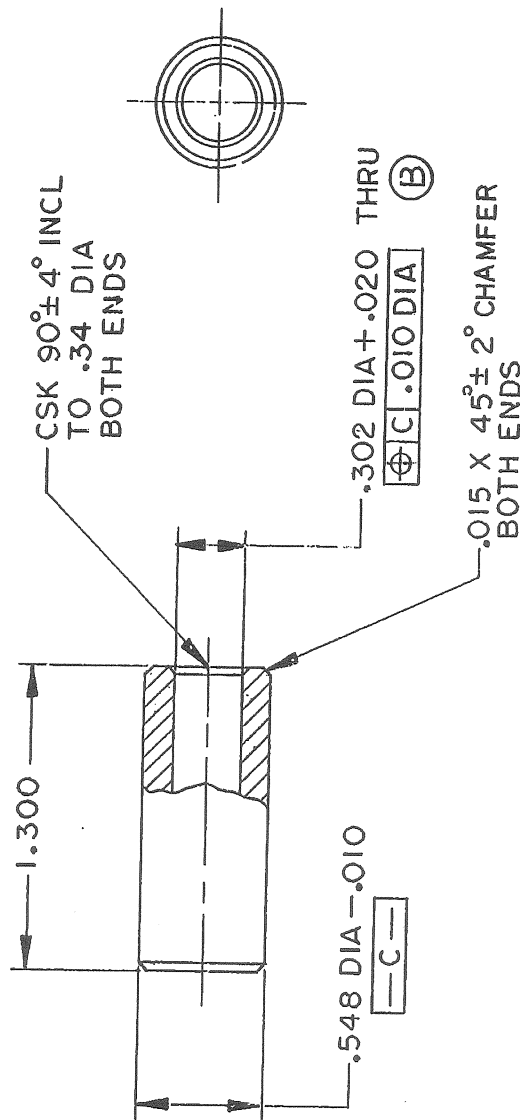
1

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NOTE:

1. AL ALLOY, 7075-T6 OR T651, COLD DRAWN PER QQ-A-225/9 OR AL ALLOY 7075-T6 OR T6510, EXTRUDED PER QQ-A-200/11.
2. FINISH 125/.
3. ALL DIMENSIONS APPLY BEFORE FINISH.
4. FINISH MIL-A-8625, TYPE III, CLASS I, FILM THICKNESS .0010 ± .0002.
5. MIL-W-13855 APPLIES.



REVISIONS			
ME.	ZONE	LTR	DESCRIPTION
			REDRAWN FROM COLT'S DRAWING
			B62412 REVISTON A
			A (2) SEE HQR 10689
			SEE ERR HQR 20778
			NOCHES0026
			82-05-21
			83-02-03
			84-04-10
			85-04-10
			86-04-10
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			95-04-10
			96-04-10
			97-04-10
			98-04-10
			99-04-10
			00-04-10

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

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DATE 27 APR 1970		DEPT OF THE ARMY	
YS	MIN	TOLERANCES:		PREP		R6D		U.S. ARMY WEAPONS COMMAND	
YS	MAX	ANGLES:		CHK		A.S. M.		ROCK ISLAND, ILLINOIS, 61201	
EL 2		3 PLACE DECIMALS ± .005		ENGR		A.S. M.			
RA		2 PLACE DECIMALS ± .01		SUBMIT		A.S. M.			
BH		MATERIAL		APPROVED		A.S. M.			
RH		SEE NOTE 1		P. J. HUNTER		A.S. M.			
NEXT ASSY		C8448615		MIG6		MIG6			
USED ON		MIG6		MIG6		MIG6			
APPLICATION		SEE NOTE 4		SEE NOTE 4		SEE NOTE 4			

SPACER, BUFFER

SIZE CODE IDENT NO. DRAWING NO.
B 19204 8448620

SCALE 2/1

SHEET 1 OF 1

AMSWE Form 4038, 29 Jul 69

CDI

ARMAMENT RESEARCH & DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801-5081

PARTS LIST
DOCUMENT/PART NUMBER C 8448615
BUFFER ASSEMBLY
CHANGE CONTROL NUMBER W552023
CURRENT FSCM NO. 19200 - ORIGINAL FSCM NO. 19204
REV. DATE 25 July 85
REVISION LETTER C
SHEET 1
AUTHENTICATION- *Edward J. Garner*
ORIG. DATE

FND QTY	UNIT FSCM	PART OR	DRAWING/DOCUMENT	NOMENCLATURE OR DOCUMENT TITLE	SUP
NO. REQ	MEAS	NO. IDENTIFYING	NO SIZE NUMBER		LST
1		8448521-1	B 8448521	PIN, SPRING	
1		8448616	D 8448616	BODY, BUFFER	
5		8448617	B 8448617	WEIGHT, BUFFER	
5		8448618	B 8448618	DISC, BUFFER	
1		8448619	B 8448619	BUMPER, BUFFER	
1		8448620	B 8448620	SPACER, BUFFER	

TOTAL NUMBER OF SHEETS 1

AR ~ AS REQUIRED, ALT - ALTERNATE, OPT - OPTIONAL, SD - SELECTION OPTIONAL

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NOTE:

1. VAPOR DEGREASE COMPONENTS NOTED.
2. INTERNAL COMPONENTS AND INTERIOR OF BUFFER BODY MUST BE FREE OF CHIPS AND/OR FOREIGN MATERIAL WHEN ASSEMBLED.

4. MIL-W-13855 APPLIES.

PIN, SPRING-8448521-I
ASSEMBLY AS SHOWNSPACER, BUFFER — 8448620
NOTE 1 APPLIESBODY, BUFFER — 8448616
NOTE 1 APPLIES5-DISC, BUFFER — 8448618
NOTE 1 APPLIESBUMPER, BUFFER
8448619NO GAP PERMISSIBLE
② AFTER ASSEMBLY5-WEIGHT, BUFFER — 8448617
NOTE 1 APPLIESPIN, SPRING SLOT TO BE
0°±90° FROM POSITION
SHOWN.120±.004 DIA THRU BUMPER BUFFER-8448619
AT ASSEMBLY USING HOLES IN BUFFER BODY
8448616 FOR LOCATION.025 MAX
BOTH ENDS

5.910 REF

DISTRIBUTION STATEMENT A FURTHER DISTRIBUTION ONLY
AS DIRECTED BY ASO/C-AIR OR HIGHER DOD AUTHORITY: 92-06-22

SEE PL-8448615

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.	
YS MIN		TOLERANCES: ANGLES ± 3 PLACE DECIMALS ± 2 PLACE DECIMALS ±		DATE 27 APR 1970	
YS MAX		MATERIAL		PREPARED	G-R [Signature]
EL 2				CHECKED	[Signature]
RA				ENGINEER	[Signature]
BH				SUBMITTED	[Signature]
RH				APPROVED	[Signature]
APPLICATION		NEXT ASSY USED ON		FINAL PROTECTIVE FINISH	
F8448604 M16					
F8448578 M16AI					

CURRENT DESIGN ACTIVITY

FSCM NO. 19200

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

BUFFER ASSEMBLY

C 19204 8448615

SCALE 2/1

SHEET 1 OF 1

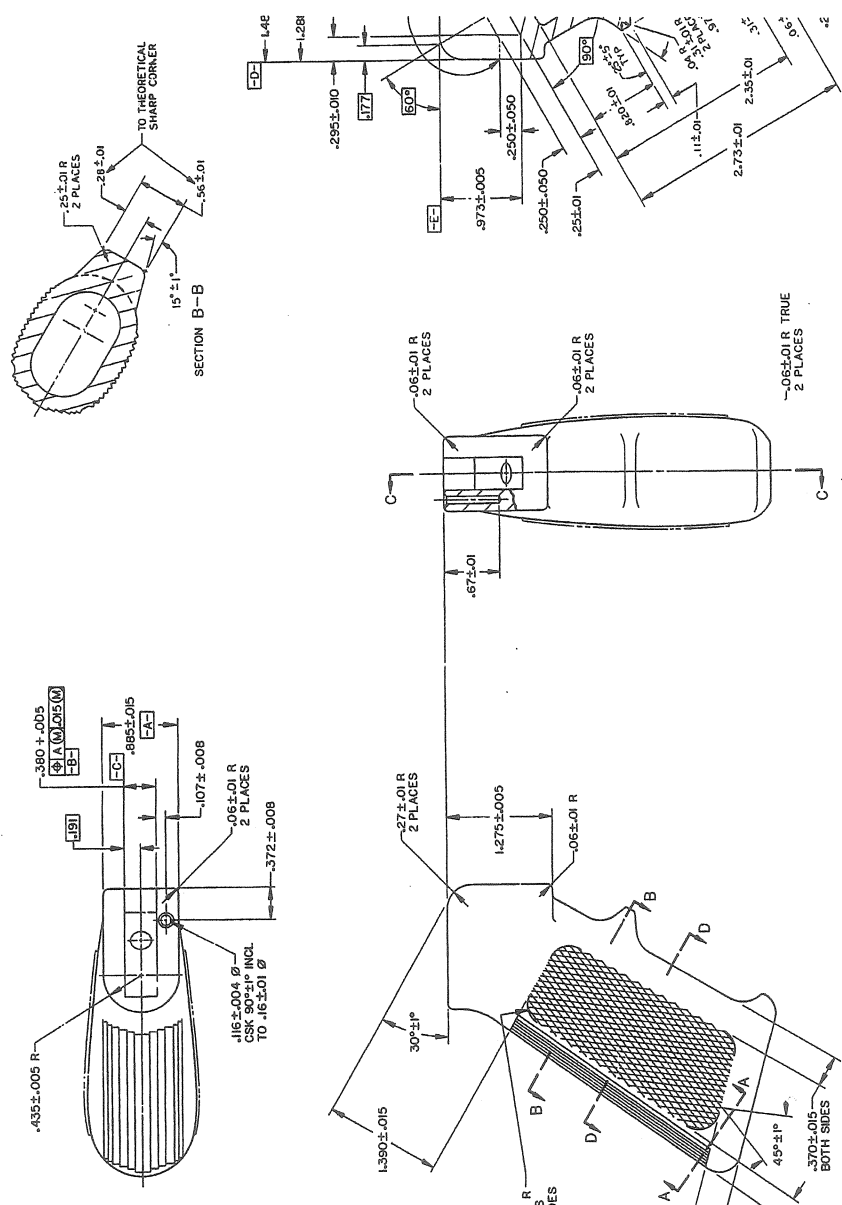
F-212

PART NO 9349127		GRIP, PISTOL		
FSCM NO. J 19200		9349127		
REV 1		REV 1		
REV 2		REV 2		
REV 3		REV 3		
REV 4		REV 4		
REV 5		REV 5		
REV 6		REV 6		
REV 7		REV 7		
REV 8		REV 8		
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REV 12		DO NOT SCALE DIMENSIONS TOLERANCES ON DIMENSIONS ARE IN INCHES TOLERANCES ON ANGLES ARE IN DEGREES	AB	
REV 13				
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REV 200		REV 200	

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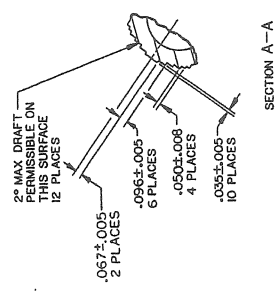
- NOTES:-
- 1—SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.
 - 2—MATERIAL: PLASTIC COMPOUND PER ASTM D4066, PL 162, TYPE 1, BUT NOT LIGHTER THAN GRAY, NO. 36076 TABLE VIII OF FED-STD-360.
 - 3—BREAK SHARP EDGES .010±.005 UNLESS OTHERWISE NOTED.
 - 4—FILLT RADI .009±.006 UNLESS OTHERWISE NOTED.
 - 5—REMOVE ALL FLASH.
 - 6—PART SHALL BE FREE FROM POROSITY, CRACKING, DEFORMATION AND/OR KNOT MARKS.
 - 7—FINISH:—EXTERNAL SURFACES MUST HAVE DULL MATTE FINISH.
 - 8—FINISH $\sqrt{125}$ ALL SURFACES UNLESS OTHERWISE NOTED.



J9349.27

F-1/2

REV J



SECTION A-A

WEAPON MFR'S IDENTIFICATION SYMBOL: .125±.015 HIGH .010±.005 DEEP. THE IDENTIFICATION SYMBOL IS TO BE LOCATED IN APPROX. POSITION SHOWN.

NOTICE: RESTRICTED AS TO USE AND DISCLOSURE

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NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313
2. PRECIPITATION HEAT TREAT AFTER FORMING, TO CONDITION CH900. HOLD AT 900°F ± 10° FOR ONE HOUR. AIR COOL.
- 3.

5. BREAK SHARP EDGES .003 ± .012

4. MIL-W-13855 APPLIES.

REVISIONS			
MF	ZONE	DESCRIPTION	DATE
B		REPLACES REV A W/CHANGE SEE ERR HQR 20778	6 OCT 72
C		NOR W952009 80-02-13	80-05-16
D		NOR W252015 82-08-20	83-02-03
E		NOR W250011 / 82-04-13 (ECP W353120 / 83-07-07)	83-11-04
F		NOR W58004/860204	890215

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER ----- 0.340 ± 0.005
COIL DIAMETER (OD) ----- 3.00 MAX
FREE LENGTH ----- 1.579 REF
TOTAL COILS ----- 15 REF
DIRECTION OF HELIX ----- OPTIONAL
LOAD AT COMPRESSED LENGTH OF 644 ----- 70 LB ± 7 LB
LOAD AT COMPRESSED LENGTH OF 902 ----- 50 LB ± 5 LB
SPRING RATE ----- 7.5 LB/IN REF
SOLID LENGTH ----- 5.175 MAX
TYPE OF ENDS ----- CLOSED, GROUND
MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

CURRENT DESIGN ACTIVITY CASE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 8448659

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY	
YS		TOLERANCES:		DATE 5 JUN 70		U.S. ARMY WEAPONS COMMAND	
MIN		ANGLES:		PREP <i>P. J. O'Connor</i>		ROCK ISLAND, ILLINOIS 61201	
YS		3 PLACE DECIMALS ± .005		CHK <i>G. D. Bunker</i>		SPRING, HELICAL,	
MAX		2 PLACE DECIMALS ± .		ENGR <i>P. J. O'Connor</i>		COMPRESSION	
EL 2		MATERIAL		SUBMITTED		SIZE CODE IDENT NO. DRAWING NO	
RA		SEE NOTE 1		APPROVED <i>P. J. O'Connor</i>		B 19204 8448659	
BH		FINAL PROTECTIVE FINISH		NEXT ASSY		SCALE NONE	
RH	15N84.5MIN	54 OF MIL-STD-171		APPLICATION		SHEET 1 OF 1	

AMSWE Form 403B, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

DUPLICATE ORIGINAL

5

4

3

2

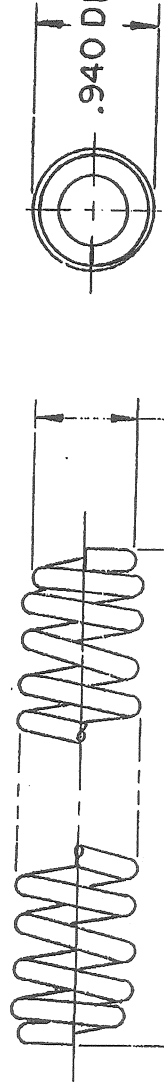
1

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NOTES:

1. WIRE, STAINLESS STEEL, TYPE 316, (17-7PH) COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO COND TN CH 900. HOLD AT 900°F ± 10° FOR ONE HOUR. AIR COOL.
3. MIL-W-13855 APPLIES. (B)
4. BREAK SHARP EDGES .003 ± .012.



SPRING DATA	
WIRE DIA:	.072 ± .001
TOTAL COILS:	44 REF
DIRECTION OF HELIX: OPTIONAL	
LOAD AT COMPRESSED LG OF 4.415 IN MIN OPERATING	
LENGTH =	10.9 LBS ± 1.0 LBS
LOAD AT COMPRESSED LG OF 8.190 MEAN ASSEMBLED	
LENGTH =	5.8 LBS ± 1.5 LBS
SOLID LENGTH:	3.285 MAX
TYPE OF ENDS: CLOSED, REDUCED AND SQUARED	

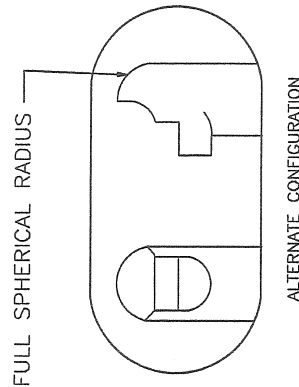
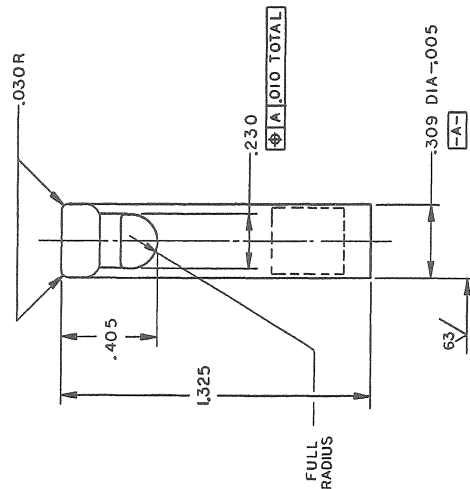
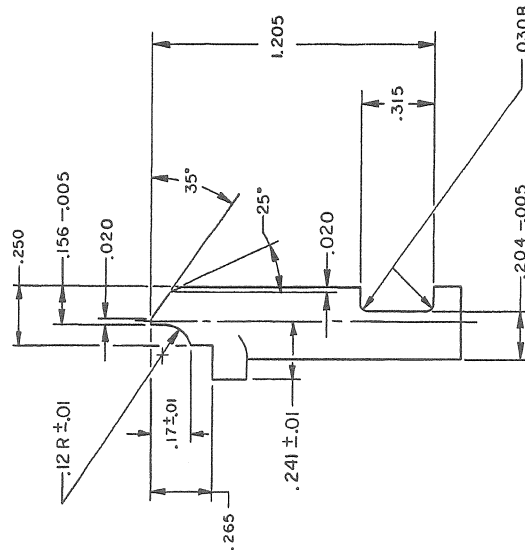
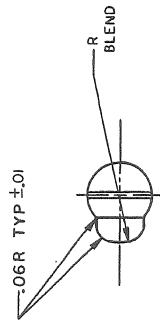
(B) MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY	
YS		TOLERANCES:		DATE	27 APR 1970	U.S. ARMY WEAPONS COMMAND	
MIN		ANGLES		PREP	9/23/70	ROCK ISLAND, ILLINOIS, 61201	
YS		3 PLACE DECIMALS ± .005		CHK	9/23/70	SPRING ACTION	
MAX		2 PLACE DECIMALS ± .01		ENGR	9/23/70		
EL-2		MATERIAL		SUBMITTED	9/23/70		
RA		SEE NOTE 1		APPROVED	9/23/70	SIZE	CODE IDENT NO.
BH						B	19204
RH	15N 84.5 MIN	FINAL PROTECTIVE FINISH	5.410F-MIL-STD-171			DRAWING NO.	8448629
APPLICATION		NEXT ASSY	USED ON	SCALE			
				NONE			
				SHEET 1 OF 1			

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
FOCM NO. 19200
CURRENT DESIGN ACTIVITY
DOVER, NEW JERSEY 07801

NOTE:

- 1-SPEC MIL-W-13955 APPLIES
2-MATERIALS--STEEL BAR, CARBON GRADE 1117 COLD FINISHED PER ASTM A108.
ALTERNATIVE MATERIAL: STEEL A151 1018.
3-CARBURIZE(TOTAL CASE DEPTH .006 TO .011) HARDEN AND TEMPER.
HARDNESS TO BE FILE HARD.
4-FINISH--▽ EXCEPT AS NOTED.
5-PROTECTIVE FINISH--5.3.1.3 OR 5.3.2.3 PLUS .30.7 OF MIL-STD-171.

[illegible]

SYN	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERR W353149/83-11-14	F4 C/LB	TT
A	NOR W453013/84-06-01	840913	W453013
B	NOR W450030/84-11-15	850402	W450030
C	NOR W653004/86-12-24	6/0218	W653004
D	NOR W558004/860204	9050215	W558004
E	NOR L753006/970224	970321	DR

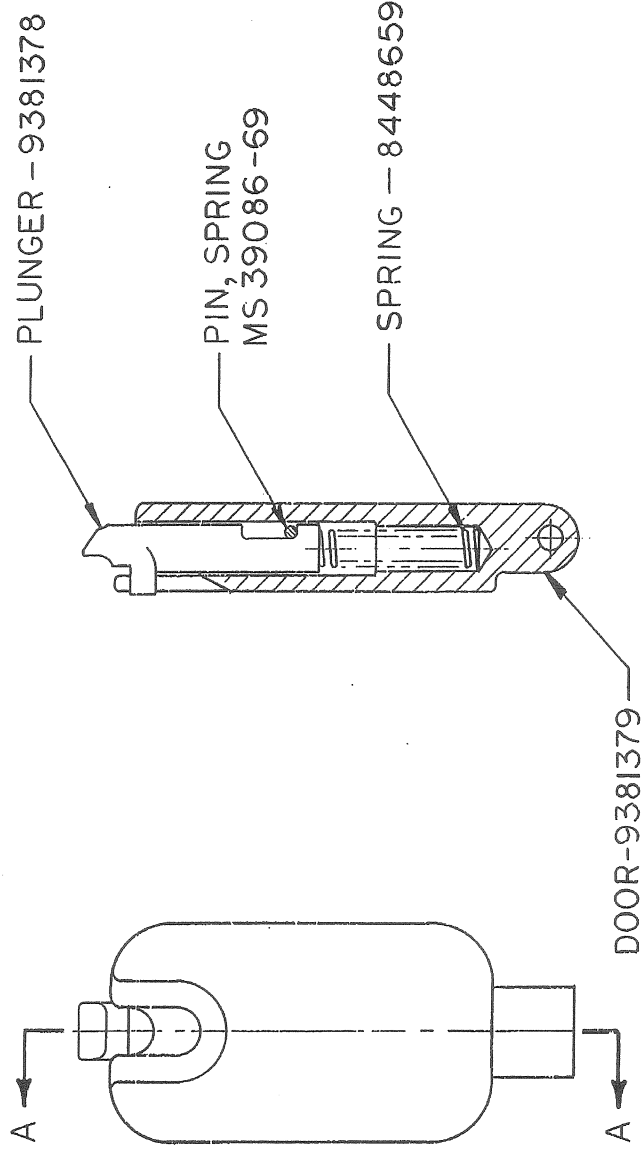
[illegible]

NOTES:
1-SPEC MIL-W-13855 APPLIES.

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REVISIONS		
SYM	DESCRIPTION	DATE
-	PRODUCTION RELEASE ERR W3S3149/83-11-14	01 02 10
A	NOR W5S8004/860204	890215

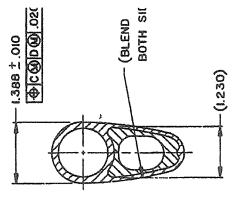


SEE SEPARATE PARTS LIST - 9381380

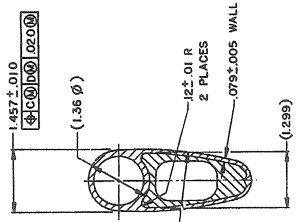
PART NO. 9381380

ORIGINAL DATE OF DRAWING 84-02-02		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DOOR ASSEMBLY, THUMB LATCH	
TOLERANCES ON DECIMALS ± FRACTIONS ± ANGLES ±		SIZE C	
FSCM NO. 19200		9381380	
SCALE 2/1		UNIT WT. SHEET	

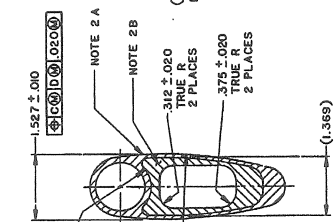
1- SPEC MIL-W-13055 AND ANSI Y14.5-73
 2- MATERIAL -
 A. POLYESTER COMPOUND PER 9349122.
 B. PLASTIC COMPOUND WITH PAPI CATALYST. THE STOCK CAVITY SHALL BE ROUGHENED FOR FOAMING BY SANDING. THE CAVITY SHALL THEN BE CLEANED AND PRIMED WITH A MIXTURE OF EQUAL VOLUMES OF PRIMER PERAST-4700. THE PRIMER SHALL BE APPLIED BY BRUSH OR SWAB APPLICATION OR DILUTED TO DESIRED VISCOSITY FOR SPRAY APPLICATION WITH SOLVENT PER 9349122. THE THICKNESS SHALL BE AT LEAST ONE (1) MINUTE DRY ROOM TEMPERATURE BEFORE APPLICATION OF FOAM. THE STOCK CAVITY SHALL BE COMPLETELY FILLED WITH PLASTIC COMPOUND AND BE PROVIDED WITH CAVITY HAVING A HARD, SMOOTH SURFACE OF .03 MINIMUM THICKNESS. THIS THICKNESS SHALL INCLUDE THE ENTIRE MASS AND THERE SHALL BE NO BLOW HOLES EITHER IN THE SKIN ITSELF OR ADJACENT TO THE SKIN.
 3- BREAK EDGES .02 MAX EXCEPT AS NOTED.
 4- FILLET RADI .03 MAX EXCEPT AS NOTED.
 5- DIMENSIONS APPLY AT INTERSECTION OF STRAIGHT LINES.
 6- WITHIN DIMENSIONAL REQUIREMENTS ALL DIMENSIONAL SECTIONS SHALL BE SMOOTHLY BLENDED.
 7- SURFACES UNIFORMLY REDUCED TO BLEND INTO AREA [F].
 8- SURFACES UNIFORMLY INCREASE IN AREA [F].
 9- REMOVE ALL FLASH.
 10- NO CRACKS PERMISSIBLE ON HARD MOLDED SHELL.
 11- IRREGULARITIES PERMISSIBLE ON EXTERIOR SURFACES, NOT TO EXCEED .156 ± .010 HIGH CYCLE MEASUREMENT OF EACH CRACK. CRACKS OF THE MOLDED SHELL SHALL BE CAPABLE OF WITHSTANDING AN IMPACT OF 5 IN-LB WITHOUT VISIBLE EVIDENCE OF FAILURE. SUCH AS CRACKING OR CHIPPING. THE IMPACTING SURFACE SHALL BE SUPPORTED BY A RADIUS OF .125 ± .010 INCHES ON THE STRIKING SURFACE. THE SHELL SHALL BE 50% HOLLOW (SEE NOTE IN ZONE C-9).
 12- THE SHELL SHALL BE CONSIDERED TO BE STRIKE PERPENDICULAR TO THE INDICATED AREA ON THE SHELL (SEE NOTE IN ZONE C-9).
 13- FINISH ON ALL EXTERIOR SURFACES SHALL BE UNLESS OTHERWISE SPECIFIED. BLACK AND STAINLESS STEEL FINISH SHALL BE UNLESS OTHERWISE SPECIFIED. TABLE VIII OF FED-STD-593.
 14- FINISH 125/ ALL SURFACES EXCEPT AS NOTED.



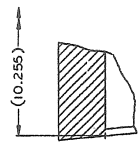
SECTION D-D



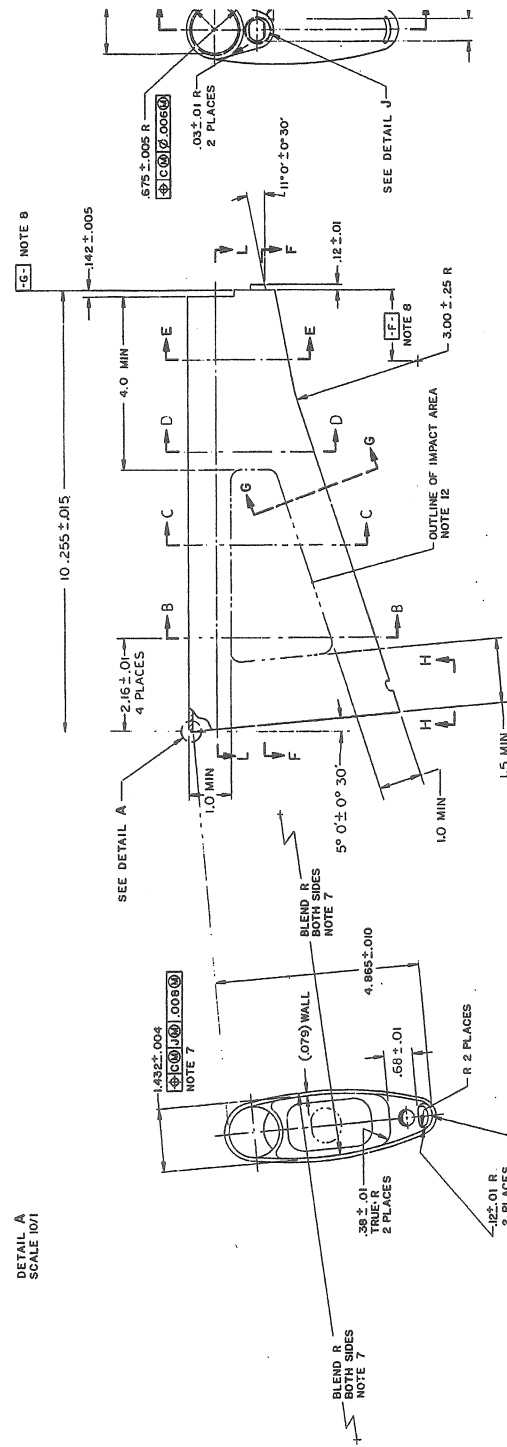
SECTION C-C



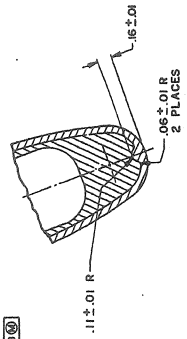
SECTION B-B



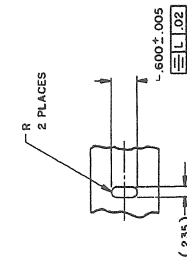
DETAIL A
SCALE 10/1



J934912
REV G
F-1/2



SECTION G-G
SCALE: 2/1



VIEW H-H

[illegible]

SECTION F-F

SECTION E-E

SECTION D-D

SECTION K-K

SECTION L-L

DETAIL J
SCALE: 4/1

VIEW H-H

F-2/2

PARTS LIST

DOCUMENT/PART NUMBER C 8448612
 HAMMER AND HAMMER PIN RETAINER ASSY

CHANGE CONTROL NUMBER 76V0018

ROCK ISLAND ARSENAL
 ROCK ISLAND IL

CODE ID 19204

AUTHENTICATION-

Loren Bunter

REV. DATE 16 APR 76
 REVISION LETTER B

SHEET 1

ORIG. DATE

FND QTY UNIT CODE PART OR DRAWING/DOCUMENT
 NO. REQ MEAS ID IDENTIFYING NO SIZE NUMBER

1	8448613	F	8448613	HAMMER	
1	8448614	B	8448614	RETAINER, HAMMER PIN	

TOTAL NUMBER OF SHEETS 1

SUP
 LST

AR - AS REQUIRED, ALT - ALTERNATE, OPT - OPTIONAL, SO - SELECTION OPTIONAL

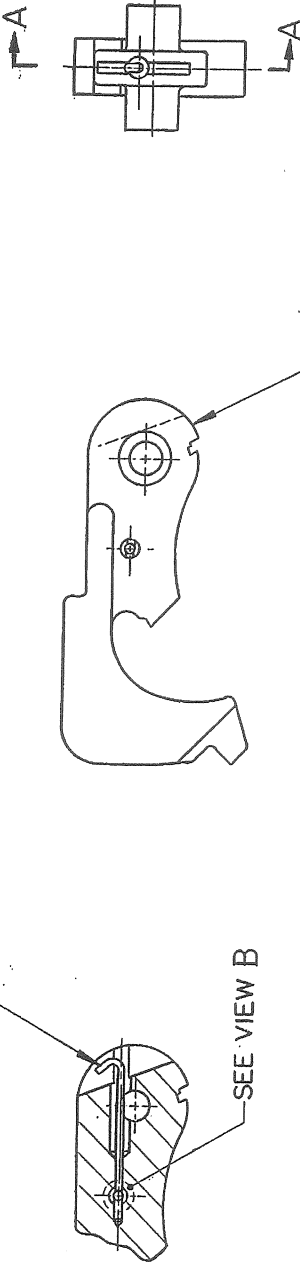
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NOTES:

1. COIN BOTH SIDES OF RETAINER, 8448614 TO [-C-]. AFTER COINING, RETAINER SHALL HAVE .010 MIN LONGITUDINAL MOVEMENT. (B)
2. MIL-W-13855 APPLIES. (A)

RETAINER, HAMMER PIN - 8448614



PARTIAL SECTION A-A

HAMMER - 8448613

VIEW B
SCALE 4/1

SEE PL- 8448612

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
YS	MIN	TOLERANCES:	ANGLES 2
YS	MAX	3 PLACE DECIMALS	2 PLACE DECIMALS
EL2			
RA			
BH			
PH			

DATE 27 APR 1970	PREPARED BY <i>W. J. M.</i>	DATE 27 APR 1970	PREPARED BY <i>W. J. M.</i>
	CHECKED BY <i>W. J. M.</i>		CHECKED BY <i>W. J. M.</i>
	ENGINEER <i>W. J. M.</i>		ENGINEER <i>W. J. M.</i>
	SUBMITTED BY <i>W. J. M.</i>		SUBMITTED BY <i>W. J. M.</i>
	APPROVED BY <i>W. J. M.</i>		APPROVED BY <i>W. J. M.</i>

B8448610	MIG	USED ON	APPLICATION
NEXT ASSY			

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

DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	HAMMER AND HAMMER PIN RETAINER ASSEMBLY
SIZE CODE IDENT NO. DRAWING NO.	C 19204 8448612
SCALE	2/1
SHEET	OF 1

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C62317 REV A	27 APR 70	
		A (2)	SEE EO HQR-10651	20 FEB 71	<i>W. J. M.</i>
		B (2)	SEE ERR HQR 20778	6 OCT 72	<i>W. J. M.</i>
		C	NOE ME 50026 82-05-21	83-02-03	<i>W. J. M.</i>

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NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.

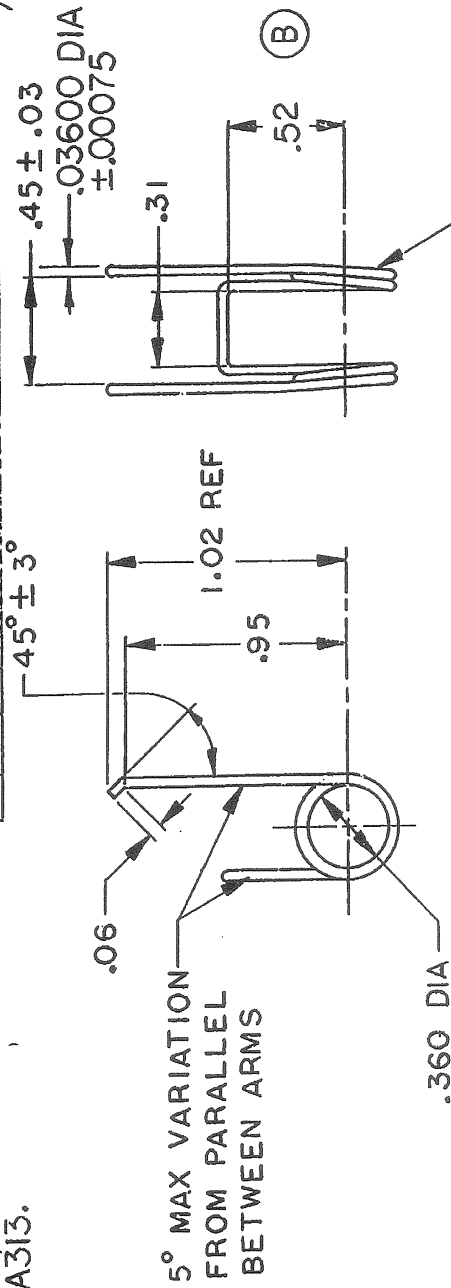
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITION CH-900. HOLD AT 900°F ± 10° FOR 1 HOUR. AIR COOL.

3. TORQUE REQUIREMENT: 1.5 ± .27 LB IN. TORQUE AT 45° DEFLECTION

4. FINISH 5.4.1 OF MIL-STD-171.

5. MIL-W-13855 APPLIES.

REV	DATE	DESCRIPTION	APPROVED
1	27 APR 70	REDRAWN FROM COLT'S DRAWING	
2	15 JULY 70	B61657 REVISION B	
3	20 FEB 71	A (1) SEE EO HRD 02197-3	
4	6 OCT 72	B (3) SEE EO HQR 10639	
5	80-05-16	C (2) SEE ERR HQR 20778	
6	82-04-13	D NOR W9S2009 80-02-13	
7	83-11-04	E NOR W250011 / 82-04-13 (ECP W250034 / 82-07-15)	
8	900815	F NOR G053100/90-06-28	



CURRENT

FSCM NO. 19200

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

MECHANICAL PROPERTIES	9390011	M4	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
YS MIN	9349115	M16A2	TOLERANCES:
YS MAX	F9327230	M231	ANGLES ± .005
EL2		M16	3 PLACE DECIMALS ± .01
RA		M16A1	2 PLACE DECIMALS ± .01
BH			MATERIAL
RH	15N 84.5 MIN		SEE NOTE 1
			FINAL PROTECTIVE FINISH
			SEE NOTE 4
			APPLICATION
			NEXT ASSY
			USED ON

CONTRACT NO.	DATE	27 APR 1970
PREP	CHK	ENGR
APPROVED	SUBMITTED	
APPROVED	SUBMITTED	

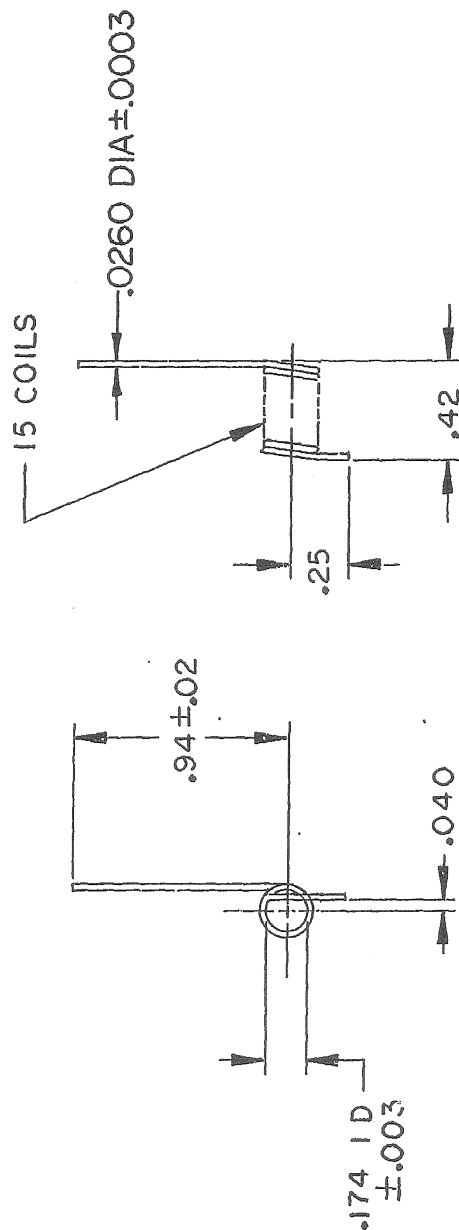
DRAWING NO.			8448593	
SIZE	CODE IDENT NO.	DRAWING NO.		
B	19204	8448593		
SCALE 2/1		SHEET 1 OF 1		

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1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH) COLD DRAWN, ASTM A313.

2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITION CH-900. HOLD AT $900^{\circ}\text{F} \pm 10^{\circ}$ FOR ONE HOUR. AIR COOL.
3. 15° MAX VARIATION PERMISSIBLE FROM 180° SPECIFIED RELATIVE TO OPPOSING ARMS.
4. MIL-W-13855 APPLIES.

REVISIONS					
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLTS DRAWING	27 APR 70	
			B61616 REVISION B		
		A	(1) SEE EO HRD 02197-3	15 JULY 70	<i>[Signature]</i>
	-W-	B	(3) SEE ERR HQR 20778	6 OCT 72	<i>[Signature]</i>
		C	NOR W250011 / 82-04-13		
		D	DECP W250034 / 82-07-15	89-11-04	<i>[Signature]</i>
		D	NOR GIS2018 91 07 08	91-10-11	<i>[Signature]</i>

[illegible]

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER

AMSWF Form 403B, 29 Jul 69

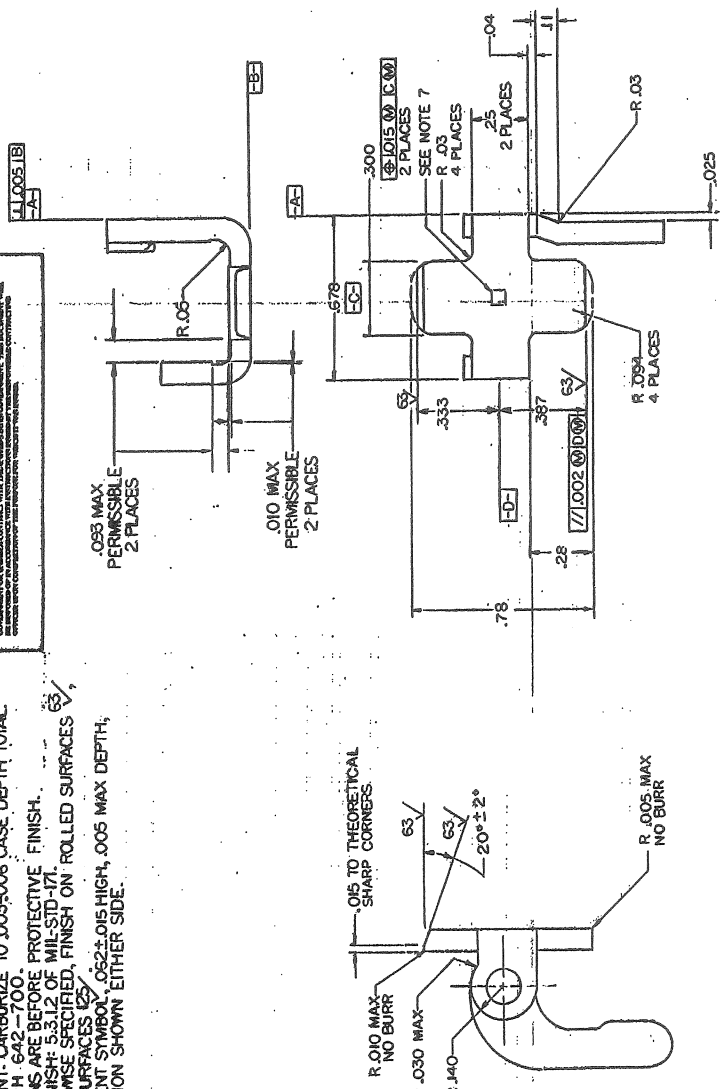
100

• **SALON**

- 1- SPEC MIL-W-13855, ANSI Y4.5M-82 AND DOD-STD-100 APPLY.
2- MATERIAL: STEEL, ALLOY, ANNEALED, GRADE 4150, ASTM A565,
3- 5065 OR A570. STOCK THICKNESS .035X.002.
4- HEAT TREATMENT: CARBURIZE TO .005-.006 CASE DEPTH. TOTAL
5- HARDNESS: DPH 642-700.
6- ALL DIMENSIONS ARE FOR PROTECTIVE FINISH.
7- PROTECTIVE FINISH: 5.312 OF MIL-STD-17.
8- UNLESS OTHERWISE SPECIFIED, FINISH ON ROLLED SURFACES
9- ON SHEARED SURFACES.
10- F-MARK MFG IDENT SYMBOL .062X.015 HIGH.
11- APPROX POSITION SHOWN EITHER SIDE.

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NEW YORK, N.Y. 10028-1576



REVISIONS		DATE	BY	APPROVED
ZONE	DATE	DESCRIPTION		
		REDRAWN WITH CHANGE NOR G153093 910805 F NOR G153146 911021 (ECP G153176 911220)	PC	920204
		G NOR G253044/920626		920625
		H NOR G253062 930715		930915

CURRENT DESIGN ACTIVITY CODE CODE 15200
U.S. ARMY
RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
DISTRIBUTION CODE NEW ARMY 07008-5000

PART NO 8448596

[illegible]

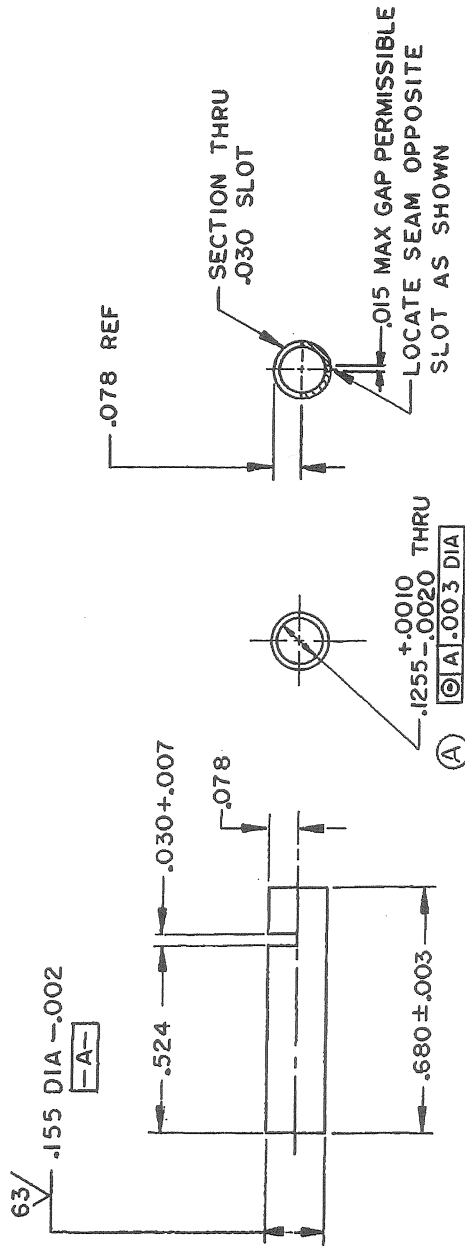
DISTRIBUTION STATEMENT: FURTHER DISTRIBUTION ONLY
AS DIRECTED BY DOD CONTROLLING OFFICE: ASQC-ARE-CI
OR, HATCHER DOD AUTHORITY: DETERMINATION NUMBER: 91-36-25.

SMICAR FORM 68, 1 DEC 87(TEMP), REPLACES SMICAR FORM 68, 1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED

REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		E	NOR G5S3110 / 951120	951221	18 FEB 95

1. STEEL, CORROSION RESISTING,
FREE MACHINING, TYPE 303,
ASTM A 484.
2. FINISH ¹²⁵✓ EXCEPT AS NOTED.
3. BREAK ALL SHARPEGES
.005 R MAX.
4. MIL-W-3855 APPLIES.



BLANKED AND FORMED
—ALTERNATE METHOD—

MATERIAL REQUIRED:
STAINLESS STEEL, AISI
TYPE 304, STRIP ANNEALED
(.014 THICK REF)

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL NEW JERSEY 07808-5000

DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201		BUSHING, AUTOMATIC SEAR		SIZE C CODE IDENT NO. 19204 DRAWING NO. 8448597	SCALE 4/1 SHEET 1 OF 1
CONTRACT NO:		DATE 27 APR 1970			
UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES ANGLES : 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS :		PREPARED <i>RGR</i> CHECKED <i>A. S. H. H. H.</i> ENGINEER <i>J. H. H. H.</i> SUBMITTED <i>B. H. H.</i>		APPROVED <i>R. S. H. H.</i>	
MATERIAL		SEE NOTE 1.		FINAL PROTECTIVE FINISH 5.4.1 OF MIL-STD-171	
MECHANICAL PROPERTIES		8448595 M4		APPLICATION	
YS MIN		8448595 M16		NEXT ASSY USED ON	
YS MAX					
EL 2					
RA					
BH					
RH					

DISTRIBUTION STATEMENT E. FURTHER DISTRIBUTION ONLY
 AS DIRECTED BY ASYNC-AEI OR HIGHER DOD AUTHORITY;
 DATE OF DETERMINATION

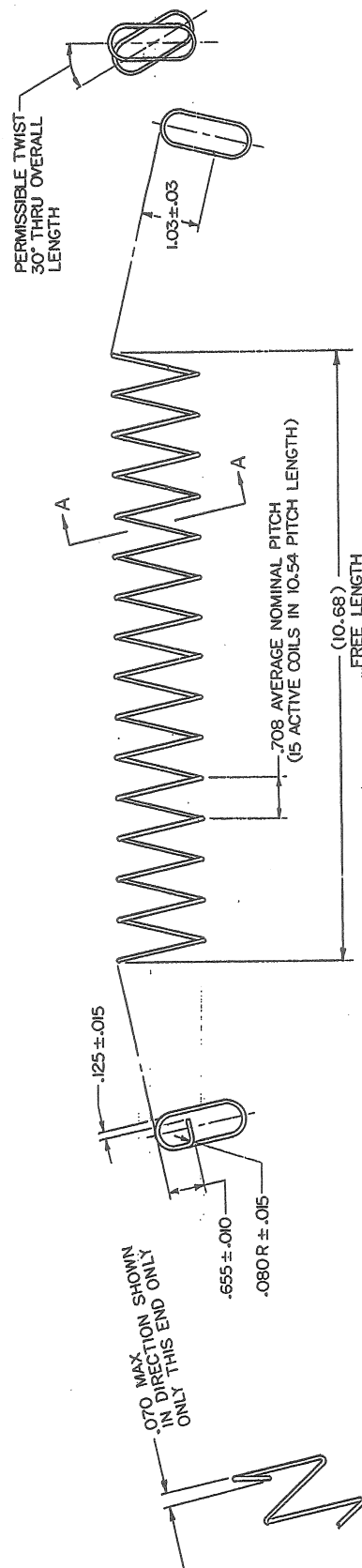
NOTICE: RESTRICTED AS TO USE AND DISCLOSURE

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NOTES:

1. MATERIAL: A36, STAINLESS STEEL, TYPE 303, (17-7PH)
2. FINISH 125/
3. FINISH PROTECTIVE FINISH: FINISH 54.1 OF MIL-STD-171.
4. HEAT TREAT PER MIL-H-9875 EXCEPT ASIDE OPTIONAL.
5. MIL-N-13065 APPLIES.
6. LOAD HEIGHT REQUIREMENTS:
 LOAD AT 6.500" = 6.3 LB. $\pm$ 4 LB.
 LOAD AT 6.500" = 6.3 LB. $\pm$ 7 LB.
 STRESS TO BE WITHIN THREE TIMES MEASURING LOADS.

SET SPRING TO SOLID HEIGHT THREE TIMES BEFORE MEASURING LOADS.



Technical drawing of a pin with the following dimensions and features:

- Overall length: $.65 \pm .02$
- Pin diameter: $.060 \text{ DIA} - .002$
- Pin length (excluding head): $1.645 \pm .020$
- Feature: FULL R (Full Round)

SECTION A-A

REVISIONS			
ZONE	UTM	DESCRIPTION	DATE/TIME AND BY APPROVED
G		REDRAWN WITH CHANGE NOR G8S2044 / 880713	890207 [Signature] G8S-32
H		NOR G1S2018	91-10-11 [Signature]

[illegible]

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
QUANTICO, ARDENN AFB, TEXAS 77805-5000

PART NO. 8448671

ROCK ISLAND ARSENAL,
ROCK ISLAND #1 61201

SPRING, MAGAZINE,
30 ROUND

8448671

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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NO QUESTIONS

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NEXT AS

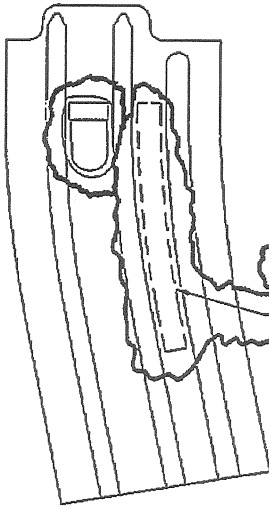
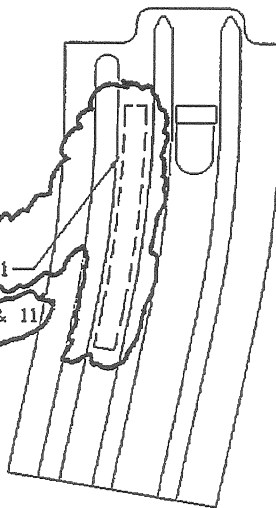
5111

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21

SMCAR FORM 68, 1 DEC 87(TEMP), REPLACES SMCAR FORM 68, 1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED

NOTICE OF REVISION (NOR)						1. DATE (YYMMDD) 990907		Form Approved OMB No. 0704-0188	
THIS REVISION DESCRIBED BELOW HAS BEEN AUTHORIZED FOR THE DOCUMENT LISTED.									
Public reporting burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget Paperwork Reduction Project (0704-0188), Washington, DC 20503. PLEASE DO NOT RETURN YOUR COMPLETED FORM TO EITHER OF THESE ADDRESSES. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT/PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.									
								2. PROCURING ACTIVITY NO.	
								3. DODAAC	
4. ORIGINATOR			b. ADDRESS (Street, City, State, Zip Code)			5. CAGE CODE 19200		6. NOR NO. 0002	
a. TYPED NAME (First, Middle Initial, Last) Skip Winters			AMSTA-AR-ESW-S ROCK ISLAND IL, 61299			7. CAGE CODE 19200		8. DOCUMENT NO. 8448673	
9. TITLE OF DOCUMENT PLATE, BOTTOM, MAGAZINE				10. REVISION LETTER				11. ECP NO.	
				a. CURRENT G		b. NEW ---		2953017	
12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES M4A1 CARBINE 5.56mm									
13. DESCRIPTION OF REVISION									
ZONE B-3,4: CHANGE FROM: "CONTRACTORS IDENTIFICATION TO BE APPROVED BY THE GOVERNMENT" TO: "SEE NOTE 8"									
UNDER NOTES ADD: "8. CONTRACTORS IDENTIFICATION IS OPTIONAL, IF IDENTIFICATION IS USED, IT MUST BE APPROVED BY THE GOVERNMENT."									
REASON: THE CONTRACTORS IDENTIFICATION IS NOW REQUIRED ON THE MAGAZINE BOX, DRAWING 8448674.									
14. THIS SECTION FOR GOVERNMENT USE ONLY									
a. (X one)	X	(1) Existing document supplemented by this NOR may be used in manufacture.							
		(2) Revised document must be received before manufacturer may incorporate this change.							
		(3) Custodian of master document shall make above revision and furnish revised document.							
b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT						c. TYPED NAME (First, Middle Initial, Last)			
d. TITLE Configuration Manager CH, Cmbt Spt & Sm Cal Wpn Sys Div	e. SIGNATURE 		f. DATE SIGNED (YYMMDD) 991006						
15.a. ACTIVITY ACCOMPLISHING REVISION			b. REVISION COMPLETED (Signature)			c. DATE SIGNED (YYMMDD)			

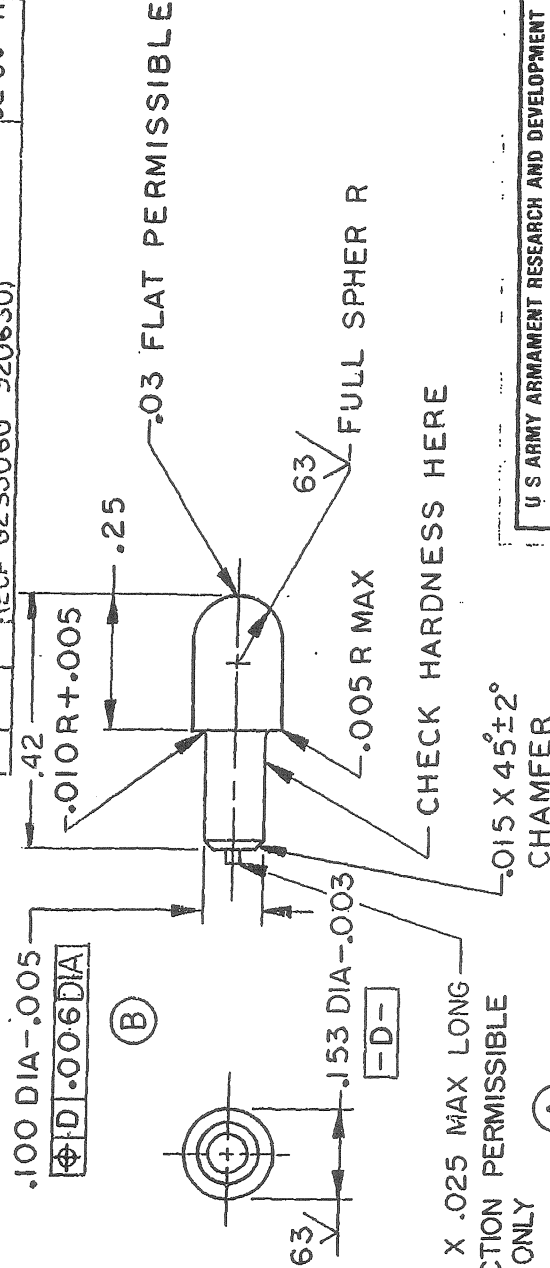
NOTICE OF REVISION (NOR)		1. DATE (YYMMDD) 990907		Form Approved OMB No. 0704-0188	
THIS REVISION DESCRIBED BELOW HAS BEEN AUTHORIZED FOR THE DOCUMENT LISTED.		Public reporting burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1218 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503. PLEASE DO NOT RETURN YOUR COMPLETED FORM TO EITHER OF THESE ADDRESSES. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT/PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.			
4. ORIGINATOR		b. ADDRESS (Street, City, State, Zip Code)		5. CAGE CODE	
a. TYPED NAME (First, Middle Initial, Last) Skip Winters		AMSTA-AR-ESW-S ROCK ISLAND IL, 61299		6. NOR NO. 0001	
				7. CAGE CODE	
				8. DOCUMENT NO. 8448674 SH 1 OF 2	
9. TITLE OF DOCUMENT BOX, MAGAZINE, 30 ROUND		10. REVISION LETTER		11. ECP NO.	
		a. CURRENT R		b. NEW	
				1953017	
12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES M4A1 CARBINE 5.56mm				NOR SH 2 OF 2	
13. DESCRIPTION OF REVISION					
ADD VIEW CALLOUTS AS SHOWN					
SHEET 1 ZONE C-3  SHEET 2 ZONE C-4  SEE NOTES 10C & 11 SEE NOTES 10B & 11					
REASON: THE BATF REQUIRES THESE CHANGES TO BE MADE.					
14. THIS SECTION FOR GOVERNMENT USE ONLY					
a. (X one)		☒ (1) Existing document supplemented by this NOR may be used in manufacture. ☐ (2) Revised document must be received before manufacturer may incorporate this change. ☐ (3) Custodian of master document shall make above revision and furnish revised document.			
		4			
b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT			c. TYPED NAME (First, Middle Initial, Last)		
d. TITLE Configuration Manager CH, Cmbt Spt & Sm Cal Wpn Sys Div		e. SIGNATURE <i>for Walter J. Sonypala</i>		f. DATE SIGNED (YYMMDD) 991006	
15.a. ACTIVITY ACCOMPLISHING REVISION		b. REVISION COMPLETED (Signature)		c. DATE SIGNED (YYMMDD)	

NOTICE OF REVISION (NOR)		1. DATE (YYMMDD) 990907	Form Approved OMB No. 0704-0188
THIS REVISION DESCRIBED BELOW HAS BEEN AUTHORIZED FOR THE DOCUMENT LISTED.		2. PROCURING ACTIVITY NO.	
Public reporting burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing this burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports, 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302, and to the Office of Management and Budget, Paperwork Reduction Project (0704-0188), Washington, DC 20503. PLEASE DO NOT RETURN YOUR COMPLETED FORM TO EITHER OF THESE ADDRESSES. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT/PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.		3. DODAAC	
4. ORIGINATOR	b. ADDRESS (Street, City, State, Zip Code)	5. CAGE CODE 19200	6. NOR NO. 0001
a. TYPED NAME (First, Middle Initial, Last) Skip Winters	AMSTA-AR-ESW-S ROCK ISLAND IL, 61299	7. CAGE CODE 19200	8. DOCUMENT NO. 8448674 SH 1 OF 2
9. TITLE OF DOCUMENT BOX, MAGAZINE, 30 ROUND	10. REVISION LETTER a. CURRENT R	b. NEW	11. ECP NO. 6953017
12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES M4A1 CARBINE 5.56mm			NOR SH 1 OF 2
13. DESCRIPTION OF REVISION DELETE NOTE 10 IN ITS ENTIRETY AND SUBSTITUTE WITH THE FOLLOWING: 10. INSCRIPTIONS A. - MANUFACTURER'S CAGE CODE AND MONTH AND YEAR, +/- TWO MONTHS OF MANUFACTURE. B. - MARKING SHALL READ AS FOLLOWS "RESTRICTED LAW ENFORCEMENT/GOVERNMENT USE ONLY" OR BATF APPROVED EQUIVALENT. C. - MARKING SHALL BE CONTRACTORS NAME, CITY, AND STATE. 11. MARKINGS ON MAGAZINE BOX SHALL BE INSCRIBED PRIOR TO APPLICATION OF HARD COAT AND SOLID FILM LUBRICANT. LETTERS SHALL BE APPROXIMATELY 0.1 HIGH X .005 + .005 DEEP. MARKING SHALL NOT EXTEND IN AREA 1.0 INCH FROM TOP OR 0.5 INCH FROM BOTTOM OF MAGAZINE BOX. ZONE C-4, CHANGE FROM: SEE NOTE 10 TO: SEE NOTES 10A & 11 ZONE E-5 ADD PHANTOM LINE AROUND THE CUTOUT FOR THE OPPOSITE SIDE. (SEE NOR SH 2 OF 2) SEE NOR SH 2 OF 2 FOR THE PLACEMENT OF REQUIRED INSCRIPTIONS. REASON: THE BATF REQUIRES THESE CHANGES TO BE MADE.			
14. THIS SECTION FOR GOVERNMENT USE ONLY			
a. (X one)	X	(1) Existing document supplemented by this NOR may be used in manufacture. (2) Revised document must be received before manufacturer may incorporate this change. (3) Custodian of master document shall make above revision and furnish revised document.	
b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT		c. TYPED NAME (First, Middle Initial, Last)	
d. TITLE Configuration Manager CH, Cmbt Spt & Sm Cal Wpn Sys Div	e. SIGNATURE 	f. DATE SIGNED (YYMMDD) 99/006	
15.a. ACTIVITY ACCOMPLISHING REVISION	b. REVISION COMPLETED (Signature)	c. DATE SIGNED (YYMMDD)	

[illegible]

125/ ✓ EXCEPT AS
1. FINISH NOTED.

2. SUGGESTED HEAT TREAT:
LIQUID CARBURIZE AT
1550°F TO OBTAIN A
TOTAL CASE DEPTH OF
.003 TO .006. HARDEN
AND TEMPER.
3. FINISH 5.3.1.2 OF
MIL-STD-171.
4. MIL-W-13855 APPLIES. (A)



**DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY
AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY: 92-06-22.**

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES		CONTRACT NO.		DATE 27 APR 1970		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201		19200	
YS	MIN			ANGLES ±	± .005	PREP	WAB	Q. & A.					
YS	MAX		M4	3 PLACE DECIMALS ±	± .01	CHK							
EL 2		F 9327230	M 231	2 PLACE DECIMALS ±		ENGR	WAB	W. J. Williams					
RA		F 8448604	M 16	MATERIAL	STEEL, CMPSN III7	SUBMITTED		D. J. Smith					
BH		F 8448578	M 16 A 1		ASTM A108	APPROVED		F. P. Williams					
RM	FILE HARD	NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH	SEE NOTE 3								
		APPLICATION				APPROVED		R. J. Henry		SIZE CODE IDENT NO. DRAWING NO.		B 19204 8448634	
										SCALE 5/1		SHEET 1 OF 1	

AMSWE Form 4038, 29 Jul 69

CDI

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NOTES:

- 1. WIRE, STAINLESS STEEL, TYPE 304, (7-7PH) COLD DRAWN, ASTM A313.
- 2. PRECIPITATION HEAT TREAT AFTER FORMING TO COND TN CH900. HOLD AT 900°F ±10° FOR 1 HOUR. AIR COOL.
- 3. MIL-W-13855 APPLIES.
- 4. BREAK SHARP EDGES .003±.012.

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER .0180 ±.0005
COIL DIAMETER (O.D.) .148 ±.004
FREE LENGTH AFTER SETTING 404 REF
TOTAL COILS 9 REF
DIRECTION OF HELIX OPTIONAL
LOAD AT COMPRESSED LENGTH OF .290 1.1 LB ±.1 LB
LOAD AT COMPRESSED LENGTH OF _____
SPRING RATE _____
SOLID LENGTH .185 MAX
TYPE OF ENDS CLOSED
MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M		B	REPLACES REV A W/CHANGE SEE ERR QOR 20778	6 OCT 72	LB
		C	NOR W9S2009 80-02-13	80-05-16	LB
		D	NOR W25 0011 / 82-04-13 DECP W25 0034 / 82-07-15 DECP W3S 3120 / 83-07-07	83-11-04	LB
		E	NOR GIS2018 / 91 07 08	91-10-11	LB

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

CURRENT FSCM NO.
PART NO. 8448633 19200

CONTRACT NO. DATE 27 APR 70		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	PREP P. Vanner	SPRING, BOLT CATCH	
TOLERANCES: ANGLES ± 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ±	CHK G. D. Dwyer	SIZE CODE IDENT NO. DRAWING NO. B 19204 8448633	
MATERIAL	ENGR G. D. Dwyer	SCALE 1 OF 1	
SEE NOTE 1	SUBMITTED D. D. Dwyer		
FINAL PROTECTIVE FINISH	APPROVED K. J. Hickey		
5.41 OF MIL-STD-171			
MECHANICAL PROPERTIES	APPLICATION		
YS MIN 9390011	NEXT ASSY USED ON		
YS MAX F9327230			
EL2 F8448604			
RA F8448578			
BH			
RH 15N 84.5MIN			

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NOTES:

- 1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
- 2. PRECIPITATION HEAT TREAT AFTER FORMING TO COND TN CH 900. HOLD AT 900°F ±10° FOR 1 HOUR. AIR COOL.
- 3. MIL-W-13855 APPLIES.
- 4. BREAK SHARP EDGES .003 ± .012.

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER _____ .0160 ± .0005
COIL DIAMETER (OD) _____ .088 ± .003
FREE LENGTH _____ L10 REF
TOTAL COILS _____ 40 REF
DIRECTION OF HELIX _____ OPTIONAL
LOAD AT COMPRESSED LENGTH OF .750 _____ 2.20 LBS ± .22 LBS
LOAD AT COMPRESSED LENGTH OF _____
SPRING RATE _____ .670 MAX
SOLID LENGTH _____ CLOSED
TYPE OF ENDS _____
MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

REVISIONS		
MF	ZONE LTR	DESCRIPTION
1	B	REPLACES REV A W/CHANGE SEE ERR HQR 20778
2	C	NOR W9S2009 80-02-13
3	D	NOR W2S0011 782-04-13 CECP W250034 782-07-15 CECF W353120 783-07-07
4	E	NOR G1S2018 791-07-08

DATE

APPROVED

6 OCT 72

80-05-16

83-11-04

91-10-11

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO: 27 APR 1970		PART NO. 8448586		FSC M NO. 19200	
YS MIN	9390011	M 4	3 PLACE DECIMALS ± .005	PREP	P. Gutierrez	DATE	27 APR 1970	U.S. ARMY WEAPONS COMMAND	
YS MAX	F9327230	M 231	2 PLACE DECIMALS ± .01	CHK	P. Gutierrez	CHK	P. Gutierrez	ROCK ISLAND, ILLINOIS 61201	
EL 2	F8448604	M16	SEE NOTE 1	ENGR	P. Gutierrez	ENGR	P. Gutierrez	SPRING, DETENT, TAKEDOWN PIN	
RA	F8448578	M16A1		SUBMITTED	P. Gutierrez	SUBMITTED	P. Gutierrez	SIZE CODE IDENT NO. DRAWING NO.	
BH				APPROVED	P. Gutierrez	APPROVED	P. Gutierrez	B 19204 8448586	
RH	15N 845 MIN	APPLICATION		NEXT ASSY		USED ON		SCALE NONE	
								SHEET 1 OF 1	

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

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NOTES:

1. WIRE, STEEL, CARBON, SPRING, MUSIC, SPEC ASTM-A228. TENSILE STRENGTH SHALL BE 376,000 MIN.
2. STRESS RELIEVE AFTER FORMING. HOLD AT 475°F ±25" FOR 30 MINUTES.
3. SET SPRING 3 TIMES AFTER STRESS RELIEF.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003 ±.012.

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER ----- 0240 ±.0003
COIL DIAMETER (OD) ----- 1.03 ±.003
FREE LENGTH AFTER SETTING ----- 926 REF
TOTAL COILS ----- 27 REF
DIRECTION OF HELIX ----- OPTIONAL
LOAD AT COMPRESSED LENGTH OF .850 ----- 2.94 LB ±.30LB
LOAD AT COMPRESSED LENGTH OF .784 ----- 5.50 LB ±.25LB
SPRING RATE -----
SOLID LENGTH ----- 650 MAX
TYPE OF ENDS ----- SQUARED, GROUND
MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572

REVISIONS			
MF	ZONE	LTR	DESCRIPTION
		C	REPLACES REV B W/CHANGE SEE ERR HQR 20778
		D	NOR W9S2009 80-02-13
		E	NOR W2S 0011 / 82-04-13 (ECP W3S 3120 / 83-07-07)
		F	ERR Z9Z1251W (ECP G9S2036/890721)
		G	NOR GIS2018 91-07-08

FSCM NO.
19200

CURRENT

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DOVER, NEW JERSEY 07801

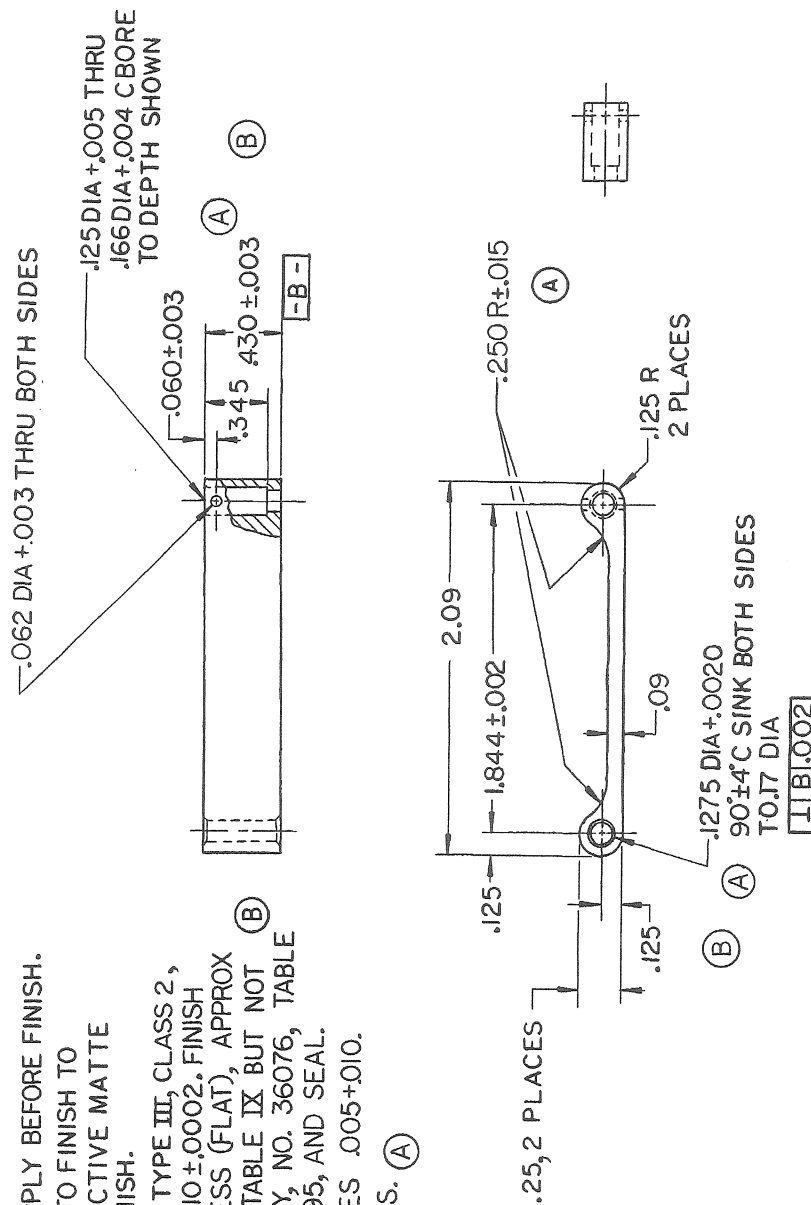
PART NO. 8448516

MECHANICAL PROPERTIES	8448509	M4	CONTRACT NO.	ROCK ISLAND ARSENAL, ROCK ISLAND, ILL 61201
YS MIN	F9327230	M 231	DATE	27 APR 70
YS MAX		M16	PREP	PV L.P.
EL2	C8448509	MISAI	CHK	GD DK
RA	F8448604	M16	ENGR	RE L.B.
BH	F8448578	MISAI	SUBMITTED	
RH			APPROVED	
NEXT ASSY USED ON		A.A. COLE		
APPLICATION		R.S. HENRY		
		SEE NOTE 1		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
		TOLERANCES:		
		ANGLES 2		
		3 PLACE DECIMALS ±.005		
		2 PLACE DECIMALS ±		
		MATERIAL		
		CONTRACT NO.		
		DATE		
		PREP		
		CHK		
		ENGR		
		SUBMITTED		
		APPROVED		
		R.S. HENRY		
		A.A. COLE		
		SEE NOTE 1		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
		TOLERANCES:		
		ANGLES 2		
		3 PLACE DECIMALS ±.005		
		2 PLACE DECIMALS ±		
		MATERIAL		
		CONTRACT NO.		
		DATE		
		PREP		
		CHK		
		ENGR		
		SUBMITTED		
		APPROVED		
		R.S. HENRY		
		A.A. COLE		
		SEE NOTE 1		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
		TOLERANCES:		
		ANGLES 2		
		3 PLACE DECIMALS ±.005		
		2 PLACE DECIMALS ±		
		MATERIAL		
		CONTRACT NO.		
		DATE		
		PREP		
		CHK		
		ENGR		
		SUBMITTED		
		APPROVED		
		R.S. HENRY		
		A.A. COLE		
		SEE NOTE 1		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
		TOLERANCES:		
		ANGLES 2		
		3 PLACE DECIMALS ±.005		
		2 PLACE DECIMALS ±		
		MATERIAL		
		CONTRACT NO.		
		DATE		
		PREP		
		CHK		
		ENGR		
		SUBMITTED		
		APPROVED		
		R.S. HENRY		
		A.A. COLE		
		SEE NOTE 1		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
		TOLERANCES:		
		ANGLES 2		
		3 PLACE DECIMALS ±.005		
		2 PLACE DECIMALS ±		
		MATERIAL		
		CONTRACT NO.		
		DATE		
		PREP		
		CHK		
		ENGR		
		SUBMITTED		
		APPROVED		
		R.S. HENRY		
		A.A. COLE		
		SEE NOTE 1		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
		TOLERANCES:		
		ANGLES 2		
		3 PLACE DECIMALS ±.005		
		2 PLACE DECIMALS ±		
		MATERIAL		
		CONTRACT NO.		
		DATE		
		PREP		
		CHK		
		ENGR		
		SUBMITTED		
		APPROVED		
		R.S. HENRY		
		A.A. COLE		
		SEE NOTE 1		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
		TOLERANCES:		
		ANGLES 2		
		3 PLACE DECIMALS ±.005		
		2 PLACE DECIMALS ±		
		MATERIAL		
		CONTRACT NO.		
		DATE		
		PREP		
		CHK		
		ENGR		
		SUBMITTED		
		APPROVED		
		R.S. HENRY		
		A.A. COLE		
		SEE NOTE 1		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
		TOLERANCES:		
		ANGLES 2		
		3 PLACE DECIMALS ±.005		
		2 PLACE DECIMALS ±		
		MATERIAL		
		CONTRACT NO.		
		DATE		
		PREP		
		CHK		
		ENGR		
		SUBMITTED		
		APPROVED		
		R.S. HENRY		
		A.A. COLE		
		SEE NOTE 1		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
		TOLERANCES:		
		ANGLES 2		
		3 PLACE DECIMALS ±.005		
		2 PLACE DECIMALS ±		
		MATERIAL		
		CONTRACT NO.		
		DATE		
		PREP		
		CHK		
		ENGR		
		SUBMITTED		
		APPROVED		
		R.S. HENRY		
		A.A. COLE		
		SEE NOTE 1		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
		TOLERANCES:		
		ANGLES 2		
		3 PLACE DECIMALS ±.005		
		2 PLACE DECIMALS ±		
		MATERIAL		
		CONTRACT NO.		
		DATE		
		PREP		
		CHK		
		ENGR		
		SUBMITTED		
		APPROVED		
		R.S. HENRY		
		A.A. COLE		
		SEE NOTE 1		
		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		
		TOLERANCES:		
		ANGLES 2		
		3 PLACE DECIMALS ±.005		
		2 PLACE DECIMALS ±		
		MATERIAL		
		CONTRACT NO.		
		DATE		
		PREP		
		CHK		
		ENGR		
		SUBMITTED		
		APPROVED		

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1. FINISH 125%.

2. ALL DIMENSIONS APPLY BEFORE FINISH.
3. SANDBLAST PRIOR TO FINISH TO PRODUCE NONREFLECTIVE MATTE SURFACE AFTER FINISH.
4. FINISH MIL - A-8625 TYPE III, CLASS 2, FILM THICKNESS .0010 ± .0002. FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL.
5. BREAK SHARP EDGES .005 ± .010.
6. MIL-W-13855 APPLIES. (A)



MECHANICAL PROPERTIES	YS MIN	
	YS MAX	
	EL2	
	RA	
	BH	
	RH	

				M4		
			B8448587	M23I		
			B8448587	MF6		
			B8448587	MIGAI		
			NEXT ASSY	USED ON		
						APPLICATION

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±.005
2 PLACE DECIMALS ±.01

MATERIAL

ALUMINUM ALLOY
7075-T6, SPEC
ASTM B221

FINAL PROTECTIVE FINISH

SEE NOTE 4

CONTRACT NO.:	
DATE	27 APR 1970
PREPARED BY	G. A. - Jot
CHECKED BY	D. G. B.
ENGINEER	A. J. - Jot
SUBMITTED	F. P. - Jot
APPROVED	D. G. B.

SIZE	CODE IDENT NO.	DRAWING NO.
C	19204	8448588

DOVER, NEW JERSEY 07801
 DEPT OF THE ARMY
 U.S. ARMY WEAPONS COMMAND
 ROCK ISLAND, ILLINOIS, 61201

GUARD, TRIGGER

AMSWE Form 403C, 29 Jul 69

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NOTES:

1. WIRE, STEEL, CORROSION RESISTING, FREE MACHINING STOCK, CLASS 303, ANNEALED, (B) COLD DRAWN, SPEC ASTM A555, A581 AND A582.
2. FINISH 125/
3. BREAK ALL SHARP EDGES .005+0.05.
4. MIL-W-13855 APPLIES. (A)

(B)

125/

.035-.005

1. WIRE, STEEL, CORROSION RESISTING, FREE MACHINING STOCK, CLASS 303, ANNEALED, (B) COLD DRAWN, SPEC ASTM A555, A581 AND A582.
2. FINISH 125/
3. BREAK ALL SHARP EDGES .005+0.05.
4. MIL-W-13855 APPLIES. (A)

1. WIRE, STEEL, CORROSION RESISTING, FREE MACHINING STOCK, CLASS 303, ANNEALED, (B) COLD DRAWN, SPEC ASTM A555, A581 AND A582.
2. FINISH 125/
3. BREAK ALL SHARP EDGES .005+0.05.
4. MIL-W-13855 APPLIES. (A)

1. WIRE, STEEL, CORROSION RESISTING, FREE MACHINING STOCK, CLASS 303, ANNEALED, (B) COLD DRAWN, SPEC ASTM A555, A581 AND A582.
2. FINISH 125/
3. BREAK ALL SHARP EDGES .005+0.05.
4. MIL-W-13855 APPLIES. (A)

.210

.115 DIA-.003

(B)

Ø .115 DIA-.003

(B) .156 DIA-.003

(B)

-B-

.015 X 45° ± 2° CHAMFER

.025 DIA MAX X .025 MAX LONG CUTOFF PROJECTION PERMISSIBLE ON THIS END ONLY.

(A)

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-ARI OR HIGHER DOD AUTHORITY. DATE OF DETERMINATION:

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MECHANICAL PROPERTIES	APPLICATION
YS MIN	8448587
YS MAX	8448587
EL2	M231
RA	M16
BM	M16AI
RH	M16AI
NEXT ASSY	USED ON
APPLICATION	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES: 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .005 MATERIAL: SEE NOTE 1	DATE 27 APR 1970
PREP RGA	CHK RGA
ENGR RGA	SUBMITTED RGA
APPROVED RGA	

CONTRACT NO.	DATE 27 APR 1970
PREP RGA	CHK RGA
ENGR RGA	SUBMITTED RGA
APPROVED RGA	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES: 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .005 MATERIAL: SEE NOTE 1	DATE 27 APR 1970
PREP RGA	CHK RGA
ENGR RGA	SUBMITTED RGA
APPROVED RGA	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES: 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .005 MATERIAL: SEE NOTE 1	DATE 27 APR 1970
PREP RGA	CHK RGA
ENGR RGA	SUBMITTED RGA
APPROVED RGA	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES: 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .005 MATERIAL: SEE NOTE 1	DATE 27 APR 1970
PREP RGA	CHK RGA
ENGR RGA	SUBMITTED RGA
APPROVED RGA	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES: 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .005 MATERIAL: SEE NOTE 1	DATE 27 APR 1970
PREP RGA	CHK RGA
ENGR RGA	SUBMITTED RGA
APPROVED RGA	

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES: 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .005 MATERIAL: SEE NOTE 1	DATE 27 APR 1970
PREP RGA	CHK RGA
ENGR RGA	SUBMITTED RGA
APPROVED RGA	

REVISIONS

ME	ZONE	LTR	DESCRIPTION	DATE	APPROVED
1			REDRAWN FROM COLT'S DRAWING	27 APR 70	
2			B64250 REVISION A		
3			A (2) SEE EO HRD 02251	15 OCT 70	RE
4			B (3) SEE ERR HQR 20778	6 OCT 72	RE
5			C NOR W9S2009 80-02-13	80-05-16	RE
6			D NOR GIS3074/910625	91 08 21	RE
7			E NOR GIS2018 91-07-08	91-10-11	RE
8			F NOR G3S3081/930831	931026	RE

CURRENT DESIGN ACTIVITY CASE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

DEPT OF THE ARMY US ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	PLUNGER, TRIGGER GUARD
SIZE B	CODE IDENT NO. 19204
DRAWING NO. 8448589	
SHEET 1 OF 1	

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REVISIONS			
REV	ZONE	DESCRIPTION	DATE
B		REPLACES REV A W/CHANGE SEE ERR HQR 20778	6 OCT 72
C		NOR W9S2009 80-02-13	80-05-16
D		INOR W250011 / 82-04-13 DECP W250034 / 82-07-15 DECP W353120 / 83-07-07	83-11-04
E		NOR GIS2018 91 07 08	91-10-11

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER _____ 0160±0005
COIL DIAMETER (O.D) _____ 145±003
FREE LENGTH _____ 310 REF
TOTAL COILS _____ 6 REF
DIRECTION OF HELIX _____ OPTIONAL
LOAD AT COMPRESSED LENGTH OF 175 _____ 148 LB ± .15 LB
LOAD AT COMPRESSED LENGTH OF _____
SPRING RATE _____
SOLID LENGTH _____ .118 MAX
TYPE OF ENDS _____ CLOSED
MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 304, (17-7PH) COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO COND TN CH900; HOLD AT 900°F ± 10° FOR ONE HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.
4. BREAK SHARP EDGES .003 ± .012.

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

CURRENT FSCM NO. 19200
PART NO 8448590

CONTRACT NO:		DATE 27 APR 1970	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		PREP BY <i>William P. Vernon</i>	
TOLERANCES:		CHK BY <i>William W. Hinkle</i>	ENGR BY <i>William W. Hinkle</i>
ANGLES ±		SUBMITTED	
3 PLACE DECIMALS ± .005			
2 PLACE DECIMALS ±			
MATERIAL			
SEE NOTE 1			
FINAL PROTECTIVE FINISH		APPROVED <i>R. S. Henry</i>	
54J OF MIL-STD-171			
MECHANICAL PROPERTIES		APPLICATION	
YS	8448587	M 4	
MIN	B8448587	AM 231	
YS		M16	
MAX		M16A1	
EL 2			
RA	B8448587		
BH		USED ON	
RH	15N 84.5 MIN	NEXT ASSY	

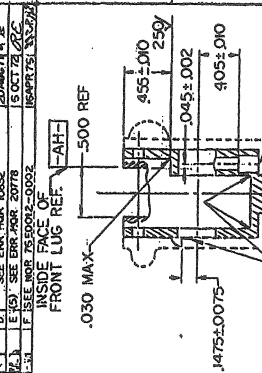
DEPT OF THE U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SPRING TRIGGER GUARD

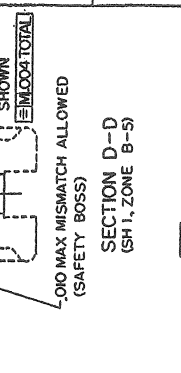
SIZE CODE IDENT NO. DRAWING NO.
B 19204 8448590

SCALE NONE SHEET 1 OF 1

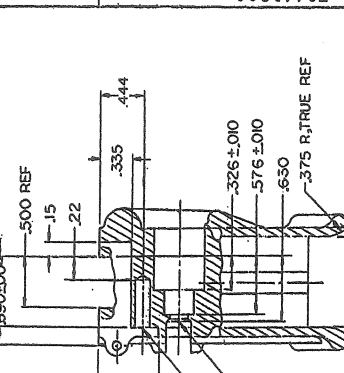
REVISED		DESCRIPTION		DATE	APPROVED
REV	DATE	BY	DESCRIPTION		
			REDRAWN FROM COLT'S DRAWING		
			612300 REV E	27 MAR 70	
			A NO CHANGE	15 JUL 70	5/2
			B 10 SEE MD 106-40	20 FEB 71	5/2
			C (5) SEE MOP 707-28	26 MAY 71	7/6
			D SEE ENR MOR 10632	20 AUG 71	4/2
			E (4) SEE ENR MOR 20078	5 OCT 71	2/2
			F SEE MOR 7520012-0012	16 MAR 72	5/2



030 R MAX



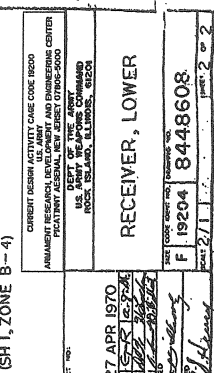
INSIDE FACE FRONT
LUG REF



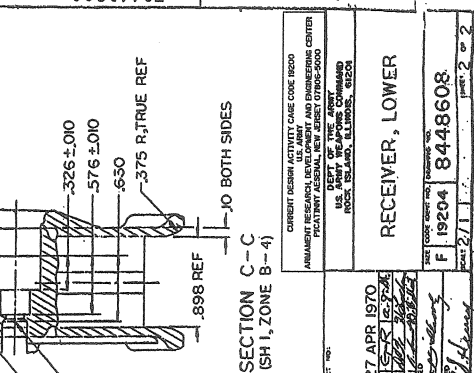
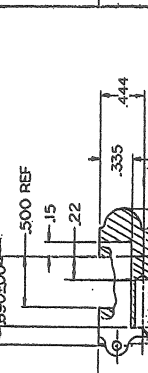
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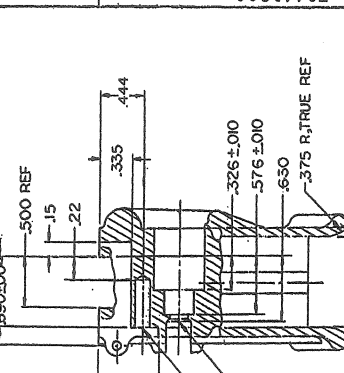
— JO BOTH SIDES



DATE	CODE	QTY	NO.	QTY	NO.
F	19204		8448608		
TOTAL 2/1			PAGE 2 OF 2		



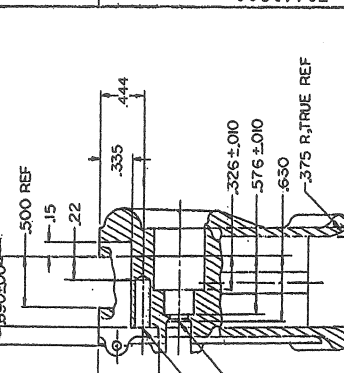
DATE	CODE	QTY	NO.	QTY	NO.
F	19204		8448608		
TOTAL 2/1			PAGE 2 OF 2		



SECTION C C

— .898 REF

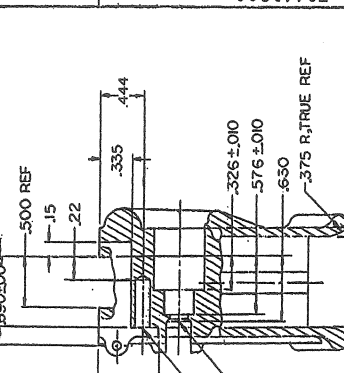
— JO BOTH SIDES



SECTION C C

— .898 REF

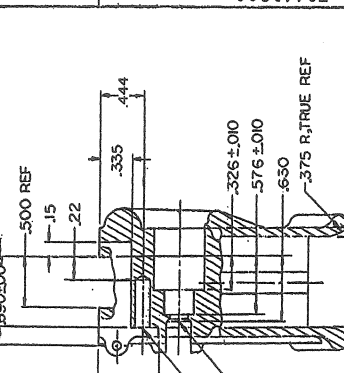
— JO BOTH SIDES



SECTION C C

— .898 REF

— JO BOTH SIDES



SECTION C C

— .898 REF

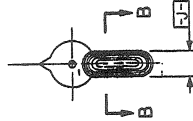
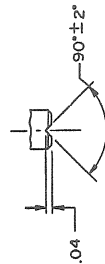
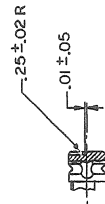
— JO BOTH SIDES

(SH 1, ZONE B-4)	CURRENT WORK ACTIVITY CASE CODE 1800 U.S. ARMY ANAMOUTH RESEARCH CENTER PLANTATION REGIONAL NEW JERSEY OFFICE-SOND	DEPT. OF THE ARMY INDIAN AFFAIRS ROCK ISLAND, ILLINOIS, REGION	RECEIVER, LOWER
	17 APR 1970 CR 2074 1000 1000	17 APR 1970 CR 2074 1000 1000	17 APR 1970 CR 2074 1000 1000

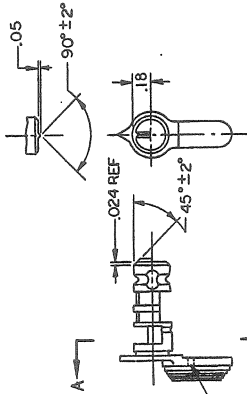
NOTICE: RESTRICTED AS TO USE AND DISCLOSURE

[illegible]

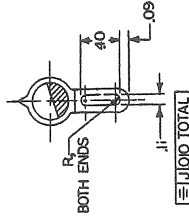
ALTERNATIVE DESIGN



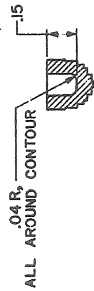
MARK MFG IDENT SYMBOL
AND CAVITY IDENTIFICATION
MARK .06 HIGH APPROX,
.005 MAX NEGATIVE ONLY,
IN APPROX POSITION SHOWN.



SECTION A-A



SECTION B-B
SCALE 4/1

[illegible]

PART NO: 9381367

SELECTOR,
FIRE CONTROL

SCM NO. 19200 9381367

SCALE	2 / 1	UNIT WT
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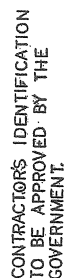
AMSWE Form 403F, 29 Jul 69

[illegible]

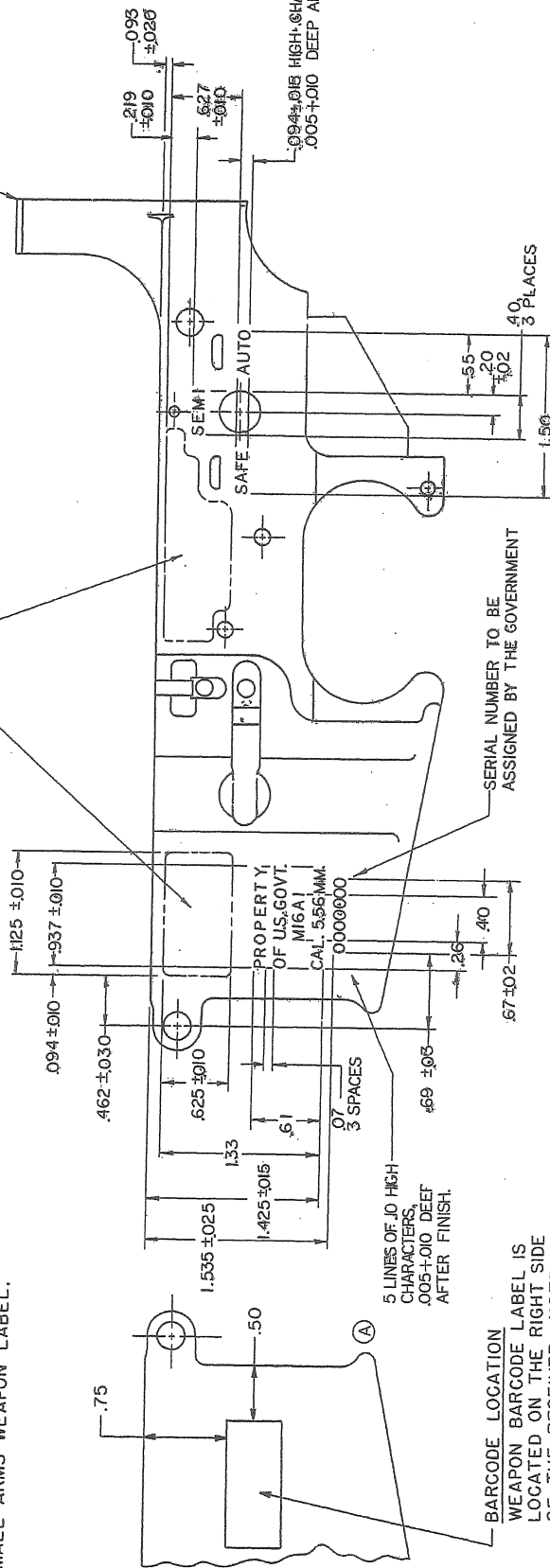
1. GRIT BLAST BEFORE FINISH TO PRODUCE NON-REFLECTIVE MATTE SURFACE AFTER FINAL FINISH.

2. FINISH MIL-A-8625, TYPE III, CLASS 2. FILM THICKNESS .0010 $\pm$.0002 FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL

- 3.MIL-W-13855 APPLIES. (A) 1.APPLY BARCODE LABEL AS SHOWN IAW TECHNICAL PURCHASE DESCRIPTION / SPECIFICATION - U.S. ARMY SMALL ARMS WEAPON LABEL.



RECEIVER, LOWER F848608 ©



BARCODE	LOCATION
WEAPON BARCODE LABEL IS	LOCATED ON THE RIGHT SIDE
OF THE RECEIVER. NOTE 4	

VIEW OF RIGHT SIDE
(REVOLVED 180°)

SEE PL 8	MECHANICAL PROPERTIES	
	YS MIN	YS MAX
	EL 2	
	RA	
	BH	
	RH	

SEE PL 8448580

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
PLACE DECIMALS ±.005

PLACE DECIMALS $\pm .01$

TRIAL

MAKE FROM
RECEIVER, LOWER
8448608

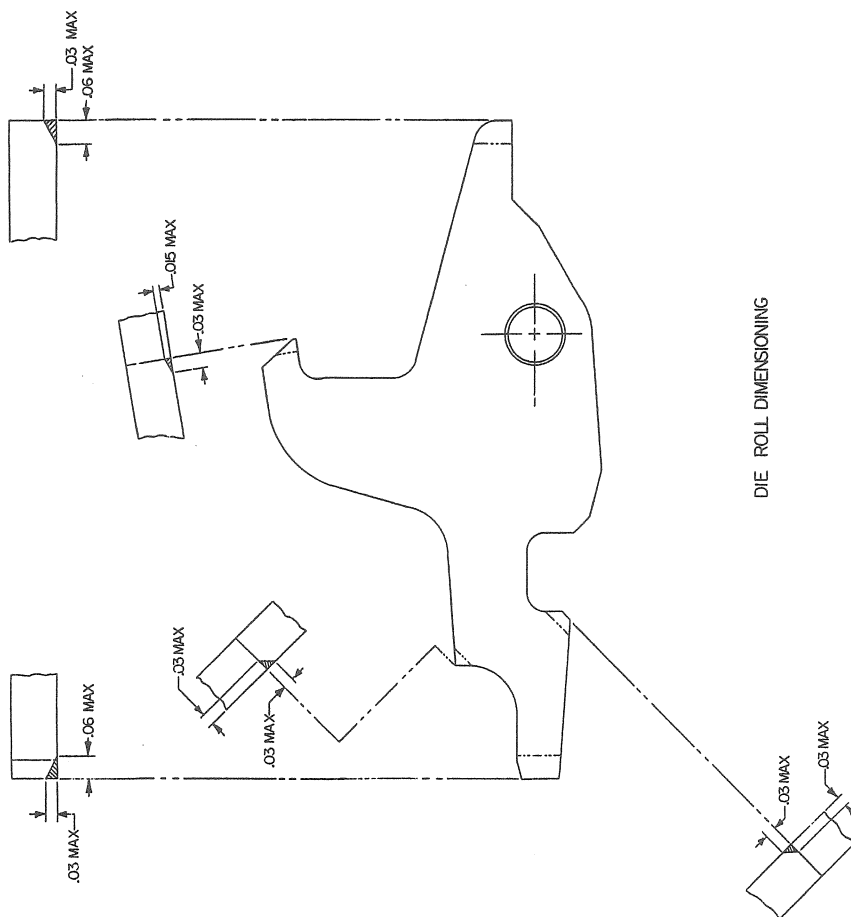
CONTRACT NO:

DATE 27 APR 1970

RECEIVER, LOWER
MODEL M16A1

SIZE	CODE IDENT NO.	DRAWING NO
D	19204	8448580

NOTICE: RESTRICTED AS TO USE AND DISCLOSURE



DIE ROLL DIMENSIONING

[illegible]

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NOTES:

1. FINISH $\sqrt{125}$ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005 MAX.
3. FINISH 5.3.1.2 OF MIL-STD-171.
4. HEAT TREATMENT: QUENCH (A) AND TEMPER TO HARDNESS SPECIFIED.
5. MIL-W-13855 APPLIES. (A)

DISTRIBUTION STATEMENT E. FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR OR HIGHER DOD AUTHORITY: 92-46-22.

MECHANICAL PROPERTIES

YS	MIN	MAX	EL 2	RA	BH	RH
9390011		M4				
F8448604		M16				
F8448578		M16A1				
NEXT ASSY		USED ON				
APPLICATION						

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCES:

ANGLES	3 PLACE DECIMALS	2 PLACE DECIMALS
± .005	± .005	± .005

WIRE STEEL CMPSN 4130, OR 4140, ASTM A331

FINAL PROTECTIVE FINISH SEE NOTE 3

APPROVED: R. S. Henry

CONTRACT NO: 27 APR 1970

DATE: 27 APR 1970

PREP: R. S. Henry

CHK: R. S. Henry

ENGR: R. S. Henry

SUBMITTED: R. S. Henry

DEPT OF THE ARMY
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PIN, AUTOMATIC SEAR

SIZE: B 19204

DRAWING NO: 8448599

SCALE: 4/1

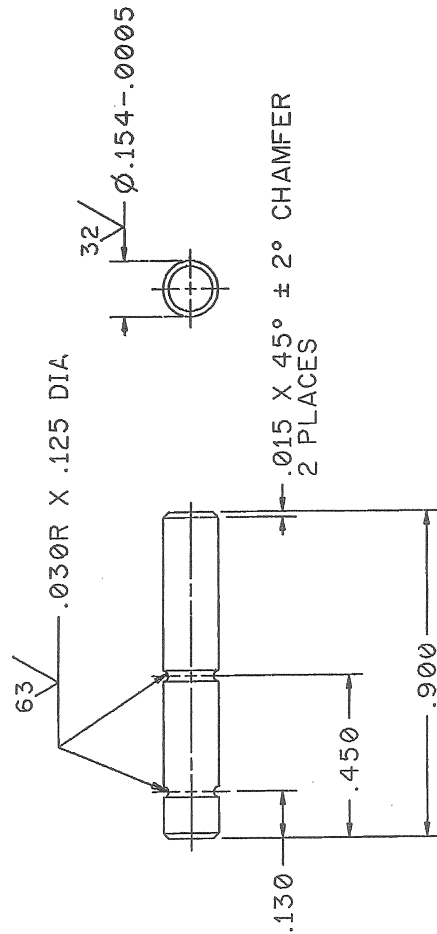
SHEET: 1 OF 1

CDI

AMSWE Form 403B, 29 Jul 69

[illegible]

6. MATERIAL: COLD FINISHED ALLOY STEEL BAR, GRADE 4130 OR 4140, ASTM A331, COLD HEADING QUALITY.



THIS DRAWING HAS BEEN GENERATED
ON A CAD SYSTEM LOCATED AT ARDEC,
BLDG. 6, PICATINNY ARSENAL, N.J.
CHANGES MUST BE INCORPORATED
W/ THIS SYSTEM.

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CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING
PICATINNY ARSENAL NEW JERSEY 07806-5000

PART NO. 8448609

DEPT OF THE ARMY
US ARMY WEAPONS COMMAND
ROCK ISLAND ILLINOIS. 61201

PIN, HAMMER & TRIGGER

SIZE	CAGE CODE	8448609
C	19204	

SCALE	UNIT WT.
4.11	

APPROVAL
B S HENRY

MATL ENGR

ASSY	USED
APPLICATION	

RH			15N 72 5-76
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DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASONC-AR OR HIGHER DOD AUTHORITY: 92-06-22.

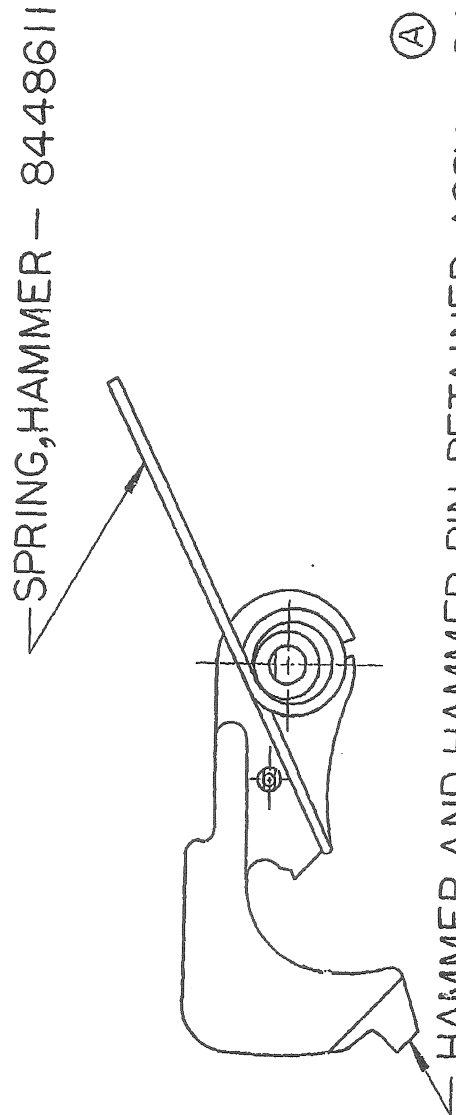
SMCAR FORM 67.1 DEC 87(TEMP). REPLACES SMCAR FORM 67.1 MAR 87(TEMP).
WHICH MAY BE USED UNTIL EXHAUSTED

SMCAR FORM 67, 1 DEC 87(TEMP), REPLACES SMCAR FORM 67, 1 MAR 87(TEMP).

[illegible]

i. MIL-W-13855 APPLIES.

Ⓐ



HAMMER AND HAMMER PIN RETAINER ASSY - 8448612

SEE PL-8448610

MECHANICAL PROPERTIES						UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS	MIN					ANGLES		DATE	27 APR 1970		
YS	MAX					3 PLACE DECIMALS ±		PREP	B.E.W. a.g.a.		
EL2						2 PLACE DECIMALS ±		CHK	W.H. W. H. W.		
RA						MATERIAL		ENGR	Robert P. Billie		
		F8448604		M16				SUBMITTED	P.P. Yellow		
		F8448578		M16A1				APPROVED	R.D. Henry		
		NEXT ASSY		USED ON		FINAL PROTECTIVE FINISH					
		APPLICATION									
								SIZE		CODE IDENT NO.	DRAWING NO.
								B		19204	8448610
								SCALE		2/1	SHEET 1 OF 1

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
1	2		REDRAWN FROM COLT'S DRAWING C62273 REV A	27 APR 70	
	A		SEE ERR HQR 20778	6 OCT 72	ORC
	B		NORW250020	82-06-09	83 02 03 LAH/LLI
	C		NOR W25 0026	82-05-21	8309 22 WOC/LLI

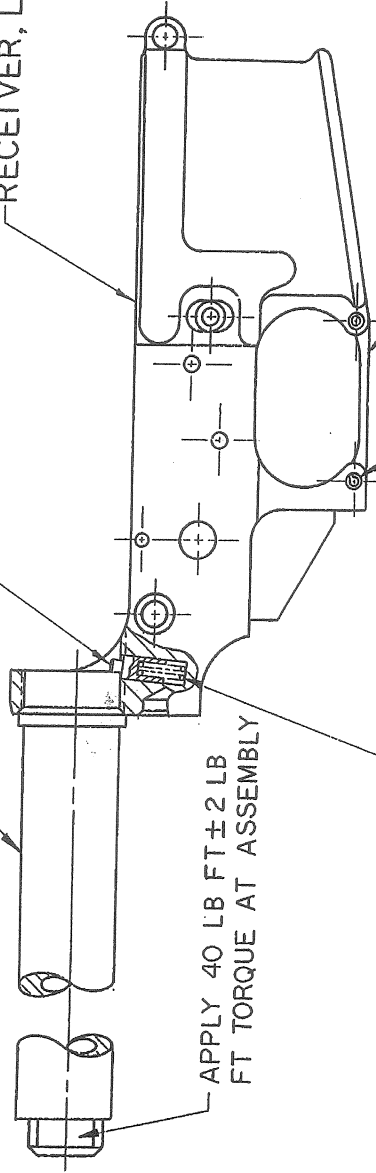
EXTENSION, RECEIVER - 8448581

NOTES:

I. MIL-W-13855 APPLIES. (A)

RETAINER, BUFFER - 8448582

RECEIVER, LOWER - 8448580



SPRING, BUFFER RETAINER - 8448583

TRIGGER, GUARD ASSY - 8448587

PIN, SPRING - MSI6562-I29
DRIVE FLUSH WITH RECEIVER

CURRENT DESIGN ACTIVITY

SEE PL-8448579

MECHANICAL PROPERTIES

YS	MIN	
YS	MAX	
EL 2		
RA		
BH		
RH		

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES ±
3 PLACE DECIMALS ±
2 PLACE DECIMALS ±

MATERIAL

F8448578	M16A1
NEXT ASSY	USED ON
APPLICATION	

FINAL PROTECTIVE FINISH

CONTRACT NO.

DATE 27 APR 1970

PREPARED BAR

CHECKED DDD

ENGINEER DDD

SUBMITTED DDD

APPROVED R.S. Henry

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
FSCM NO. 19200

DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201LOWER RECEIVER AND
RECEIVER EXTENSION
ASSEMBLY

SIZE CODE IDENT NO. DRAWING NO.

C 19204

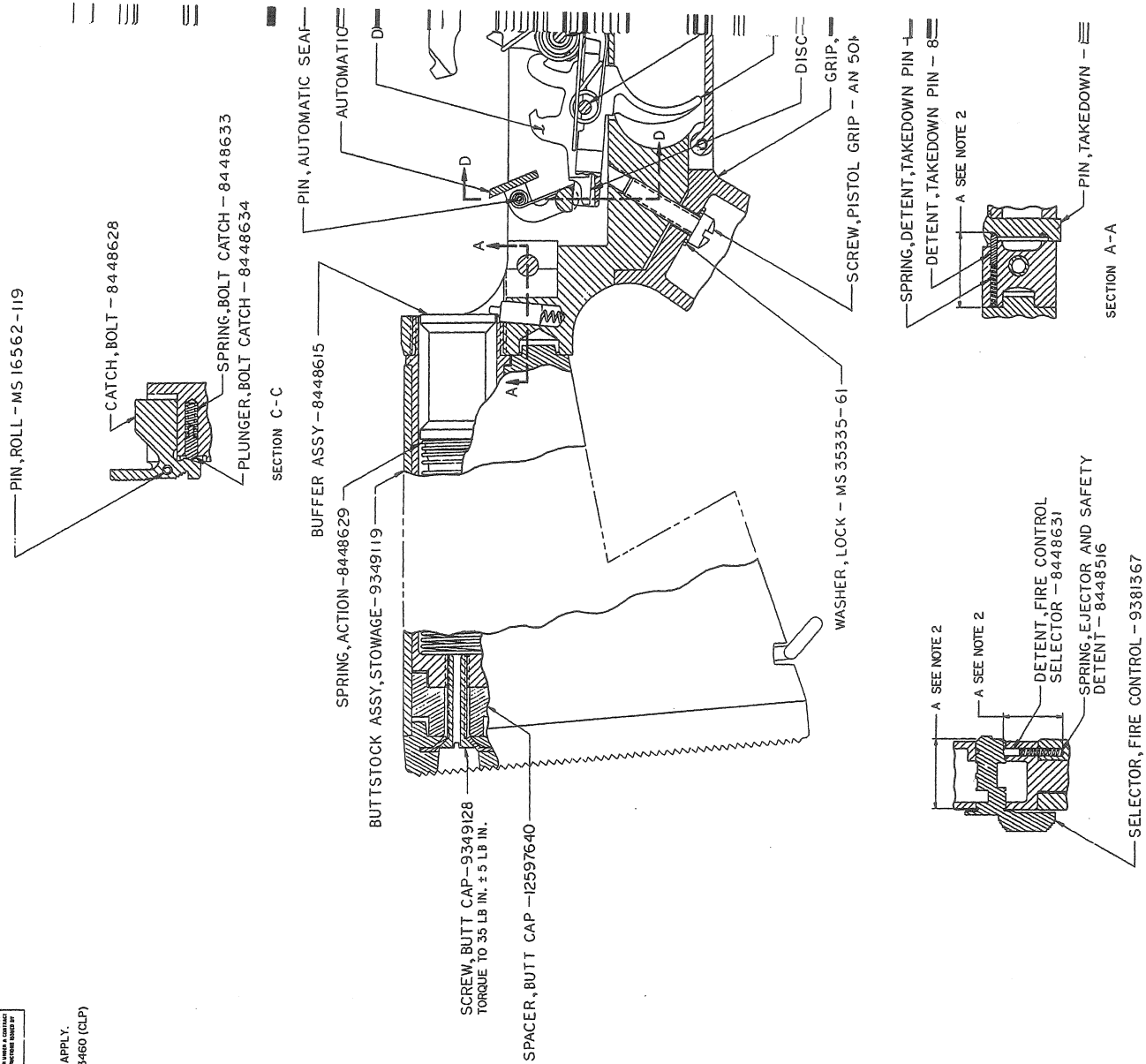
SCALE 1/1

SHEET 1 OF 1

8448579

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- NOTES:-
- 1- SPEC. MIL-W-58855 AND ANSI Y14.5-73 APPLY.
 - 2- APPLY MIL-L-46000 (LSA) OR MIL-L-63460 (CLP) AT ASSEMBLY OVER A.

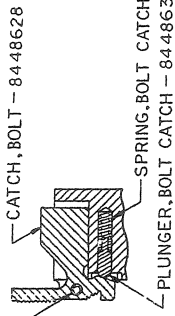


SECTION D-D

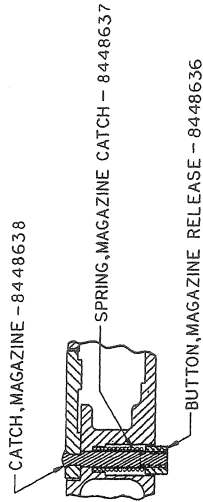
SECTION A-A

SECTION C-C

PIN, ROLL - MS 16562-119

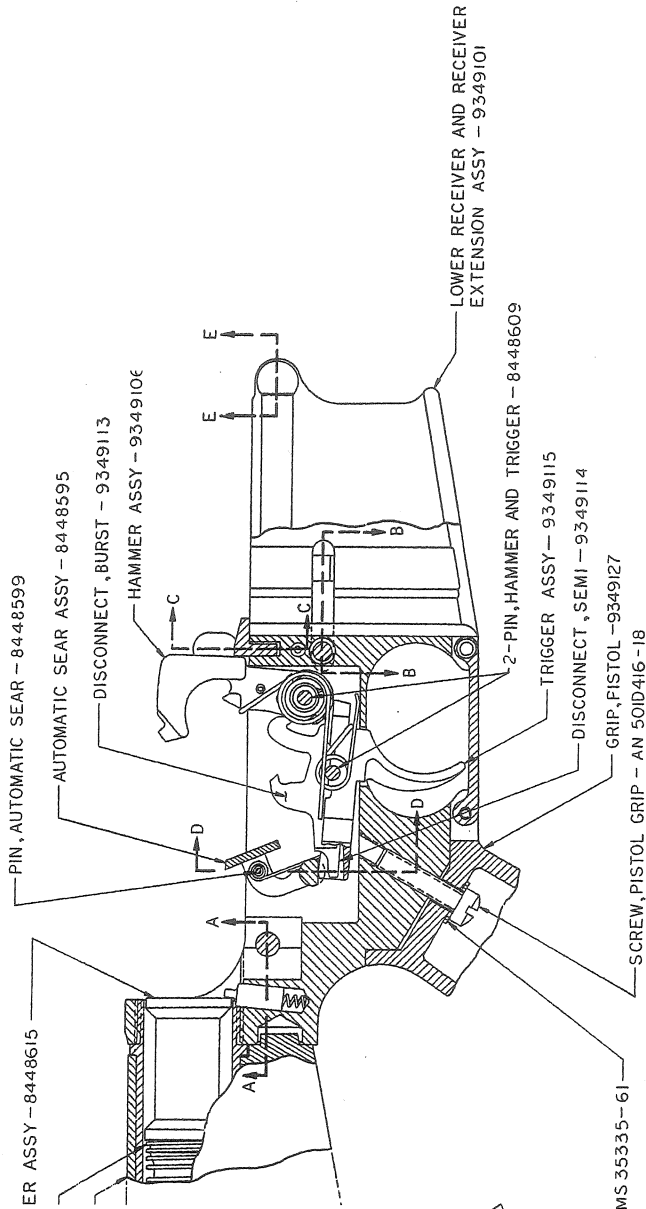


SECTION C-C



SECTION B-B

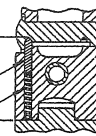
ER ASSY - 8448615



MS 35335-61

SPRING, DETENT, TAKEDOWN PIN - 8448586
DETENT, TAKEDOWN PIN - 8448585

A SEE NOTE 2

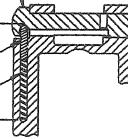


SECTION A-A

AFETY

SPRING, DETENT, TAKEDOWN PIN - 8448586
DETENT, TAKEDOWN PIN - 8448585

A SEE NOTE 2



SECTION E-E

PIN, RECEIVER PIVOT - 8448621

FOR ENGINEERING PARTS LIST SEE PL 9349100		PART NO. 9349100	
DRAWING TITLE		US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER	
DRAWING NO.		9349100	
DRAWING DATE		19200	
DRAWING BY		J 19200	
DRAWING CHECKED BY		J 19200	
DRAWING APPROVED BY		J 19200	
DRAWING SCALE		1:1	
DRAWING SHEET NO.		1 OF 1	

9349100 REV G (F-2/2)

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6. THE DRAWING IS TO BE USED IN CONFORMANCE WITH THE PROVISIONS AND FOR THE PURPOSES OF THE U.S. ARMY.
7. THE DRAWING IS TO BE USED IN CONFORMANCE WITH THE PROVISIONS AND FOR THE PURPOSES OF THE U.S. ARMY.
8. THE DRAWING IS TO BE USED IN CONFORMANCE WITH THE PROVISIONS AND FOR THE PURPOSES OF THE U.S. ARMY.
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10. THE DRAWING IS TO BE USED IN CONFORMANCE WITH THE PROVISIONS AND FOR THE PURPOSES OF THE U.S. ARMY.

NOTES:-

1- SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.

REV	DESCRIPTION	DATE	APPROVAL
1	PRODUCTION RELEASE	820614	820614
2	FOR W450030/84-11-15	850402	850402

EXTENSION, RECEIVER -8448581

APPLY 40 FT. LBS. $\pm$ 2 FT. LBS. TORQUE
AT ASSEMBLY

RETAINER, BUFFER -8448582

RECEIVER, LOWER -9349102

SPRING, BUFFER RETAINER -8448583

GUARD ASSEMBLY, TRIGGER -8448587

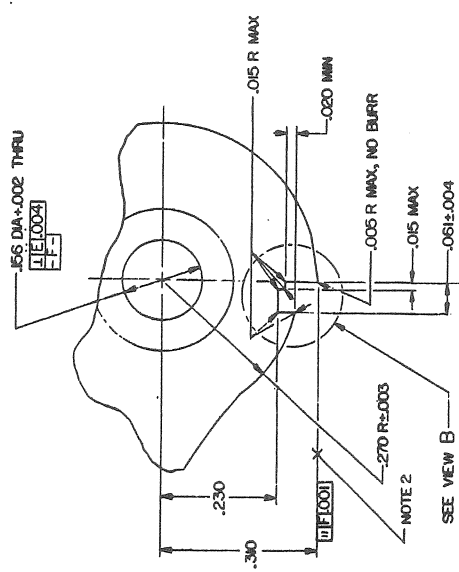
PIN, SPRING-MS16562-129
DRIVE FLUSH WITH LOWER RECEIVER

FOR ENGINEERING PARTS LIST SEE PL 9349101

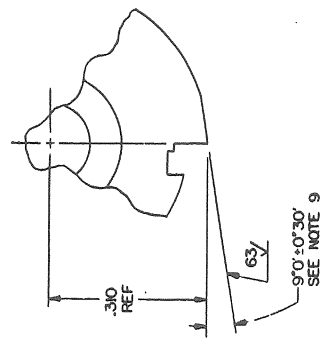
PART NO. 9349101		U.S. ARMY ARMAMENT CENTER DOVER, NEW JERSEY 07801	
ORIGINAL DATE OF CHANGE 82-03-25		CONFIRMATION MM CONFIRMATION MM CONFIRMATION MM	
DO NOT SCALE DRAWINGS UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DIMENSIONS ARE FRACTIONS ARE ANGLES ARE		DRAWN BY CHECKED BY APPROVED BY	
MECHANICAL PROPERTIES		MATERIAL SPECIFICATION	
9349100		M16A1E1	
NEXT PART		USED ON	
APPLICATION		FSCM NO D 19200	
9349101		9349101	
SHEET 1 OF 1		SHEET 1 OF 1	

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3. THIS DRAWING IS NOT TO BE USED FOR ANY OTHER PURPOSES WITHOUT THE WRITTEN PERMISSION OF THE U.S. GOVERNMENT.

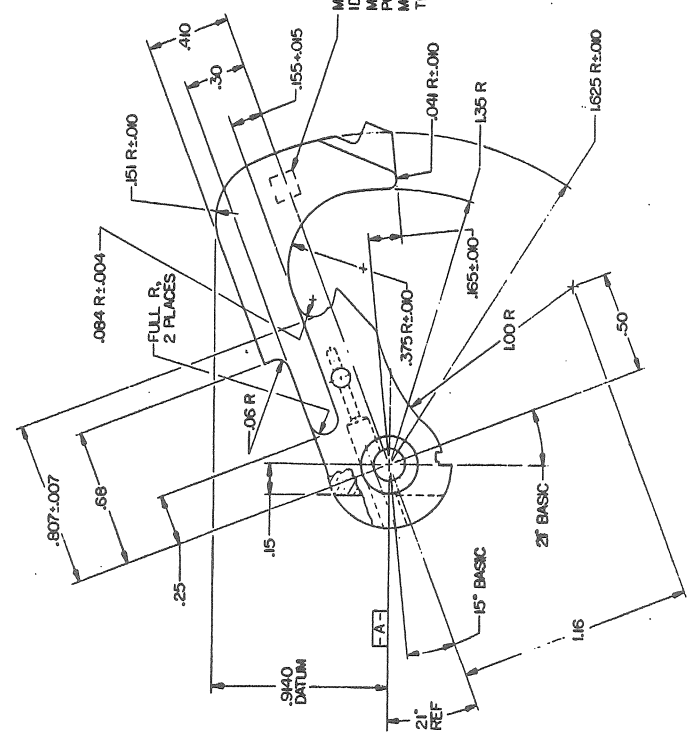
REV	DATE	DESCRIPTION	BY	CHKD
1	20 FEB 71	REPLACES 181(A) W/CHANGE	SEE E.O. 12812	
2	6 OCT 72	SEE E.O. 12812		
3	18-02-03	18-02-03		
4	18-02-03	18-02-03		
5	18-02-03	18-02-03		
6	18-02-03	18-02-03		
7	18-02-03	18-02-03		
8	18-02-03	18-02-03		
9	18-02-03	18-02-03		
10	18-02-03	18-02-03		
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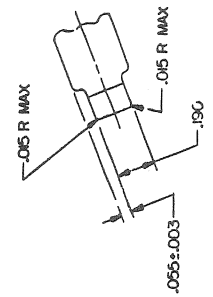
VIEW A-A
SCALE 10/1



VIEW B
SCALE 10/1



VIEW D-D



VIEW C-C

© MFG. IDENT SYMBOL AND CAVITY IDENT MARK .125 ± .015 HIGH, .005 MAX NEGATIVE ONLY IN APPROX POSITION SHOWN, EITHER SIDE. MARKS TO BE APPROVED BY THE GOVT.

REVISIONS TO THIS DRAWING SHALL BE MADE BY THE U.S. GOVERNMENT. DATE OF DETERMINATION 10-10-10.

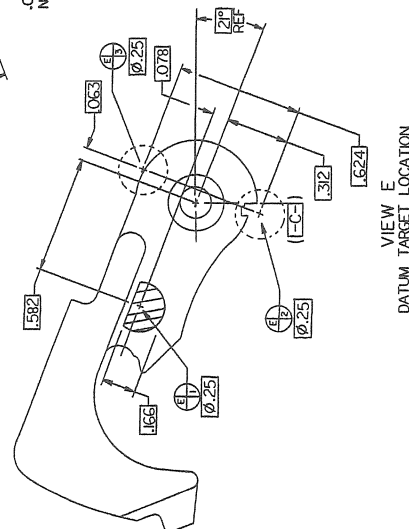
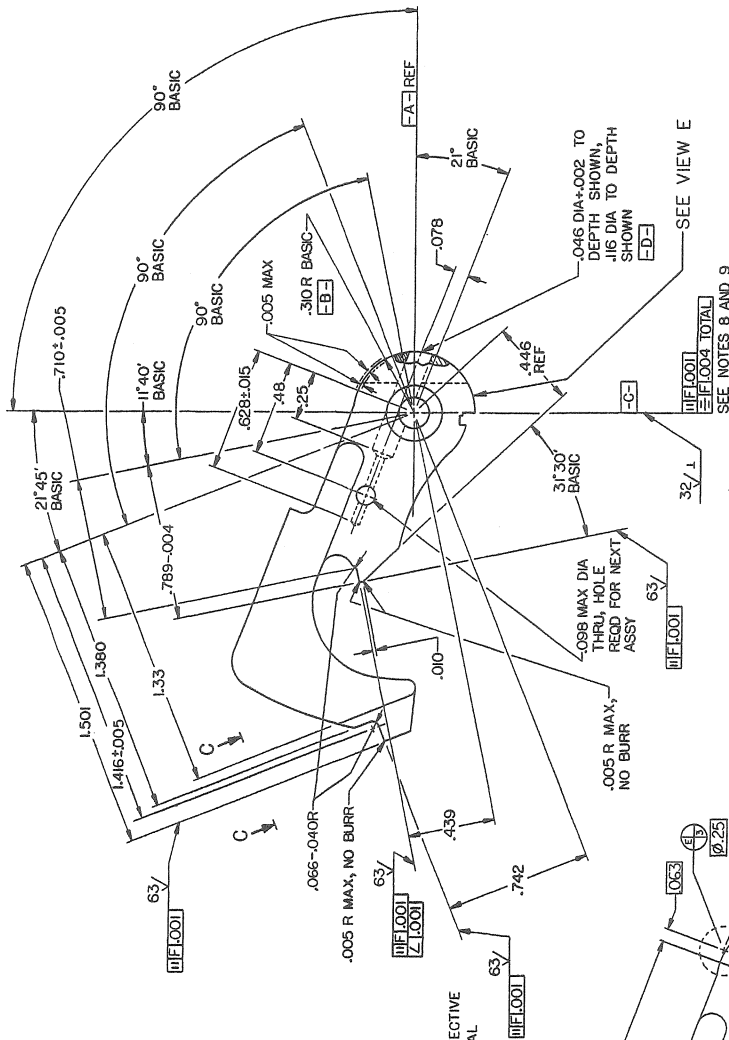
CURRENT DESIGN ACTIVITY FSCH NO. 19204
U.S. ARMY AMMUNITION DEVELOPMENT CENTER
ROCK ISLAND, ILLINOIS, 61201

DATE 27 APR 70		DRAWN BY [Signature]		CHECKED BY [Signature]	
DESIGNED BY [Signature]		APPROVED BY [Signature]		DATE 10/1/10	
PROJECT NO. 19204		DRAWING NO. 8448613		PAGE 2 OF 2	

[illegible]

③ L STEEL, INVESTMENT CASTING, CMPSN IC 4620 OR IC 8620, SPEC MIL-S-2214I, EXCEPT THAT MANGANESE CONTENT SHALL BE

2. ALL DIMENSIONS ARE BEFORE FINAL PROTECTIVE FINISH EXCEPT THOSE DEFINING
3. FILLET RADI .026±.010 UNLESS OTHERWISE SPECIFIED.
4. EDGE RADI .005 TO .036 UNLESS OTHERWISE SPECIFIED.
5. $\overline{F-A}$ ESTABLISHED BY $\overline{F-F}$ AND .9140 DATUM DIMENSION.
6. CLASSIFICATION AND INSPECTION OF CASTING TO BE IN ACCORDANCE WITH MIL-STD-275, CLASS 2, GRADE A.
7. CARBURIZE TO PRODUCE A TOTAL CASE DEPTH OF .014±.004.
8. .009 MIN CASE DEPTH REQUIRED IF SURFACE IS MACHINED AFTER HEAT TREATMENT.
9. NO FINAL PROTECTIVE FINISH IN THIS AREA. COAT WITH LUBRICATING OIL PER MIL-L-46000 OR MIL-L-63460.
10. FINISH 125/ EXCEPT AS NOTED. (C)
11. BREAK ALL SHARP EDGES PRODUCED BY MACHINING .005±.010 UNLESS OTHERWISE SPECIFIED.
12. ALL FILLET RADI PRODUCED BY MACHINING .003±.012 UNLESS OTHERWISE SPECIFIED.
13. PARTING LINE .005 MAX MISMATCH.
14. MIL-W-13855 APPLIES.
15. GRIND $\overline{C-C}$ AFTER HEAT TREAT AND FINAL PROTECTIVE FINISH. DIRECTION OF GRIND $\overline{I-I}$ MAY METAL REMOVED BY GRINDING 0.005.



LINE	ZONE	DISPOSITION	DATE	AMOUNT
B		REPLACES REPAIR/ W/CHANGE	20 FEB 78	14.44
C		SEE EMP 20778	6 OCT 72	9.72
D		(4) SEE EMP 20778	18 OCT 72	10.44
E		W/MP 25002/ 78-05-21	18 OCT 72	10.44
F		W/MP 25002/ 78-05-21	18 OCT 72	10.44
G		EMP 233 1251 AD	900309	900309
H		EMP W65 3044/ 8608121	900309	900309
I		GNR 625 3033/ 92 04 08	920509	920509
J		GNR 625 3032/ 9211 10	930128	930128
K		GNR 625 3009/ 930303	930401	930401
L		JNOR 655311/ 960719	961204	961204

[illegible]

REV STATUS OF SHT'S	
SH 1	SH 2
K	J

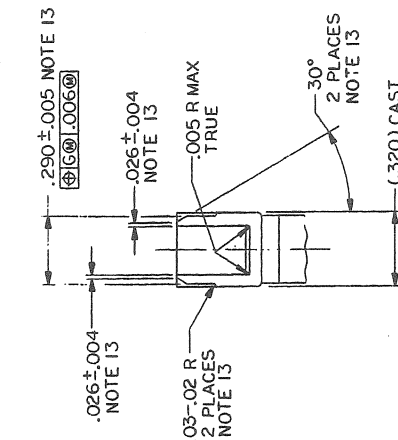
DATUM	TARGET	VIEW	E	LOCATION
1	2	3	4	5

NOTICE: INTENDED AS TO USE AND DISCLOSURE

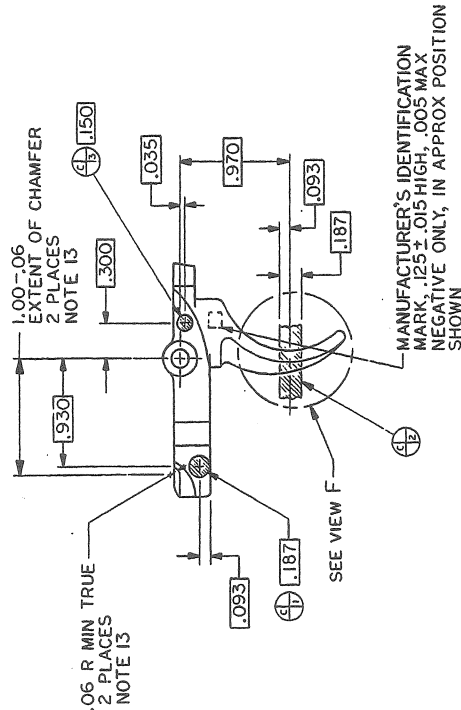
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NOTICE: RESTRICTED A2 TO USE AND DISCLOSURE

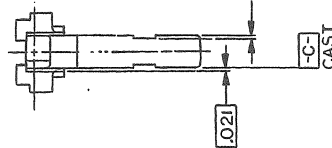
NO	PRODUCTION RELEASE	DATE	APPROVAL
—	ERR W550028 / 8410-16	850204	
A	NOR W550267 / 85-07-23 (ECP W65302 / 86-05-27)	860724	6
F	NOR G253059 / 920716 (ECP 6253060 / 920630)	920811	A/JL
G	NOR G353080 / 930903	931101	H = 2
H	NOR 6453080 / 940204	940523	6



VIEW E
SCALE 4/1



VIEW F



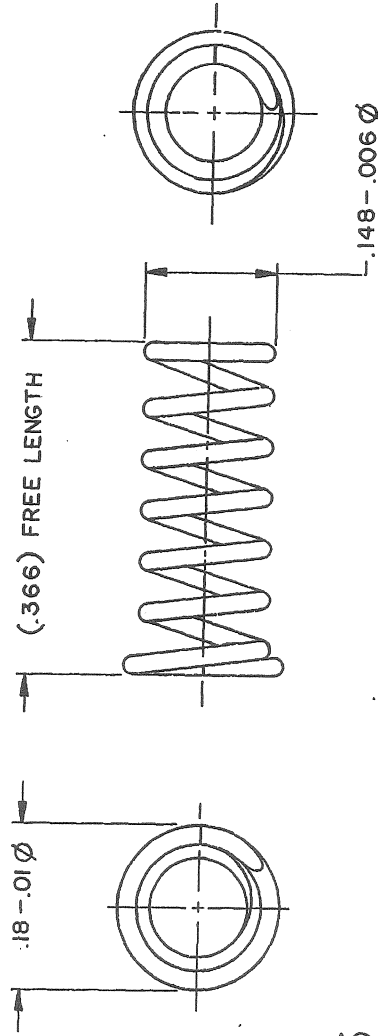
DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQC-AR OR HIGHER DOD AUTHORITY: 92-06-22.

[illegible]

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NOTES: -

- 1- SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY,
- 2- MATERIAL:
WIRE, STAINLESS STEEL, TYPE 301 (17-7PH),
COLD DRAWN, ASTM-A313.
- 3- WIRE DIAMETER: $-.0200 \pm .0005$.
- 4- DIRECTION OF HELIX: - OPTIONAL.
- 5- TOTAL NO. OF COILS: - (7.5)
- 6- LOAD AT COMPRESSED LENGTH OF .263: - 2.1 LBS $\pm$.2 LBS.
- 7- MAX. SOLID HEIGHT: - .154.
- 8- BREAK SHARP EDGES $.003 \pm .012$.
- 9- FINISH $\sqrt{125}$ ALL SURFACES.
- 10- MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572 EXCEPT PARAGRAPH 4.4.4.1 SHALL NOT APPLY.
- 11- PRECIPITATION HEAT TREAT AFTER FORMING. HOLD AT $900^{\circ}\text{F} \pm 10^{\circ}\text{F}$ FOR ONE HOUR, AIR COOL.
- 12- HARDNESS EQUIV TO ROCKWELL C 48 MIN.
- 13- TYPE OF ENDS: - ONE CLOSED AND GROUND. ONE CLOSED, FLARED AND GROUND.
- 14- PROTECTIVE FINISH: - 5.41 OF MIL-STD-171.
- 15- SPRING REQUIREMENTS APPLY AFTER COMPRESSING TO SOLID LENGTH.
- 16- FOR ASSEMBLY OF DISCONNECT SPRINGS TO TRIGGER USE OPTIONAL KEY AND SPRING INSERT TOOL DRAWING NO. (D12011964) OR SIMILAR DEVICE.



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
-	PRODUCTION RELEASE ERRW252013	820614	1/12/12-12/12/12
A	NOR W252011/82-04-13 (ECP W353120/83-07-07)	83-11-04	1/12/12
B	NOR W25258/82-12-30	840904	1/12/12
C	NOR W45 0030/84-11-15	850402	1/12/12
D	NOR W55 2030/85-05-25	850731	1/12/12
E	NOR GOS3152/901002	910322	PF 52
F	NOR G152018 91 07 08	91-10-11	52
G	NOR G153138/911001	920205	52

PART NO. 9349116

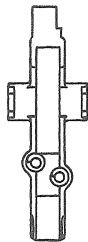
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
ORIGINAL DATE OF DRAWING 82-02-26	
DRAFTSMAN M M CHECKER DEW	
ENGR ENGR ENGR	
DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS $\pm$ FRACTIONS $\pm$ ANGLES $\pm$	
MECHANICAL PROPERTIES Y P T S E L R A B H	
9392518 M 4	
9349115 M16A2	
NEXT ASST USED ON	
APPLICATION	
SPRING, DISCONNECT	
SIZE C	FSCM NO. 19200
SCALE 10/1	UNIT WT.
9349116	SHEET 1 OF 1

DRAWING SIZE D
(ASAPADCOM 76-12) 8

NOTES:—
1—SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2 FOR ASSEMBLY OF DISCONNECT SPRINGS TO TRIGGER USE
OPTIONAL KEY AND SPRING INSERT TOOL DRAWING NO:D2011964)
OR SIMILAR DEVICE.

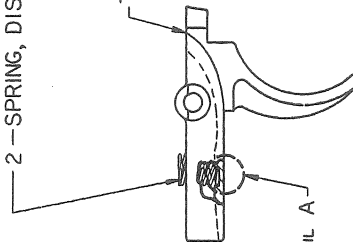
NOTES:—

- 1—SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.
- 2 FOR ASSEMBLY OF DISCONNECT SPRINGS TO TRIGGER USE
OPTIONAL KEY AND SPRING INSERT TOOL DRAWING NO:D2011964)
OR SIMILAR DEVICE.



2—SPRING, DISCONNECT-9349116

TRIGGER-9390736



SEE DETAIL A



LARGE DIAMETER OF SPRING MUST BE
SEATED FULLY IN THE RECESS.

DETAIL A
2 PLACES
SCALE:10/1

REV	DESCRIPTION	DATE	APPROVAL
1	PRODUCTION RELEASE	850224	
2	ECN 450028 / 84-10-16		
3	ECN 450099 / 84-12-20		
4	NOR 6053143 / 900913	90108	
5	NOR 6053152 / 901002	91022	
6	NOR 6153138 / 911001	920206	

FOR ENGINEERING PARTS LIST SEE PL 9392518

PART NO. 9392518

U.S. ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER
DOWEL NEW JERSEY 07031

TRIGGER SUBASSEMBLY

FSCN NO. 9392518

19200

SCALE 2/1

SHEET 1 OF 1

MECHANICAL PROPERTIES	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED	ORIGINAL INT'L OF DRAWING 95-02-04
VP	UNLESS OTHERWISE SPECIFIED	UNLESS OTHERWISE SPECIFIED
TS	DIMENSIONS ARE IN INCHES	DIMENSIONS ARE IN INCHES
RA	TOLERANCES ON DECIMALS ±	TOLERANCES ON DECIMALS ±
BR	FRACTIONS ±	FRACTIONS ±
RM	ANGLES ±	ANGLES ±
9349115	M16A2	
NEXT ASST	USED ON	
APPLICATION		

NOTICE: RESTRICTED AS TO USE AND DISCLOSURE

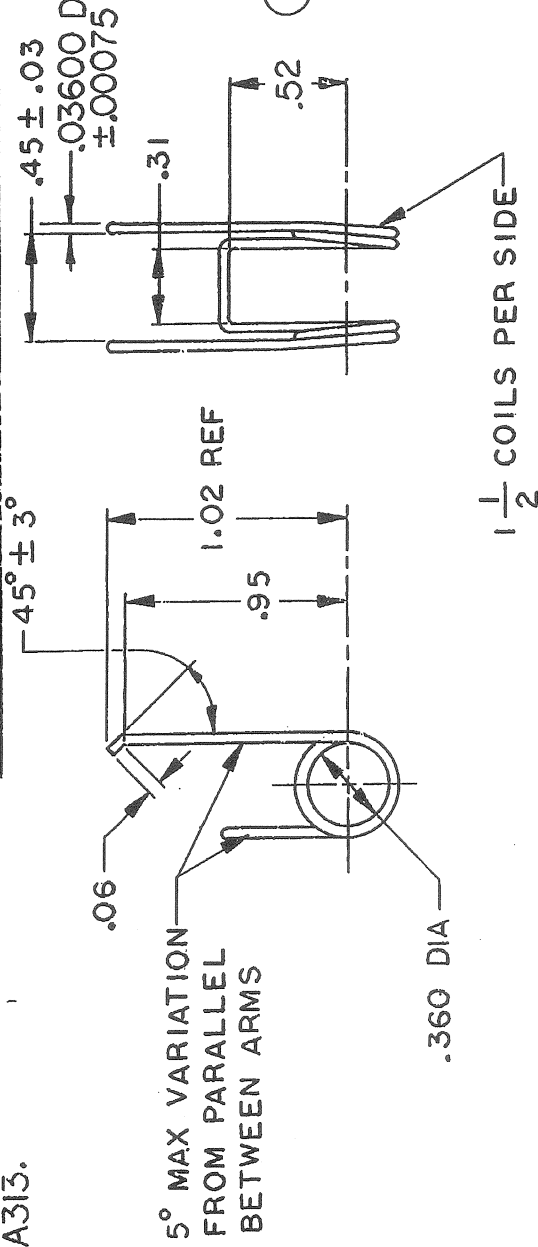
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G NORGIS2018 910708 91-10-11

REV	DATE	DESCRIPTION
1	27 APR 70	REDRAWN FROM COLT'S DRAWING
2	15 JULY 70	B61657 REVISION B
3	20 FEB 71	A (1) SEE EO HRD 02197-3
4	6 OCT 72	B (3) SEE EO HQR 10639
5	80-05-16	C (2) SEE ERR HQR 20778
6	82-04-13	D NOR W9S2009 80-02-13
7	83-11-04	E NOR W250011 / 82-04-13
8	900815	F (ECP W250034 / 82-07-15)

NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITION CH-900. HOLD AT 900°F ± 10° FOR 1 HOUR. AIR COOL.
3. TORQUE REQUIREMENT: 1.5 ± .27 LB IN. TORQUE AT 45° DEFLECTION
4. FINISH 5.4.1 OF MIL-STD-171.
5. MIL-W-13855 APPLIES.



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

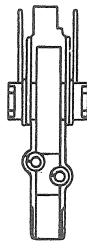
CONTRACT NO.	DATE	PREP	CHK	ENGR	SUBMITTED	APPROVED
	27 APR 1970	PREP	CHK	ENGR		
DATE 27 APR 1970						
TOLERANCES: 3 PLACE DECIMALS ± .005						
2 PLACE DECIMALS ± .01						
MATERIAL						
SEE NOTE 1						
FINAL PROTECTIVE FINISH						
SEE NOTE 4						

MECHANICAL PROPERTIES	9390011	M4	9349115	M16A2	F 9327230	M231	M16	B8448591	M16A1	15N 84.5 MIN
YS										
MIN										
YS										
MAX										
EL2										
RA										
BH										
RH										
APPLICATION										

NOTES: -

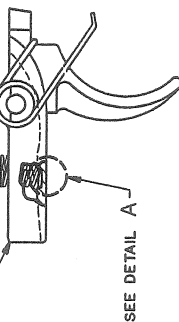
1 - SPEC. MIL-W-13855 AND ANSI Y14.5 -73 APPLY.

REVISIONS				
SYN	DESCRIPTION	DATE	APPROVAL	
—	PRODUCTION RELEASE ERRW25Z013	820614	07% 12-14	
A	NOR W450028/84-10-16 (ECP W452099/84-12-21)	850204	07% 12-14	



TRIGGER SUBASSEMBLY
9392518

-SPRING, TRIGGER-8448593



SEE DETAIL A.



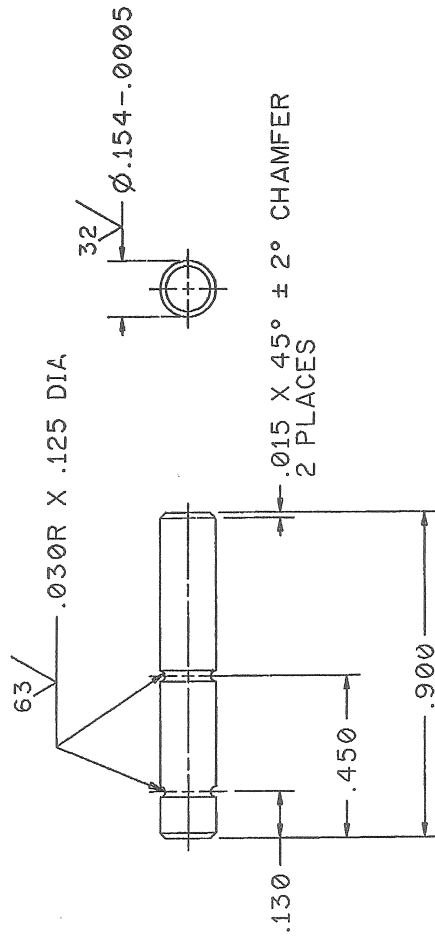
FLARED END OF SPRING

DETAIL A
2 PLACES
SCALE: 10/1

[illegible]

NOTE:

1. FINISHED ¹²⁵✓ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005 MAX.
3. FINISH 5.3.1.2 OF MIL-STD-171.
4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
5. MIL-W-13855 APPLIES.
6. MATERIAL: COLD FINISHED ALLOY STEEL BAR, GRADE 4130 OR 4140, ASTM A331, COLD HEADING QUALITY.



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CURRENT DESIGN ACTIVITY CAGE CODE 19200
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICAATINNY ARSENAL, NEW JERSEY 07806-3000

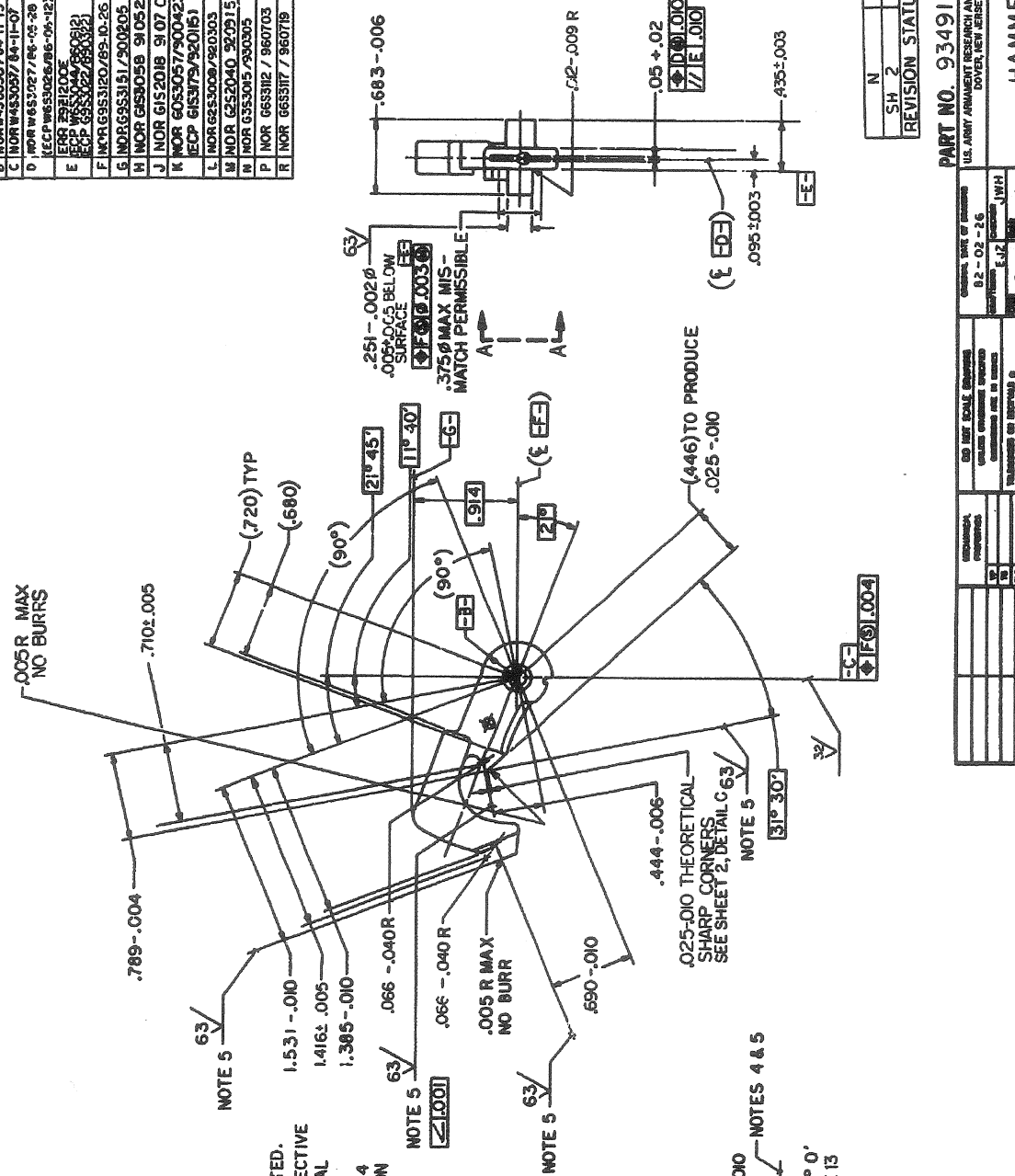
PART NO. 8448609

PMIC	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	CONTRACT NUMBER	DEPT OF THE ARMY US ARMY WEAPONS COMMAND ROCK ISLAND ILLINOIS, 61201
MECHANICAL PROPERTIES	TOLERANCES ON DECIMAL FRACTION ±	CONTRACTOR	PIN, HAMMER & TRIGGER
YP	2 PL ±	DRAWN BY PEM	SIZE CASE CODE
TS	3 PL ± .005	DATE(YR-MO-DA) 700427	C 19204
EL2		ENGINEER D. SMART	8448609
IR1	9390011 M4	CHECKER DHW	SCALE 4/1
BH	F8448604 M16	DRAWING APPROVAL F. P. GILHOOLY	SHEET
RH	F8448578 M16A1	DESIGN APPROVAL R. S. HENRY	
	NEXT ASSY USED ON APPLICATION		
	15N 72.5-76		

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASORC-AR OR HIGHER DOD AUTHORITY: 92-66-22.

SMCAR FORM 67, 1 DEC 87(TEMP), REPLACES SMCAR FORM 67, 1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED

- [illegible]



LINE	DESCRIPTION	DATE	GENERAL
-	PRODUCTION RELEASE	8/26/14	
1	PROD/32013	8/26/14	
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B	NOR W353.3862/03/13-22	8/26/14	
C	NOR W353.0359/04-11-07	8/26/14	
D	NOR W353.0359/04-11-07	8/26/14	
E	NOR W353.0359/04-11-07	8/26/14	
F	NOR W353.0359/04-11-07	8/26/14	
G	NOR W353.0359/04-11-07	8/26/14	
H	NOR W353.0359/04-11-07	8/26/14	
I	NOR W353.0359/04-11-07	8/26/14	
J	NOR W353.0359/04-11-07	8/26/14	
K	NOR W353.0359/04-11-07	8/26/14	
L	NOR W353.0359/04-11-07	8/26/14	
M	NOR W353.0359/04-11-07	8/26/14	
N	NOR W353.0359/04-11-07	8/26/14	
O	NOR W353.0359/04-11-07	8/26/14	
P	NOR W353.0359/04-11-07	8/26/14	
Q	NOR W353.0359/04-11-07	8/26/14	
R	NOR W353.0359/04-11-07	8/26/14	
S	NOR W353.0359/04-11-07	8/26/14	
T	NOR W353.0359/04-11-07	8/26/14	
U	NOR W353.0359/04-11-07	8/26/14	
V	NOR W353.0359/04-11-07	8/26/14	
W	NOR W353.0359/04-11-07	8/26/14	
X	NOR W353.0359/04-11-07	8/26/14	
Y	NOR W353.0359/04-11-07	8/26/14	
Z	NOR W353.0359/04-11-07	8/26/14	

N	R
SH 2	SH 1
REVISION STATUS OF SHEETS	

PART NO. 9349111		U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
HAMMER			
QNTY	FSCIN NO. 19200	9349111	
QNAZ 2/1	UNIT WTY.	INVENT 1 OF 2	

DETAIL A
SCALE: 4/1
DISTRIBUTION STATEMENT B. FURTHER DISTRIBUTION ONLY AS
DIRECTED BY ARDC, SMCN-ISH, ROCK ISLAND, IL,
ASDC-AR-9102.

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3



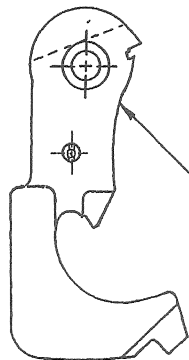
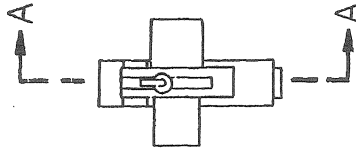
2

1

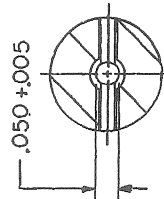
NOTES: -

- 1 - SPEC. MIL-W-13855 AND ANSI Y14.5-73
APPLY.
- 2 - COIN BOTH SIDES OF RETAINER (8448614), AFTER
COINING RETAINER IS TO HAVE .010 MIN
LONGITUDINAL MOVEMENT.

RETAINER, HAMMER PIN-8448614



HAMMER-9349!!!



SECTION A-A

SEE DETAIL B

DETAIL B
SCALE 4/1

PART NO. 9349110

[illegible]

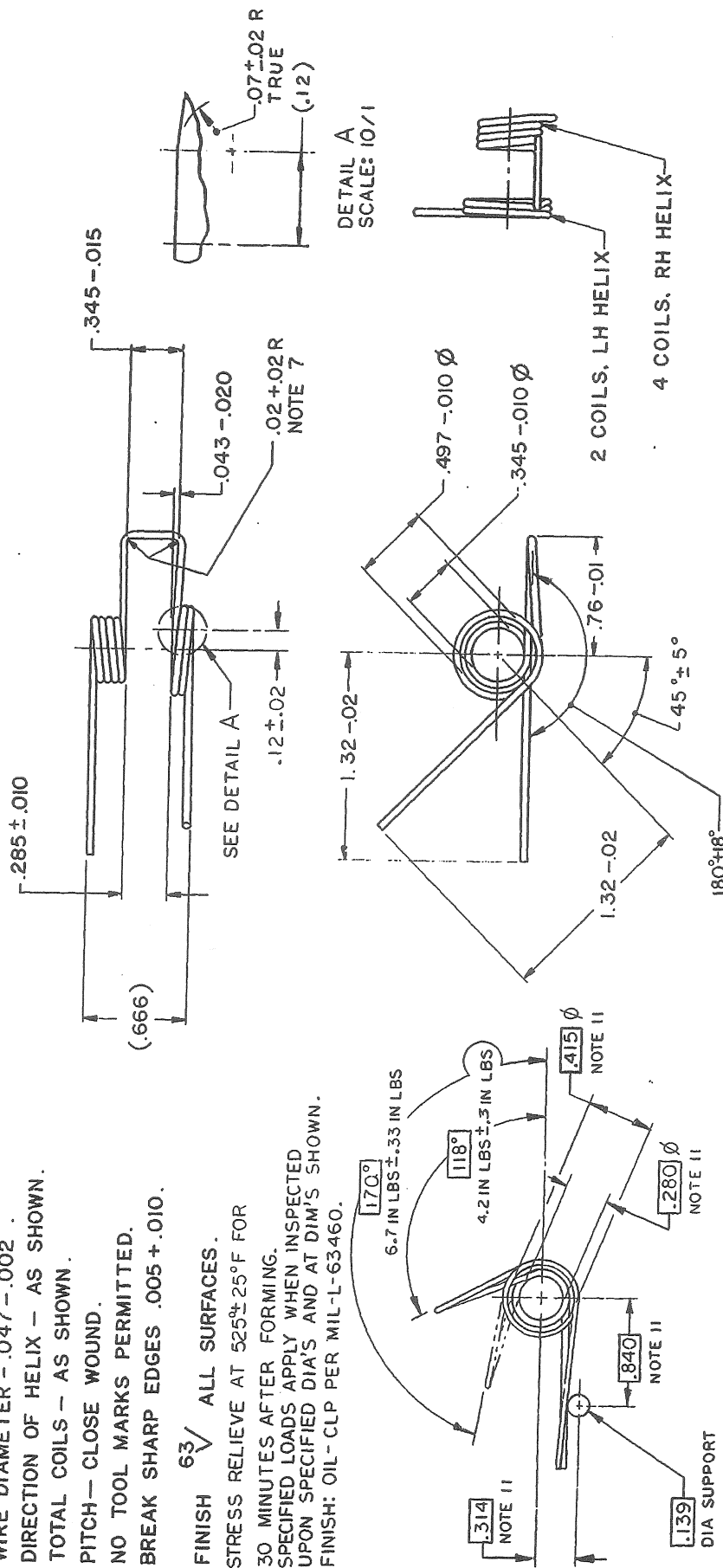
As access continues to be denied, the role of the attorney general, who is charged with the responsibility of protecting the public interest, becomes increasingly important. The attorney general should be given the authority to investigate and, if necessary, to prosecute any individual or entity that is found to be in violation of the law. This would ensure that the public interest is protected and that the law is enforced.

NOTES :-

- 1- SPEC MIL-W-13855 AND ANSI Y14.5-73
APPLY.

- 2-MATERIAL :- MUSIC WIRE PER ASTM-A228

- 3-WIRE DIAMETER -.047 -.002 .
- 4-DIRECTION OF HELIX - AS SHOWN .
- 5-TOTAL COILS - AS SHOWN .
- 6-PITCH - CLOSE WOUND .
- 7-NO TOOL MARKS PERMITTED .
- 8-BREAK SHARP EDGES .005 + .010 .
- 9-FINISH $\sqrt{63}$ ALL SURFACES .
- 10-STRESS RELIEVE AT 525 $\pm$ 25°F FOR 30 MINUTES AFTER FORMING .
- 11-SPECIFIED LOADS APPLY WHEN INSPECTED UPON SPECIFIED DIA'S AND AT DIM'S 5
- 12-FINISH: OIL-CLP PER MIL-L-63460 .



REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
—	PRODUCTION RELEASE ERR W252013	820614	W252013
A	NOR W2S3258/82-12-30 (ECP W4S3151/83-11-14) (ECP W4S3010/84-05-07)	840504	W4S3151
B	NOR W4S0030/84-11-15	85-04-02	W4S0030
C	NOR G8S2005/880310	880927	W4S0030
D	NOR G0S3095/900618	901107	W4S0030
E	NOR G1S2018 31 0708	91-10-11	W4S0030

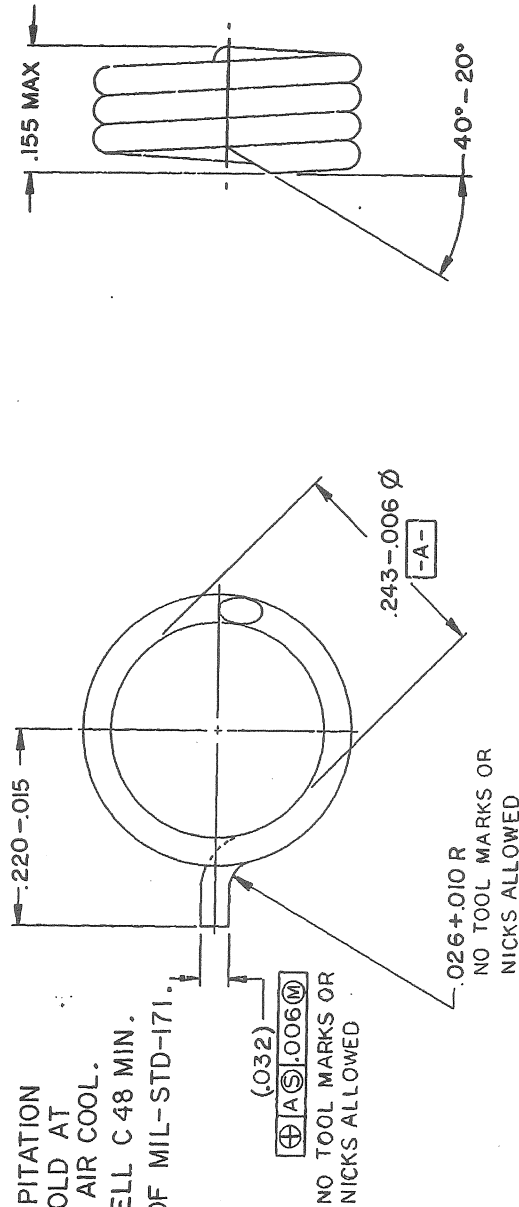
PART NO. 9349107		U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801		SPRING, HAMMER		SIZE FSCM NO. C 19200		9349107		SCALE 2/1		UNIT WT.		SHEET 1 OF 1	
ORIGINAL DATE OF DRAWING 82-06-09		DRAFTSMAN M M		CHECKER DEW		ENGR M M		ENGR M M		ENGR M M		ENGR M M		ENGR M M	
DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES ON DECIMALS ±		FRACTIONS ±		ANGLES ±		ANGLES ±		ANGLES ±		ANGLES ±		ANGLES ±	
MECHANICAL PROPERTIES		Y _P		TS		B ₂		BA		BH		RH		RH	
9300032		M4		9349106		M16A2		USED ON		NEXT ASSY		APPLICATION		APPLICATION	

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REVISIONS		
SYM	DESCRIPTION	DATE
—	PRODUCTION RELEASE ERR W252013	820614
A	NOR W250011/82-04-13 (ECP W353120/83-07-07)	83-11-04
B	NOR W253258/82-12-30 (ECP W353151/83-11-14)	840504
C	NOR W450030/84-11-15	850402
D	NOR GIS2018	91-10-11

NOTES:—

- 1—SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
- 2—MATERIAL:—WIRE, STAINLESS STEEL, TYPE 631 (17-7PH), COLD DRAWN, ASTM A313.
- 3—WIRE DIAMETER — .032 — .001.
- 4—DIRECTION OF HELIX — RIGHT HAND.
- 5—TOTAL COILS — 3.5 REF.
- 6—PITCH — CLOSE WOUND.
- 7—BREAK SHARP EDGES .003 ± .012.
- 8—FINISH $\sqrt{63}$ ALL SURFACES.
- 9—STRESS RELIEVE AND PRECIPITATION HARDEN AFTER FORMING. HOLD AT 900°F ± 10°F FOR ONE HOUR, AIR COOL.
- 10—HARDNESS EQUIV TO ROCKWELL C 48 MIN.
- 11—PROTECTIVE FINISH: — 5.4.1 OF MIL-STD-171.

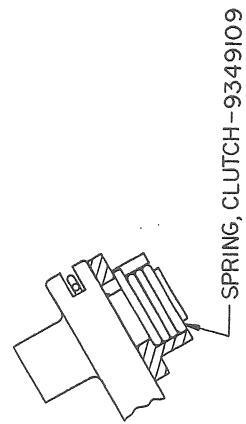


PART NO. 9349109

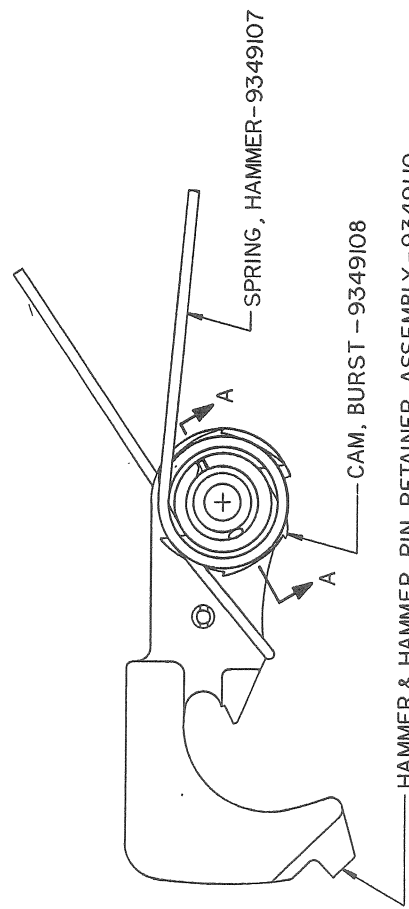
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
ORIGINAL DATE OF DRAWING 82-02-26	CHECKER DEW
DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAFTSMAN M M
TOLERANCES ON DECIMALS ± FRACTIONS ±	ENGR ENGR
MECHANICAL PROPERTIES	ENGR
YP	
TS	
EL2	
RA	
BH	
RH	
9350032 M4	
9349106 M16A2	
NEXT ASSY	USED ON
APPLICATION	
SPRING, CLUTCH	
SIZE C	FSCM NO. 19200
SCALE 10/1	UNIT WT. 9349109
SHEET 1 OF 1	

DRAWING SIZE D
(A8) 100mm x 150mm

NOTES:
1 - SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.



SECTION A-A
WITH (SPRING, HAMMER-9349107) REMOVED



SPRING, CLUTCH-9349109
SPRING, HAMMER-9349107
CAM, BURST-9349108
HAMMER & HAMMER PIN RETAINER ASSEMBLY-9349110

REV	DESCRIPTION	DATE	APPROVAL
1	PRODUCTION RELEASE ERRW-52013	820614	for the...
2	A NOR W450030/84-11-15	850402	for the...

FOR ENGINEERING PARTS LIST SEE PL 9349106

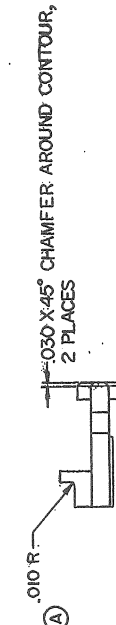
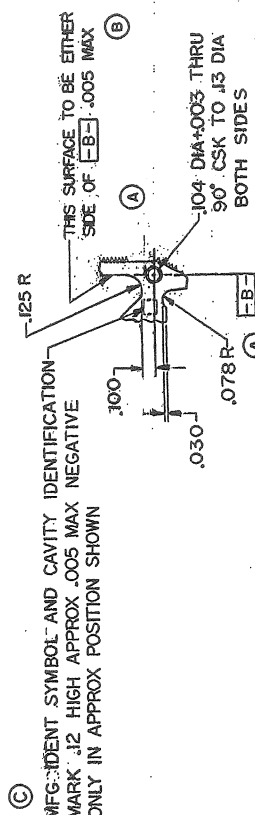
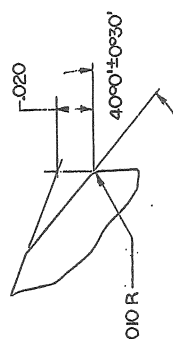
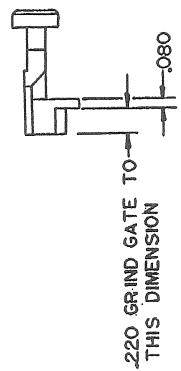
PART NO. 9349106

DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING 92-02-26	U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS: FRACTIONS: ANGLES:		CHECKED: JWH DATE: 92-02-26 BY: JWH	HAMMER ASSEMBLY	
MECHANICAL PROPERTIES TEMPERATURE: 100-150 STRENGTH: 100-150 ELONGATION: 100-150 TENSILE: 100-150 COMPRESSION: 100-150 BENDING: 100-150 TORSION: 100-150 IMPACT: 100-150 VIBRATION: 100-150 OTHER: 100-150		FSCM NO 19200 9349106 PAGE 4/11 UNIT WT.		

5	4	3	2	1																																																
NOTICE: RESTRICTED AS TO USE AND DISCLOSURE THIS DRAWING AND ALL INFORMATION HEREON IS HEREBY TO BE KEPT SECRET AND NOT TO BE DISCLOSED, REPRODUCED OR COPIED IN WHOLE OR IN PART, WITHOUT THE WRITTEN PERMISSION OF THE ARMY. THIS DRAWING IS THE PROPERTY OF THE ARMY AND IS LOANED TO YOU FOR YOUR INFORMATION ONLY. IT IS NOT TO BE DISTRIBUTED OUTSIDE YOUR ORGANIZATION. IT IS TO BE RETURNED TO THE ARMY WHEN NO LONGER REQUIRED. IT IS TO BE DESTROYED IN ACCORDANCE WITH THE ARMY'S DISPOSITION OF INFORMATION POLICY. IT IS TO BE KEPT IN A SECURE PLACE AND NOT TO BE LOANED TO ANY OTHER PERSON. IT IS TO BE KEPT IN A SECURE PLACE AND NOT TO BE LOANED TO ANY OTHER PERSON. IT IS TO BE KEPT IN A SECURE PLACE AND NOT TO BE LOANED TO ANY OTHER PERSON.																																																				
REVISIONS <table><thead><tr><th>MF</th><th>ZONE</th><th>LTR</th><th>DESCRIPTION</th><th>DATE</th><th>APPROVED</th></tr></thead><tbody><tr><td></td><td></td><td></td><td>REDRAWN FROM COLT'S DRAWING</td><td>27 APR 70</td><td></td></tr><tr><td></td><td></td><td></td><td>B61615 REVISION B</td><td></td><td></td></tr><tr><td></td><td>A</td><td></td><td>(4) SEE ERR HQ R 20778</td><td>6 OCT 72</td><td>ORC</td></tr><tr><td></td><td>B</td><td></td><td>NOR W9S2009 80-02-13</td><td>80-05-16</td><td>ORC</td></tr><tr><td></td><td>C</td><td></td><td>NOR G8S3003/880229</td><td>880926</td><td>ORC</td></tr><tr><td></td><td>D</td><td></td><td>NOR GIS2018 / 91 07 08</td><td>91-10-11</td><td>RR</td></tr><tr><td></td><td>E</td><td></td><td>NOR G2S3059 920716 (ECP G2S3060 920630)</td><td>92-08-11</td><td>AJL</td></tr></tbody></table>					MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED				REDRAWN FROM COLT'S DRAWING	27 APR 70					B61615 REVISION B				A		(4) SEE ERR HQ R 20778	6 OCT 72	ORC		B		NOR W9S2009 80-02-13	80-05-16	ORC		C		NOR G8S3003/880229	880926	ORC		D		NOR GIS2018 / 91 07 08	91-10-11	RR		E		NOR G2S3059 920716 (ECP G2S3060 920630)	92-08-11	AJL
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NOTES: 1. FINISH $125\sqrt{\text{EXCEPT AS NOTED.}}$ 2. BREAK ALL SHARP EDGES .005 MAX. 3. FINISH 5-3-1.2 OF MIL-STD-171. 4. HEAT TREATMENT: QUENCH (A) AND TEMPER TO HARDNESS SPECIFIED. 5. MIL-W-13855 APPLIES. (A)																																																				
63° .1230 DIA ±.0005 -A- .900 63° .0185 R ±.0025 .250 2 PLACES .033 REF .105 DIA ±.004 .020 X 45° ±2° CHAM BOTH ENDS (A) 63°																																																				
DISTRIBUTION STATEMENT: E. FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQC-AR OR HIGHER DOD AUTHORITY, 92-06-22.																																																				
CURRENT DESIGN ACTIVITY CODE 19200 ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER PICATINNY ARSENAL, NEW JERSEY 07806-5000																																																				
PIN, AUTOMATIC SEAR DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201 CONTRACT NO. DATE 27 APR 1970 PREP CHK ENGR SUBMITTED APPROVED SEE NOTE 3 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS ± WIRE, STEEL, CMPSN 4130, OR 4140; ASTM A331 FINAL PROTECTIVE FINISH MECHANICAL PROPERTIES <table><thead><tr><th>YS</th><th>MIN</th><th>MAX</th><th>EL 2</th><th>RA</th><th>BH</th><th>RH</th></tr></thead><tbody><tr><td>9390011</td><td>M4</td><td></td><td></td><td></td><td></td><td></td></tr><tr><td>F8448604</td><td>M16</td><td></td><td></td><td></td><td></td><td></td></tr><tr><td>F8448578</td><td>M16A1</td><td></td><td></td><td></td><td></td><td></td></tr></tbody></table> APPLICATION USED ON NEXT ASSY 15N 72-5-76 SCALE 4/1 SHEET 1 OF 1 CDI					YS	MIN	MAX	EL 2	RA	BH	RH	9390011	M4						F8448604	M16						F8448578	M16A1																									
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9390011	M4																																																			
F8448604	M16																																																			
F8448578	M16A1																																																			

[illegible]

1. STEEL INVESTMENT CASTING; CMPSN IC8620, SPEC MIL-S-2141, EXCEPT - THAT MANGANESE CONTENT SHALL BE .70 TO 1.20 %.
2. CLASSIFICATION AND INSPECTION OF CASTINGS SHALL BE IN ACCORDANCE WITH CLASS 3, GRADE A, SPEC MIL-STD-2175, EXCEPT CLASS 2, GRADE C IS PERMISSIBLE IN AREA F.
3. FINISH 125 EXCEPT AS NOTED.
4. EJECTOR PIN MARKS .010 NEGATIVE MAX.
5. CARBURIZE TO PRODUCE A TOTAL CASE DEPTH OF .014 TO .018.
6. BREAK SHARP EDGES .005+/.010 UNLESS OTHERWISE SPECIFIED. (A)
7. MIL-W-13855 APPLIES. (R)



REVISEMENTS		DATE	APPROVED
DATE	DESCRIPTION	DATE	APPROVED
12-APR-70	RE-DRAWN FROM COLT'S DRAWING 02-5401, REV B	27-APR-70	
15-JUL-70	A (5) SEE EO HRD 02197-3	15-JUL-70	3/20
20-FEB-72	B (4) SEE EOR MOR 10642	20-FEB-72	1/20
6-OCT-72	C (3) SEE EOR MOR 20778	6-OCT-72	1/20
22-OCT-72	D (2) SEE EOR MOR 20778	22-OCT-72	1/20
85-11-21	E (EOR W552039) 85-11-21	85-07-08	1/20
91-02-25	F (EOR G153016) 91-02-25	91-02-05	1/20
91-10-11	G (EOR G153016) 91-10-11	91-10-11	1/20

[illegible]

ORIGINAL DESIGN ACTIVITY FROM NO. 19204-
CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOWRY, NEW JERSEY, 07080

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

CATCH BOL T

SIZE	CODE	POINT NO.	DRAWING NO.
D		19204	8448628
DATE 2/1			SHEET 1 OF 1

[illegible]

1. STEEL, ALLOY, UNSP. 8620 OR 86120,
ASTM A322.
2. FINISH 125/ EXCEPT AS-NOTED.
3. FILLET RADI: .010-MAX.
4. BREAK ALL. SHARP EDGES: .010-MAX.
5. HEAT TREATMENT: CARBURIZE
TOTAL CASE DEPTH: .010 ± .005.
6. GRIND AFTER HEAT TREATMENT: MAX.
REDUCTION IN DIAMETER BY
GRINDING .006.
7. MIL-W-13855 APPLIES.



REVIEWS		DESCRIPTION	DATE	APPROVED
1	REDRAWN FROM COLT'S DRAWINGS		27 APR 70	
2	D62221 REV A		15 JUL 70	3070
3	A (41) SEE 50 HMD 0297-3		23 APR 71	B
4	B (3) SEE HOR 10659		6 OCT 72	B
5	C (4) SEE ERH HQT 20778		16 MAY 73	B
6	D SEE ERH HOR 50648		30 OCT 73	B
7	E INOR WPS2009 80-02-13		30 OCT 73	B
8	F INOR G520B 51-07-08		31 DEC 71	1525-1
9	G (RCP G235059 32016)		32 OCT 71	31
10	H (RCP G235060 320630)			

[illegible]

CONTRACT NO. 2	DATE	27 APR 1970
PREPARED	BY	RL
CHECKED	BY	RL
REVIEWED	BY	RL
SUBMITTED	BY	RL
APPROVED	for R. G. G. G.	

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOWRY, NEW JERSEY 07001		CODE IDENT NO. 19200
CURRENT		
DEPT OF THE ARMY US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOWRY, NEW JERSEY 07001		
PIN, RECEIVER PIVOT		
SIZE	CODE IDENT NO.	QUANTITY
D	19200#	8 4 4 8 6 2 1
SCALE	5/1	SHEET 1 OF 1

DISTRIBUTION STATEMENT 2: FURTHER DISTRIBUTION
ONLY AS DIRECTED BY ASQC-AR OR HIGHER DOD
AUTHORITY: 92-46-22.

ASWE Form 403D, 29 Jul 69

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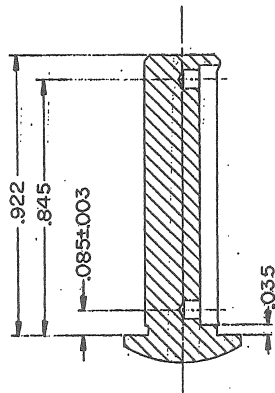
1. STEEL, ALLOY, CMPSN 8620 OR 86L20, (A)
ASTM A322.

3. BREAK ALL SHARP EDGES .010 MAX.

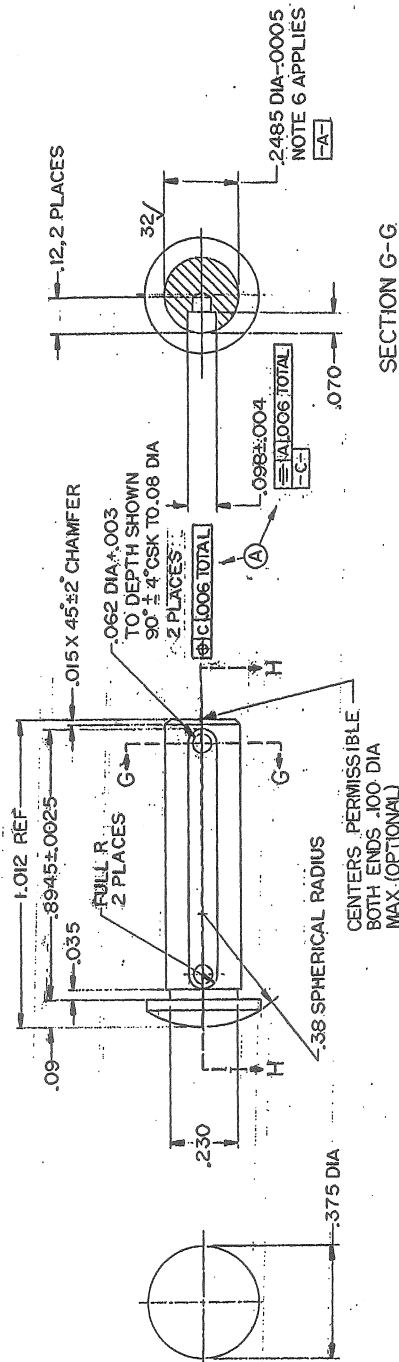
5. HEAT TREATMENT, CARBURIZE,

0.010 ± 0.005, TOTAL CASE DEPTH.
6. GRIND AFTER HEAT TREAT, MAX REDUCTION
IN DIAMETER AFTER GRINDING 0.006.

7. MIL-W-13855 APPLIES. (A)



SECTION H-H



SECTION G-G

REV	REVISED	DATE	DESCRIPTION	REVISIONS	
				DATE	APPROVED
		27 APR 70	SEDRAWN FROM COLT'S DRAWING		
		6 OCT 70	DISSESS. REV. B		
		16 OCT 70	A 13/SEE EBR NOR 20778		
		16 MAY 75	C SEE EBR NOR 50646		
		30-05-1975	D NOR W952020 90-02-13		
		901112	E NOR 6953143 900112		
		31-10-11	F NOR G152048 901001		
		22 OCT 11	F NOR G252059 920716		
			FCP G252060 920630		

[illegible]

CURRENT DESIGN ACTIVITY CASE CODE H200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT, AND ENGINEERING CENTER
BULFORD ARMOIAL RES. DEV. CTR. DTIC-9000

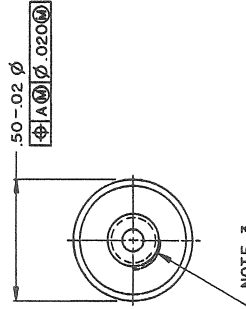
...DEPT. OF THE ARMY
-U.S. ARMY-WEAPONS COMMAND

PIN TAKEDOWN

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52 53 54 55 56 57 58 59 60 61 62 63 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 79 80 81 82 83 84 85 86 87 88 89 90 91 92 93 94 95 96 97 98 99 100 101 102 103 104 105 106 107 108 109 110 111 112 113 114 115 116 117 118 119 120 121 122 123 124 125 126 127 128 129 130 131 132 133 134 135 136 137 138 139 140 141 142 143 144 145 146 147 148 149 150 151 152 153 154 155 156 157 158 159 160 161 162 163 164 165 166 167 168 169 170 171 172 173 174 175 176 177 178 179 180 181 182 183 184 185 186 187 188 189 190 191 192 193 194 195 196 197 198 199 200 201 202 203 204 205 206 207 208 209 210 211 212 213 214 215 216 217 218 219 220 221 222 223 224 225 226 227 228 229 230 231 232 233 234 235 236 237 238 239 240 241 242 243 244 245 246 247 248 249 250 251 252 253 254 255 256 257 258 259 260 261 262 263 264 265 266 267 268 269 270 271 272 273 274 275 276 277 278 279 280 281 282 283 284 285 286 287 288 289 290 291 292 293 294 295 296 297 298 299 300 301 302 303 304 305 306 307 308 309 310 311 312 313 314 315 316 317 318 319 320 321 322 323 324 325 326 327 328 329 330 331 332 333 334 335 336 337 338 339 340 341 342 343 344 345 346 347 348 349 350 351 352 353 354 355 356 357 358 359 360 361 362 363 364 365 366 367 368 369 370 371 372 373 374 375 376 377 378 379 380 381 382 383 384 385 386 387 388 389 390 391 392 393 394 395 396 397 398 399 400 401 402 403 404 405 406 407 408 409 410 411 412 413 414 415 416 417 418 419 420 421 422 423 424 425 426 427 428 429 430 431 432 433 434 435 436 437 438 439 440 441 442 443 444 445 446 447 448 449 450 451 452 453 454 455 456 457 458 459 460 461 462 463 464 465 466 467 468 469 470 471 472 473 474 475 476 477 478 479 480 481 482 483 484 485 486 487 488 489 490 491 492 493 494 495 496 497 498 499 500 501 502 503 504 505 506 507 508 509 510 511 512 513 514 515 516 517 518 519 520 521 522 523 524 525 526 527 528 529 530 531 532 533 534 535 536 537 538 539 540 541 542 543 544 545 546 547 548 549 550 551 552 553 554 555 556 557 558 559 560 561 562 563 564 565 566 567 568 569 570 571 572 573 574 575 576 577 578 579 580 581 582 583 584 585 586 587 588 589 590 591 592 593 594 595 596 597 598 599 600 601 602 603 604 605 606 607 608 609 610 611 612 613 614 615 616 617 618 619 620 621 622 623 624 625 626 627 628 629 630 631 632 633 634 635 636 637 638 639 640 641 642 643 644 645 646 647 648 649 650 651 652 653 654 655 656 657 658 659 660 661 662 663 664 665 666 667 668 669 670 671 672 673 674 675 676 677 678 679 680 681 682 683 684 685 686 687 688 689 690 691 692 693 694 695 696 697 698 699 700 701 702 703 704 705 706 707 708 709 710 711 712 713 714 715 716 717 718 719 720 721 722 723 724 725 726 727 728 729 730 731 732 733 734 735 736 737 738 739 740 741 742 743 744 745 746 747 748 749 750 751 752 753 754 755 756 757 758 759 760 761 762 763 764 765 766 767 768 769 770 771 772 773 774 775 776 777 778 779 780 781 782 783 784 785 786 787 788 789 790 791 792 793 794 795 796 797 798 799 800 801 802 803 804 805 806 807 808 809 810 811 812 813 814 815 816 817 818 819 820 821 822 823 824 825 826 827 828 829 830 831 832 833 834 835 836 837 838 839 840 841 842 843 844 845 846 847 848 849 850 851 852 853 854 855 856 857 858 859 860 861 862 863 864 865 866 867 868 869 870 871 872 873 874 875 876 877 878 879 880 881 882 883 884 885 886 887 888 889 890 891 892 893 894 895 896 897 898 899 900 901 902 903 904 905 906 907 908 909 910 911 912 913 914 915 916 917 918 919 920 921 922 923 924 925 926 927 928 929 930 931 932 933 934 935 936 937 938 939 940 941 942 943 944 945 946 947 948 949 950 951 952 953 954 955 956 957 958 959 960 961 962 963 964 965 966 967 968 969 970 971 972 973 974 975 976 977 978 979 980 981 982 983 984 985 986 987 988 989 990 991 992 993 994 995 996 997 998 999 1000 1001 1002 1003 1004 1005 1006 1007 1008 1009 1010 1011 1012 1013 1014 1015 1016 1017 1018 1019 1020 1021 1022 1023 1024 1025 1026 1027 1028 1029 1030 1031 1032 1033 1034 1035 1036 1037 1038 1039 1040 1

NOTES:—

-
- Technical drawing of a mechanical assembly showing a screw and an element with various dimensions and callouts.
- Dimensions and Tolerances:**
- $.02 \pm .02$ 2 PLACES
 - $.04 \pm .02$ R
 - $.064 \pm .011$
 - $.07 \pm .02$
 - $.15 \pm .02$
 - $.215 \pm .006 \phi$
 - $.216 \pm .006 \phi$
 - $.219 \pm .010$
 - $.28 \pm .4^\circ$
 - $.09 \pm .02$
 - $.14 \pm .02$
 - $.48$ MIN
 - $.55 \pm .05$ FULL THD.
 - $1.23 \pm .06$
 - 250°
- Callouts and Notes:**
- (A) SCREW NOTE 2
 - (B) ELEMENT NOTE 2
 - A-
 - $\phi A \text{ (M)} .010 \text{ (M)}$

[illegible]

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(A)

1. STEEL, CMPSN 1010 TO 1020, PER ASTM A576.
2. FINISH ¹²⁵/ EXCEPT AS NOTED.
3. FINISH-5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
4. MIL-W-13855 APPLIES.

FIG. 1

Technical drawing of a shaft with a central hole. The shaft has a diameter of .156 DIA - .002. The hole has a diameter of .010 and a length of .722. The shaft has a 63 V chamfer at both ends. The drawing is labeled 'FIG. 1'.

[illegible]

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL NEW JERSEY 07806-5000

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

 $\frac{Z}{a}$

SIZE B	CODE IDENT NO. 19204	DRAWING NO. 8448655
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SCALE 1/1	SHEET	OF
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DUPLICATE ORIGINAL

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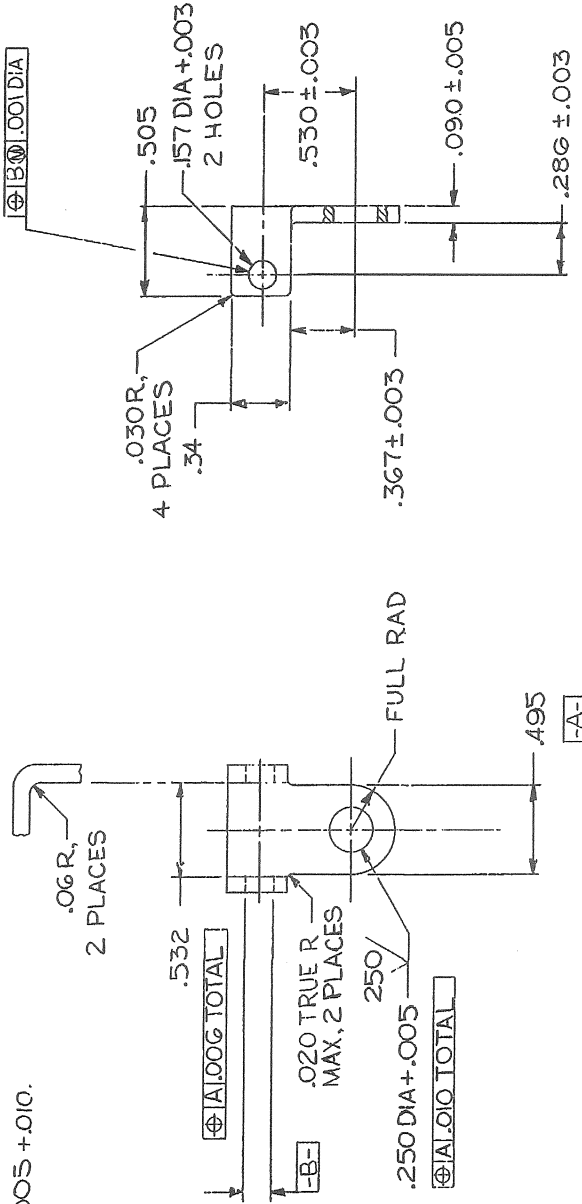
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NOTES:

1. BLANK EDGES $\frac{250}{125}$ V. EXCEPT AS NOTED.
2. FINISH $\frac{125}{125}$ V. EXCEPT AS NOTED.
3. FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
4. BREAK SHARP EDGES .005 ± .010.
5. MIL-W-13855 APPLIES.

DIRECTION OF GRAIN



REV	ZONE	UTR	DESCRIPTION	DATE	APPROVED
1	A	(2)	SEE EO HRD-02231	25 AUG 70	W. J. H. H.
2	B	(4)	SEE ERR HQR 2077B	6 OCT 72	ORC
3	C		SEE ERR HQR 30671	22 MAR 73	S. B.
4	D		105 W280229 82-07-15	83-02-03	W. J. H. H.
5	E		NOR W25 0026 82-05-21	83-09-22	W. J. H. H.
6	F		NOR W58004 / 860204	890215	0072-88-10
7	G		NOR 663149 961024	961215	JB

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

CONTRACT NO. W		DATE 5 JUN 70		PREPARED T. A. Wilson T. A. 5316		CHECKED W. J. H. H.		ENGINEER B. B. 2077B		SUBMITTED W. J. H. H.		APPROVED R. J. H. H.	
UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES ANGLES ± .005 3 PLACE DECIMALS ± .01		MATERIAL STEEL, CMPSN 1010 THEN 1020 SPEC ASTM A109		MIG, M16A2		D9349119		MIGAL		NEXT ASSY		USED ON	
MECHANICAL PROPERTIES YS MIN YS MAX EL2 RA BH RH		APPLICATION SEE NOTE 3		FINAL PROTECTIVE FINISH		HINGE		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201		SIZE CODE IDENT NO C 19204		DRAWING NO. 8448653	
SCALE 2/1		SHEET 1		OF 1									

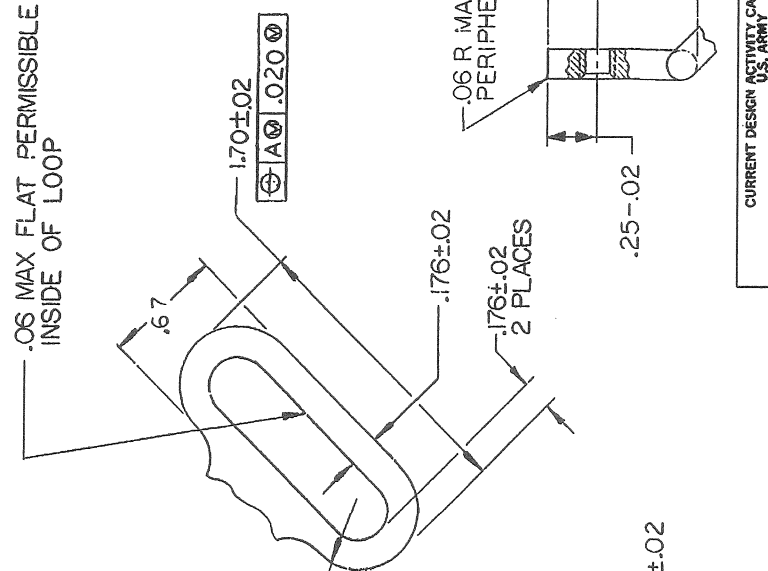
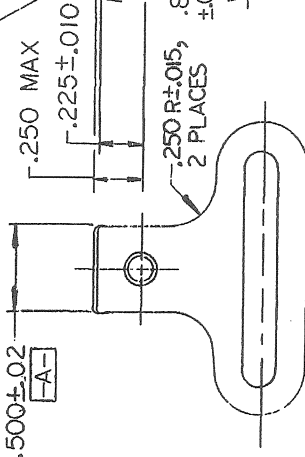
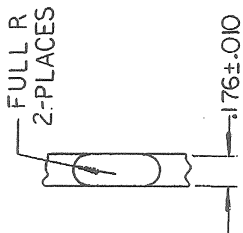
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NOTES:-

- 1-STEEL STRIP, TEMPER NO.2, ASTM A109 OR STEEL BAR, 1018 THRU 1020, ASTM A576, FORGED PER MIL-S-45172, GRADE C OR D.
- 2-FINISH 125/EXCEPT AS NOTED.
- 3-MIL-W-13855 APPLIES
- 4-EDGE RADIUS .045 ± .015 UNLESS OTHERWISE SPECIFIED.
- 5-DIE MISMATCH .015 MAX.
- 6-DRAFT ANGLE 7 ± 2°.
- 7-NO FLASH EXTENSION PERMISSIBLE.
- 8-.08 MAX PARTING LINE TRIM FLAT.
- 9-DIMENSIONS APPLY TO INTERSECTION OF STRAIGHT LINES.

.2160-28UNF-2B
A .010 TOTAL



MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL2	
RA	
BH	
RH	

12012082	M4, M4A1
D9349119	M16A1
NEXT ASSY	USED ON

UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES	
ANGLES	± 1°
3 PLACE DECIMALS	± .005
2 PLACE DECIMALS	± .01
MATERIAL	
SEE NOTE 1	
FINAL PROTECTIVE FINISH	
5.3.1.2 OR 5.3.2.2	
OF MIL-STD-171	

CONTRACT NO	
DATE	5 JUN 70
PREPARED BY	B. Boudry
CHECKED BY	R. H. H. H.
ENGINEER	R. H. H. H.
SUBMITTED	R. H. H. H.
APPROVED	R. H. H. H.

DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
SWIVEL	
SIZE CODE IDENT NO	C 19204
DRAWING NO	8448652
SCALE	2/1
SHEET	1 OF 1

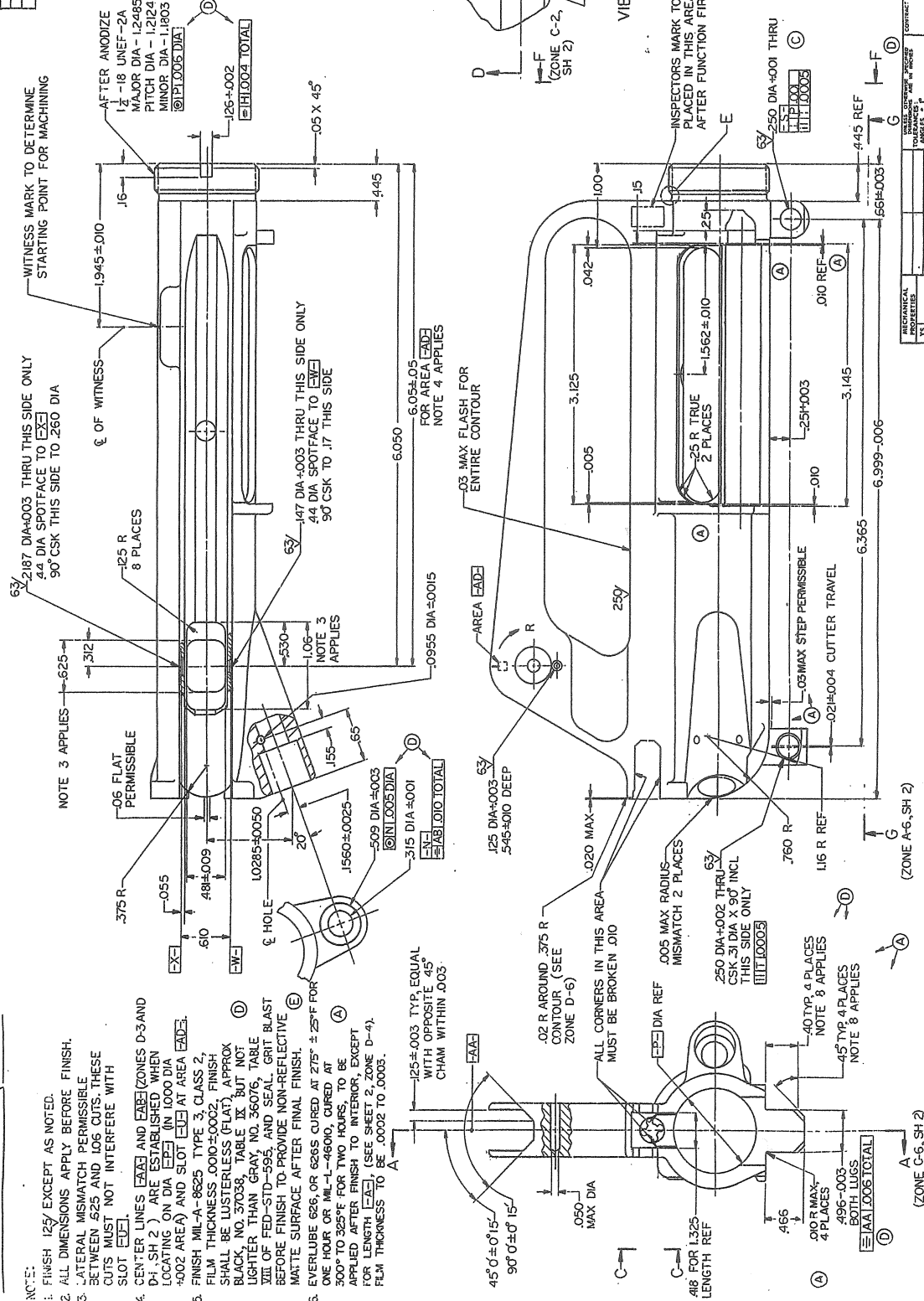
CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL NEW JERSEY 07806-5000

[illegible]

7. BREAK SHARP EDGES .005 $\pm$.010
UNLESS OTHERWISE SPECIFIED.

NOTICE: RESTRICTED AS TO USE AND DISCLOSURE

1. FINISH 125' EXCEPT AS NOTED.
2. ALL DIMENSIONS APPLY BEFORE FINISH.
3. LATERAL MISMATCH PERMISSIBLE BETWEEN 525 AND 106 CUTS. THESE CUTS MUST NOT INTERFERE WITH SLOT CUT.
4. CENTER LINES 15A3 AND 15A5 ZONES D-3 AND D1 SH 2) ARE ESTABLISHED WHEN LOCATING ON DIA 15B3 IN 1000 DIA +002 AREA AND SLOT 15C3 AT AREA 15A3.
5. FINISH MIL-A-8625 TYPE 2, CLASS 2, FILM THICKNESS .0000-0.0002. FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO. 370388, TABLE XI BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE XII OF FED-STD-595, AND SEAL GRIT BLAST BEFORE FINISH TO PROVIDE NON-REFLECTIVE MATE SURFACE AFTER FINAL FINISH.
6. EVERLUBE 626, OR 626S CURED AT 275° ± 25°F FOR ONE HOUR OR MIL-A-4600, CURED AT 300° TO 325°F FOR TWO HOURS, TO BE APPLIED AFTER FINISH TO INTERIOR. EXCEPT FOR LENGTH 15A3 (SEE SHEET 2, ZONE D-4). FILM THICKNESS TO BE .0002 TO .0003.



REV STATUS OF SH1'S		
SH 1	SH 2	
F	F	

ARCHIVAL PROPERTIES	VALUE SHOWN IN INCREASE	CONTRACT NO.
1	TOLERANCE	
2	3 PLACE DECIMALS ± .005	
3	2 PLACE DECIMALS ± .01	
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CURRENT DESIGN ACTIVITY, FSCM, NO. 19200

US ARMY BALLISTIC RESEARCH AND DEVELOPMENT CENTER BORDO, NEW JERSEY 07001	DEPT OF THE ARMY US ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS 61201
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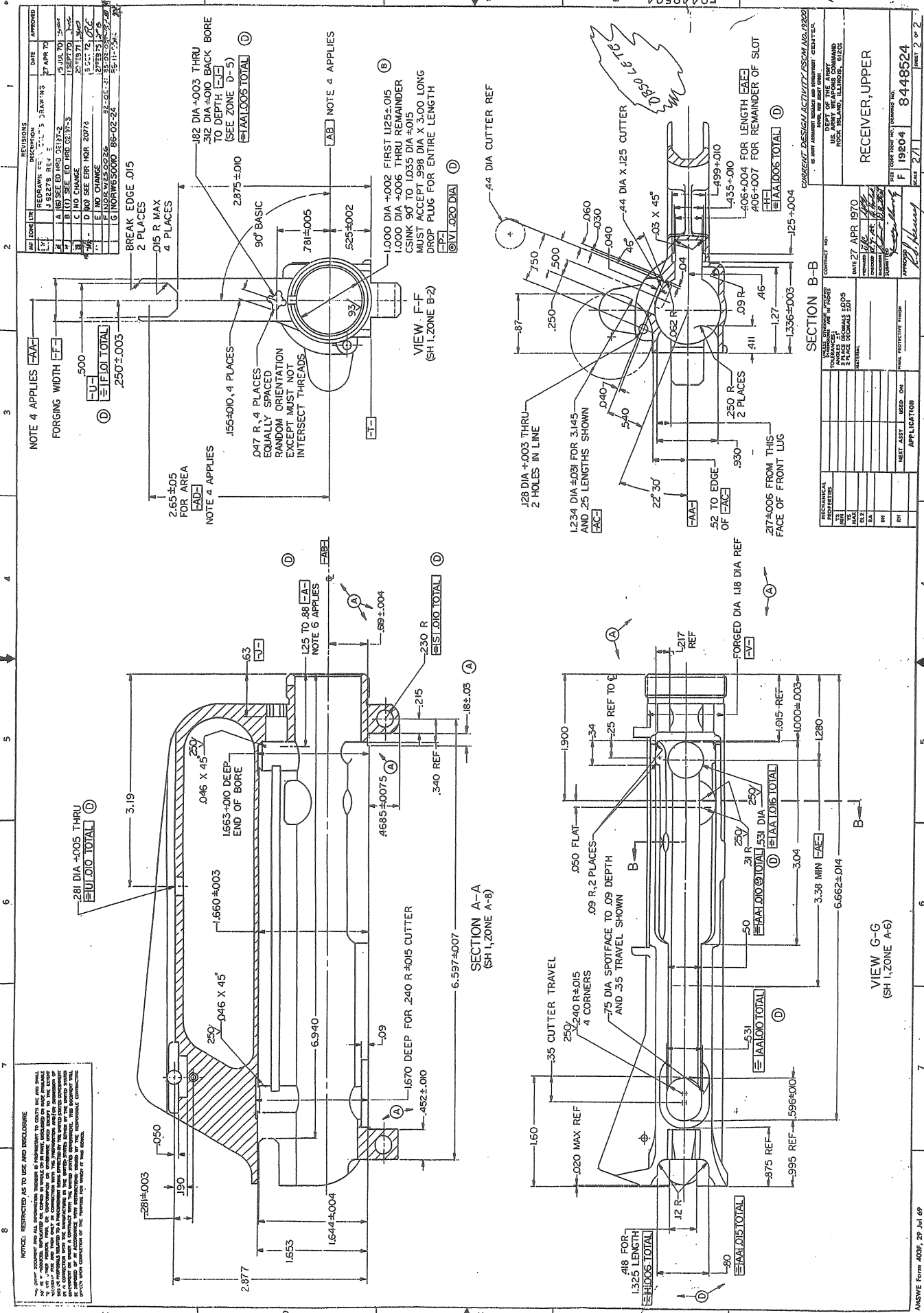
RECEIVED, UPPER

SIZE F	CODE IDENT. NO. 19204	QUANTITY NO. 8448524
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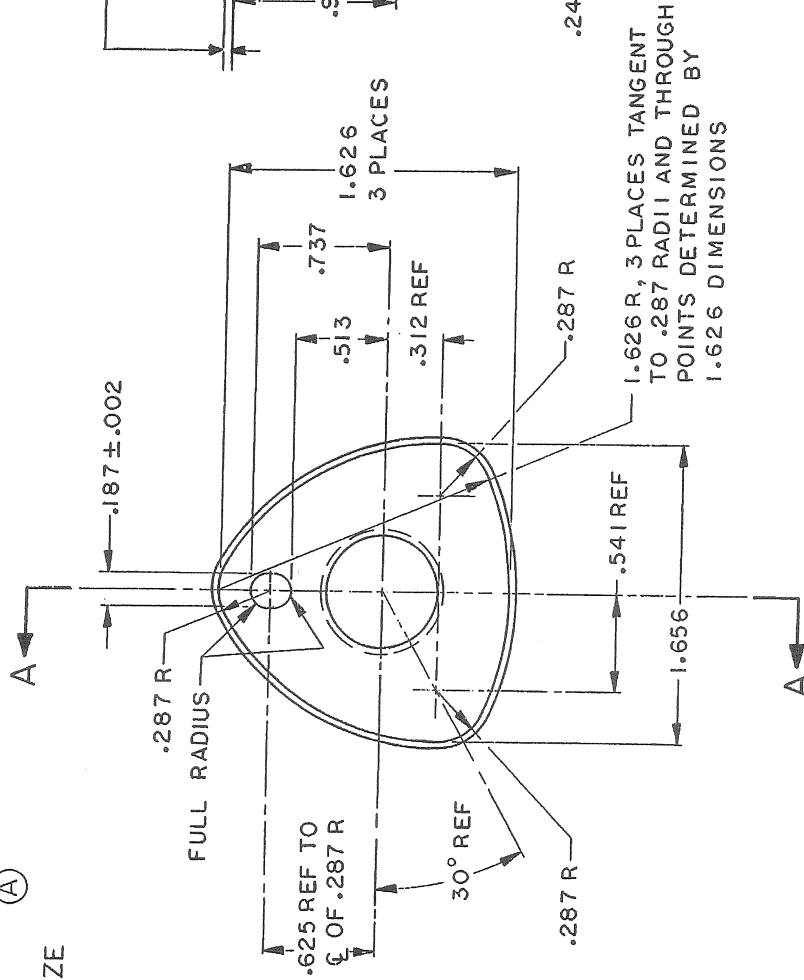
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NOTE :

1. STEEL, CMPSN 1045 THRU 1070, COLD ROLLED, SPHEROIDIZE ANNEALED, SPEC QQ-S-700.
2. FINISH $125/\sqrt{}$.
3. BREAK SHARP EDGES .010 R MAX.
4. FINISH 5.3.1.2 OF MIL-STD-171.
5. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
6. MIL-W-13855 APPLIES.

(A)



SECTION A-A

CURRENT DESIGN ACTIVITY

FSCN NO. 19200

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER

DOVER, NEW JERSEY 07801

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

CAP, HANDGUARD

SIZE CODE IDENT NO. DRAWING NO.
C 19204 8448564SHEET 2/1 OF 1
CDI

CONTRACT NO.:

DATE 27 APR 1970

PREPARED *Chap* *29.14*CHECKED *W. J. H. H.*ENGINEER *W. J. H. H.*SUBMITTED *W. J. H. H.*APPROVED *R. J. Henry*UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES:

ANGLES $\pm$ 3 PLACE DECIMALS $\pm$.0052 PLACE DECIMALS $\pm$.01

MATERIAL

SEE NOTE 1

FINAL PROTECTIVE FINISH

SEE NOTE 4

MECHANICAL PROPERTIES

YS

MIN

YS

MAX

EL 2

RA

BH

RH 15N 79.5-815

APPLICATION

NEXT ASSY

USED ON

M16

M16A1

M16A1

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NOTES:

1. WIRE, STAINLESS STEEL, TYPE 316 (17-7PH), COLD DRAWN; ASTM A313.

2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITN CH900. HOLD AT 900°F ± 10° FOR ONE HOUR. AIR COOL.

3. MIL-W-13855 APPLIES.

4. BREAK SHARP EDGES .003 ± .012.

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER .0180 ± .0005
COIL DIAMETER (OD) .115 ± .003
FREE LENGTH .75 REF
TOTAL COILS 20 REF
DIRECTION OF HELIX OPTIONAL
LOAD AT COMPRESSED LENGTH OF .557 AFTER SET 1.78 LB ± .18 LB
LOAD AT COMPRESSED LENGTH OF _____
SPRING RATE _____
SOLID LENGTH 390 MAX
TYPE OF ENDS CLOSED
MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

CURRENT DESIGN ACTIVITY
FSCM NO. 19208

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448574

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY	
YS MIN		ANGLES ±		DATE 27 APR 70	PREP P. Venero	U.S. ARMY WEAPONS COMMAND	
YS MAX		3 PLACE DECIMALS ± .005		CHK R. D. Brown	ENGR R. E. Brown	ROCK ISLAND, ILLINOIS, 61201	
EL2		2 PLACE DECIMALS ±		SUBMITTED	APPROVED	SPRING, FRONT	
RA		SEE NOTE 1				SIGHT, DETENT	
BH		FINAL PROTECTIVE FINISH				SIZE CODE IDENT NO. DRAWING NO.	
RH 15N 845 MIN		5.41 OF MIL-STD-171				B 19204 8448574	
NEXT ASSY USED ON		APPLICATION		SCALE		SHEET 1 OF 1	

PARTS LIST		PL-8448501		ROCK ISLAND ARSENAL		REV. DATE 16 APR 76	
DOCUMENT/PART NUMBER D 8448501				ROCK ISLAND IL		REVISION LETTER A	
BOLT CARRIER ASSEMBLY				CODE ID 19204		SHEET 1	
CHANGE CONTROL NUMBER 76V0018				AUTHENTICATION-		ORIG. DATE 27 APR 70	

FND QTY	UNIT CODE	PART OR IDENTIFYING NO	DRAWING/DOCUMENT SIZE	NUMBER	NOMENCLATURE OR DOCUMENT TITLE	SUP
NO.	REQ	MEAS	ID			LST
1		8448502	C	8448502	PIN, CAM	
1		8448503	D	8448503	PIN, FIRING	
1		8448504	B	8448504	PIN, RETAINING, FIRING PIN	
1		8448505	C	8448505	KEY AND BOLT CARRIER ASSEMBLY	X
1		8448509	C	8448509	BOLT ASSEMBLY	X
TOTAL NUMBER OF SHEETS					1	

AR - AS REQUIRED, ALT - ALTERNATE, OPT - OPTIONAL, SD - SELECTION OPTIONAL

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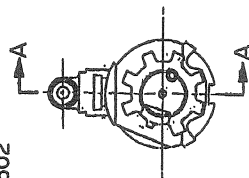
NOTES:-

- 1- BOLT ASSEMBLY- 12972691 MUST CAM FREELY IN KEY AND BOLT CARRIER ASSEMBLY- 8448505.
- 2- FIRING PIN- 8448503 MUST MOVE FREELY IN BOLT ASSEMBLY- 12972691.
- 3- FIRING PIN RETAINING PIN- 8448504 MUST BE SECURE AND MUST HOLD FIRING PIN SECURELY.
- 4- MIL-W-13855 APPLIES.

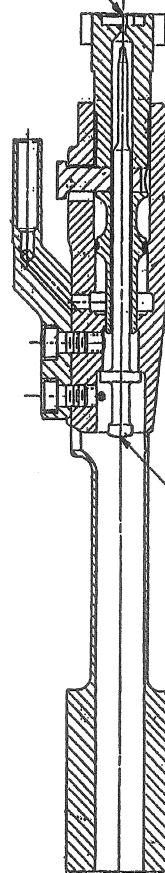
REVISIONS		DATE	APPROVED
REV	DESCRIPTION		
1	PRODUCT BASELINE	95/02/01	HJS
2	ERR 0550081		
3	NOR L753059 971016		
4	(ECP L853000 980126)	980213	JB
5	(ECP L853007 980225)		

KEY AND BOLT CARRIER ASSEMBLY-8448505

CAM PIN- 8448502



FIRING PIN RETAINING PIN- 8448504
INSERT FROM OPPOSITE SIDE
SEE NOTE 3

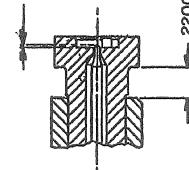


BOLT ASSEMBLY- 12972691
SEE NOTE 1

FIRING PIN- 8448503
SEE NOTE 2

.028 TO .036 FIRING PIN PROTRUSION
WITH BOLT IN LOCKED POSITION AT
.2200 GAGE DIMENSION

SECTION A-A



SEE PL- 8448501

PART NO. 12011849

DESIGN ACTIVITY		U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER		
MANUFACTURING BRANCH, TEST FACILITY 0700-0000		
CONTRACT NUMBER		
CONTRACTOR		
DRAWN BY		HJS
CHECKER		95/02/01
DRAWING APPROVAL		
DESIGN APPROVAL		
SCALE		2/1
UNIT WT.		
SHEET		
BOLT CARRIER ASSEMBLY		
SIZE		D 19200
CAGE CODE		12011849

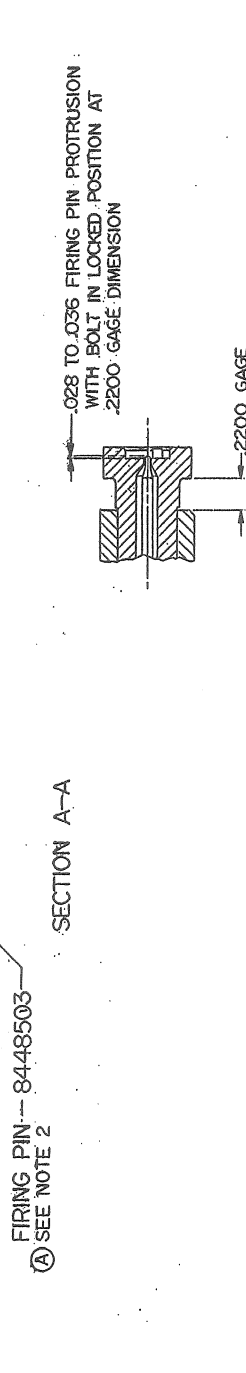
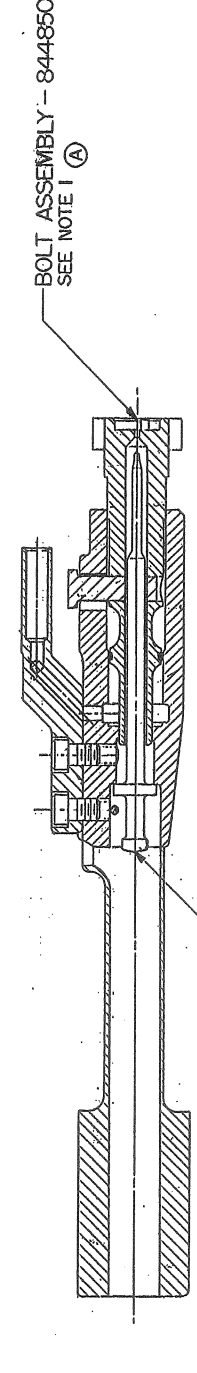
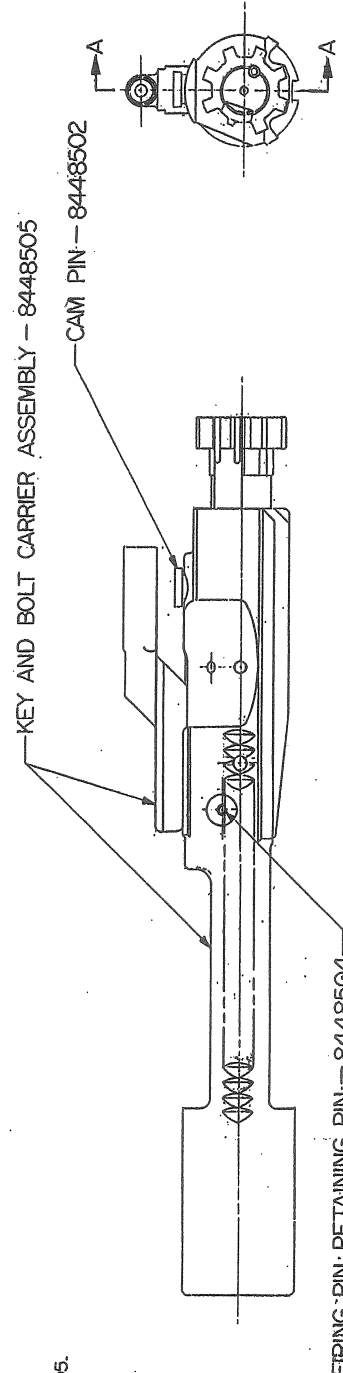
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8 7 6 5 4 3 2 1

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- NOTE
1. BOLT ASSEMBLY-8448509 MUST CAM FREELY IN KEY AND BOLT CARRIER ASSEMBLY-8448505.
 2. FIRING PIN-8448503 MUST MOVE FREELY IN BOLT ASSEMBLY-8448509.
 3. FIRING PIN RETAINING PIN-8448504 MUST BE SECURE AND MUST HOLD FIRING PIN SECURELY.
 4. MIL-W-13855 APPLIES. (A)



SEE PL 8448501

REVISIONS

REV	ZONE	DATE	DESCRIPTION	APPROVED
1		27 APR 70	REDRAWN FROM COLT'S DRAWING 052287 REV B	
2		05 OCT 72	A (4) SEE ERR NOR 20778	
3		05 OCT 72	B (1) NOR 6152018	
4		05 OCT 72	C (1) NOR 6152018	

DATE 27 APR 1970

PREPARED BY: [Signature]

CHECKED BY: [Signature]

APPROVED BY: [Signature]

CONTRACT NO. 8448501

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER

DEPT. OF THE ARMY

ROCK ISLAND, ILLINOIS 61201

BOLT CARRIER ASSEMBLY

8448501

19204

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REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
		B	REPLACES REV A W/CHANGE SEE ERR HQR 20778	6 OCT 72	XB
		C	NOR W250011 / 82-04-13 (ECP W250034 / 82-07-15)	83-11-04	HB
		D	ERR Z921182AN (ECP G8S311188109)	890828	HB

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER _____ 0.0220 ± 0.0005

COIL DIAMETER (QD) _____ 1.18 ± 0.003

FREE LENGTH _____ 500 REF

TOTAL COILS _____ 13 REF

DIRECTION OF HELIX _____ OPTIONAL

LOAD AT COMPRESSED LENGTH OF .370 _____ 4.29 LB ± .43 LB

LOAD AT COMPRESSED LENGTH OF _____

SPRING RATE _____

SOLID LENGTH _____ 3.15 MAX

TYPE OF ENDS _____ CLOSED

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

1. WIRE, CORROSION RESISTING, TYPE 631, (17-7 PH), ASTM A313.

2. PRECIPITATION HEAT TREAT AFTER FORMING TO COND TN CH900. HOLD AT 900°F ± 10° FOR ONE HOUR. AIR COOL.

3. MIL-W-13855 APPLIES.

MECHANICAL PROPERTIES

YS	MIN	
YS	MAX	
EL2		
RA		
BH		
RH	15N 84.5 MIN	

APPLICATION

USED ON

NEXT ASSY

15N 84.5 MIN

84448602

M16

84448523

M16A1

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES

TOLERANCES:

ANGLES ±

3 PLACE DECIMALS ± .005

2 PLACE DECIMALS ± .01

MATERIAL

SEE NOTE 1

FINAL PROTECTIVE FINISH

54.1 OF MIL-STD-171

CONTRACT NO.

DATE 27 APR 70

PREP

CHK

ENGR

SUBMITTED

APPROVED

DEPT OF THE ARMY

U.S. ARMY WEAPONS COMMAND

ROCK ISLAND, ILLINOIS, 61201

SPRING, REAR SIGHT DETENT

SIZE

CODE IDENT NO.

DRAWING NO.

B 19204

8448538

SCALE

SHEET 1 OF 1

PART NO. 8448538

DUPLICATE ORIGINAL

AMSWWE Form 403B, 29 Jul 69

October 15, 2004 10:56 AM

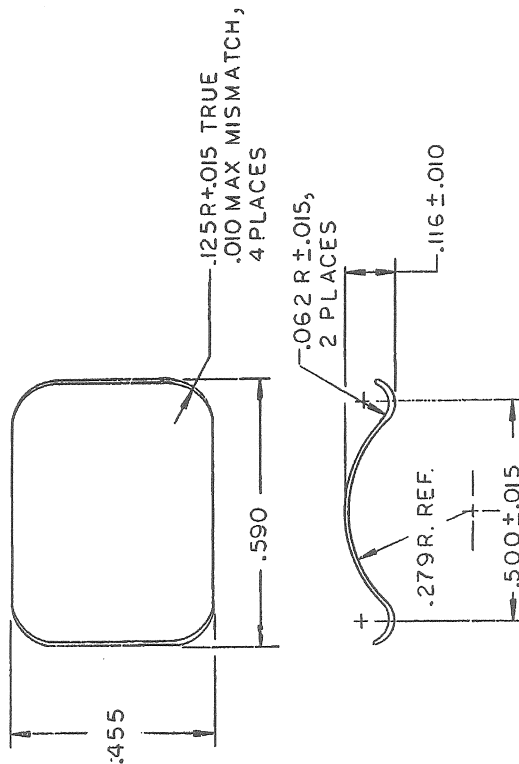
CURRENT DESIGN ACTIVITY, CAGE CODE 19200
U.S. ARMY AND ENGINEERING CENTER
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL NEW JERSEY 07806-5000

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NOTES:

1. STEEL, CARBON, UNTEMPERED SPRING QUALITY, ANEAL, CMPSN 1095, SPEC ASTM A684 OR AMS 5121, .010 ± .001 THICK.
2. FINISH 63/EXCEPT SHEARED EDGES 25Q/.
3. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
4. MIL-W-13855 APPLIES.
5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2. OF MIL-STD-171.
6. HARDNESS: DPH484-528.



PART NO. 12011987

PMIC		CONTRACT NUMBER		DESIGN ACTIVITY	
MECHANICAL PROPERTIES		CONTRACTOR		U.S. ARMY	
YP		DRAWN BY		ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER	
TS		R.C.R.		PIEDMONT ARSENAL, NEW JERSEY 07006-1000	
EL2		CHECKER			
RA		DRAWING APPROVAL		SIZE CASE CODE	
BH		DESIGN APPROVAL		C 19200	
RH		MATERIAL ENGR		SCALE NONE	
				12011987	
				SHEET	
				SPRING REAR SIGHT	

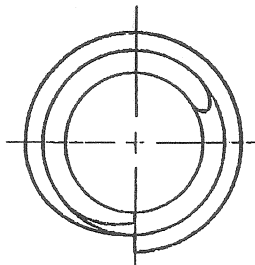
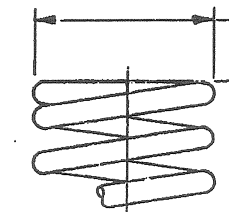
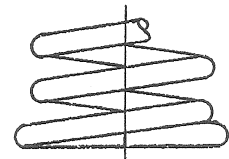
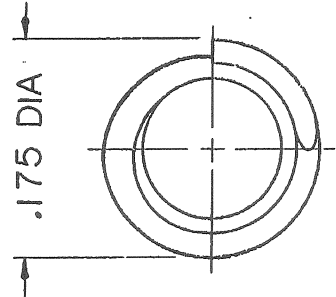
SMCAR FORM 67, 1 DEC 87(TEMP), REPLACES SMCAR FORM 67, 1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED

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NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH) COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITN CH900. HOLD AT 900°F ± 10° FOR 1 HOUR. AIR COOL.
3. MIL-W-13855 APPLIES.



MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
YS	MIN	DATE	27 APR 1970
YS	MAX	PREP	P.A.R. A.G.H.
EL 2		CHK	A.A.W. B.L. Saylor
RA		ENGR	P. S. Henny
BH		SUBMITTED	F. P. Saylor
RH	15N-84.5 MIN	APPROVED	P. S. Henny
		NEXT ASSY USED ON	
		APPLICATION	

MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

TYPE OF ENDS - ONE CLOSED AND GROUND		WIRE DIA .0200 ± .0005	
- ONE CLOSED, FLARED AND GROUND		DIRECTION OF HELIX - OPTIONAL	
TOTAL COILS - 7 REF		LOAD AT COMPRESSED LENGTH OF .217 IN. = 2.79 LB ± .28 LB	
MAX. SOLID LENGTH -.150		MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572	

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

CONTRACT NO.		DATE	
27 APR 1970		PREP	
P.A.R. A.G.H.		CHK	
A.A.W. B.L. Saylor		ENGR	
P. S. Henny		SUBMITTED	
F. P. Saylor		APPROVED	
P. S. Henny		FINAL PROTECTIVE FINISH	
5.4.1 OF MIL-STD-171		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
		TOLERANCES:	
		ANGLES	
		3 PLACE DECIMALS ± .005	
		2 PLACE DECIMALS ± .005	
		MATERIAL	
		SEE NOTE 1	
		M16	
		B8448591 M16AI	
		NEXT ASSY USED ON	
		APPLICATION	

DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201		DRAWING NO.	
B8448594		SIZE	
B		CODE IDENT NO.	
19204		SCALE	
10/1		SHEET	
1		OF 1	

SPRING, DISCONNECT

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NOTES:

1. WIRE, STEEL, CARBON, SPRING, MUSIC, SPEC ASTM-A228. TENSILE STRENGTH SHALL BE 376,000 MIN.
2. STRESS RELIEVE AFTER FORMING. HOLD AT 475°F ± 25° FOR 30 MINUTES.
3. SET SPRING 3 TIMES AFTER STRESS RELIEF.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003 ± .012.

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER ----- 0240 ± .0003
 COIL DIAMETER (O.D) ----- 1.03 ± .003
 FREE LENGTH AFTER SETTING ----- 926 REF
 TOTAL COILS ----- 27 REF
 DIRECTION OF HELIX ----- OPTIONAL
 LOAD AT COMPRESSED LENGTH OF .850 ----- 2.94 LB ± .30LB
 LOAD AT COMPRESSED LENGTH OF .784 ----- 5.50 LB ± .25LB
 SPRING RATE -----
 SOLID LENGTH ----- 650 MAX
 TYPE OF ENDS ----- SQUARED, GROUND
 MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572

REVISIONS			
MF	ZONE	LTR	DESCRIPTION
		C	REPLACES REV B W/CHANGE SEE ERR HQR 20778
		D	NOR W9S2009 80-02-13
		E	NOR W2S 0011 / 82-04-13 (ECP W3S 3120 / 83-07-07)
		F	ERR Z9Z1251W (ECP G9S2036/890721)
		G	NOR GIS2018 91-07-08
			DATE
			6 OCT 72
			30-05-16
			83-11-04
			900403
			91-10-11

MECHANICAL PROPERTIES		8448509		M4	
YS MIN		F9327230	M 231	M16	
YS MAX		C8448509	M16A1	M16	
EL 2		F8448604	M16	M16A1	
RA		F8448578	M16A1	USED ON	
BH		NEXT ASSY			
RH		APPLICATION			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DATE	
TOLERANCES:		DATE 27 APR 70		PREP	
3 PLACE DECIMALS ± .005		PV		L.P.	
2 PLACE DECIMALS ± .01		CHK		D.K.	
MATERIAL		ENGR		L.B.	
SEE NOTE 1		SUBMITTED		A.A. COLE	
FINAL PROTECTIVE FINISH		APPROVED		R.S. HENRY	
SCALE NONE		SIZE		CODE IDENT NO.	
SCALE NONE		B		19204	
DRAWING NO.		8448516		SHEET 1 OF 1	

PART NO. 8448516

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

CURRENT

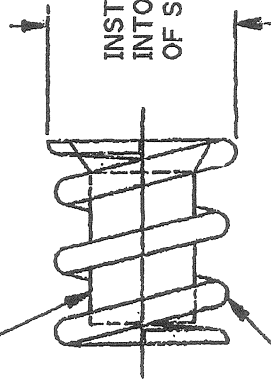
FSCM NO.
19200

NOTES:-

1- MIL-W-13855 APPLIES.

REVISIONS	
ZONE	DESCRIPTION
1	PRODUCT BASELINE ERR 65S3081
DATE (YR MO DA)	APPROVED
951211	HJS

BUFFER, EXTRACTOR- 12972693



SPRING, EXTRACTOR- 8448753

DISTRIBUTION STATEMENT A.
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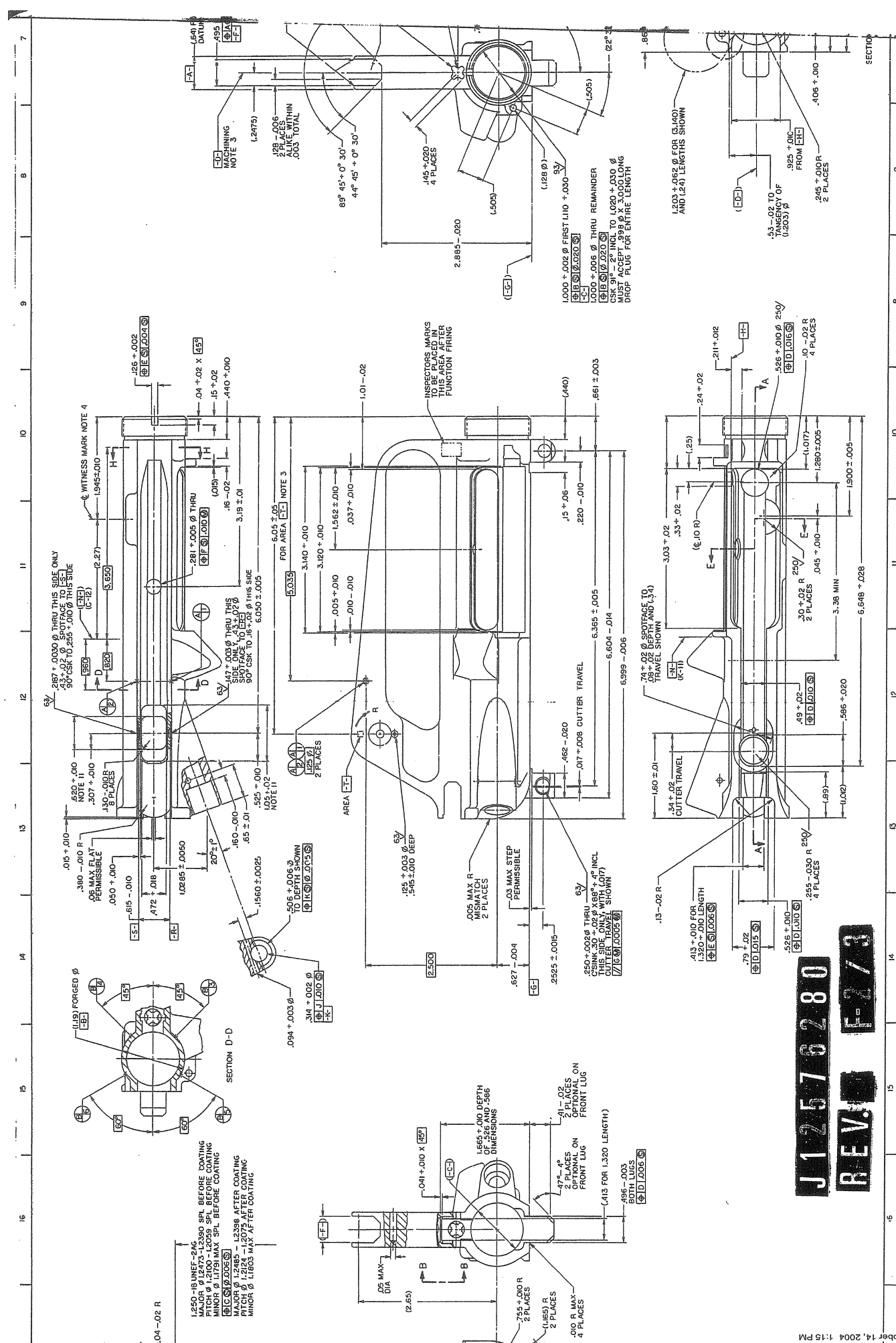
PART NO. 12972692

PMIC		CONTRACT NUMBER		DESIGN ACTIVITY U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER PICATINNY ARSENAL, NEW JERSEY 07806-5000	
MECHANICAL PROPERTIES		CONTRACTOR		SPRING ASSY, EXTRACTOR	
YD		DRAWN BY	HJS	DATE (YR-MO-DA)	951211
TS		CHECKER		ENGINEER	
EL2		DRAWINGS APPROVAL	-		
RA		DESIGN APPROVAL	-		
BH					
RH					
12972691		M4/M4A1		SIZE	
NEXT ASSY		USED ON		3 1920C	
APPLICATION				CAGE CODE	
				10/1	
				UNIT WT.	
				12972692	
				SCALE	

SMCAR FORM 66, 1 MAR 88(TEMP) REPLACES SMCAR FORM 66, 1 JUL 87(TEMP)
WHICH MAY BE USED UNTIL EXHAUSTED

- 1- SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.
- 2- MATERIAL- MAKE FROM FORGING, UPPER RECEIVER- 12576273.
- 3- CENTER LINE ON [C] (H-7) AND [E] (E-7) ARE ESTABLISHED WHEN LOCATING ON Ø [C], AND SLOT [E] AT AREA [C] (6-12).
- 4- WITNESS MARK (K-11) TO DETERMINE STARTING POINT FOR MACHINING.
- 5- ALL DIMENSIONS APPLY BEFORE PROTECTIVE FINISH UNLESS OTHERWISE NOTED.
- 6- FINISH SPEC. 005+.010 UNLESS OTHERWISE NOTED.
- 7- FILLER, RADIUS DR.
- 8- FLUETTER 626 OR 626S CURED AT 275° F. 25% F. FOR 1 HOUR. OR MIL-L 46010 CURED 300° F. TO 325° F. FOR 2 HOURS. TO BE APPLIED AFTER PROTECTIVE FINISH TO INTERIOR EXCEPT FOR .375 TO 1.25 LENGTH (8-19). FILM THICKNESS .0008+.0001.
- 9- FINISH 125/ ALL MACHINED SURFACES, EXCEPT AS NOTED.
- 10- PROTECTIVE FINISH- MIL-A-8625 TYPE III CLASS 2, FILM THICKNESS .0010 ± .0002, FINISH SHALL BE LUSTERLESS (FLAT), APPEAR BLACK, NON-GLOSS, BUT NOT LIGHTER THAN GRAY, NO 36076, OF FED-STD-593, 1963 EDITION. FINISH TO FINISH TO PROVIDE NON REFLECTIVE MATE SURFACE AFTER FINISH.
- 11- LATERAL MISMATCH PERMISSIBLE BETWEEN .625 AND .106 OUNTS. THESE OUNTS MUST NOT INTERFERE WITH SLOT [C].

J11257 69280
REV. 5
F-1173



J12576280
REV. F-273

[illegible]

NOTES:-

- 1- SPEC MIL-W-13565 AND ANSI Y14.5-73 APPLY.
- 2- MATERIAL- NAME FROM FORGING, UPPER RECEIVER-1257627S.
- 3- CENTER LINE [E-7] AND [E-7] [E-7] ARE ESTABLISHED WHEN COATING ON θ [E-7] AND SLOT [E-7] AT AREA [E-7] (G-12).
- 4- WITNESS MARK-110 TO DETERMINE STARTING POINT FOR MACHINING.
- 5- DIMENSIONS X-14 TO PROVIDE PROTECTIVE FINISH UNLESS OTHERWISE SPECIFIED.
- 6- BREAK SHARP EDGES .005+/- UNLESS OTHERWISE NOTED.
- 7- FILLET RADIUS .012 UNLESS OTHERWISE SPECIFIED.
- 8- EVERLUBE 608 OR 626S COATED AT 275°F $\pm$ 25°F FOR 1 HOUR OR MIL-L-46500 COATED 300°F TO 325°F FOR 2 HOURS; TO BE APPLIED AFTER PROTECTIVE FINISH TO INTERIOR EXCEPT FOR .875 TO 1.25 LENGTH (G-19) FILM THICKNESS .0002 $\pm$.0001.
- 9- PROTECTIVE FINISH 125/ ALL MACHINED SURFACES EXCEPT AS NOTED.
- 10- PROTECTIVE FINISH- MIL-A-8625, TYPE III CLASS 2, FILM THICKNESS .0002 $\pm$.0002, FINISH SHALL BE LUSTERLESS (FLAT), APPROX BLACK, NO .37038, BUT NOT LIGHTER THAN GRAY NO. 36076, OF FED-STD-595, AND SEAL GRIT BLAST PRIOR TO FINISH TO PROVIDE NON REFLECTIVE MATTE SURFACE FINISH.
- 11- LATERAL MISMATCH PERMISSIBLE BETWEEN .625 AND .106 CUTS. THESE CUTS MUST NOT INTERFERE WITH SLOT [E-7].

IF THESE CUTS MUST NOT INTERFERE WITH SLOT [F]-

J12579280
REV.
F-173

[illegible]

[illegible]

1. FINISH ¹²⁵✓ EXCEPT AS NOTED.

2. ALL DIMENSIONS APPLY BEFORE FINISH.
3. BEFORE FINISH, GRIT BLAST EXTERIOR OVER LENGTH 12 MIN TO PRODUCE NON-REFLECTIVE MATTE FINISH AFTER FINISH.
4. FINISH MIL-A-8825 TYPE III, CLASS 2, FILM THICKNESS .0010 ±.0002. FINISH SHALL BE LUSTERLESS (FLAT). APPROX BLACK, NO. 370398, TABLE IX BUT NOT LIGHTER THAN GRAY NO. 36076, TABLE XVIII OF FED-STD-595, AND SEAL.
5. BREAK SHARP EDGES .005±.010 UNLESS OTHERWISE SPECIFIED.
6. MIL-W-13895 APPLIES.

[illegible]

02/24/93

ARMAMENT RESEARCH, DEVELOPMENT & ENGINEERING CENTER

COVER SHEET

PICATINNY ARSENAL, NEW JERSEY 07806-5000

CAGE 19200

TECHNICAL DATA PACKAGE LIST : 19204 8448519
DOCUMENT NUMBER : D 19204 8448519
SPECIFICATION : MIL-W-63150
NATIONAL STOCK NO :
LATCH, CHARGING HANDLE

REQUEST/PRON ID : GALA73

TDPL COVER SHEET

RELEASED BY:

B.F. John A. Kania

1. MANUFACTURE AND ACCEPTANCE INSPECTION OF THE ABOVE MATERIAL SHALL BE IN ACCORDANCE WITH ALL DRAWINGS, SPECIFICATIONS AND OTHER TECHNICAL DATA LISTED IN THIS TDPL.
2. THIS TDPL IS COMPRISED OF THE FOLLOWING SECTIONS WHICH LIST THE DRAWINGS AND ASSOCIATED DOCUMENTS (WITH THEIR REVISION AND AMENDMENT LEVELS) REQUIRED TO PRODUCE, PACKAGE AND INSPECT THE MATERIAL BEING PRODUCED. (NA INDICATES NOT APPLICABLE)

	FROM	TO
A. PRODUCT DRAWING AND ASSOCIATED LISTS	0001	0001
B. PACKAGING DRAWINGS AND DOCUMENTS	0002	0002
C. INSPECTION DRAWINGS AND DOCUMENTS	0003	0003
D. SPECIFICATIONS AND STANDARDS	0004	0004
E. OUTSTANDING APPROVED ENGINEERING CHANGES	NA	NA
F. TDPL NOTE LEGEND	0005	0005
3. DRAWINGS/DOCUMENTS AND ASSOCIATED LISTS LISTED IN THE ABOVE TDPL SECTIONS ARE IDENTIFIED AS TO TYPE BY PREFIX CODES AS FOLLOWS:
 - PD PACKAGING DATA SHEET
 - QS SUPPLEMENTAL QUALITY ASSURANCE PROVISION
4. THE SPECIFICATIONS AND STANDARDS SECTION OF THE TDPL IS A COMPIATION OF ALL SPECIFICATIONS AND STANDARDS WHICH ARE ESSENTIAL FOR BIDDING AND MANUFACTURING PURPOSES. THE ABSENCE OF ANY SPECIFICATION OR STANDARD FROM THE LISTING WHICH IS OTHERWISE REFERRED TO IN ANY SPECIFICATION OR STANDARD LISTED THEREIN OR IS CALLED OUT ON A PRODUCT, PACKAGING OR INSPECTION DRAWING IS NOT TO BE CONSTRUED AS CONSTITUTING RELIEF FROM REQUIREMENTS OF THE SPECIFICATIONS. THE AMENDMENT OR REVISION LEVEL FOR SUCH UNLISTED SPECIFICATIONS AND STANDARDS SHALL BE AS SPECIFIED IN THE LATEST ISSUE OF DOD INDEX OF SPECIFICATIONS AND STANDARDS IN EFFECT AS OF THE DATE OF THIS TDPL. SUPERSEDED SPECIFICATIONS AND STANDARDS WHICH MAY BE REFERENCED ON DRAWINGS ARE LISTED TOGETHER WITH THE APPROPRIATE SUPERSEDING SPECIFICATION OR STANDARD. WHEN INTERIM CHANGES TO SPECIFICATIONS AND STANDARDS ARE ISSUED (AMENDMENTS, NOTICES OR CHANGE NOTICES), ONLY THE LATEST ISSUE IS LISTED IN THE TDPL. WHERE THESE INTERIM CHANGES ARE NOT CUMULATIVE, ALL PREVIOUS ISSUES ALSO APPLY, UNLESS THE DOCUMENT ITSELF STATES OTHERWISE.
5. ALL REFERENCES ON DRAWINGS/DOCUMENTS AND ASSOCIATED LISTS TO PICATINNY, FRANKFORD OR ROCK ISLAND ARSENALS WILL BE CONSIDERED AS CHANGED TO COMMANDER, ARDEC, ATTN: SMCAR-BAC, PICATINNY ARSENAL, NJ 07806-5000
6. ALL REFERENCES TO PARTS LISTS ON US ARMY TANK AUTOMOTIVE COMMAND (TACOM) DRAWINGS SHALL BE DISREGARDED.

Distribution Statement F.
Further distribution only as directed by ARDEC.
Form 1280-101, 1-78
1280RS3

02/24/93

ARMAMENT RESEARCH, DEVELOPMENT & ENGINEERING CENTER

SHEET NO

1 of 5

PICATINNY ARSENAL, NEW JERSEY 07806-5000

CAGE 19200

TECHNICAL DATA PACKAGE LIST : 19204 8448519
DOCUMENT NUMBER : D 19204 8448519
SPECIFICATION : MIL-W-63150
NATIONAL STOCK NO :
LATCH, CHARGING HANDLE

REQUEST/PRON ID :GALA73

PREFIX	DRAWING/DOCUMENT	NO	OF	REV	DATE	CL	DOCUMENT TITLE	NOTE	REVIEW
CODE	SIZE	CAGE	NUMBER						DATE

PRODUCT DRAWINGS AND ASSOCIATED LISTS

E 19200 12579607	1	1	A	01/08/88			GEOMETRIC SYMBOLS FOR DIMENSIONING AND TOLERANCING		
D 19204 8448519	1	1	H	08/11/92	LM		LATCH, CHARGING HANDLE		

02/24/93

ARMAMENT RESEARCH, DEVELOPMENT & ENGINEERING CENTER

SHEET NO

2

PICATINNY ARSENAL, NEW JERSEY 07806-5000

CAGE 19200

TECHNICAL DATA PACKAGE LIST : 19204 8448519
DOCUMENT NUMBER : D 19204 8448519
SPECIFICATION : MIL-W-63150
NATIONAL STOCK NO : - - -
LATCH, CHARGING HANDLE REQUEST/PRON ID :GALA73

PREFIX	DRAWING/DOCUMENT	CODE	SIZE	CAGE	NUMBER	-SHEET-	REV	DOCUMENT	SEC	DOCUMENT	TITLE	NOTE	REVIEW
						NO	OF	SYM	DATE	CL			DATE

PACKAGING DRAWINGS AND DOCUMENTS

PD	19204	8448519	1	1	B	06/11/80	LIM	PKG DATA SHT	-LATCH, CHARGING HANDLE				
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02/24/93

ARMAMENT RESEARCH, DEVELOPMENT & ENGINEERING CENTER

SHEET NO 3

PICATINNY ARSENAL, NEW JERSEY 07806-5000

CAGE 19200

TECHNICAL DATA PACKAGE LIST : 19204 8448519
DOCUMENT NUMBER : D 19204 8448519
SPECIFICATION : MIL-W-63150
NATIONAL STOCK NO :
LATCH, CHARGING HANDLE

REQUEST/PRON ID :GALA73

PREFIX	DRAWING/DOCUMENT	NO	OF	SYM	DATE	CL	DOCUMENT TITLE	NOTE	REVIEW DATE
CODE	SIZE CAGE	NUMBER							
INSPECTION DRAWINGS AND DOCUMENTS									
B	19204 8443551	1	1	A	10/24/69		GAGE, FIXTURE, COMPARTOR		
D	19204 8443842	1	1	B	10/19/73		PLATE, COMPARTOR		
D	19204 8443905	1	2	A	09/16/70		GAGE, LOCATION		
		2	2	A	09/16/70				
D	19204 8443948	1	1	A	09/16/70		ADAPTER COMPARTOR FIXTURE		
OS	19204 8448519	1	4	D	09/10/92 LIM		SOAP -LATCH, CHARGING HANDLE		
		2	4	D	09/10/92 LIM				
		3	4	D	09/10/92 LIM				
		4	4	D	09/10/92 LIM				

02/24/93

ARMAMENT RESEARCH, DEVELOPMENT & ENGINEERING CENTER

SHEET NO

4

PICATINNY ARSENAL, NEW JERSEY 07806-5000

CAGE 19200

TECHNICAL DATA PACKAGE LIST : 19204 8448519
DOCUMENT NUMBER : D 19204 8448519
SPECIFICATION : MIL-W-63150
NATIONAL STOCK NO :
LATCH, CHARGING HANDLE

REQUEST/PRON ID : GAIA73

NOTE

DOCUMENT TITLE

QPL/ DOCUMENT REV AND INT SUPPL DOCUMENT SEC
RECMAT NUMBER SYM NO CHG NO DATE CL

SPECIFICATIONS AND STANDARDS

QPL/ RECMAT	DOCUMENT NUMBER	REV	AND SYM	INT NO	SUPPL NO	DOCUMENT SEC NO	DATE	CL	DOCUMENT TITLE	NOTE
PPP-B-00636		L					01/01/91		BOXES, SHIPPING, FIBERBOARD	*
PPP-B-636		C				(REPLACED BY PPP-B-00636)	08/02/84		TAPE, PACKAGING, PAPER /FOR CARTON SEALING/	*
PPP-T-76		F					09/25/78		ALUMINUM AND ALUMINUM ALY, PLATE & SHEET, GENL SPEC FOR	*
QQ-A-250		F					11/05/91		ALUMINUM ALY, PLATE AND SHEET, 7075	*
QQ-A-250/12		B				1	12/15/89		COLORS	*
FED-STD-595		E					11/13/89		ANODIC COATINGS, FOR ALUMINUM AND ALUMINUM ALLOYS	*
MIL-A-8625		E					04/23/90		BAG, SLEEVE AND TUBING-INTERIOR PACKAGING	*
MIL-B-117		F				1	02/19/82		GAGES, DIMENSIONAL CONTROL	*
MIL-G-10944		B				3	10/24/91		PRESERVATION, METHODS OF	*
MIL-P-116		J				1	02/28/92		PARTS, EOPT AND TOOLS FOR ARMY MATERIEL, PKG OF	*
MIL-P-14232		E				2	05/28/87		WEAPONS, SMALL ARMS & A/C ARMAMENT SUBSYSTEMS, SPEC	*
MIL-W-13855		D				1	09/09/88		WEAPONS AND SPRT MATERIEL, STD QA PROV FOR	*
MIL-W-63150		E				3	05/10/89		SMPLE PROCEDURES & TABLES FOR INSPECTION BY ATTRIBUTES	*
MIL-STD-105		E					01/10/92		MARKING FOR SHIPMENT AND STORAGE	*
MIL-STD-129		L				1	06/21/91		DOD MATL PROC FOR DEV AND APPL OF PACKAGING REQT	*
MIL-STD-2073-1		B					00/00/85		SURFACE TEXTURE/SURFACE ROUGHNESS, WAVINESS & LAY/	**
ANSI-B46.1						(REPLACED BY ANSI-B46.1)			)	**
ASA-B46.1									GAGE BLANKS	**
ANSI-B47.1							00/00/88		)	**
CS8						(REPLACED BY ANSI-B47.1)			DIMENSIONING AND TOLERANCING FOR ENGINEERING DRAWINGS	**
ANSI-Y14.5							00/00/73		DIMENSIONING AND TOLERANCING FOR ENGINEERING DWGS.	**
ANSI-Y14.5M							01/01/82		)	**
USASI-Y14.5						(REPLACED BY ANSI-Y14.5M)				**

02/24/93

ARMAMENT RESEARCH, DEVELOPMENT & ENGINEERING CENTER

SHEET NO 5

PICATINNY ARSENAL, NEW JERSEY 07806-5000

CAGE 19200

TECHNICAL DATA PACKAGE LIST : 19204 8448519
DOCUMENT NUMBER : D 19204 8448519
SPECIFICATION : MIL-W-63150
NATIONAL STOCK NO :
LATCH, CHARGING HANDLE

REQUEST/PRON ID :GALA73

TDPL NOTE LEGEND

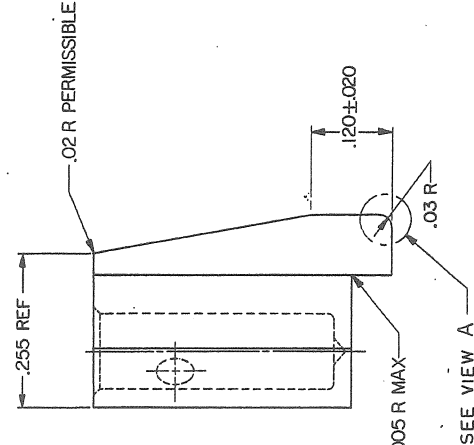
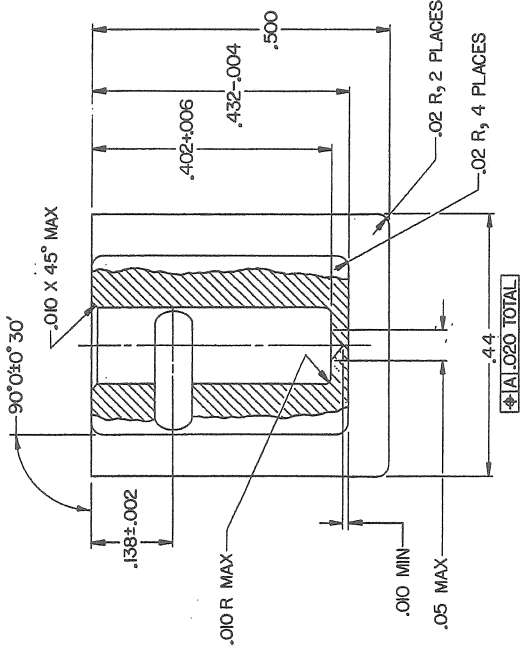
DESCRIPTION OF SYMBOLS IN THE NOTE COLUMN

* - Not Furnished - To be obtained from C.O. Naval Publications and Forms Ctr., 5801 Tabor Ave., Phila., Penna., 19120, ATTN. Code 105. If not available, immediately advise the procuring contracting officer.

** - Not Furnished - Commercial Specifications and Standards may be obtained from the publishers. They are not available from government sources.

NOTES:

1. STEEL, CMFSPN 1018 TO 1022, SPEC ASTM A1048 OR SINTERED STEEL, GRADE I, CLASS A, DENSITY TYPE II PER ASTM B484-70. SINTERED MAT'L SHALL BE SEALED WITH POLYESTER RESIN.
2. FINISH $12\frac{3}{4}$.
3. BREAK ALL SHARP EDGES .005+0/0 EXCEPT AS NOTED.
4. MIL-W-13865 APPLIES.



VIEW A
ALTERNATIVE CONFIGURATION
NOT TO SCALE

DISTRIBUTION STATEMENT F
DISTRIBUTION IS AUTHORIZED TO DOD AGENCIES AND DOD
QUALIFIED U.S. ORNANCE CONTRACTORS, FURTHER DISSEMINA
TION AS DIRECTED BY
OR HIGHER DOD AUTHORITY.

EDITION OF 29 JUL 69 MAY BE USED

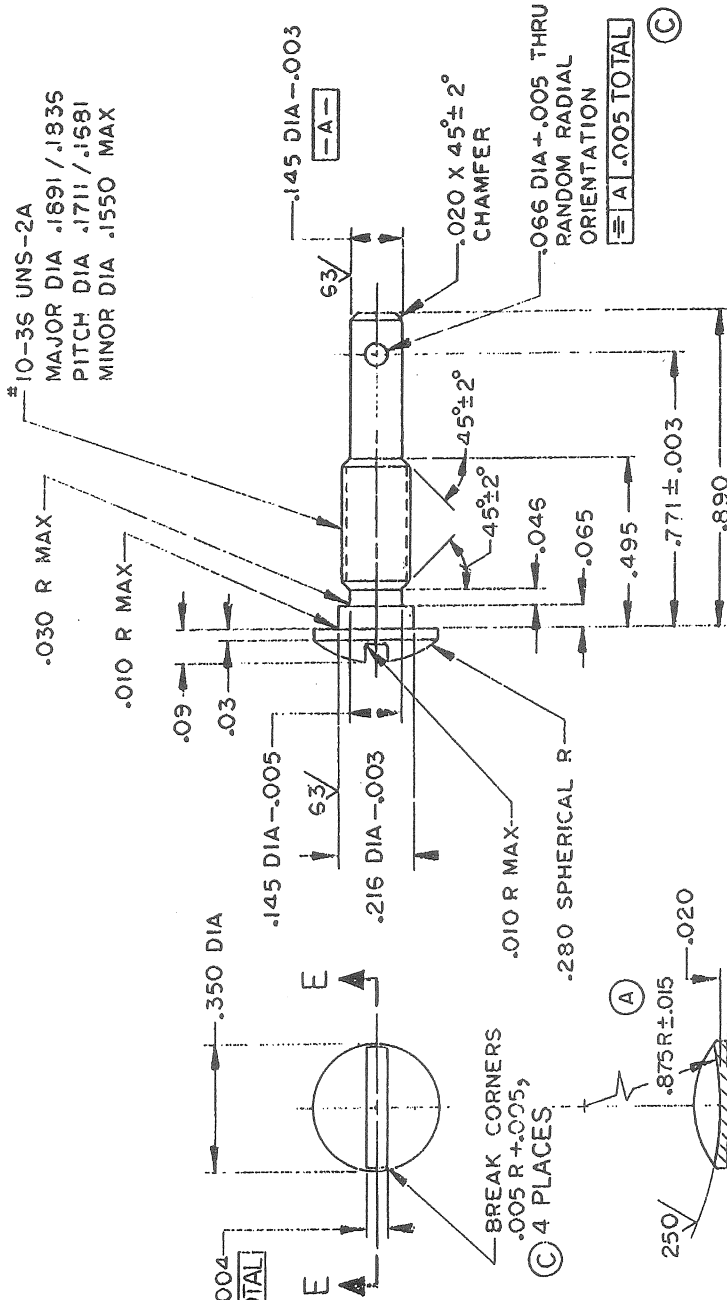
NOTICE: RESTRICTED AS TO USE AND DISCLOSURE

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NOTE:

1. FINISH 125/ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .010 MAX, EXCEPT AS NOTED. (A)
3. HEAT TREATMENT: QUENCH (C) AND TEMPER TO .064 ± .004 (A).015 TOTAL
4. MIL-W-13855 APPLIES. (B)

REVISIONS			DATE	APPROVED
REV	ZONE	DESCRIPTION		
1		REDRAWN FROM COLT'S DRAWING	27 APR 70	
2		C51702 REVISION A		
3	A	(3) SEE E0 HRD C2197-3	15 JUL 70	
4	B	(2) SEE HQR 10719	11 MAY 71	
5	C	(5) SEE ERR HQR 20778	16 OCT 72	
6	D	NOR W552009	20 02 13	



PARTIAL SECTION E-E

CODE IDENT NO
19200

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

ITEM OF WORK
SCREW REAR SIGHT WINDAGE
DOCS 15-240 15-240-1 15-240-2 15-240-3

SCREW,
REAR SIGHT WINDAGE
SIZE CODE IDENT NO. DRAWING NO.
C 19200 8448534
SCALE 4/1
SHEET 1 OF 1
CDI

CONTRACT NO.
DATE 27 APR 1970
PREPARED FOR
CHECKED BY
ENGINEER
SUBMITTED
APPROVED
K. S. Henry

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
ANGLES 2
3 PLACE DECIMALS ± .005
2 PLACE DECIMALS ± .01
MATERIAL
STEEL, CMPSN 4130,
4140, 41L30, 41L40,
OR 4037, ASTM A322
FINAL PROTECTIVE FINISH
5.3.1.2 OF
MIL-STD-171

MECHANICAL PROPERTIES		APPLICATION	
YS	MIN	RM	15N 72.5-76
YS	MAX		
EL2			
RA			
BH			
D8448602M16		NEXT ASSY USED ON	
D8448523M16A1			

5 4 3 2 1

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REVISIONS		DATE	APPROVED
MF	ZONE LTR	DESCRIPTION	
A		SEE ERR HQR 20778	15 OCT 72
B		NOR W9S2009 80-02-13	80-05-15
C		NOR W2S2015 82 08 20	83 02 03
D		NOR W2S 0011 / 82-04-13	83-11-04
E		CEP W3S3120 / 83-07-07	91-10-11
F		NOR G1S2018 91-07-08	920327
		NOR G2S3016 / 920213	613

SPRING, HELICAL, COMPRESSION

- WIRE DIAMETER .0120 ± .0003
- COIL DIAMETER (OD) .120 ± .002
- FREE LENGTH .413 REF
- TOTAL COILS 8 REF
- DIRECTION OF HELIX OPTIONAL
- LOAD AT COMPRESSED LENGTH OF .201 .80 LB ± .08 LB
- LOAD AT COMPRESSED LENGTH OF .377 LB/IN REF
- SPRING RATE .0984 MAX
- SOLID LENGTH CLOSED
- TYPE OF ENDS
- MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

NOTES:

- WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
- PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITION CH900. HOLD AT 900°F ± 10°F FOR ONE HOUR. AIR COOL.
- FINISH 5.4.1 OF MIL-STD-171.
- MIL-W-13855 APPLIES.
- BREAK SHARP EDGES .003 ± .012.

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

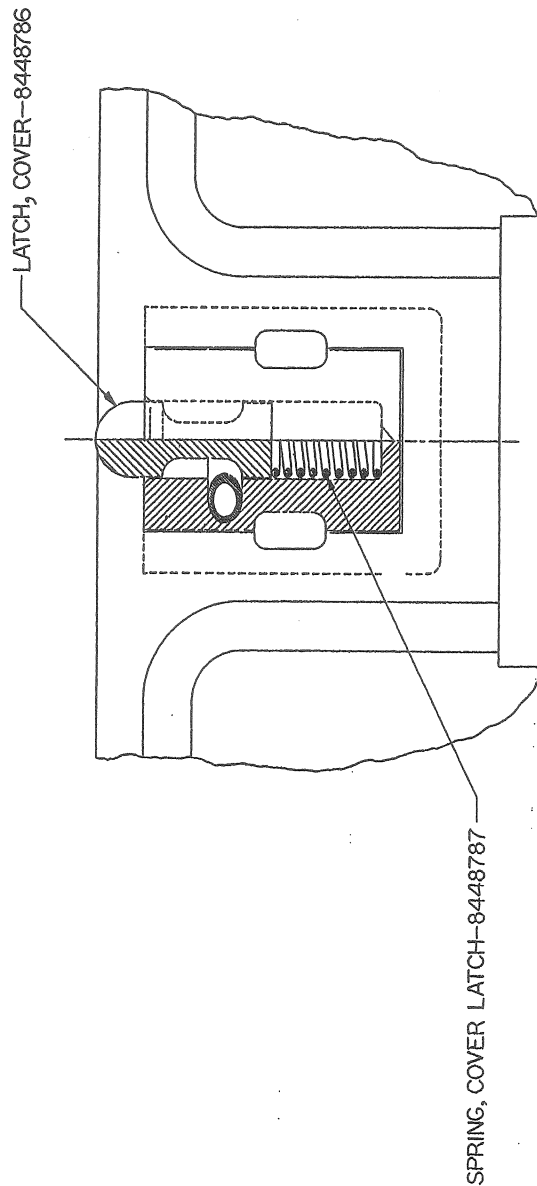
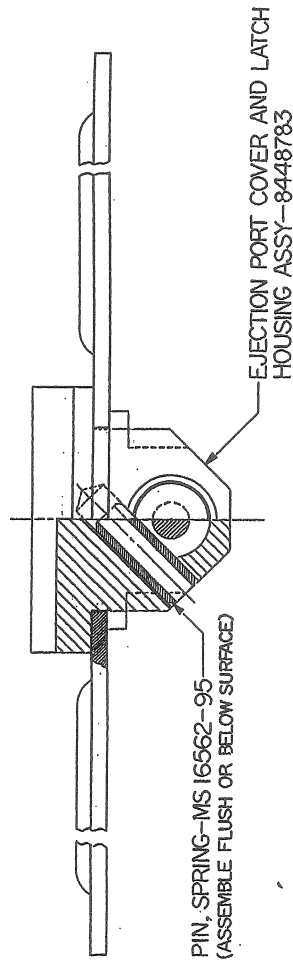
CURRENT FSCM NO. 19200
PART NO. 8448787

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO. DATE 15 SEPT 72		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS MIN		ANGLES		PREP	R. Henry	CHK	R. Henry
YS MAX		3 PLACE DECIMALS		ENGR	G. B. Buntin	ENGR	G. B. Buntin
EL 2		2 PLACE DECIMALS		SUBMITTED			
RA		MATERIAL		SEE NOTE 1			
BH		3448525 M 4		FINAL PROTECTIVE FINISH			
RH		D8448525 M 231		SEE NOTE 3			
NEXT ASSY USED ON		D8448525 M16/M16AI					
APPLICATION							

SPRING, COVER LATCH
SIZE CODE IDENT NO. DRAWING NO.
B 19204 8448787
SCALE — SHEET 1 OF 1

[illegible]

1. THE LOAD NECESSARY TO DEPRESS THE LATCH, COVER 8448786, .060 INCHES FROM ITS ASSEMBLED POSITION SHALL BE 12 ± 3 LB.



REVIEWS	DATE	APPROVED
REPLACES REV (S) W/CHANGE A SEE ERR MOR 2048	21-SEP-72	
B MOR WSS22009 80-02-13	80-05-16	8/2/72
C MOR G152018/910708	91Q11	RR 3/ 5
D NOR G253059/930716	92-06-11	JA1
E IECP G253060/930630		5

CURRENT DESIGN ACTIVITY CASE CODE 15200
U.S. ARMY
ARMAMENT RESEARCH DEVELOPMENT AND ENGINEERING CENTER
BULFINGTON, MISSISSIPPI 39205-5000

SEE PI-8448525

MECHANICAL PROPERTIES		THERMAL PROPERTIES		ELECTRICAL PROPERTIES		ENVIRONMENTAL PROPERTIES		PHYSICAL PROPERTIES		CHEMICAL PROPERTIES	
1	2	3	4	5	6	7	8	9	10	11	12
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1	2										

PART NO 8448525

DEPT OF THE ARMY
S ARMY WEAPONS COMMAND
ROCK-ISLAND, ILLINOIS 61201

EJECTION PORT COVER ASSY

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQC-AR OR HIGHER DOD AUTHORITY 92-06-72.

ASWE Form 403D 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED

CHANDRASEKHAR, a 1960s-era Indian film, was the first to depict the lives of Indians in the United States. It was a landmark film, as it was the first to show Indians in a positive light. It was a landmark film, as it was the first to show Indians in a positive light. It was a landmark film, as it was the first to show Indians in a positive light.

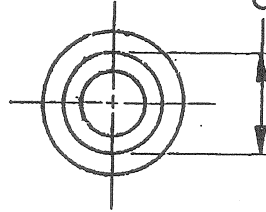
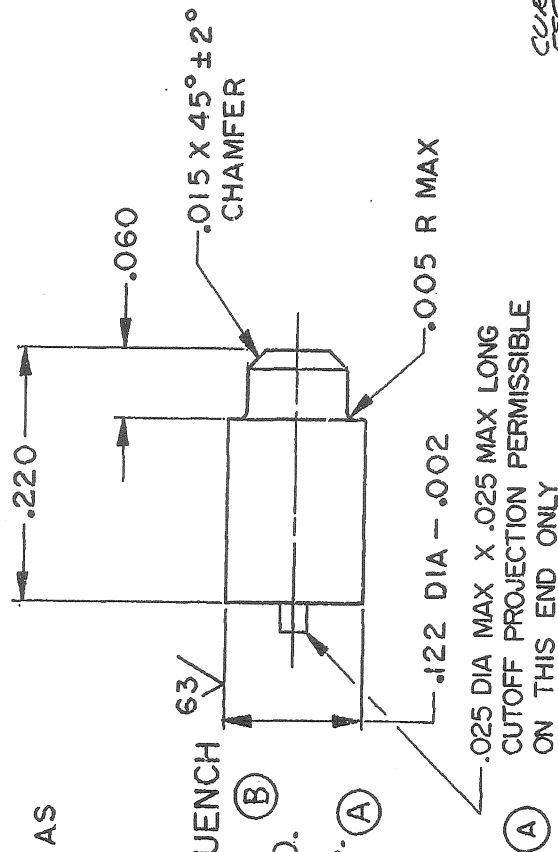
1. TUMBLE TO BREAK SHARP
EDGES TO .005R + .005.

125/✓ EXCEPT AS
2. FINISH
NOTED.

3. FINISH 5.3.1.2 OF
MIL-STD-171.

4. HEAT TREATMENT: QUENCH AND TEMPER TO (B) HARDNESS SPECIFIED.

5. MIL-W-13855 APPLIES. (



CURRENT DESIGN ACTIVITY
FSCM NO. 19200

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

MECHANICAL PROPERTIES						UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DOVER, NEW JERSEY 07801	
YS						TOLERANCES:	DATE 27 APR 1970	DEPT OF THE ARMY		U.S. ARMY WEAPONS COMMAND	
MIN						ANGLES ± .005	PREP C.H.K. G.S.M.	ROCK ISLAND, ILLINOIS, 61201		DETENT, REAR SIGHT	
YS						3 PLACE DECIMALS ± .005	CHK R.D.G. R.D.G.				
MAX						2 PLACE DECIMALS ±	ENGR D.D.M. R.D.G.				
EL 2		D8448602	M16			MATERIAL	SUBMITTED				
RA		D8448523	M16 A1			STEEL; CARBON, CMPSM; H33 HILZ ORTEL IL 41	APPROVED				
BH						SPEC ASIM A108-81	<i>P.P. Yellowing</i>	SIZE CODE IDENT NO. DRAWING NO.		B 19204 8448537	
RH	MSN 725-76					FINAL PROTECTIVE FINISH	<i>K.J. Henry</i>	SCALE 10/1		SHEET 1 OF 1	
		NEXT ASSY	USED - ON	APPLICATION		SEE NOTE 3					

(B)

AMSWE Form 403B, 29 Jul 69

AMSWE Form 403B, 29 Jul 69

15

[illegible]

1. WIRE, STEEL, CMPSN 1010 OR 1018,
.156 DIA, ASTM A510. (E)

5. APPLY BLACK PLASTIC SOL COATING,
PER MIL-P-20689, TYPE I, CLASS 2,
TO AREAS INDICATED BY [F-F]

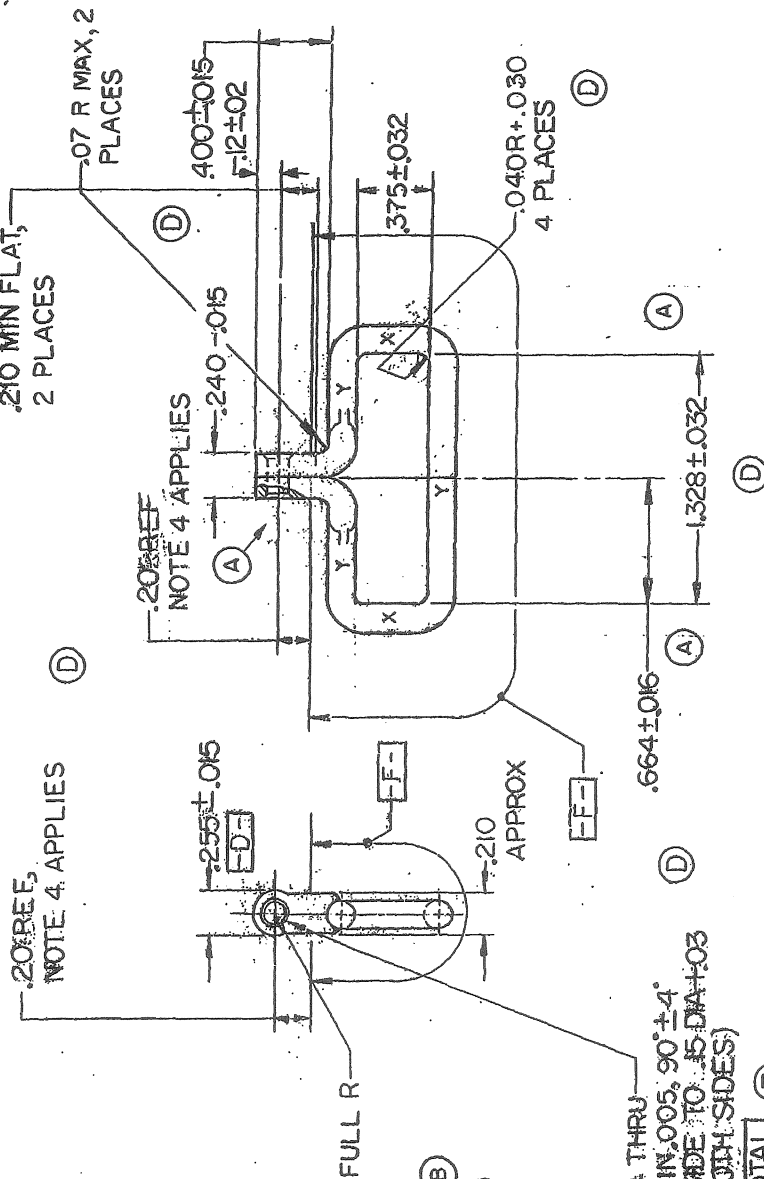
4. PLASTISOL COAT ALL SURFACES TO WITHIN:

20" ± .05" O.E. = MOUNTING HOLE CENTER AREA
AROUND MOUNTING HOLE MUST BE FREE
OF COATING. PLASTIC COATED DIA TO BE
.165 ± .040 (2) VERT. LEGS (X) .165 ± .060
ON (3) HORIZONTAL SECTIONS (X).

5. FINISH 5.3.1.3 OF MIL-STD-171 BEFORE FINISH SPECIFIED IN NOTE 3.

6. TOOL AND FORMING MARKS. PERMISSIBLE PRIOR TO PLAST-ISOL COATING, PROVIDED COATING IS NOT DEGRADED TO THE EXTENT OF SURFACE DISCONTINUITIES.

7. MIL-W-13855 APPLIES.



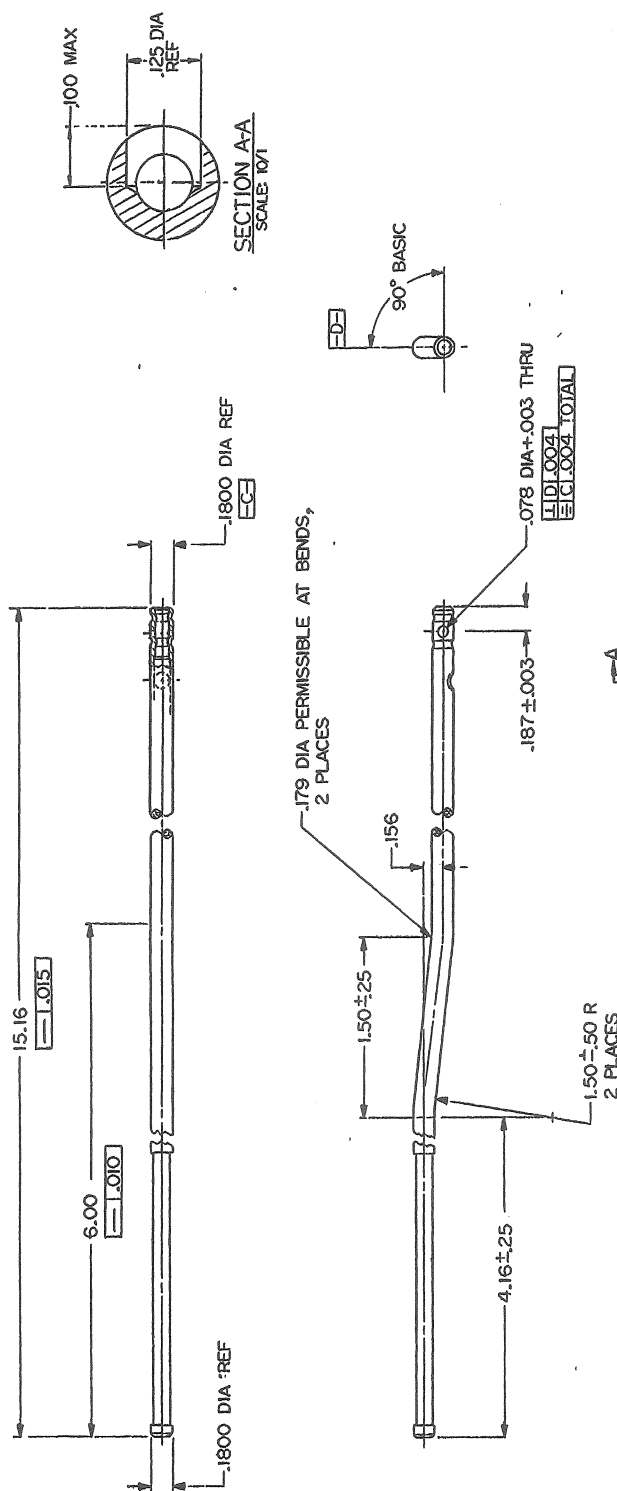
CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING
PICATINNY ARSENAL, NEW JERSEY 07806-5000

DISTRIBUTION STATEMENT F: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQNC-AR, 91113.									
MECHANICAL PROPERTIES									
YS									
MIN									
YS									
MAX									
EL2									
RA				9349057	M16A2				
BH				9390901	M4				
				C8448565	M16				
				C8448565	M16A1				
RH									
				APPLICATION					
				NEXT ASSY		USED ON			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: ANGLES ± 3 PLACE DECIMALS ±.005 2 PLACE DECIMALS									
MATERIAL SEE NOTE 1									
FINAL PROTECTIVE FINISH SEE NOTES 3, 4, AND 5									
CONTRACT NO: DATE 27 APR 1970									
PREPARED: <i>9/2/70 A.S.H.</i> CHECKED: <i>DRG R. Kelly</i> ENGINEER: <i>John W. Billard</i> SUBMITTED: <i>P. Kelly</i> APPROVED: <i>P.S. Henry</i>									
SIZE CODE IDENT NO. DRAWING NO. C 19204 8448571									
SCALE 2/1 SHEET OF									

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- NOTE
1. MAKE FROM GAS TUBE AND PLUG ASSEMBLY - 8448568
 2. FINISH 125.
 3. MIL-W-13855 APPLIES.

REV	ZONE	DATE	DESCRIPTION	APPROVED
1		27 APR 70	REDRAWN FROM COLT'S DRAWINGS	
2		15 JUL 70	D6645 REV B	
3		6 OCT 72	(1) SEE E.O. HRD 02197-3	
4		20 DEC 72	(3) SEE E.O. HRD 20778	
5		20 DEC 72	20 DEC 72	
6		20 DEC 72	20 DEC 72	
7		20 DEC 72	20 DEC 72	
8		20 DEC 72	20 DEC 72	
9		20 DEC 72	20 DEC 72	
10		20 DEC 72	20 DEC 72	
11		20 DEC 72	20 DEC 72	
12		20 DEC 72	20 DEC 72	
13		20 DEC 72	20 DEC 72	
14		20 DEC 72	20 DEC 72	
15		20 DEC 72	20 DEC 72	
16		20 DEC 72	20 DEC 72	
17		20 DEC 72	20 DEC 72	
18		20 DEC 72	20 DEC 72	
19		20 DEC 72	20 DEC 72	
20		20 DEC 72	20 DEC 72	



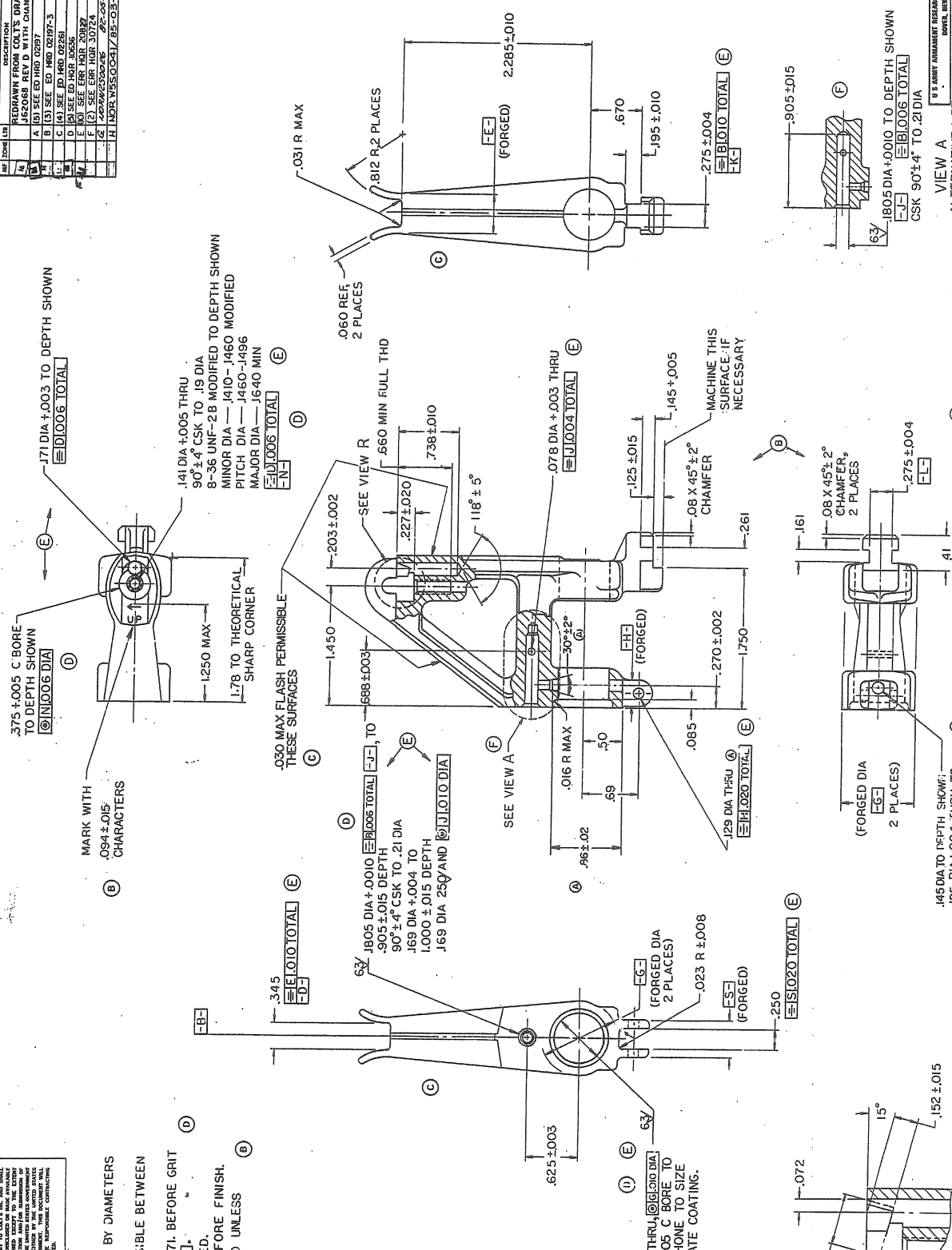
CURRENT DESIGN ACTIVITY
 CSDM NO. 19200

U.S. ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801		DEPT OF THE ARMY U.S. ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER ROCK ISLAND, ILLINOIS 61201	
CONTRACT NO.		DATE 27 APR 1970	
SUBJECT: GAS TUBE ASSEMBLY		ENGINEER: [Signature]	
DRAWN: [Signature]		CHECKED: [Signature]	
APPROVED: [Signature]		DATE 27 APR 1970	
SEE NOTE 1		MATERIAL: [Blank]	
MIL-STD-171		MIL-STD-171	
NET ASST: [Blank]		USED ON: [Blank]	
APPLICATION: [Blank]		APPLICATION: [Blank]	

DISTRIBUTION STATEMENT: FURTHER DISTRIBUTION
 ONLY AS DIRECTED BY ASO/C-AIR OR HIGHER DOD
 AUTHORITY: 54-46-2L

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1. PLANE FB IS ESTABLISHED BY DIAMETERS EC AND WIDTH ED.
2. .005 MAX MISMATCH PERMISSIBLE BETWEEN SURFACES FX AND FL.
3. FINISH, 5.3-12 OF MIL-STD-171. BEFORE GRIT BLAST, MASK DIAMETER FJ.
4. FINISH 125/ EXCEPT AS NOTED.
5. ALL DIMENSIONS APPLY BEFORE FINISH.
6. BREAK SHAW? EDGES .005+.010 UNLESS OTHERWISE SPECIFIED.
7. MIL-W-13855 APPLIES. C



ALTERNATIVE METHOD	CURRENT D
CONTRACT NO.:	

[illegible]

VIEW R
SCALE: 4/1

2260

A SWE Form 403F, 29 Jul 69

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4

3

2

1

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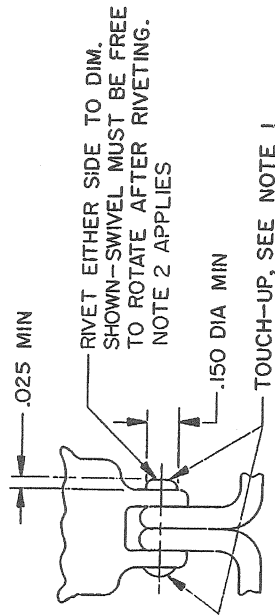
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NOTES:

1. AFTER SPREADING, THE RIVET SHALL BE REFINISHED (TOUCHED-UP) IN ACCORDANCE WITH PARA 3.5.5.3 OF MIL-W-13855, OR LACQUER, MIL-L-19538, CLASS I, COLOR BLACK 37038.

2. CRACKS PERMISSIBLE, PROVIDED THAT:

- A. NO MORE THAN TWO CRACKS PER QUADRANT AND THREE PER RIVET APPEAR.
- B. NO CRACK EXTENDS INTO THE TUBULAR PORTION OF THE RIVET.
- C. NO BROKEN SECTIONS RESULT FROM ADJACENT CRACKS.
3. MIL-W-13855 APPLIES.



VIEW A-A
SCALE 2/1

SEE PL-8448565

MECHANICAL PROPERTIES	
YS MIN	
YS MAX	
EL 2	
RA	
BH	MIG
RH	MIGAI

APPLICATION

UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES
ANGLES:
3 PLACE DECIMALS
2 PLACE DECIMALS

MATERIAL

DATE 27 APR 70

PREPARED BY: [Signature]

CHECKED BY: [Signature]

ENGINEER: [Signature]

SUBMITTED BY: [Signature]

APPROVED BY: [Signature]

CONTRACT NO:

CONTRACT NO:

DATE 27 APR 70

PREPARED BY: [Signature]

CHECKED BY: [Signature]

ENGINEER: [Signature]

SUBMITTED BY: [Signature]

APPROVED BY: [Signature]

CONTRACT NO:

CURRENT DESIGN ACTIVITY FSCM NO. 19200

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

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

SIGHT AND GAS TUBE ASSY

SIZE: CODE IDENT NO. DRAWING NO.
C 19204 8448565

AMSWE Form 403C, 29 Jul 69

REVISIONS

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REPLACES B8448565 REV(0)		
			W/CHANGES		
		A	(4) SEE EO HRD 02197-1	15 JUL 70	[Signature]
		B	(2) SEE ERR HQR 10730	26 MAY 71	[Signature]
		C	SEE ERR HQR 10842	14 SEP 71	[Signature]
		D	SEE ERR HQR 10862	8 OCT 71	[Signature]
		E	(2) SEE ERR HQR 20665	11 APR 72	[Signature]
		F	(2) SEE ERR HQR 20679	21 JUL 72	[Signature]
		G	SEE ERR HQR 20778	6 OCT 72	[Signature]
		H	NORW250020	83-02-03	[Signature]
		J	INORW25 0026	82-06-09	[Signature]
				82-05-21	[Signature]

SIGHT, FRONT - 8448566

PIN, SPRING-MSI6562-106

GAS TUBE ASSY - 8448567

RIVET - 8448697

SWIVEL, SLING - 8448571

C 8448565

B

A

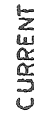
[illegible]

I. SUGGESTED HEAT TREAT:

2. BREAK SHARP EDGES
.005+.010.

3. STEEL, CMPSN 4027, 4028, AND 4037, SPEC ASTM A 304 OR STEEL, CMPSN 1030, 1033, 1035, 1037, AND 1038, SPEC ASTM A108.

4. MIL-W-13855 APPLIES.



CODE IDENT NO.

19200

**DISTRIBUTION STATEMENT E FURTHER DISTRIBUTION ONLY
AS DIRECTED BY ASQC-AR OR HIGHER DOD AUTHORITY: 92-06-22.**

[illegible]

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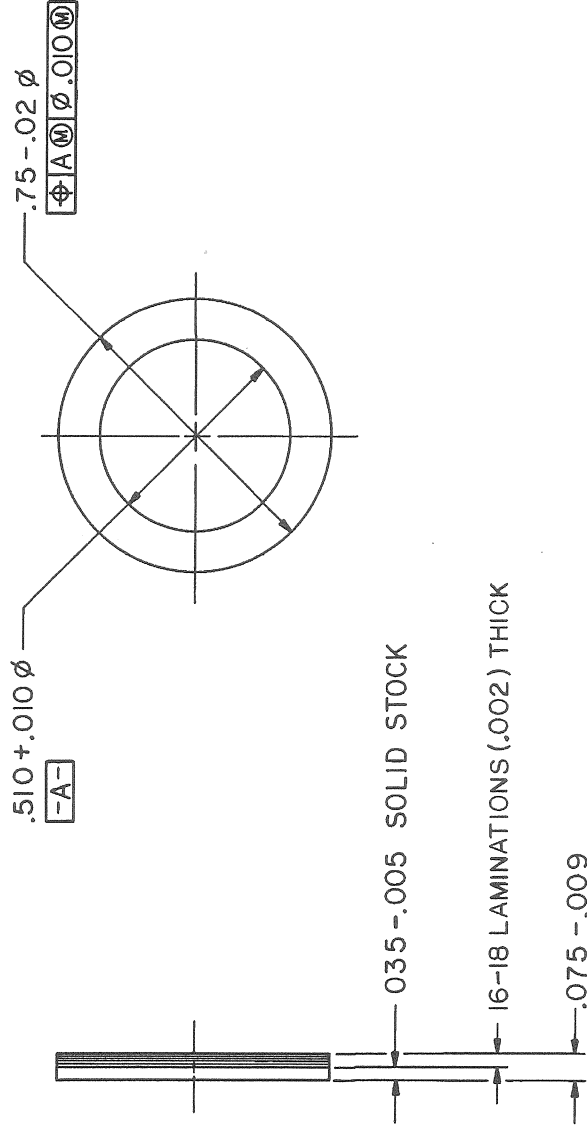
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NOTES: -

- 1 - SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
- 2 - MATERIAL: - LAMINATED SHIM STOCK PER MIL-S-22499, COMPOSITION 3, TYPE TO BE AS SHOWN, CLASS 1.
- 3 - BREAK SHARP EDGES .005 +.010 UNLESS OTHERWISE SPECIFIED.
- 4 - FINISH $\sqrt{125}$ ALL SURFACES.

5-



PART NO. 9349052

8448522		M16A1		MECHANICAL PROPERTIES		DO NOT SCALE DRAWING		ORIGINAL DATE OF DRAWING		U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
8448601		M16		YF		UNLESS OTHERWISE SPECIFIED		82-02-2 G			
9327227		M231FPW		TS		DIMENSIONS ARE IN INCHES		DRAFTSMAN E J Z		CHECKER DEW	
9390001		M4		EL2		TOLERANCES ON DECIMALS ±		ENGR. J. P. G. S.		ENGR	
9349050		M16 A2 E 3		RA		FRACTIONS ±		ENGR		ENGR	
		M16 A2		BH		ANGLES ±					
NEXT ASSY		USED ON		RH							
APPLICATION											

SIZE	FSCM NO.	9349052
C	19200	
SCALE	4/1	UNIT WT.
SHEET 1 OF 1		

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NOTES:

1. WIRE, STAINLESS STEEL, TYPE 316 (17-7PH), COLD DRAWN, ASTM A316.

2. PRECIPITATION HEAT TREAT AFTER FORMING TO CONDITN CH900. HOLD AT 900°F ± 10° FOR ONE HOUR. AIR COOL.

3. MIL-W-13855 APPLIES.

4. BREAK SHARP EDGES .003 ± .012.

SPRING, HELICAL, COMPRESSION

WIRE DIAMETER .0180 ± .0005
COIL DIAMETER (OD) .115 ± .003
FREE LENGTH .75 REF
TOTAL COILS 20 REF
DIRECTION OF HELIX OPTIONAL
LOAD AT COMPRESSED LENGTH OF .557 AFTER SET 1.78 LB ± .18 LB
LOAD AT COMPRESSED LENGTH OF _____
SPRING RATE _____
SOLID LENGTH 390 MAX
TYPE OF ENDS CLOSED
MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE B, MIL-S-13572

CURRENT DESIGN ACTIVITY
FSCM NO. 19200

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

PART NO. 8448574

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS		TOLERANCES:	DATE 27 APR 70	PREP	P. Henry	SPRING, FRONT	
MIN		ANGLES ±	CHK	CHK	G. D. Henry	SIGHT, DETENT	
YS		3 PLACE DECIMALS ± .005	ENGR	ENGR	R. E. Henry	SIZE CODE IDENT NO. DRAWING NO.	
MAX		2 PLACE DECIMALS ±	SUBMITTED	SUBMITTED	R. E. Henry	B 19204 8448574	
EL 2		MATERIAL	APPROVED		R. E. Henry	SCALE	
RA		SEE NOTE 1	FINAL PROTECTIVE FINISH		SHEET 1 OF 1		
BH		5.41 OF MIL-STD-171	APPLICATION				
RH	15N 845 MIN	NEXT ASSY	USED ON				
		APPLICATION					

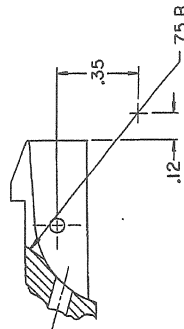
NOTICE: RESTRICTED AS TO USE AND DISCLOSURE

1. FINISH 63/ EXCEPT AS NOTED.

2. ANNEAL FOR LENGTH $\boxed{-C-}$.

3. BREAK SHARP EDGES, 0.005±.010.

4. MIL-W-13855 APPLIES.



VIEW A
ALTERNATIVE DESIGN

REVISIONS

CONTRACT NO:

RESEARCH AND DEVELOPMENT CENTER

PLUNGER

SIZE	CODE IDENT NO.	DRAWING NO.
D	19204	8448546

SCALE 4/1	SHEET	OF
-----------	-------	----

SWE Form 403D; 29. Jul 69

NOTES:—

- 1 — SPEC. MIL-W-3855 AND ANSI Y14.5-73
MATERIAL.
- 2 — MATERIAL— STEEL BAR, ASTM 108, CHRSN 1137, OR 1141,
ANNEALED AND COLD DRAWN BRINELL HARDNESS 286 MAX.
- 3 — BREAK SHARP EDGES .005±.010 UNLESS
OTHERWISE NOTED.
- 4 — ALL DIAMETERS $\varnothing \frac{1.00}{.99}$ UNLESS
OTHERWISE NOTED.
- 5 — FINISH $\frac{125}{\sqrt{}}$ ALL SURFACES UNLESS
OTHERWISE NOTED.



-SEE DETAIL B

SECTION A-A

[illegible]

DISTRIBUTION STATEMENT F.
FURTHER DISSEMINATION ONLY AS DIRECTED
BY ARDEC, AMSTA-ARA-ESW, ROCK ISLAND, IL
ASQNC-ARI-CT 91025 OR HIGHER DoD
AUTHORITY.

[illegible][illegible]

NOTES:—

1-SPEC. MIL-W-13855 AND ANSI Y14.5-73

APPLY.

2-BREAK SHARP EDGES .005+.010 EXCEPT

AS NOTED.

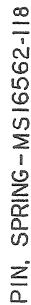
3-INSET SPRING PIN SO THAT ENDS ARE BELOW SURFACE ON EITHER SIDE AS SHOWN.

4-DIMENSIONS APPLY BEFORE PROTECTIVE FINISH.

125/

5-FINISH 11-5
ALL SURFACES

6-PROTECTIVE FINISH:-- 5.3.1.2 OF MIL-STD-171.



NOTE 3

FOR ENGINEERING PARTS LIST SEE PL 9349085

5 4 3 2 1

NOTICE RESTRICTED AS TO USE AND DISCLOSURE

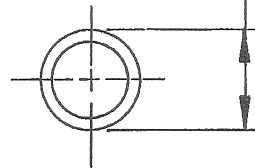
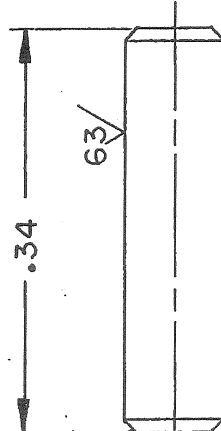
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NOTE:

1. FINISH 125/ EXCEPT AS NOTED.
2. SUGGESTED HEAT TREAT:
LIQUID CARBURIZE AT 1550°F TO OBTAIN A TOTAL CASE DEPTH OF .010 TO .015 • HARDEN AND TEMPER AT MIN (A) OF 400°F.
3. BREAK SHARP EDGES .005±.010. (B)
4. MIL-W-13855 APPLIES. (B)
5. MATERIAL:
WIRE, STEEL, CMPSN 1018 OR 1020 OR 1022, ASTM A108.
ALTERNATE MATERIAL: BAR, STEEL, CMPSN 1117, ASTM A108.

REV	NO	DATE	APPROVED	REVISIONS	
				DESCRIPTION	DATE
H	NOR G2S3059/920716 (ECP G2S3060/920630)	920811	AJL	REDRAWN FROM COLT'S DRAWING	27 APR 70
J	NOR G2S3122/930108	930310	GHS	B62270 REVISION A	
A				(2) SEE EO HRD 02197-3	15 JULY 70
B				(2) SEE HQR 10689	26 APR 71
C				(2) SEE ERR HQR 20778	6 OCT 72
D				NOR W9S2009 80-02-13	80-05-16
E				NOR W5S3037/850917	861211
F				NOR GIS3096 910814	910916
G				NOR GIS2018/910708	911011

.010 X 45°± 2° CHAM
BOTH ENDS



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AS DIRECTED BY ASQC-AR OR HIGHER DOD AUTHORITY, 92-06-22.

CURRENT DESIGN ACTIVITY CAGE CODE 19200
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PICATINNY ARSENAL, NEW JERSEY 07806-5000

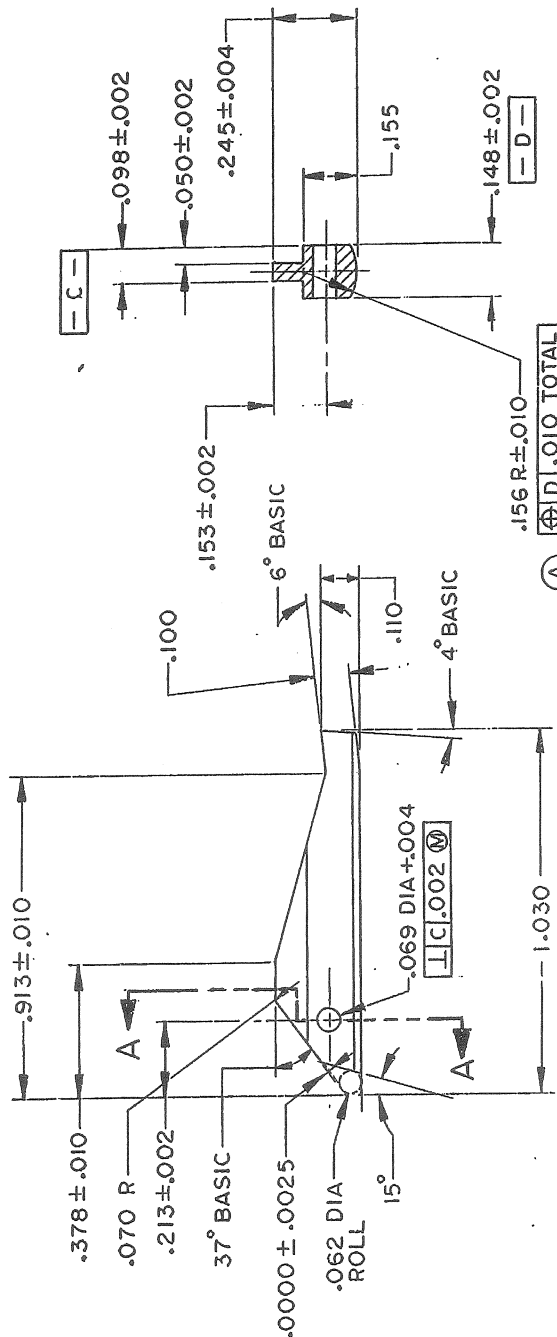
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DATE 27 APR 1970		DEPT OF THE ARMY	
YS	MIN	TOLERANCES:		PREP	CHK	ENGR	SUBMITTED	U.S. ARMY WEAPONS COMMAND	
YS	MAX	3 PLACE DECIMALS ±.005						ROCK ISLAND, ILLINOIS, 61201	
EL	2	2 PLACE DECIMALS ±.01						DETENT, PAWL	
RA		MATERIAL		SEE NOTE 5				SIZE CODE IDENT NO. DRAWING NO.	
BH		9349086 M4						B 19204 8448544	
RH	15N 89MIN	C8448541 M16A1						SCALE 10/11	
NEXT ASSY		USED ON		APPROVED		E. S. Kearney		SHEET 1 OF 1	
APPLICATION									

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NOTE:-

1. FINISH 63/.
2. BREAK ALL EDGES .005+.005.
3. STEEL, GMPN 1137, 1141, OR 1144, SPEC ASTM A108.
4. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS SPECIFIED.
5. MIL-W-13855 APPLIES.



SECTION A-A

DISTRIBUTION STATEMENT F. FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQC-AK OR HIGHER DOD AUTHORITY, 92-06-22.

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO:		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS MIN		TOLERANCES:		DATE 27 APR 1970	PREPARED	PAWL, FORWARD ASSIST	
YS MAX		ANGLES 1°		CHECKED	RGH	SIZE CODE IDENT NO. DRAWING NO.	
EL 2		2 PLACE DECIMALS ± .005		ENGINEER	RGH	C 19204	8448543
RA		3 PLACE DECIMALS ± .005		SUBMITTED	RGH	SHEET 1 OF 1	
BH				APPROVED	T.P. Galloway	CDI	
RH	C44-48	APPLICATION			K. J. Henry		
		9349086 M4					
		C8448541 M16A1					
		NEXT ASSY USED ON					
		5.3.1.2 OF MIL-STD-171					

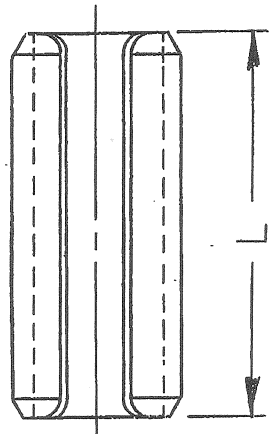
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NOTE:

- 1. BREAK ALL SHARP EDGES
.003+-.012.

PART NO.	MS MODIFIED	DIM L	NEXT ASSY
8448521-1	MS16562-130	.719 ±.010	C8448615
8448521-2	MS16562-97	.267 ±.010	B8448517 D9349086



MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
M			REPLACES COLT'S PART NUMBERS 95103 95113 AND 95138-1 FROM COLT'S DRAWING D95101 REV C	27 APR 70	
	A	(4)	SEE EO HRD 02197-3	15 JULY 70	8448521
	B		SEE ERR HQR 10822	9 AUG 71	813
	C		SEE ERR HQR 10836	13 SEP 71	813
	D		NOR W952009 80-02-13	80-05-16	8448521
	E		NOR W250020 82-06-09	83-02-03	LAH 8114
	F		NOR W453048 / 84-10-09	85-02-14	8448521
	G		NOR GIS2018 / 91 07 08	91-10-11	RR 52

CURRENT
FSCM NO.
19200

ALTERED ITEM DRAWING

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

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.	
YS MIN	8448517	TOLERANCES:		DATE 27 APR 1970	
YS MAX	B8448517	ANGLES:		PREP 8524	
EL 2		3 PLACE DECIMALS ±		CHK 2-8-74	
RA		2 PLACE DECIMALS ±		ENGR 2-8-74	
BH	SEE TABLE M16A1	MATERIAL		SUBMITTED 2-8-74	
RH	NEXT ASSY USED ON	FINAL PROTECTIVE FINISH		APPROVED R. J. Henry	
APPLICATION				SCALE NONE	
				SIZE CODE IDENT NO. DRAWING NO.	
				B 19204 8448521	
				SHEET 1 OF 1	

B8448542

DRAWING SIZE D
(ASAP) 100mm 75-125 8

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NOTES:—
1—SPEC. MIL-W-13855 AND ANSI Y14.5-73
APPLY.

2—INSERT ROLL PIN SUCH THAT ENDS ARE
FLUSH WITH OR BELOW SURFACE ON BOTH
SIDES AS SHOWN.

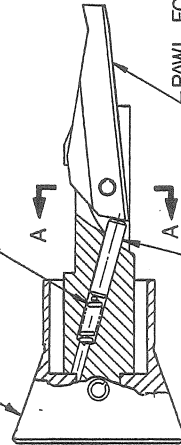
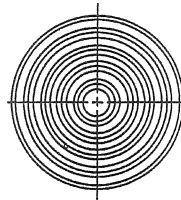
PLUNGER ASSEMBLY-9349085

SPRING, BOLT-8448542

PAWL, FORWARD ASSIST-8448543

PIN ROLL-8448521-2

DETENT, PAWL-8448544



SECTION A-A

REV	DESCRIPTION	DATE	APPROVAL
1	PRODUCTION RELEASE	820614	
2	ERR 25013	820614	
3	NOR 450030 / M4-11-10	831108	
4	NOR 450030 / M4-11-10	830904	
5	NOR 450030 / M4-11-10	830904	
6	NOR 450030 / M4-11-10	830904	
7	NOR 450030 / M4-11-10	830904	
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99	NOR 450030 / M4-11-10	830904	
100	NOR 450030 / M4-11-10	830904	

FOR ENGINEERING PARTS LIST SEE PL 9349086

PART NO 9349086

DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS 1/16, 1/8, 3/16, 1/2, 5/8, 3/4, 7/8, 1 1/8, 1 1/4, 1 3/4, 1 7/8, 2, 2 1/4, 2 1/2, 2 3/4, 3, 3 1/4, 3 1/2, 3 3/4, 4, 4 1/4, 4 1/2, 4 3/4, 5, 5 1/4, 5 1/2, 5 3/4, 6, 6 1/4, 6 1/2, 6 3/4, 7, 7 1/4, 7 1/2, 7 3/4, 8, 8 1/4, 8 1/2, 8 3/4, 9, 9 1/4, 9 1/2, 9 3/4, 10, 10 1/4, 10 1/2, 10 3/4, 11, 11 1/4, 11 1/2, 11 3/4, 12, 12 1/4, 12 1/2, 12 3/4, 13, 13 1/4, 13 1/2, 13 3/4, 14, 14 1/4, 14 1/2, 14 3/4, 15, 15 1/4, 15 1/2, 15 3/4, 16, 16 1/4, 16 1/2, 16 3/4, 17, 17 1/4, 17 1/2, 17 3/4, 18, 18 1/4, 18 1/2, 18 3/4, 19, 19 1/4, 19 1/2, 19 3/4, 20, 20 1/4, 20 1/2, 20 3/4, 21, 21 1/4, 21 1/2, 21 3/4, 22, 22 1/4, 22 1/2, 22 3/4, 23, 23 1/4, 23 1/2, 23 3/4, 24, 24 1/4, 24 1/2, 24 3/4, 25, 25 1/4, 25 1/2, 25 3/4, 26, 26 1/4, 26 1/2, 26 3/4, 27, 27 1/4, 27 1/2, 27 3/4, 28, 28 1/4, 28 1/2, 28 3/4, 29, 29 1/4, 29 1/2, 29 3/4, 30, 30 1/4, 30 1/2, 30 3/4, 31, 31 1/4, 31 1/2, 31 3/4, 32, 32 1/4, 32 1/2, 32 3/4, 33, 33 1/4, 33 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TECHNICAL DATA PACKAGE LIST 8448535
 DOCUMENT NUMBER D 9448535
 SPECIFICATION MIL-W-63150
 NATIONAL STOCK NUMBER
 DRUM, WINDAGE

ARMAMENT RESEARCH DEVELOPMENT & ENGINEERING CENTER
 DOVER, NEW JERSEY 07801-5001
 CAGE 19200

19 NOV 87

SHEET 1 OF 4

REQUEST/PRON 811713

PRODUCT DRAWINGS AND ASSOCIATED DOCUMENTS

CAGE CD	PRE-FIX	DRAWING/DOCUMENT SIZE	NUMBER	SHEET NO - OF	REV SYM	DOCUMENT DATE	SEC CL	DOCUMENT TITLE	NOTE
19204	D	8448535		1	1	D	02/06/85	LMTD DRUM, WINDAGE	
19204	PS	8448535		1	1	C	06/11/80	LMTD PKG DATA SHT - DRUM, WINDAGE	
19204	SQ	8448535		1	3	D	02/06/85	LMTD SQAP - DRUM, WINDAGE	
				2	3	D	02/06/85		
				3	3	D	02/06/85		
				1	1		11/24/86	GEOMETRIC SYMBOLS FOR DIMENSIONING AND TOLERANCING	

TECHNICAL DATA PACKAGE LIST 8448535
 DOCUMENT NUMBER D 8448535
 SPECIFICATION MIL-W-63150
 NATIONAL STOCK NUMBER
 DRUM, WINDAGE

ARMAMENT RESEARCH DEVELOPMENT & ENGINEERING CENTER
 DOVER, NEW JERSEY 07801-5001
 CAGE 19200

19 NOV 87

SHEET 2

REQUEST/PRON 811713

INSPECTION EQUIPMENT DRAWINGS AND ASSOCIATED DOCUMENTS

CAGE PRE- CD	DRAWING/DOCUMENT FIX SIZE	NUMBER	SHEET NO - OF	REV SYM	DOCUMENT DATE	SEC CL	DOCUMENT TITLE	NOTE
19204	D 8443613	1	1	B	12/21/73		GAGE, LOCATION	
19204	D 8443856	1	1	B	12/21/73		GAGE, LOCATION	
19204	EL 8448535	1	1		02/05/75	LMTD	IEL - DRUM, WINDAGE	

TECHNICAL DATA PACKAGE LIST 8448535
DOCUMENT NUMBER D 8448535
SPECIFICATION MIL-W-63150
NATIONAL STOCK NUMBER
DRUM, WINCAGE

ARMAMENT RESEARCH DEVELOPMENT & ENGINEERING CENTER
DOVER, NEW JERSEY 07801-5001
CAGE 19200

19 NOV 87

SHEET 3

REQUEST/PRON 811713

SPECIFICATIONS AND STANDARDS

QPL	DOCUMENT NUMBER	REV AND SYM NO	INT CHG NO	DOCUMENT DATE	SEC CL	DOCUMENT TITLE	NOTE
Q	VV-L-800	C 1		09/15/86		LUBRICATING OIL, GENL PURPOSE PRESERVATIVE	*
	PPP-B-636	J 1		01/20/82		BOX, SHIPPING, FIREBOARD	*
	PPP-T-76	C		08/02/84		TAPE, PRESSURE-SENS ADH PAPER, WATER RES	*
	FED-STD-791	C		09/30/86		LUBRICANTS, LIQUID FUELS, REL PROD, MTHD OF TSTG	*
	MIL-P-116	H 1		04/11/85		METHOD OF PACK PRESERVATION	*
	MIL-P-117	E 1		07/15/75		BAG, SLEEVE & TUBING, INTERIOR PACKAGING	*
	MIL-P-3420	E 2		02/20/85		PACKAGING MATERIALS, VOLATILE CRSN INHIBITOR, TREATED	*
	MIL-G-10944	B 3		02/19/82		GAGES, DIMENSIONAL CONTROL	*
	MIL-W-13855	D	4	10/09/84		WEAPONS, SMALL ARMS AND AIRCRAFT ARMAMENT SYS, GEN SPEC	*
	MIL-P-14232	E 2		09/02/81		PARTS, EQUIPMENT AND TOOLS FOR ARMY MATERIAL, PKG OF	*
Q	DOD-P-16232	F		11/07/78		PHOSPHATE COATINGS, HEAVY, MANGANESE OR ZINC BASE	*
	MIL-P-16232	(REPLACED BY DOD-P-16232)					*
	MIL-W-63150	1		09/15/81		WEAPONS AND SPRT MATERIEL, STD QA PROV FOR	*
	MIL-STD-105	D	2	03/20/64		SMPLE PROCEDURES & TABLES FOR INSPECTION BY ATTRIBUTES	*
	MIL-STD-129	J	1	11/05/86		MARKING FOR SHIPMENT AND STORAGE	*
	MIL-STD-171	D	3	12/17/85		FINISHING OF METAL AND WOOD SURFACES	*
	MIL-STD-1189	A		09/04/84		STANDARD DEPARTMENT OF DEFENSE BAR CODE SYMBOLOLOGY	*
	ANSI-B46.1			00/00/79		SURFACE TEXTURE	**
	ANSI-B47.1			00/00/81		GAGE BLANKS	**
	CS8	(REPLACED BY ANSI-B47.1)					**
Q	ANSI-Y14.5			00/00/73		DIMENSIONING AND TOLERANCING FOR ENGINEERING DRAWINGS	**
	ASTM-A108			00/00/81		STEEL BARS, CARBON, COLD FINISHED, STD QUAL, SPEC FOR	**
	ASTM-B310			00/00/83		SINTERED CARBON STEEL STRUCTURAL PARTS SPEC FOR	**
	ASTM-C3951			00/00/92		STANDARD PRACTICE FOR COMMERCIAL PACKAGING	**

* - NOT FURNISHED - TO BE OBTAINED FROM C.O. NAVAL PUBLICATIONS AND FORMS CTR.,
5801 Tabor Ave., PHILA., PENNA., 19120, ATTN. CODE 105. IF NOT AVAILABLE,
IMMEDIATELY ADVISE THE PROCURING CONTRACTING OFFICER.

Q - THE LETTER (Q) BEFORE THE SPECIFICATION NUMBER INDICATES THAT A QUALIFIED PRODUCTS
LIST IS REQUIRED. THE NUMBER OF THE QPL IS THE SAME AS THE NUMBER OF THE SPECIFICATION.

** - NOT FURNISHED - COMMERCIAL SPECIFICATIONS AND STANDARDS MAY BE OBTAINED
FROM THE PUBLISHERS. THEY ARE NOT AVAILABLE FROM GOVERNMENT SOURCES.

TECHNICAL DATA PACKAGE 8448535
DOCUMENT NUMBER D8448535
SPECIFICATION MIL-W-63150
NATIONAL STOCK NUMBER
DRUM, WINDAGE

U. S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
DOVER, NEW JERSEY 07801-5001
FSCN 19200

DATE 19 Nov 87
SHEET 4 of 4

REQUEST/PRON 811713

3. ENGINEERING CHANGES AND ADDITIONS:

a. THE FOLLOWING ENGINEERING CHANGE PROPOSAL FORMS A PART OF THIS TECHNICAL DATA PACKAGE:

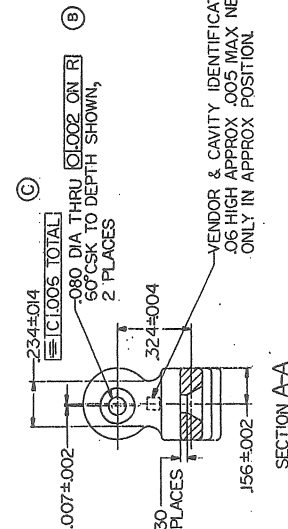
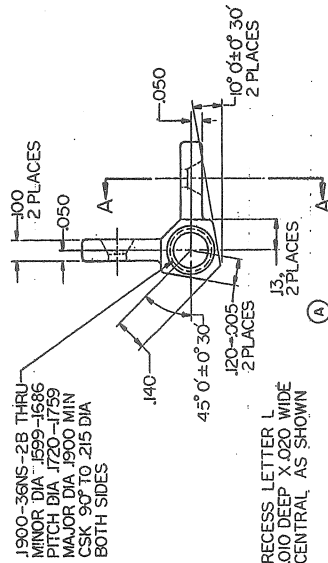
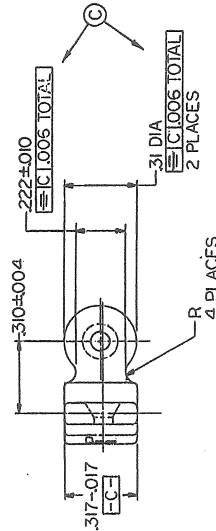
ECP NO	NO OF CARDS
G782043	<u>1</u>

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NOTES:

1. STEEL, INVESTMENT CASTING, CMPSN IC 4130, SPEC MIL-S-22141, EXCEPT THAT SILICON CONTENT SHALL BE .20 TO .70 %.
2. CLASSIFICATION AND INSPECTION OF CASTINGS SHALL BE IN ACCORDANCE WITH CLASS 2, GRADE B, MIL-STD-2175, WITH FINISH $12\sqrt{R}$ EXCEPT AS NOTED.
3. ALL EDGES AND FILLETS ARE .005 TO .020 R.
4. EJECTOR PIN MARKS .005 POSITIVE TO .005 NEGATIVE.
5. PARTING LINE FLASH TO BE .005 MAX.
6. MIL-W-13855 APPLIES. (A)



REV	DATE	DESCRIPTION	APPROVED
1	27 APR 70	REDRAWN FROM COLT'S DRAWINGS	
2	15 OCT 70	D-61700 REV B	
3	25 APR 71	B (1) SEE HQR 10689	
4	6 OCT 72	C (4) SEE ERR HQR 20778	
5	8 OCT 72	D NOR W952009 80-02-15	
6	8 OCT 72	E NOR W952009 85-11-21	

ORIGINAL DESIGN ACTIVITY FROM NO. 19 20 4
CURRENT DESIGN ACTIVITY FROM NO. 19 20 4
U.S. ARMY AIRCRAFT RESEARCH AND DEVELOPMENT CENTER
DAVID, NEW JERSEY 07001

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES		CONTRACT NO.	
MS		ANGLES		DATE	27 APR 1970
TE		TOLERANCES		DESIGNED BY	12-1-70
MAX		3 PLACE DECIMALS ±.005		CHECKED BY	12-1-70
ELC				APPROVED BY	12-1-70
EN				SUBMITTED	12-1-70
BN					
BY					
APPLICATION		5312 OF MIL-STD-171		APPROVED	
NEXT ASSY USED ON		MIL-STD-171		8448539	
MATERIAL		SEE NOTE 1		SHEET 4/1	
RECESS LETTER L		.010 DEEP X .020 WIDE		8448539	
CENTRAL AS SHOWN				8448539	

4

3

2

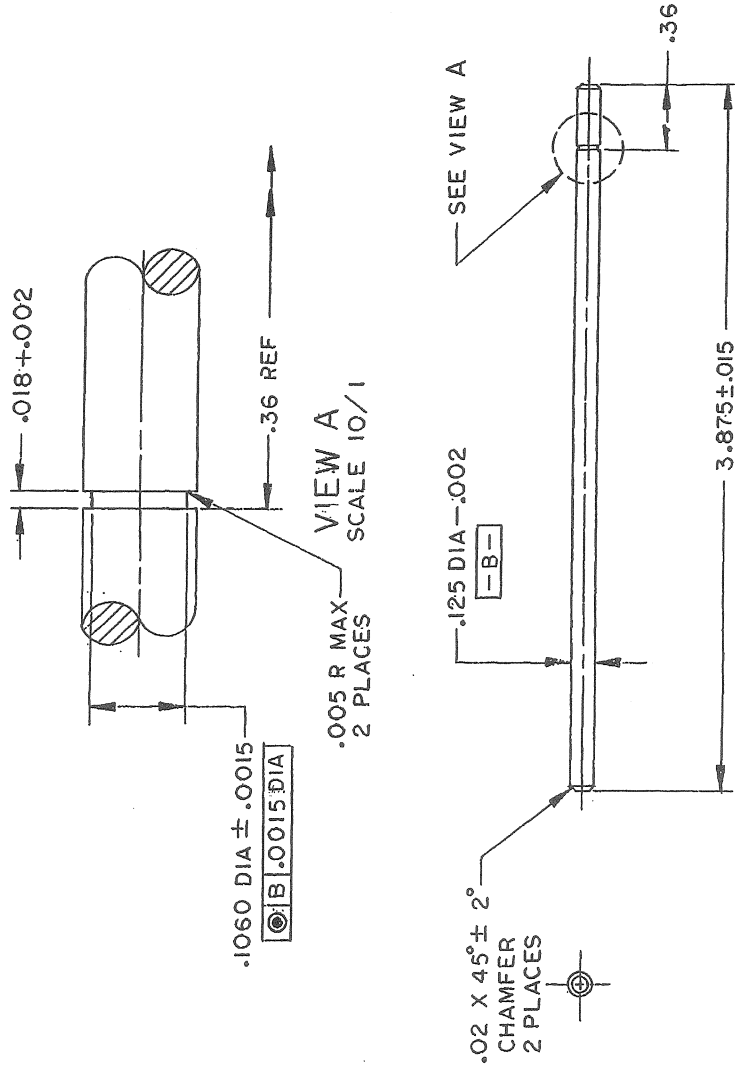
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NOTE:

1. STEEL, COLD FINISHED, AISI 1018, 1112, OR 1215. SPEC ASTM A108.
2. FINISH $\frac{63}{\sqrt{}}$.
3. BREAK SHARP EDGES .003 MAX.
4. MIL-W-13855 APPLIES
5. HEAT TREAT: CARBURIZE .003 TO .008 TOTAL CASE DEPTH, HARDNESS SHALL BE R15N 80-87.

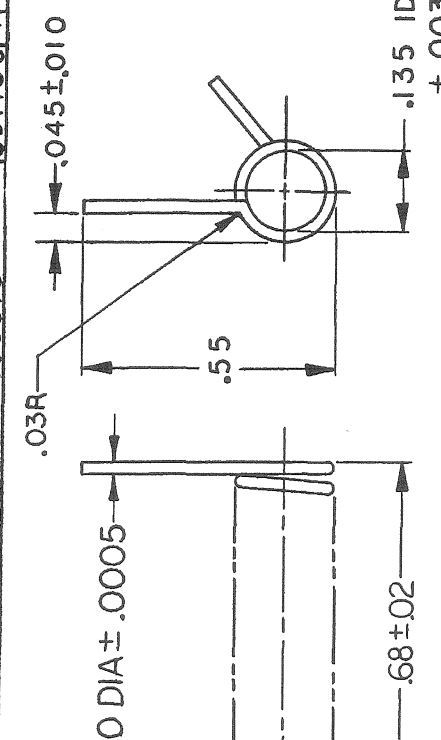


DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQC-AR OR HIGHER DOD AUTHORITY, 92-46-22.

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES		CONTRACT NO.		DEPT. OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS MIN		ANGLES ±		DATE 27 APR 1970			
YS MAX		2 PLACE DECIMALS ±		PREPARED			
EL 2		2 PLACE DECIMALS ±		CHECKED			
RA				ENGINEER			
BH				SUBMITTED			
RH				APPROVED			
APPLICATION		MATERIAL		SIZE		CODE IDENT NO.	
NEXT ASSY USED ON		SEE NOTE 1		C 19204		8448533	
MIL-STD-171		5.3.1.2 OF		SCALE		2/1	
				SHEET		OF 1	

[illegible]

1. WIRE, CORROSION RESISTING, TYPE 631, COLD DRAWN, PER ASTM A313, OR STEEL, CORROSION RESISTING, COMPSN 302, CONDTN B, SPEC. MIL-S-7720, EXCEPT % ELONGATION AND % REDUCTION OF AREA IN TABLE II SHALL NOT APPLY.
2. DIRECTION OF HELIX - LEFT HAND.
3. TOTAL COILS 29 3/4.
4. PRECIPITATION HEAT TREAT TYPE 631 MATERIAL AFTER FORMING. HOLD AT $900^{\circ}\text{F} \pm 10^{\circ}$ FOR ONE HOUR.
5. SPRING SHALL BE FREE FROM BURRS, NICKS, SNAGS AND OTHER INJURIOUS DEFECTS. .07
6. MIL-W-13855 APPLIES.
7. BREAK SHARP EDGES .003 $\pm$.012.



CURRENT DESIGN ACTIVITY CAGE CODE 19200
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

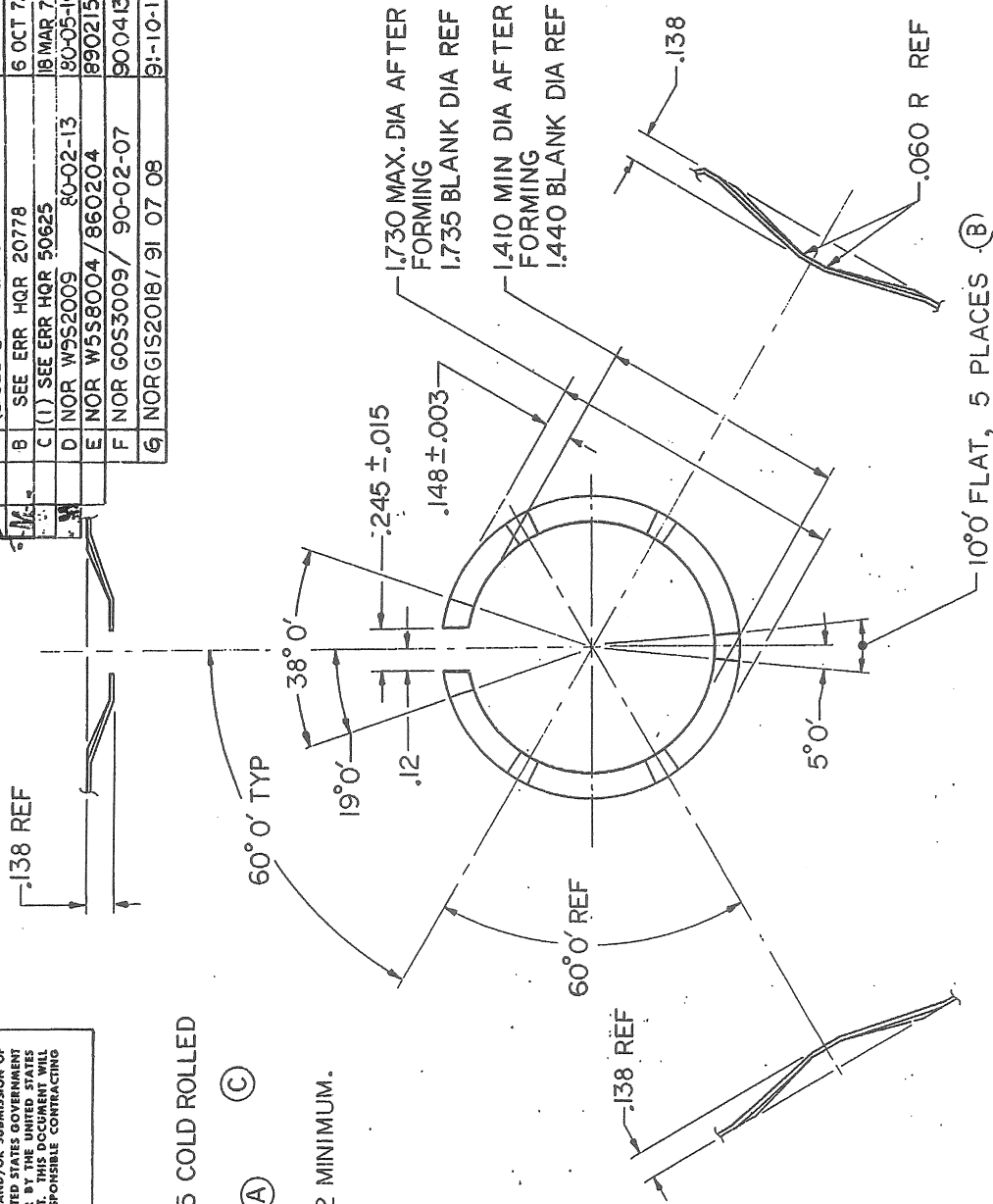
MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS		9390029	M4	ANGLES ±		PREP	DATE 27 APR 1970	SPRING, COVER	
MIN		9349062	M16A2	3 PLACE DECIMALS ±	0.1	CHK	06/6 0.8.8.8		
YS		D9327228	M231	2 PLACE DECIMALS ±	0.1	ENGR	06/6 0.8.8.8		
EL2		D8448602	M16	MATERIAL		SUBMITTED	06/6 0.8.8.8		
RA		D8448523	M16A1	SEE NOTE 1		APPROVED	F.P. Allwoy	SIZE CODE IDENT NO DRAWING NO B 19204 8448532	
BH				FINAL PROTECTIVE FINISH				SCALE 5/1	
RH	15N 84.5 MIN	APPLICATION		3.3.4 OF MIL-STD-171				SHEET OF	

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NOTE:

1. STEEL, ASTM A684, 1075 COLD ROLLED STRIP ANNEALED. MATERIAL THICKNESS .020 ± .001. (A)
2. FINISH 125/. (A)
3. DEBURR AND BREAK EDGES TO .002 MINIMUM.
4. BEND RADIUS .06.
5. MIL-W-13855 APPLIES. (A)



MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING D61961 REV A	27 APR 70	
		A	(2) SEE ERR HQR 10726	26 MAY 71	X B
		B	SEE ERR HQR 20778	6 OCT 72	X C
		C	(1) SEE ERR HQR 50625	18 MAR 75	X B
		D	NOR W5S2009 80-02-13	90-05-16	(P2 R2) W
		E	NOR W5S8004 / 860204	890215	04-27-88 W
		F	NOR GOS3009 / 90-02-07	900413	
		G	NORGIS2018 / 91 07 08	91-10-11	R L

MECHANICAL PROPERTIES YS MIN YS MAX EL2 RA BH RH		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE IN INCHES 3 PLACES DECIMALS ±.005 2 PLACES DECIMALS ±.01 MATERIAL SEE NOTE 1		CONTRACT NO. DATE 27 APR 1970 PREPARED P. R. G. J. M. CHECKED P. R. G. J. M. ENGINEER P. R. G. J. M. SUBMITTED P. R. G. J. M. APPROVED P. R. G. J. M.		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS 61201 SPRING SECTION, HAND GUARD SLIP RING	
C8448555 M4 C8448555 M231 C8448555 M16 M16A2 C8448555 M16A1		APPLICATION NEXT ASSY USED ON		SIZE CODE IDENT NO. / DRAWING NO. C 19204 8448556		SCALE 2/1 SHEET 1 OF 1	

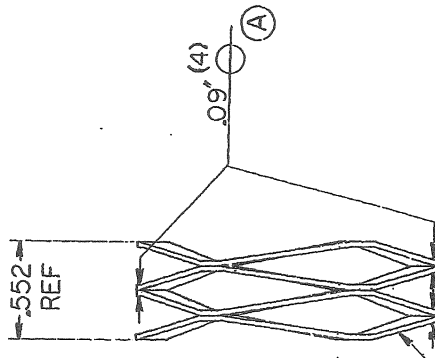
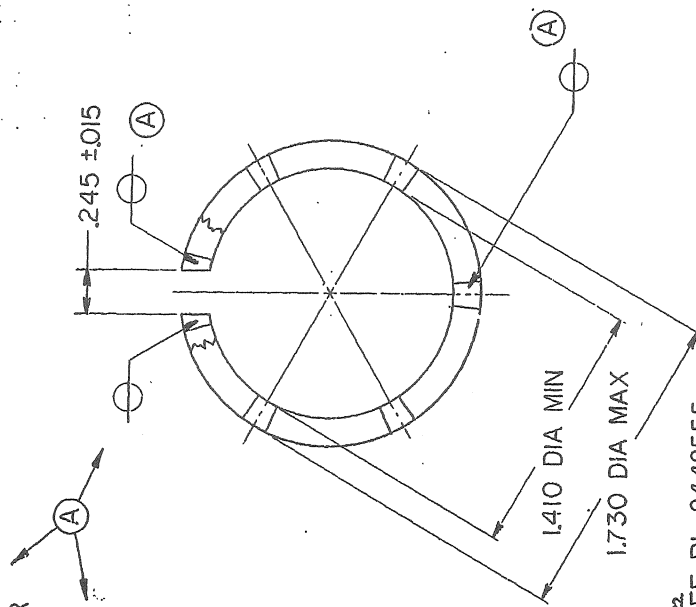
C8448556
 CURRENT DESIGN ACTIVITY CAGE CODE 19200
 U.S. ARMY
 ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
 PICATINNY ARSENAL, NEW JERSEY 07806-5000

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NOTES:

1. FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171, EXCEPT: CLEAN IN ACCORDANCE WITH METHOD II, SPEC TT-C-490. ABRASIVE BLASTING SHALL NOT BE USED.
2. SPOT WELDS MUST HOLD AFTER COMPRESSION TO .215 HEIGHT ON SPRING TESTER.
3. MIL-W-13855 APPLIES.



4-SPRING SECTION,
HAND GUARD SLIP RING-
8448555

DISTRIBUTION STATEMENT B: FURTHER DISTRIBUTION ONLY
AS DIRECTED BY ASQC-AR OR HIGHER DOD AUTHORITY; 92-06-22.

SEE PL-8448555

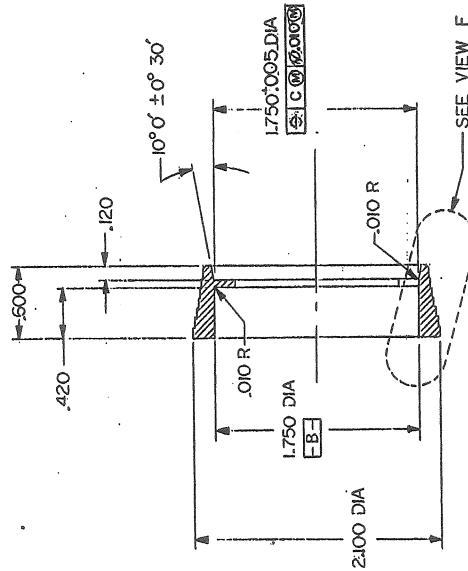
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES: FRACTIONS ± 1/16 DECIMALS ± .005 2 PLACE DECIMALS ± .01		CONTRACT NO.	
YS MIN				DATE 27 APRIL 1970	PREPARED E.C.B. A.S. 8-8-70
YS MAX					CHECKED M.L.G. M. G. 8-8-70
EL 2					ENGINEER M.L.G. M. G. 8-8-70
RA					SUBMITTED F.P. 4-11-70
BH					APPROVED R.P. Hurry
RH	15N				
	82.5-84.5				
APPLICATION		MATERIAL		SIZE CODE IDENT NO. DRAWING NO.	
NEXT ASSY USED ON		MIG-M16A2		C 19204	
		MIG-M16A1		8448555	
				SCALE 2/1	
				SHEET 1 OF 1	

NOTICE: RESTRICTED. AS TO USE AND DISCLOSURE

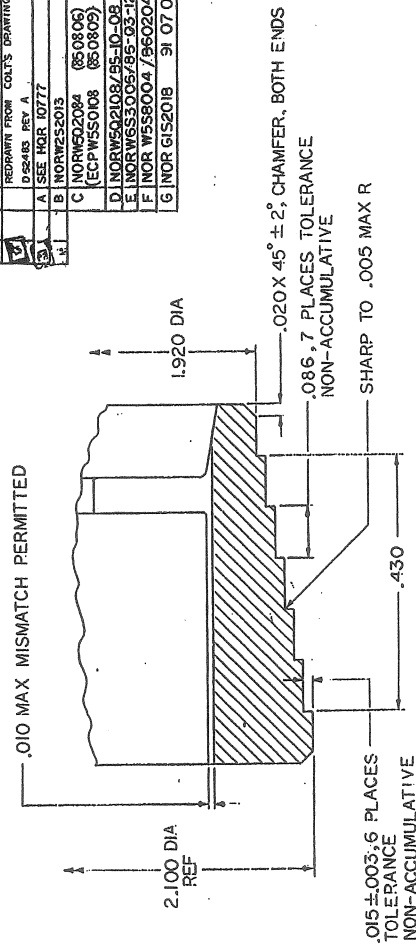
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NOTES:

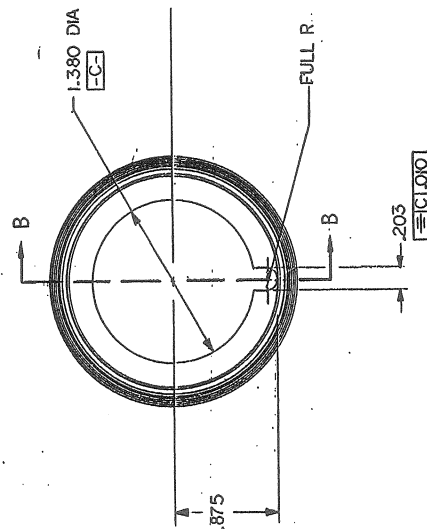
1. FINISH 125% N/A
2. BREAK SHARP EDGES .005 MAX.
3. ALL DIAMETERS ϕ C1.000
4. ALL DIMENSIONS APPLY BEFORE FINISH.
5. GRIT BLAST CONTOURED O.D. PRIOR TO FINISH TO PRODUCE NON REFLECTIVE MATTIE SURFACE AFTER FINISH.
6. FINISH MIL -A-8625, TYPE 3, CLASS 2 FILM THICKNESS .0010 ± .0002 FINISH SHALL BE LUSTERLESS(FLAT) APPROX. BLACK, NO. 37038, TABLE IX BUT NOT LIGHTER THAN GRAY, NO. 36076, TABLE VIII OF FED-STD-595, AND SEAL



SECTION B-B



VIEW F
SCALE 10/1

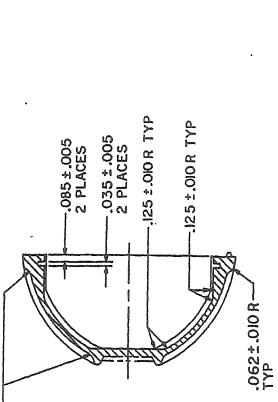


IN	ZONE	LT	REVISIONS	DESCRIPTION	DATE	APPROVED
				REDRAWN FROM COLT'S DRAWING	27 April	
				0.52405 REV A	18 JUN 77	
		A		A SEE NOR 1077	18 JUN 77	SPB
		B		A NOR 25205	18 JUN 77	SPB
		C		C NOR 650204 (85 08 06) (ECPW550008 (85 08 05)	18 JUN 77	SPB
		D		D NOR 652108/45-10-08	18 JUN 77	SPB
		E		E NOR 652305/05-05-12	18 JUN 77	SPB
		F		F NOR 558004 / 796004	18 JUN 77	SPB
		G		G NOR 615208	18 JUN 77	SPB
		H		H NOR 615208	18 JUN 77	SPB

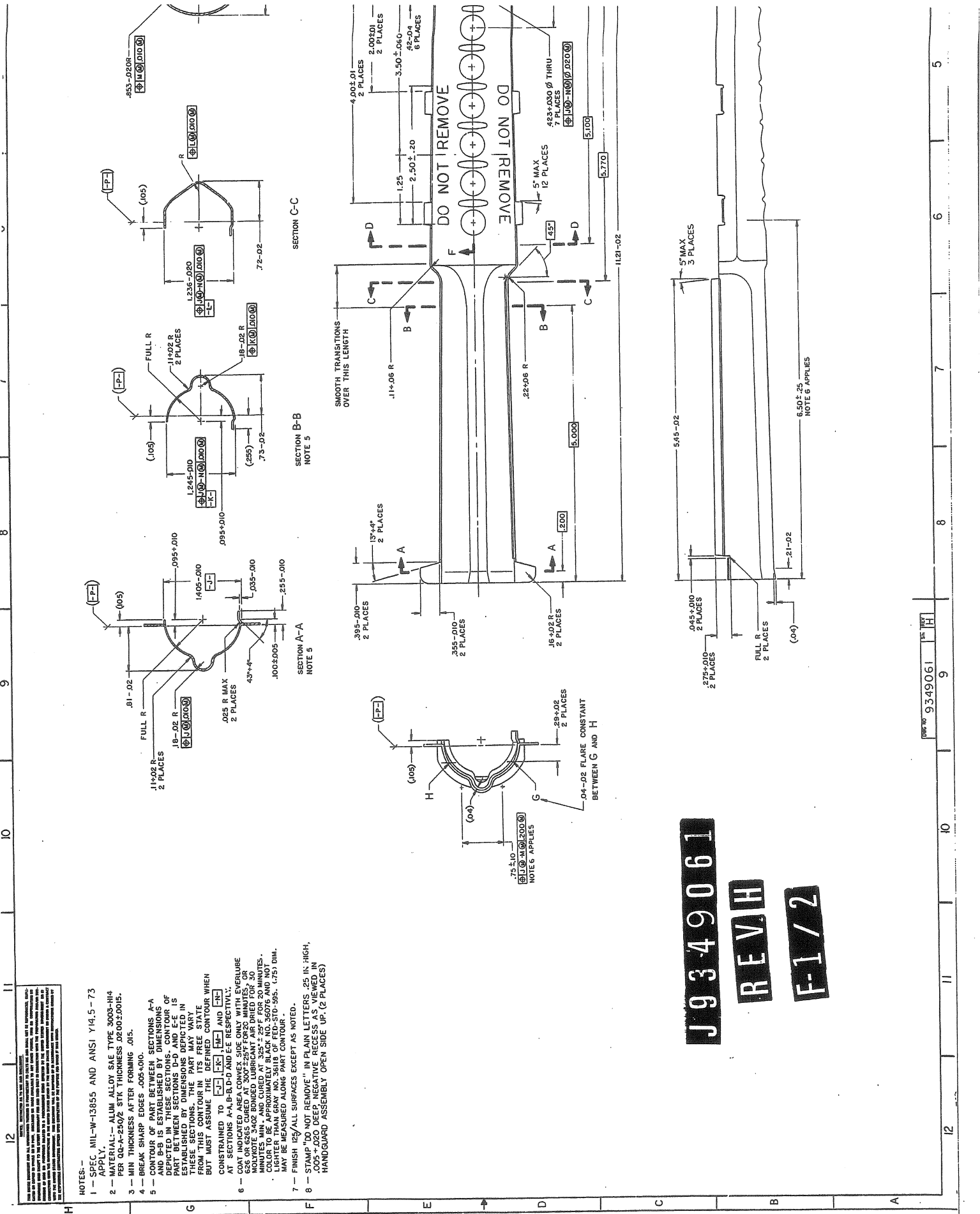
CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

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81



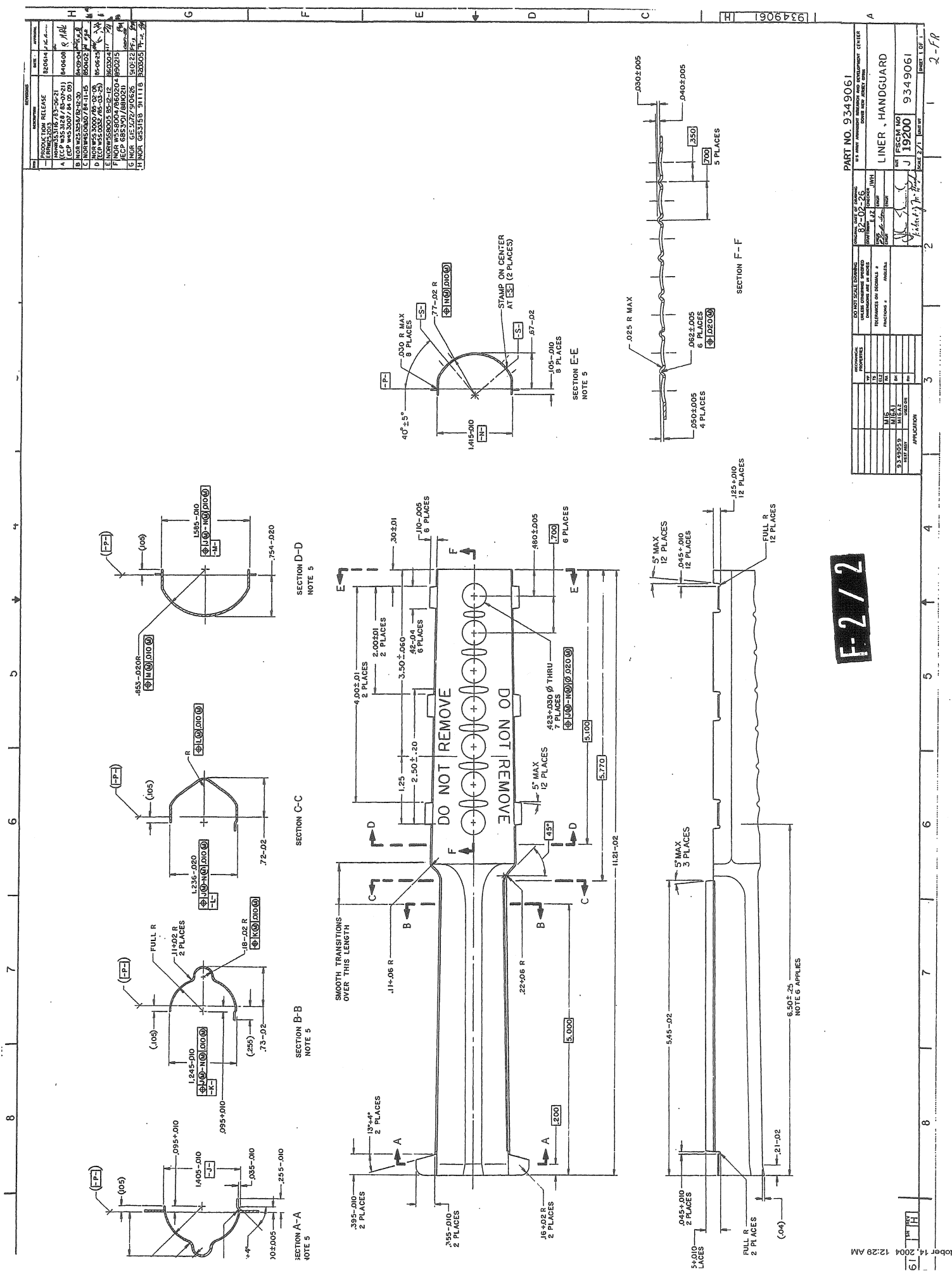
SECTION D-D



- NOTES: -
- 1 - SPEC MIL-W-13855 AND ANSI Y14.5-73 APPLY.
 - 2 - MATERIAL: - ALUM ALLOY SAE TYPE 3003-H14 PER QQ-A-250/2 STK THICKNESS .0005±.0015.
 - 3 - MIN THICKNESS AFTER FORMING .015.
 - 4 - BREAK SHARP EDGES .005±.010.
 - 5 - CONTOUR OF PART BETWEEN SECTIONS A-A AND B-B IS ESTABLISHED BY DIMENSIONS OF PART BETWEEN SECTIONS D-D AND E-E IS ESTABLISHED BY DIMENSIONS DEPICTED IN THESE SECTIONS. THE PART MAY VARY FROM THIS ASSUMED CONTOUR WHEN DIMENSIONS ARE CONstrained TO B-B, D-D AND E-E RESPECTIVELY.
 - 6 - AT DESIGNATED AREA CORNER SIDE ONLY WITH EVERLURE 626 OR 626S CURED AT 300°±25°F FOR 20 MINUTES, OR MOLYNOTE 3402 BONDED LUBRICANT AIR DRIED FOR 30 MINUTES. COLOR TO BE APPROXIMATELY BLACK NO. 36076 AND NOT LIGHTER THAN GRAY NO. 3618 OF FED-STD-595. (.75) DIM. MAY BE MEASURED ALONG PART CONTOUR.
 - 7 - FINISH 125/ALL SURFACES EXCEPT AS NOTED.
 - 8 - STAMP "DO NOT REMOVE" IN PLAIN LETTERS .25 IN. HIGH, .005±.020 DEEP NEGATIVE RECESS AS VIEWED IN HANDGUARD ASSEMBLY OPEN SIDE UP. (2 PLACES)

J9349061
REV. H
F-1/2

9349061



F-212

PART NO. 9349061 LINER, HANDGUARD		FSCM NO J 19200 9349061	
DO NOT SCALE DIMENSIONS DIMENSIONS ARE IN INCHES DIMENSIONS ON ORIGINALS DIMENSIONS ON REVISIONS		DATE 2-71 DRAWN BY CHECKED BY APPROVED BY	
APPLICATION USED ON NOT USED ON		SHEET 1 OF 1 2-FR	

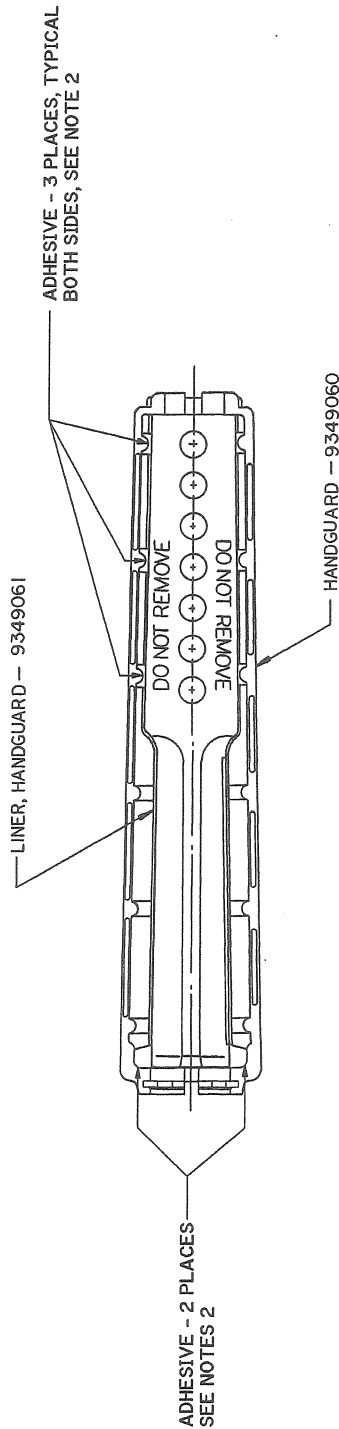
DRAWING SIZE D
CARBIDE - 75-120 8

NOTES: -
1- SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
2- APPLY UNIFORM COATING OF ADHESIVE P/N 12012054 TO
SLOTS BETWEEN HANDGUARD - 9349060 AND LINER,
HANDGUARD - 9349061, 8 PLACES TOTAL.

REV	DESCRIPTION	DATE	APPROVAL
1	PRODUCTION RELEASE	820614	
2	FORGEWORK		
3	NOR W45030 / 84-11-15	850409	
4	NOR W55005 65-12-12	860304	
5	NOR W558004 / 860204	860215	
6	NOR 6552044	960205	
7	NOR 6552044	960311	RLV

NOTES: -

- 1- SPEC. MIL-W-13855 AND ANSI Y14.5-73 APPLY.
- 2- APPLY UNIFORM COATING OF ADHESIVE P/N 12012054 TO
SLOTS BETWEEN HANDGUARD - 9349060 AND LINER,
HANDGUARD - 9349061, 8 PLACES TOTAL.



FOR ENGINEERING PARTS LIST SEE PL 9349059

PART NO. 9349059

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

HANDGUARD ASSEMBLY

SIZE FSCN NO
D 19200 9349059

SCALE 1/1 UNIT WTC
SHEET 1 OF 1

DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING 82-02-26	CHECKER DRAFTSMAN DHB	WH ENGR
DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS: FRACTIONS: ANGLES:			
MECHANICAL PROPERTIES			
VP			
TS			
EL			
HA			
RA			
AP			
MECHANICAL PROPERTIES			
VP			
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MECHANICAL PROPERTIES			
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AP			

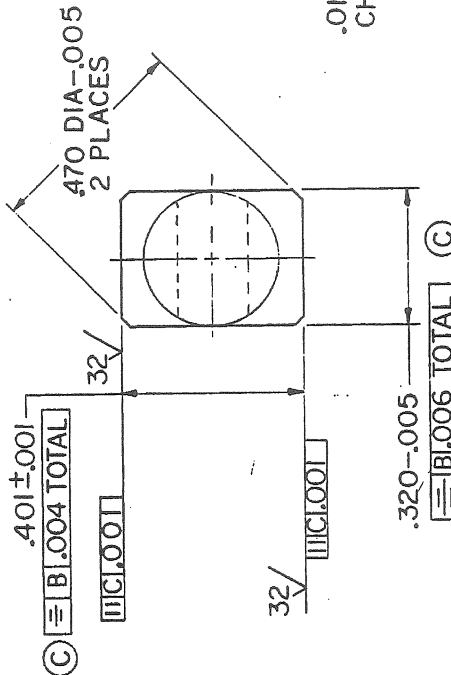
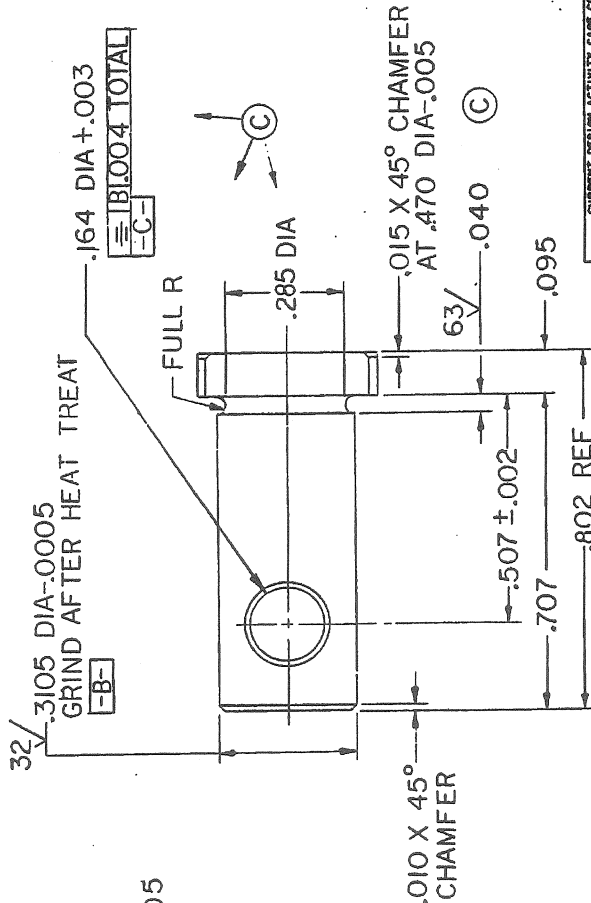
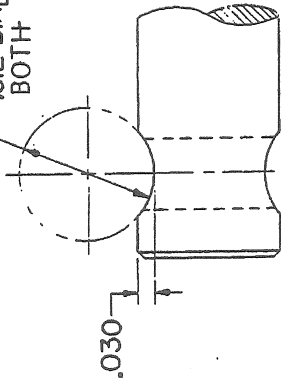
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NOTE:

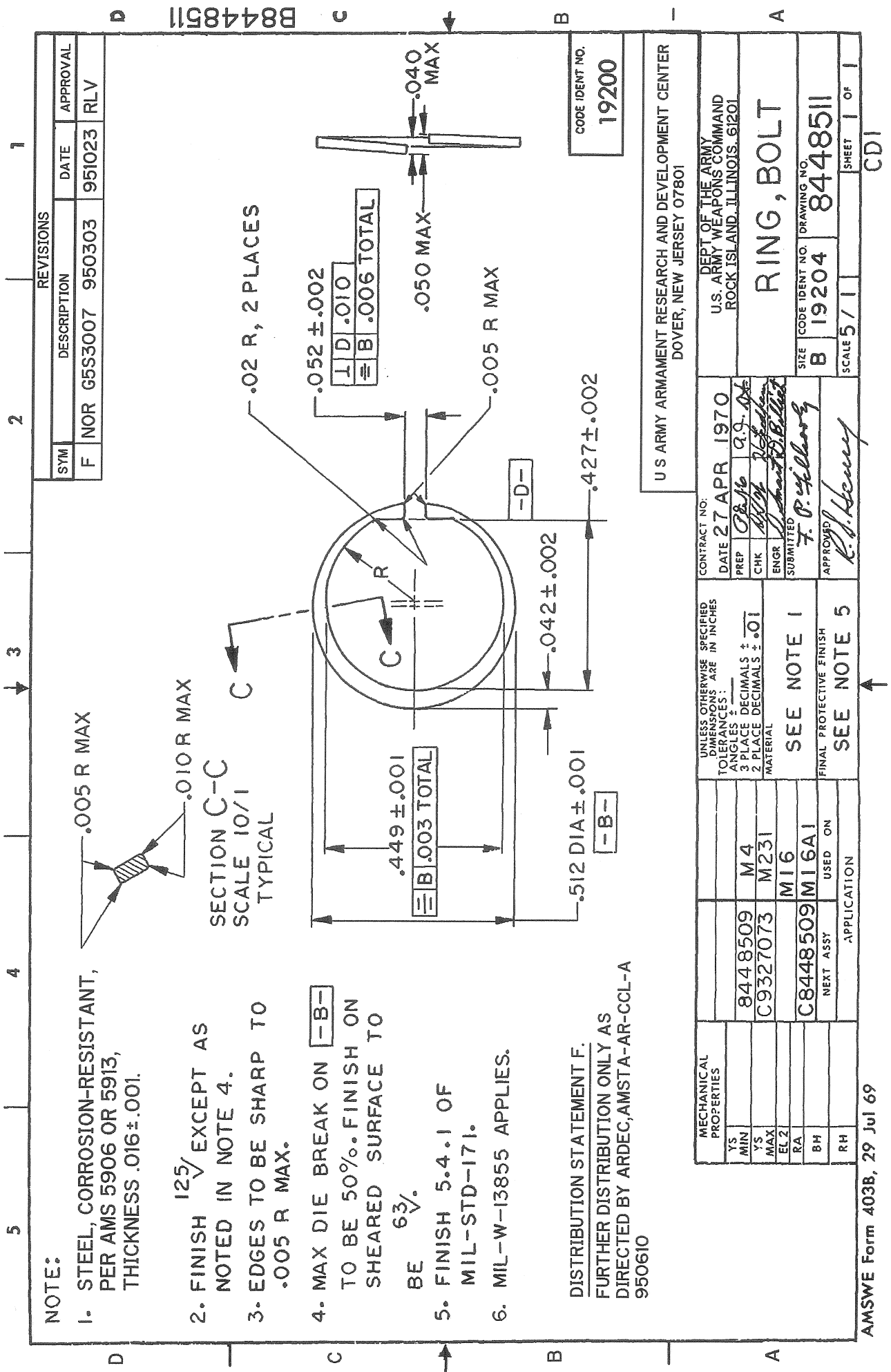
1. FINISH 125/ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005+.005.
3. APPLY DRY FILM LUBRICANT MIL-L-46010.
 FILM THICKNESS .0002-.0004. CURE ONE HOUR AT 375° F.
 OR USE EVERLUBE 626 OR 626S. FILM THICKNESS .0002-.0004. CURE FOR 1 HOUR AT 375° F.
4. SUGGESTED HEAT TREATMENT:
 QUENCH IN OIL FROM 1500°F TO 1550°F. TEMPER AT 625°F TO 675°F FOR ONE HOUR.
5. MIL-W-13855 APPLIES.

BOTH SIDES



CURRENT DESIGN ACTIVITY CASE CODE 19200
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PILGRIM, ARIZONA, NEW JERSEY 07068-5006

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO:		DATE 27 APR 1970		DEPT-OF-THE-ARMY US-ARMY WEAPONS-COMMAND ROCK ISLAND, ILLINOIS, 61201	
YS MIN		TOLERANCES		PREPARED	DATE	CHECKED	DATE	SIZE CODE IDENT NO.	DRAWING NO.
YS MAX		ANGLES		8448501	27 APR 1970	8448501	27 APR 1970	C	19204
EL2		2 PLACE DECIMALS		09327072		09327072			
RA		2 PLACE DECIMALS		08448501		08448501			
PH									
PH	C45-48								
APPLICATION		FINAL PROTECTIVE FINISH		5.3.1.3 OF MIL-STD-171		APPROVED		SCALE 5/1	
						P. C. Yellowing		8448502	
						P. C. Yellowing			



NOTE:

1. STEEL, CORROSION-RESISTANT, PER AMS 5906 OR 5913, THICKNESS .016 ± .001.
2. FINISH $\sqrt[125]{}$ EXCEPT AS NOTED IN NOTE 4.
3. EDGES TO BE SHARP TO .005 R MAX.
4. MAX DIE BREAK ON $\overline{B-}$ TO BE 50% FINISH ON SHEARED SURFACE TO BE $\sqrt[63]{}$.
5. FINISH 5.4.1 OF MIL-STD-171.
6. MIL-W-13855 APPLIES.

DISTRIBUTION STATEMENT F.
FURTHER DISTRIBUTION ONLY AS
DIRECTED BY ARDEC, AMSTA-AR-CCL-A
950610

MECHANICAL PROPERTIES		8448509		M4	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY	
YS	MIN	C9327073		M231	TOLERANCES:		DATE 27 APR 1970		U.S. ARMY WEAPONS COMMAND	
YS	MAX	C8448509		M16A1	ANGLES:		PREP		ROCK ISLAND, ILLINOIS 61201	
EL2		NEXT ASSY			3 PLACE DECIMALS ± .01		CHK			
RA		APPLICATION			2 PLACE DECIMALS ± .01		ENGR		RING, BOLT	
BH					MATERIAL		SUBMITTED		SIZE CODE IDENT NO. DRAWING NO.	
RH					SEE NOTE 1		APPROVED		B 19204 8448511	
					FINAL PROTECTIVE FINISH		F. P. Williams		SCALE 5/1	
					SEE NOTE 5		K. J. Henry		SHEET 1 OF 1	

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

CODE IDENT NO.
19200

AMSWE Form 403B, 29 Jul 69

4

3

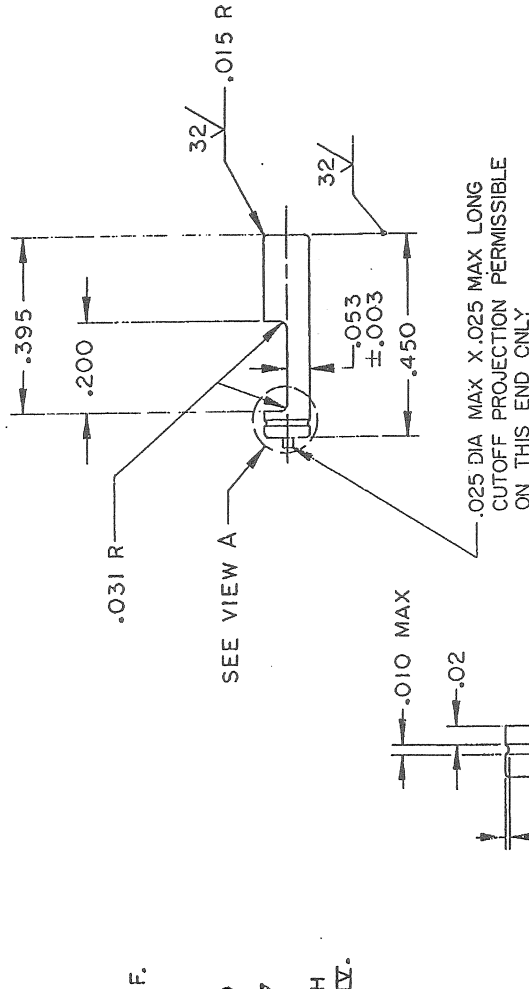
2

1

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- NOTE: 125/ EXCEPT AS NOTED.
1. FINISH 125/ EXCEPT AS NOTED.
 2. BREAK SHARP EDGES .010 R MAX.
 3. OIL QUENCH FROM 1600°F. TEMPER AT 275°F TO 400°F.
 4. AFTER TEMPERING, STEEL SHOT PEEN ALL OVER. S-70 SHOT, .005-.007-A2 ALMEN, 150% COVERAGE.
 5. CLEAN IN ACCORDANCE WITH TT-C-490, METHOD III OR IV. FINISH 5.3.1.2 OF MIL-STD-171.
 6. MIL-W-13855 APPLIES.



VIEW A
SCALE 10/1

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-3000

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		ROCK ISLAND ARSENAL, ROCK ISLAND, ILL 61201	
YS MIN		TOLERANCES:		DATE	27 APR 1970	EJECTOR	
YS MAX		ANGLES		PREPARED	RGH		
EL2		3 PLACE DECIMALS ±.005		CHECKED	HL		
RA		2 PLACE DECIMALS ±.01		ENGINEER	D.S.		
BH		MATERIAL	TOOL STEEL, TYPE S2, ASTM-A681	SUBMITTED	F.P. FILLINOLY		
RM	15N 88.5 -90.5	FINAL PROTECTIVE FINISH	SEE NOTE 5	APPROVED	RS. HENRY		
NEXT ASSY USED ON APPLICATION				SCALE 5/1		SHEET 1 OF 1	

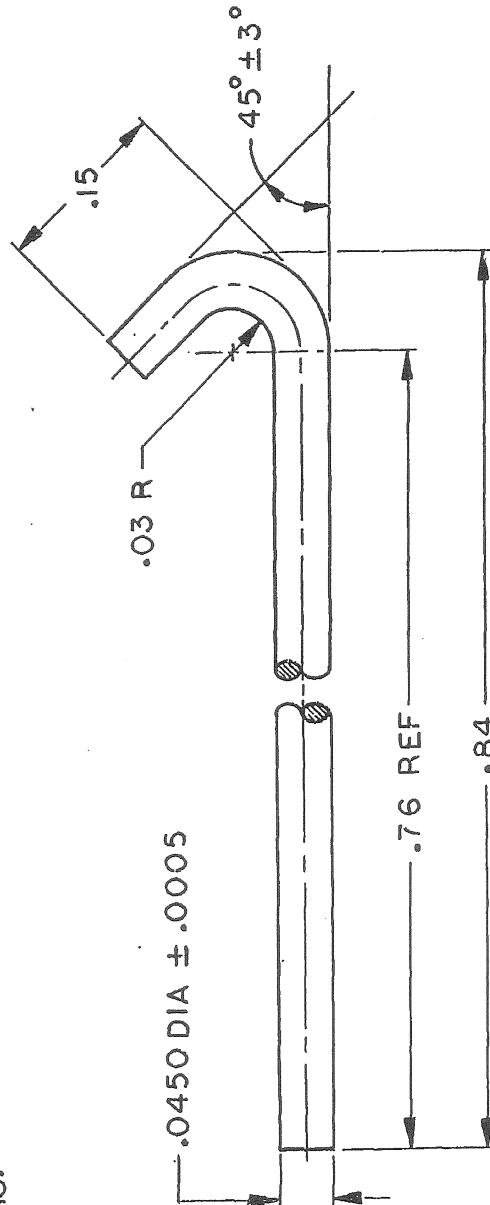
DISTRIBUTION STATEMENT
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ARDEC
SMCRA-25X, ROCK ISLAND IL OR HIGHER DAD AUTHORITY
ASPC-AR 92010

NOTICE RESTRICTED AS TO USE AND DISCLOSURE

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NOTES:

1. WIRE, STAINLESS STEEL, TYPE 631, (17-7PH), COLD DRAWN, ASTM A313.
2. PRECIPITATION HEAT TREAT AFTER FORMING. HOLD AT 900°F ± 10° FOR 1 HOUR. AIR COOL.
3. FINISH 5.4.1 OF MIL-STD-171.
4. MIL-W-13855 APPLIES.

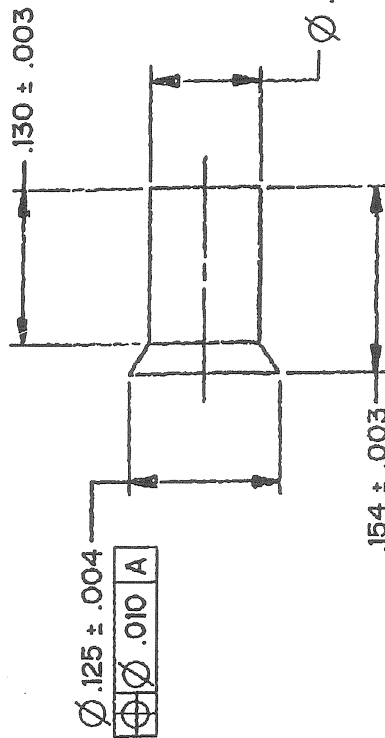


REV	DATE	DESCRIPTION
1	27 APR 70	REDRAWN FROM COLT'S DRAWING
2	15 JUL 70	C61820 REVISION A
3	6 OCT 72	A (1) SEE EO HRD 02197-3
4	83-02-03	B (2) SEE ERR HQR 20778
5	83-09-22	C NORW252015 82-08-20
6	91-10-11	D NORW250026 82-05-21
7		E NOR GIS2018 91 07 03

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DEPT OF THE ARMY	
YS		TOLERANCES:		DATE	27 APR 1970	U.S. ARMY WEAPONS COMMAND	
MIN		ANGLES		PREP	C. H. M.	ROCK ISLAND, ILLINOIS, 61201	
MAX		3 PLACE DECIMALS	± .01	CHK	C. H. M.	RETAINER, HAMMER PIN	
EL2		2 PLACE DECIMALS	± .01	ENGR	C. H. M.	DRAWING NO.	
RA		MATERIAL		SUBMITTED	C. H. M.	B 19204 8448614	
BH		SEE NOTE 1		APPROVED	C. H. M.	SCALE 10/1	
RH	15N 84.5 MIN	FINAL PROTECTIVE FINISH				SHEET 1 OF 1	
		NEXT ASSY				CDI	
		APPLICATION					

NOTES:-

- 1- MATERIAL: CLASS 1, BUNA-N, SHORE HARDNESS 80 ± 5
DUROMETER PER MIL-R-6855, EXCEPT LOW-TEMP.
TEST PER PARA 4.6.4 OF MIL-R-6855 SHALL UTILIZE
MIL-L-46000 OR MIL-L-63460 LUBRICATE IN LIEU OF
TEST FLUIDS TYPE I AND III PER TT-S-735. MUST ALSO
MEET OZONE REQUIREMENT OF CLASS 2, TYPE A.
- 2- ALL CORNERS AND FILLETS TO BE .005 R MAX.
- 3- MIL-W-13855 APPLIES.
- 4- COLOR SHALL BE APPROXIMATELY WHITE, NO. 37722
TO 37925 OF FED-STD-595.



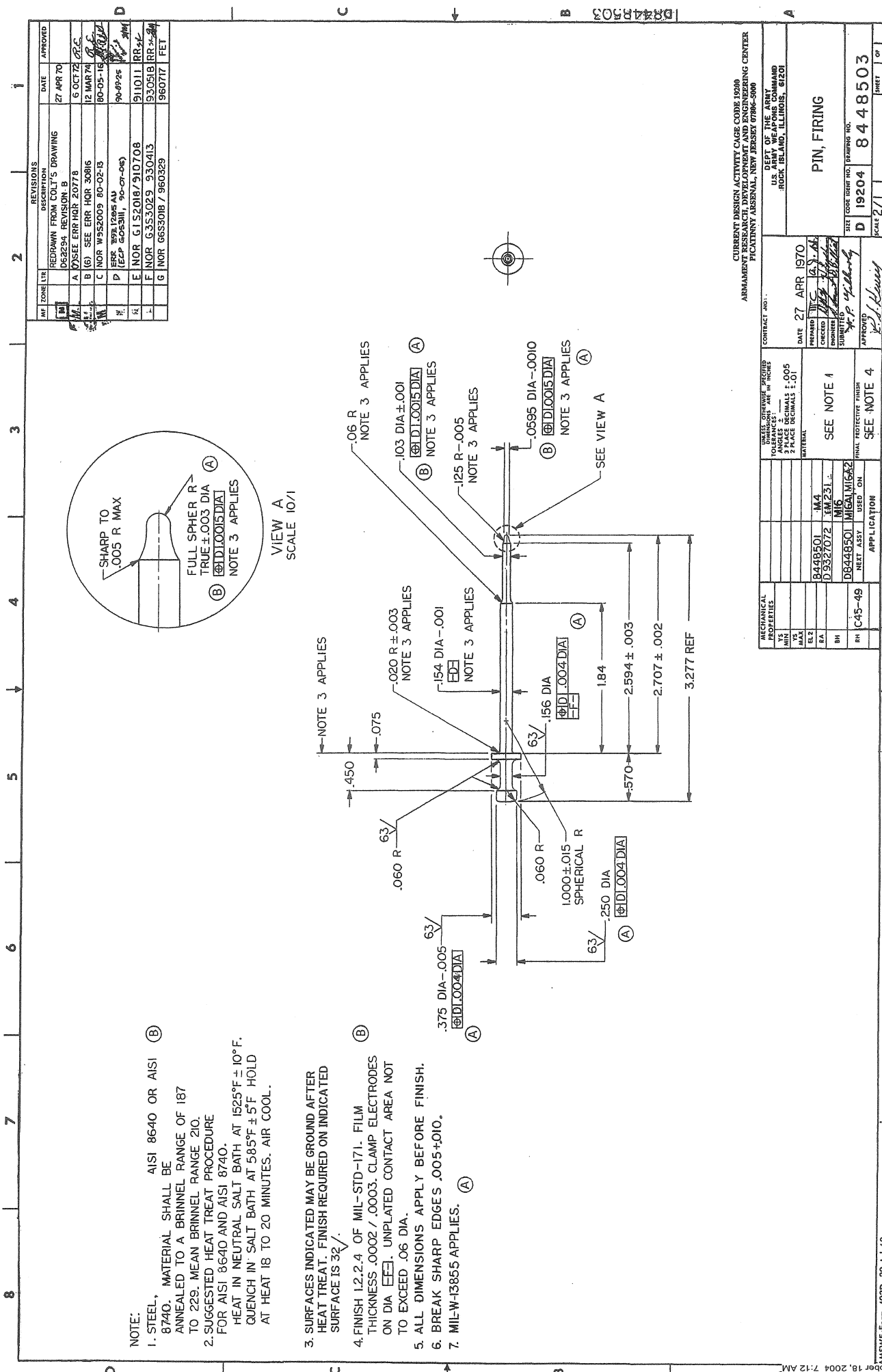
DISTRIBUTION STATEMENT A.
APPROVED FOR PUBLIC RELEASE;
DISTRIBUTION IS UNLIMITED.

PART NO. 12972693

REVISIONS		
ZONE	DESCRIPTION	DATE (YY MM DAY) APPROVED
---	PRODUCT BASELINE ERR G5S3081 (ECP G5S3101 950915)	951211 HJS
A	NOR G6S3117 / 960719 (ECP G6S3011 / 960227)	961204 FET
B	NOR L8S3046/990524	990712 FET
C	NOR L9S3041 000113	000214 RLV

DESIGN ACTIVITY U.S. ARMY ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER PICATINNY ARSENAL, NEW JERSEY 07806-5000	
BUFFER, EXTRACTOR	
SIZE B 19200	CAGE CODE 12972693
SCALE 10/1	UNIT INCHES
SHEET 15	

CONTRACT NUMBER	CONTRACTOR	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMAL FRACTION 2 PL ± 3 PL ±
DRAWN BY HJS	CHECKER 951211	THIRD ANGLE PROJECTION
ENGINEER	DRAWING APPROVAL	MATL ENGR
DESIGN APPROVAL		
12972692	M4	
NEXT ASSY	USED ON	
APPLICATION		

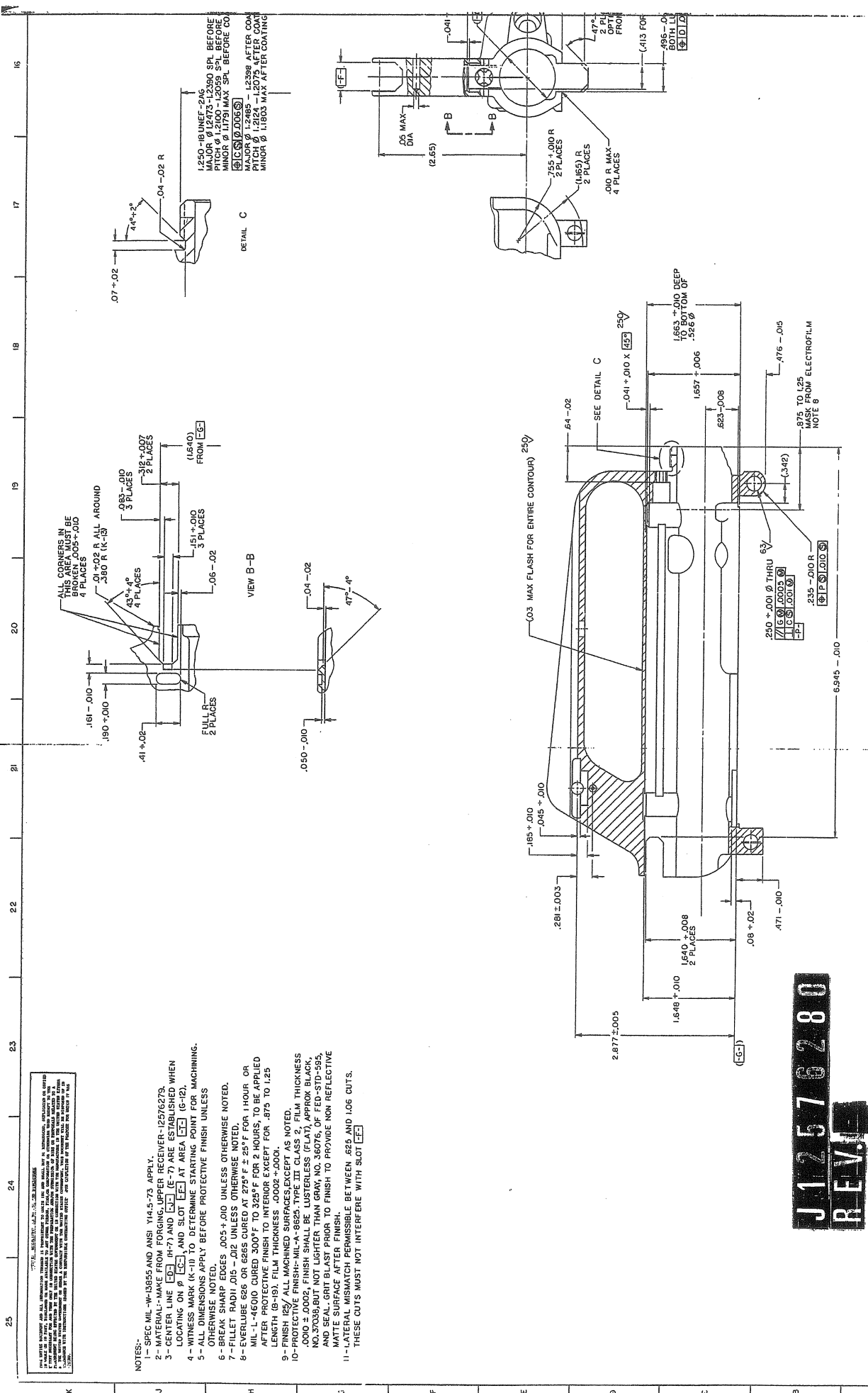


REV	DATE	DESCRIPTION	APPROVED
1	27 APR 70	REDRAWN FROM COLT'S DRAWING D32234 REVISION B	
2	12 MAR 74	(6) SEE ERR HQR 30816	
3	80-05-15	C NOR W552009 80-02-15	
4	90-09-25	D NOR 397812005 AU (ECP 505311, 90-07-06)	
5	911011	E NOR G152018/910706	
6	930518	F NOR G353029 930413	
7	960717	G NOR 0655018 / 960329	

NOTE:
1. STEEL, AISI 8640 OR AISI 8740. MATERIAL SHALL BE ANNEALED TO A BRINELL RANGE OF 187 TO 229. MEAN BRINELL RANGE 210.
2. SUGGESTED HEAT TREAT PROCEDURE FOR AISI 8640 AND AISI 8740.
HEAT IN NEUTRAL SALT BATH AT 1525°F ± 10°F.
QUENCH IN SALT BATH AT 585°F ± 5°F HOLD AT HEAT 18 TO 20 MINUTES. AIR COOL.

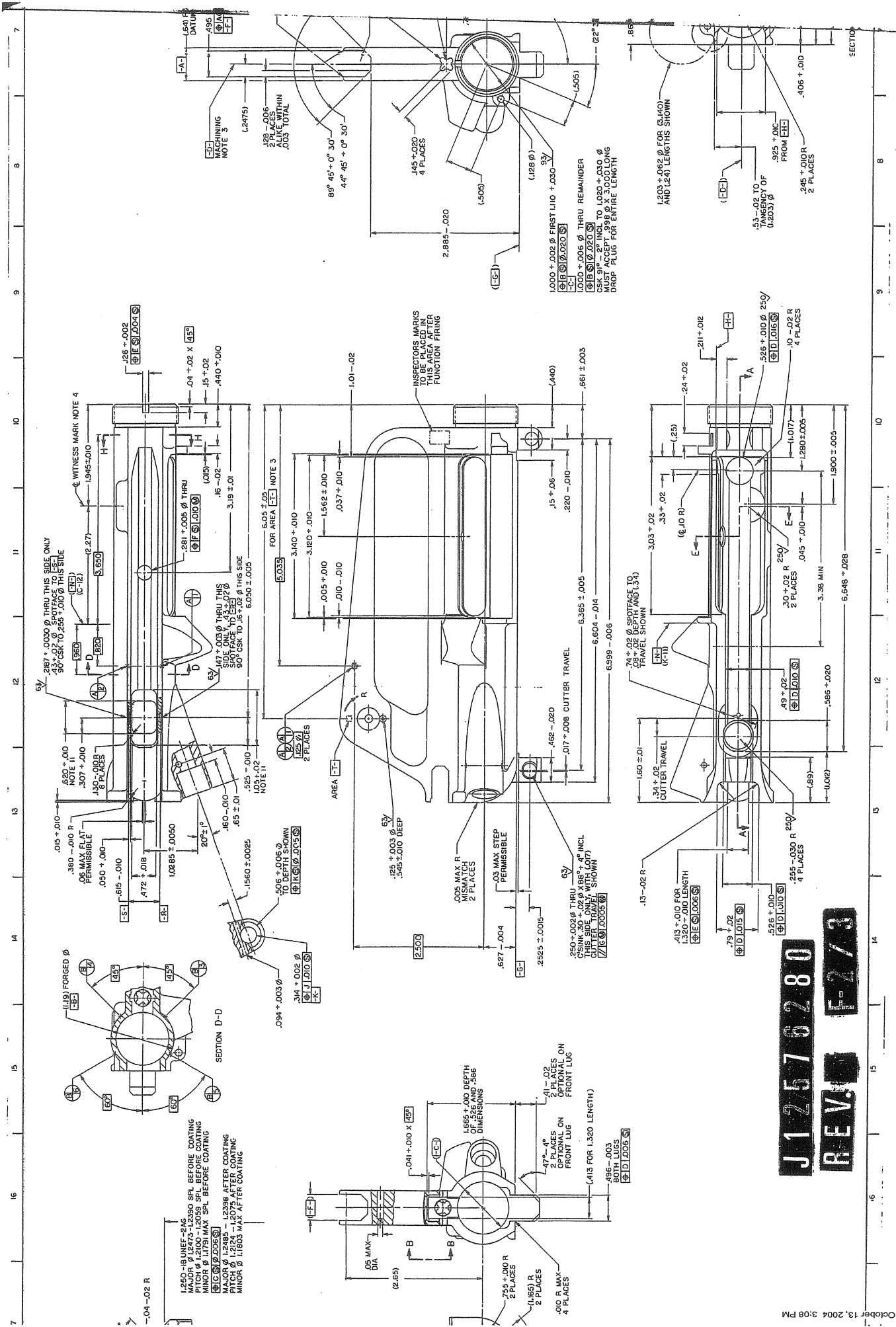
3. SURFACES INDICATED MAY BE GROUND AFTER HEAT TREAT. FINISH REQUIRED ON INDICATED SURFACE IS 32/
4. FINISH 12.2.4 OF MIL-STD-171. FILM THICKNESS .0002 / .0003. CLAMP ELECTRODES ON DIA $\square\square\square$. UNPLATED CONTACT AREA NOT TO EXCEED .06 DIA.
5. ALL DIMENSIONS APPLY BEFORE FINISH.
6. BREAK SHARP EDGES .005±.010.
7. MIL-W-13855 APPLIES. (A)

CURRENT DESIGN ACTIVITY CAGE CODE 19200		ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER PICKETT ARSENAL, NEW JERSEY 07866-5000	
CONTRACT NO.		DATE 27 APR 1970	
REVISIONS		PREPARED BY: [Signature]	
REVISIONS		CHECKED BY: [Signature]	
REVISIONS		ENGINEERED BY: [Signature]	
REVISIONS		SUBMITTED BY: [Signature]	
REVISIONS		APPROVED BY: [Signature]	
REVISIONS		PIN, FIRING	
REVISIONS		TIT: GORE TIGHT HO, DRAWING NO.	
REVISIONS		D 19204 8448503	
REVISIONS		SCALE 2/1	
REVISIONS		SHEET 1 OF 1	



J12576280
REV
F-173

NOTES:
 1- SPEC MIL-W-13655 AND ANSI Y14.5-73, APP. Y
 2- MATERIAL-MAKE FROM FORGING UPPER RECENER-12576273
 3- CENTER LINE [E] (H-7) AND [E] (E-7) ARE ESTABLISHED WHEN LOCATING ON [E] AND SLOT [E] AT AREA [E] (G-2).
 4- WITNESS MARK (K-10) TO DETERMINE STARTING POINT FOR MACHINING.
 5- ALL DIMENSIONS APPLY BEFORE PROTECTIVE FINISH UNLESS OTHERWISE NOTED.
 6- BREAK SHARP EDGES .005 ± .010 UNLESS OTHERWISE NOTED.
 7- FILLET RADI .010 ± .012 UNLESS OTHERWISE NOTED.
 8- EVERLUBE 626 OR 626S CURED AT 275°F ± 25°F FOR 1 HOUR OR MIL-L-4610 CURED 300°F TO 325°F FOR 2 HOURS, TO BE APPLIED AFTER PROTECTIVE FINISH TO INTERIOR EXCEPT FOR .875 TO 1.25 LENGTH .185/ .211 MAXIMUM THICKNESS .0008 ± .0001.
 9- FINISH .185/ .211 MAXIMUM THICKNESS .0008 ± .0001.
 10- PROTECTIVE FINISH- MIL-A-8825 EXCEPT AS NOTED.
 11- LATERAL MISMATCH PERMISSIBLE BETWEEN .625 AND .106 CUTS. THESE CUTS MUST NOT INTERFERE WITH SLOT [E].



J12570280
REV. F-273

[illegible]

PART NO. 12576280

RECEIVER, UPPER

200	12576280
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UNIT NO.	DATE
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STAKE 4 PLACES-STAKE EACH SCREW (2) PLACES SIMULTANEOUSLY, STAKES TO BE 180° ± 5° OPPOSED. DEPTH TO BE SUFFICIENT TO GIVE A REMOVAL TORQUE OF 55 TO 100 IN.LB.

NO DISTORTION PERMISSIBLE ON THESE SURFACES

0.01, 4 PLACES

SEE VIEW B

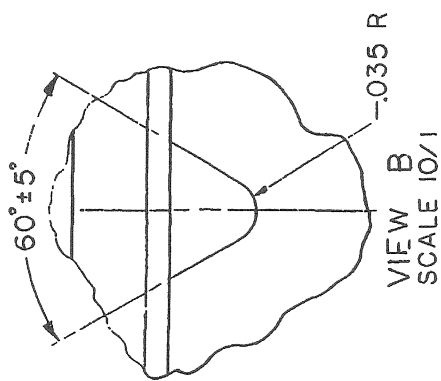
APPLY PERMATX NO.3D AVIATION FORM-A-GASKET (LIQUID) AROUND GAS HOLE ONLY ON BOLT CARRIER PRIOR TO ASSEMBLY. SEE NOTE 2

2-SCREW, CAP, HEX SOCKET HEAD - 8448508 TIGHTENING TORQUE 58 LB IN.-8 LB IN.

0.025 MAX 4 PLACES

CARRIER, BOLT - 8448507

KEY, BOLT CARRIER - 8448506



NOTE:

- 1. MIL-W-13855 APPLIES. (A)
- 2. ALTERNATIVE MATERIAL: MIL-S-45180 TYPE III

DISTRIBUTION STATEMENT E
FURTHER DISSEMINATION ONLY AS DIRECTED BY ARDEC, FMOAR-ESW, 6002
ISLAND, IL ASONG-AR OR GCHQ/EX DND AUTHORITY 520323.

AMSWE Form 403C, 29 Jul 69

MF	ZONE	LTR	DESCRIPTION	DATE	APPROVAL
			REDRAWN FROM COLT'S DRAWING C62286 REVISION C	27 APR 70	
		A	SEE ERR HQR 20778	6 OCT 72	
		B	NOE 12800286	05-02-03	
		C	NOR G1S2018	91-10-11	
		D	NOR G2S2012/320330	3204-9	
		E	NOR G2S3034/920408	920707RV	
		F	NOR G2S3056/92-07-16	92-10-07	
		G	NOR G2S3081/92-09-04	93-01-08	
		H	NOR G3S3007 930305	930402	
		J	NOR G6S3024 960426	961023	

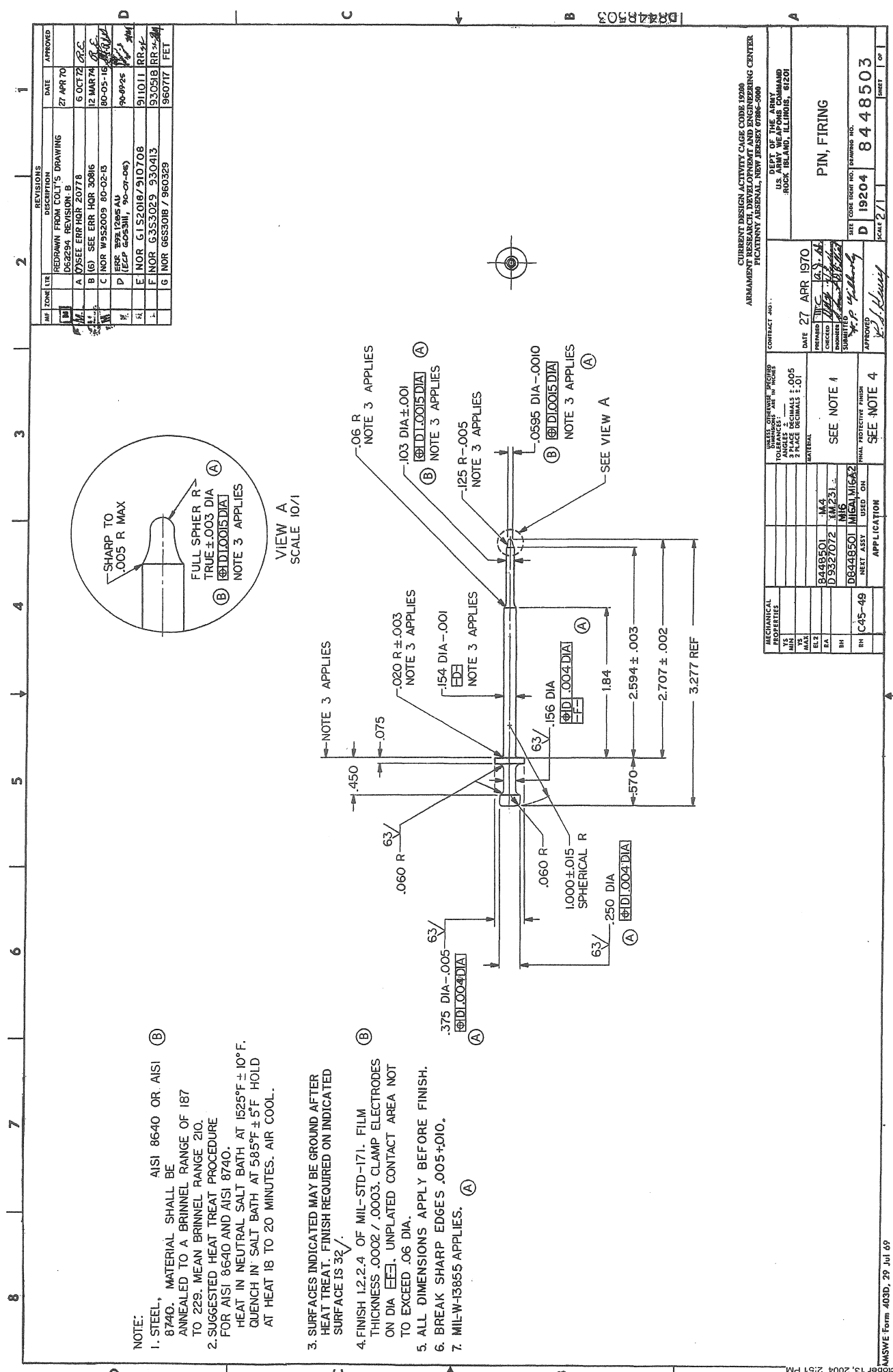
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO	
YS	MIN	TOLERANCES ARE IN INCHES		DATE 27 APR 1970	
YS	MAX	3 PLACE DECIMALS ±.005		PREPARED REB	
EL 2	RA	2 PLACE DECIMALS ±.01		CHECKED	
SH	SH	MATERIAL		ENGINEER	
RH	RH	8448501 M4		SUBMITTED	
APPLICATION		M16		APPROVED	
NEXT ASSY		M16A1		R. J. Henry	
USED ON		D8448501			

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS, 61201

KEY AND BOLT
CARRIER ASSEMBLY

SIZE CODE IDENT NO DRAWING NO
C 19204 8448505

SCALE 2/1



- NOTE:
- 1. STEEL, AISI 8640 OR AISI 8740. MATERIAL SHALL BE ANNEALED TO A BRINELL RANGE OF 187 TO 229. MEAN BRINELL RANGE 210.
 - 2. SUGGESTED HEAT TREAT PROCEDURE FOR AISI 8640 AND AISI 8740.
HEAT IN NEUTRAL SALT BATH AT 1525°F ± 10°F.
QUENCH IN SALT BATH AT 585°F ± 5°F HOLD AT HEAT 18 TO 20 MINUTES. AIR COOL.
 - 3. SURFACES INDICATED MAY BE GROUND AFTER HEAT TREAT. FINISH REQUIRED ON INDICATED SURFACE IS 32.
 - 4. FINISH 12.2.4 OF MIL-STD-171. FILM THICKNESS .0002 / .0003. CLAMP ELECTRODES ON DIA .06 DIA. UNPLATED CONTACT AREA NOT TO EXCEED .06 DIA.
 - 5. ALL DIMENSIONS APPLY BEFORE FINISH.
 - 6. BREAK SHARP EDGES .005 ± .010.
 - 7. MIL-W-13855 APPLIES. (A)

REV	ZONE	DATE	DESCRIPTION	APPROVED
1		27 APR 70	REDRAWN FROM COLT'S DRAWING	
2		6 OCT 72	DS2294 REVISION B	
3		12 MAR 74	A (G) SEE ERR HQR 30816	
4		80-05-16	C NOR W952009 80-02-18	
5		90-09-26	D (ECP 60533M, 90-07-06)	
6		911011	E NOR G152018/910708	
7		930518	F NOR G353029 930413	
8		960717	G NOR G6S3018 / 960329	

CURRENT DESIGN ACTIVITY CLAS CODE 1000
ARMAMENT RESEARCH DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07866-5000

CONTRACT NO. 4030

DATE 27 APR 1970

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

PIN, FIRING

SEE CURR DESG HQR NO. 30816

D 19204 8 4 48503

SCALE 2/1

APPROVED: *[Signature]*

MECHANICAL PROPERTIES	WARRANTY REQUIREMENTS	WARRANTY REQUIREMENTS	WARRANTY REQUIREMENTS
MIN	MIN	MIN	MIN
YS	YS	YS	YS
UTS	UTS	UTS	UTS
RA	RA	RA	RA
SH	SH	SH	SH
EN	EN	EN	EN
C45-49	C45-49	C45-49	C45-49
APPLICATION	APPLICATION	APPLICATION	APPLICATION
SEE NOTE 4	SEE NOTE 4	SEE NOTE 4	SEE NOTE 4

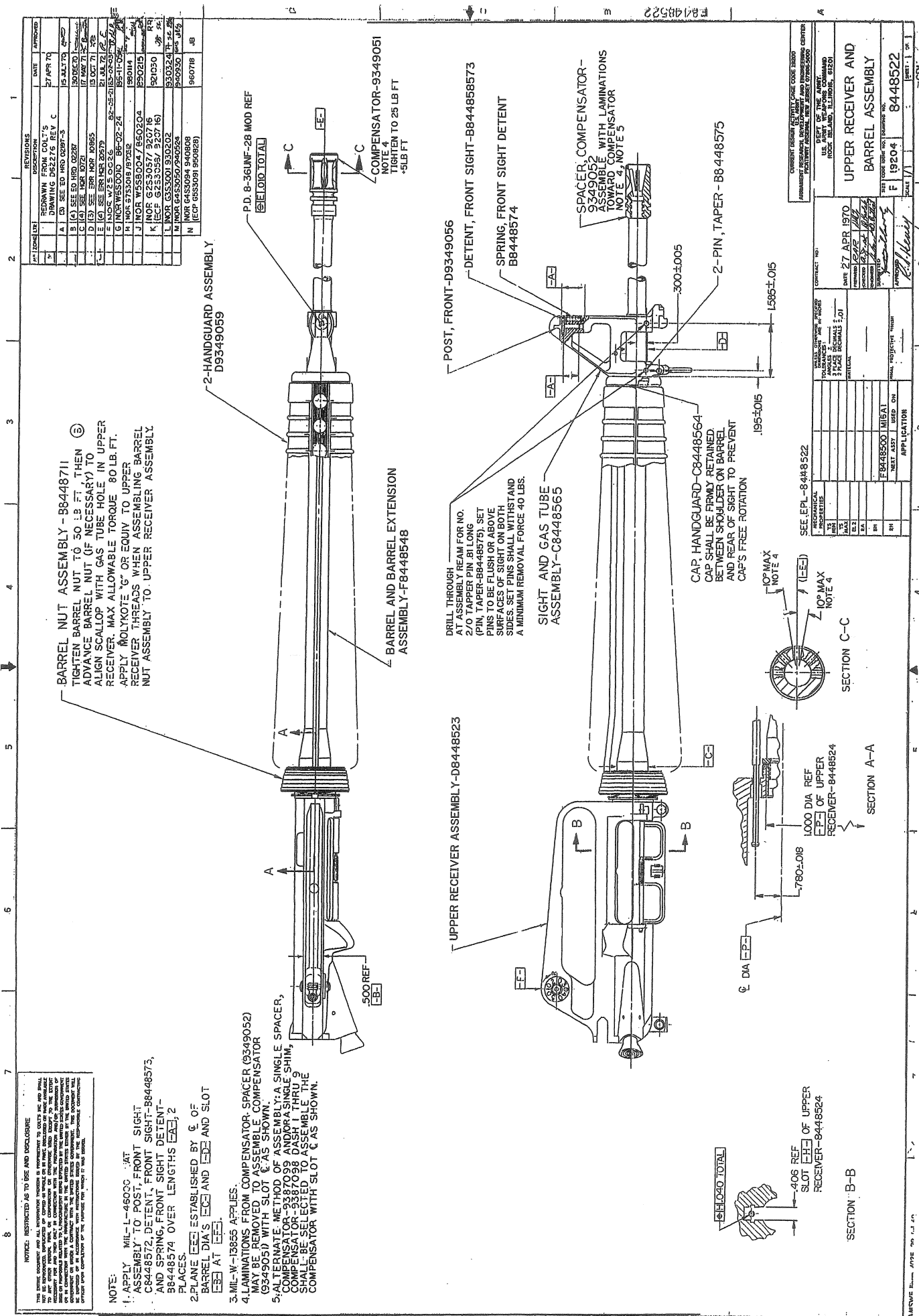
[illegible]

ALICE V. MILLER-1-4503

2. PLANE EE ESTABLISHED BY G OF
BARREL DIA'S CC AND DD AND SLOT
BB AT FF.

4. LAMINATIONS FROM COMPENSATOR. SPACER (9349052) MAY BE REMOVED TO ASSEMBLE COMPENSATOR

5: ALTERNATE METHOD OF ASSEMBLY: A SINGLE SPACER,
(9349051) WITH SLOT C AS SHOWN.



REV	DATE	DESCRIPTION	REVISED	DATE	APPROVED
1	27 APR 70	REDAWN FROM COLT'S DRAWING DE22176 REV C			
2	10 JUL 70	A CD SEE HD 02087-5			
3	30 DEC 70	B (A) SEE HD 02087			
4	17 MAR 71	C (A) SEE HD 0721			
5	10 OCT 71	D (1)3 SEE HD 00955			
6	21 JUL 72	E (A) SEE HD 20679			
7	05 OCT 72	F (A) SEE HD 00766			
8	05 OCT 72	G (A) SEE HD 00766			
9	05 OCT 72	H (A) SEE HD 00766			
10	05 OCT 72	I (A) SEE HD 00766			
11	05 OCT 72	J (A) SEE HD 00766			
12	05 OCT 72	K (A) SEE HD 00766			
13	05 OCT 72	L (A) SEE HD 00766			
14	05 OCT 72	M (A) SEE HD 00766			
15	05 OCT 72	N (A) SEE HD 00766			
16	05 OCT 72	O (A) SEE HD 00766			
17	05 OCT 72	P (A) SEE HD 00766			
18	05 OCT 72	Q (A) SEE HD 00766			
19	05 OCT 72	R (A) SEE HD 00766			
20	05 OCT 72	S (A) SEE HD 00766			
21	05 OCT 72	T (A) SEE HD 00766			
22	05 OCT 72	U (A) SEE HD 00766			
23	05 OCT 72	V (A) SEE HD 00766			
24	05 OCT 72	W (A) SEE HD 00766			
25	05 OCT 72	X (A) SEE HD 00766			
26	05 OCT 72	Y (A) SEE HD 00766			
27	05 OCT 72	Z (A) SEE HD 00766			
28	05 OCT 72	AA (A) SEE HD 00766			
29	05 OCT 72	AB (A) SEE HD 00766			
30	05 OCT 72	AC (A) SEE HD 00766			
31	05 OCT 72	AD (A) SEE HD 00766			
32	05 OCT 72	AE (A) SEE HD 00766			
33	05 OCT 72	AF (A) SEE HD 00766			
34	05 OCT 72	AG (A) SEE HD 00766			
35	05 OCT 72	AH (A) SEE HD 00766			
36	05 OCT 72	AI (A) SEE HD 00766			
37	05 OCT 72	AJ (A) SEE HD 00766			
38	05 OCT 72	AK (A) SEE HD 00766			
39	05 OCT 72	AL (A) SEE HD 00766			
40	05 OCT 72	AM (A) SEE HD 00766			
41	05 OCT 72	AN (A) SEE HD 00766			
42	05 OCT 72	AO (A) SEE HD 00766			
43	05 OCT 72	AP (A) SEE HD 00766			
44	05 OCT 72	AQ (A) SEE HD 00766			
45	05 OCT 72	AR (A) SEE HD 00766			
46	05 OCT 72	AS (A) SEE HD 00766			
47	05 OCT 72	AT (A) SEE HD 00766			
48	05 OCT 72	AU (A) SEE HD 00766			
49	05 OCT 72	AV (A) SEE HD 00766			
50	05 OCT 72	AW (A) SEE HD 00766			
51	05 OCT 72	AX (A) SEE HD 00766			
52	05 OCT 72	AY (A) SEE HD 00766			
53	05 OCT 72	AZ (A) SEE HD 00766			
54	05 OCT 72	BA (A) SEE HD 00766			
55	05 OCT 72	BB (A) SEE HD 00766			
56	05 OCT 72	BC (A) SEE HD 00766			
57	05 OCT 72	BD (A) SEE HD 00766			
58	05 OCT 72	BE (A) SEE HD 00766			
59	05 OCT 72	BF (A) SEE HD 00766			
60	05 OCT 72	BG (A) SEE HD 00766			
61	05 OCT 72	BH (A) SEE HD 00766			
62	05 OCT 72	BI (A) SEE HD 00766			
63	05 OCT 72	BJ (A) SEE HD 00766			
64	05 OCT 72	BK (A) SEE HD 00766			
65	05 OCT 72	BL (A) SEE HD 00766			
66	05 OCT 72	BM (A) SEE HD 00766			
67	05 OCT 72	BN (A) SEE HD 00766			
68	05 OCT 72	BO (A) SEE HD 00766			
69	05 OCT 72	BP (A) SEE HD 00766			
70	05 OCT 72	BQ (A) SEE HD 00766			
71	05 OCT 72	BR (A) SEE HD 00766			
72	05 OCT 72	BS (A) SEE HD 00766			
73	05 OCT 72	BT (A) SEE HD 00766			
74	05 OCT 72	BU (A) SEE HD 00766			
75	05 OCT 72	BV (A) SEE HD 00766			
76	05 OCT 72	BW (A) SEE HD 00766			
77	05 OCT 72	BX (A) SEE HD 00766			
78	05 OCT 72	BY (A) SEE HD 00766			
79	05 OCT 72	BZ (A) SEE HD 00766			
80	05 OCT 72	CA (A) SEE HD 00766			
81	05 OCT 72	CB (A) SEE HD 00766			
82	05 OCT 72	CC (A) SEE HD 00766			
83	05 OCT 72	CD (A) SEE HD 00766			
84	05 OCT 72	CE (A) SEE HD 00766			
85	05 OCT 72	CF (A) SEE HD 00766			
86	05 OCT 72	CG (A) SEE HD 00766			
87	05 OCT 72	CH (A) SEE HD 00766			
88	05 OCT 72	CI (A) SEE HD 00766			
89	05 OCT 72	CJ (A) SEE HD 00766			
90	05 OCT 72	CK (A) SEE HD 00766			
91	05 OCT 72	CL (A) SEE HD 00766			
92	05 OCT 72	CM (A) SEE HD 00766			
93	05 OCT 72	CN (A) SEE HD 00766			
94	05 OCT 72	CO (A) SEE HD 00766			
95	05 OCT 72	CP (A) SEE HD 00766			
96	05 OCT 72	CQ (A) SEE HD 00766			
97	05 OCT 72	CR (A) SEE HD 00766			
98	05 OCT 72	CS (A) SEE HD 00766			
99	05 OCT 72	CT (A) SEE HD 00766			
100	05 OCT 72	CU (A) SEE HD 00766			
101	05 OCT 72	CV (A) SEE HD 00766			
102	05 OCT 72	CW (A) SEE HD 00766			
103	05 OCT 72	CX (A) SEE HD 00766			
104	05 OCT 72	CY (A) SEE HD 00766			
105	05 OCT 72	CZ (A) SEE HD 00766			
106	05 OCT 72	DA (A) SEE HD 00766			
107	05 OCT 72	DB (A) SEE HD 00766			
108	05 OCT 72	DC (A) SEE HD 00766			
109	05 OCT 72	DD (A) SEE HD 00766			
110	05 OCT 72	DE (A) SEE HD 00766			
111	05 OCT 72	DF (A) SEE HD 00766			
112	05 OCT 72	DG (A) SEE HD 00766			
113	05 OCT 72	DH (A) SEE HD 00766			
114	05 OCT 72	DI (A) SEE HD 00766			
115	05 OCT 72	DJ (A) SEE HD 00766			
116	05 OCT 72	DK (A) SEE HD 00766			
117	05 OCT 72	DL (A) SEE HD 00766			
118	05 OCT 72	DM (A) SEE HD 00766			
119	05 OCT 72	DN (A) SEE HD 00766			
120	05 OCT 72	DO (A) SEE HD 00766			
121	05 OCT 72	DP (A) SEE HD 00766			
122	05 OCT 72	DQ (A) SEE HD 00766			
123	05 OCT 72	DR (A) SEE HD 00766			
124	05 OCT 72	DS (A) SEE HD 00766			
125	05 OCT 72	DT (A) SEE HD 00766			
126	05 OCT 72	DU (A) SEE HD 00766			
127	05 OCT 72	DV (A) SEE HD 00766			
128	05 OCT 72	DW (A) SEE HD 00766			
129	05 OCT 72	DX (A) SEE HD 00766			
130	05 OCT 72	DY (A) SEE HD 00766			
131	05 OCT 72	DZ (A) SEE HD 00766			
132	05 OCT 72	EA (A) SEE HD 00766			
133	05 OCT 72	EB (A) SEE HD 00766			
134	05 OCT 72	EC (A) SEE HD 00766			
135	05 OCT 72	ED (A) SEE HD 00766			
136	05 OCT 72	EE (A) SEE HD 00766			
137	05 OCT 72	EF (A) SEE HD 00766			
138	05 OCT 72	EG (A) SEE HD 00766			
139	05 OCT 72	EH (A) SEE HD 00766			
140	05 OCT 72	EI (A) SEE HD 00766			
141	05 OCT 72	EJ (A) SEE HD 00766			
142	05 OCT 72	EK (A) SEE HD 00766			
143	05 OCT 72	EL (A) SEE HD 00766			
144	05 OCT 72	EM (A) SEE HD 00766			
145	05 OCT 72	EN (A) SEE HD 00766			
146	05 OCT 72	EO (A) SEE HD 00766			
147	05 OCT 72	EP (A) SEE HD 00766			
148	05 OCT 72	EQ (A) SEE HD 00766			
149	05 OCT 72	ER (A) SEE HD 00766			
150	05 OCT 72	ES (A) SEE HD 00766			
151	05 OCT 72	ET (A) SEE HD 00766			
152	05 OCT 72	EU (A) SEE HD 00766			
153	05 OCT 72	EV (A) SEE HD 00766			
154	05 OCT 72	EW (A) SEE HD 00766			
155	05 OCT 72	EX (A) SEE HD 00766			
156	05 OCT 72	EY (A) SEE HD 00766			
157	05 OCT 72	EZ (A) SEE HD 00766			
158	05 OCT 72	FA (A) SEE HD 00766			
159	05 OCT 72	FB (A) SEE HD 00766			
160	05 OCT 72	FC (A) SEE HD 00766			
161	05 OCT 72	FD (A) SEE HD 00766			
162	05 OCT 72	FE (A) SEE HD 00766			
163	05 OCT 72	FF (A) SEE HD 00766			
164	05 OCT 72	FG (A) SEE HD 00766			
165	05 OCT 72	FH (A) SEE HD 00766			
166	05 OCT 72	FI (A) SEE HD 00766			
167	05 OCT 72	FJ (A) SEE HD 00766			
168	05 OCT 72	FK (A) SEE HD 00766			
169	05 OCT 72	FL (A) SEE HD 00766			
170	05 OCT 72	FM (A) SEE HD 00766			
171	05 OCT 72	FN (A) SEE HD 00766			
172	05 OCT 72	FO (A) SEE HD 00766			
173	05 OCT 72	FP (A) SEE HD 00766			
174	05 OCT 72	FQ (A) SEE HD 00766			
175	05 OCT 72	FR (A) SEE HD 00766			
176	05 OCT 72	FS (A) SEE HD 00766			
177	05 OCT 72	FT (A) SEE HD 00766			
178	05 OCT 72	FU (A) SEE HD 00766			
179	05 OCT 72	FV (A) SEE HD 00766			
180	05 OCT 72	FW (A) SEE HD 00766			
181	05 OCT 72	FX (A) SEE HD 00766			
182	05 OCT 72	FY (A) SEE HD 00766			
183	05 OCT 72	FZ (A) SEE HD 00766			
184	05 OCT 72	GA (A) SEE HD 00766			
185	05 OCT 72	GB (A) SEE HD 00766			
186	05 OCT 72	GC (A) SEE HD 00766			
187	05 OCT 72	GD (A) SEE HD 00766			
188	05 OCT 72	GE (A) SEE HD 00766			
189	05 OCT 72	GF (A) SEE HD 00766			
190	05 OCT 72	GG (A) SEE HD 00766			
191	05 OCT 72	GH (A) SEE HD 00766			
192	05 OCT 72	GI (A) SEE HD 00766			
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194	05 OCT 72	GK (A) SEE HD 00766			
195	05 OCT 72	GL (A) SEE HD 00766			
196	05 OCT 72	GM (A) SEE HD 00766			
197	05 OCT 72	GN (A) SEE HD 00766			
198	05 OCT 72	GO (A) SEE HD 00766			
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200	05 OCT 72	GQ (A) SEE HD 00766			
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202	05 OCT 72	GS (A) SEE HD 00766			
203	05 OCT 72	GT (A) SEE HD 00766			
204	05 OCT 72	GU (A) SEE HD 00766			
205	05 OCT 72	GV (A) SEE HD 00766			
206	05 OCT 72	GW (A) SEE HD 00766			
207	05 OCT 72	GX (A) SEE HD 00766			
208	05 OCT 72	GY (A) SEE HD 00766			
209	05 OCT 72	GZ (A) SEE HD 00766			
210	05 OCT 72	HA (A) SEE HD 00766			
211	05 OCT 72	HB (A) SEE HD 00766			
212	05 OCT 72	HC (A) SEE HD 00766			
213	05 OCT 72	HD (A) SEE HD 00766			
214	05 OCT 72	HE (A) SEE HD 00766			
215	05 OCT 72	HF (A) SEE HD 00766			
216	05 OCT 72	HG (A) SEE HD 00766			
217	05 OCT 72	HH (A) SEE HD 00766			
218	05 OCT 72	HI (A) SEE HD 00766			
219	05 OCT 72	HJ (A) SEE HD 00766			
220	05 OCT 72	HK (A) SEE HD 00766			
221	05 OCT 72	HL (A) SEE HD 00766			
222	05 OCT 72	HM (A) SEE HD 00766			
223	05 OCT 72	HN (A) SEE HD 00766			
224	05 OCT 72	HO (A) SEE HD 00766			
225	05 OCT 72	HP (A) SEE HD 00766			
226	05 OCT 72	HQ (A) SEE HD 00766			
227	05 OCT 72	HR (A) SEE HD 00766			
228	05 OCT 72	HS (A) SEE HD 00766			
229	05 OCT 72	HT (A) SEE HD 00766			
230	05 OCT 72	HU (A) SEE HD 00766			
231	05 OCT 72	HV (A) SEE HD 00766			
232	05 OCT 72	HW (A) SEE HD 00766			
233	05 OCT 72	HX (A) SEE HD 00766			
234	05 OCT 72	HY (A) SEE HD 00766			
235	05 OCT 72	HZ (A) SEE HD 00766			
236	05 OCT 72	IA (A) SEE HD 00766			
237	05 OCT 72	IB (A) SEE HD 00766			
238	05 OCT 72	IC (A) SEE HD 00766			
239	05 OCT 72	ID (A) SEE HD 00766			
240	05 OCT 72	IE (A) SEE HD 00766			

[illegible]

CCF FBI - 8418509

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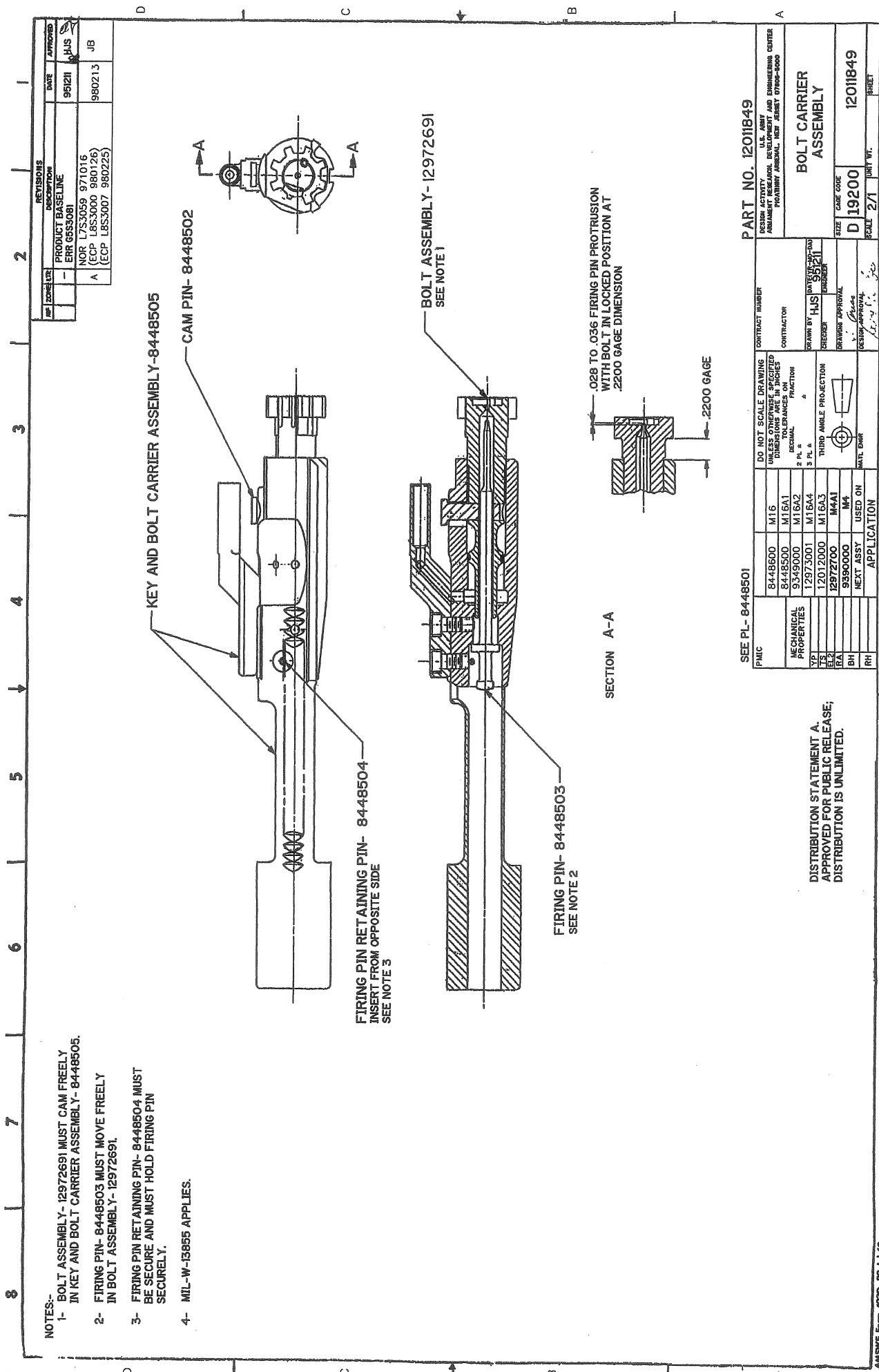
SECTION A-A

[illegible]

RABBIT ASSEMBLY

A. J. St.	W. H. Schick
-----------	--------------

ANSWER: 102E 90 1.1 10



- NOTES:-
- 1- BOLT ASSEMBLY- 12972691 MUST CAM FREELY IN KEY AND BOLT CARRIER ASSEMBLY- 8448505.
 - 2- FIRING PIN- 8448503 MUST MOVE FREELY IN BOLT ASSEMBLY- 12972691.
 - 3- FIRING PIN RETAINING PIN- 8448504 MUST BE SECURE AND MUST HOLD FIRING PIN SECURELY.
 - 4- MIL-W-13855 APPLIES.

REVISIONS		DATE	APPROVED
REV	DESCRIPTION		
1	PRODUCT BASELINE	95121	HJS
2	ERR 6553081		
3	NOR L753059 971015		
4	(ECP L853000 980126)		
5	A (ECP L853007 980225)	980213	JB

SEE PL- 8448501

PART NO. 12011849

DESIGN ACTIVITY: U.S. ARMY AND ENGINEERING CENTER
ADMINISTRATIVE: U.S. ARMY AND ENGINEERING CENTER
PROPERTY: ARMY, NAVY, AIR FORCE, MARINE CORPS

CONTRACT NUMBER: 8448500

CONTRACTOR: M16

DATE: 95121

DESIGNED BY: HJS

DESIGNED: 95121

ENGINEER: HJS

DRIVING APPROVAL: HJS

DESIGN APPROVAL: HJS

SCALE: 2/1

UNIT: IN.

SHEET: 12011849

DO NOT SCALE DRAWING	UNLESS OTHERWISE SPECIFIED	ALL DIMENSIONS ARE IN INCHES
TOLERANCES ON DIMENSIONS	2 PL. 4	3 PL. 4
THIRD ANGLE PROJECTION	M16	M16A1
THIRD ANGLE PROJECTION	M16A1	M16A2
THIRD ANGLE PROJECTION	M16A2	M16A3
THIRD ANGLE PROJECTION	M16A3	M16A4
THIRD ANGLE PROJECTION	M16A4	M16A5
THIRD ANGLE PROJECTION	M16A5	M16A6
THIRD ANGLE PROJECTION	M16A6	M16A7
THIRD ANGLE PROJECTION	M16A7	M16A8
THIRD ANGLE PROJECTION	M16A8	M16A9
THIRD ANGLE PROJECTION	M16A9	M16A10
THIRD ANGLE PROJECTION	M16A10	M16A11
THIRD ANGLE PROJECTION	M16A11	M16A12
THIRD ANGLE PROJECTION	M16A12	M16A13
THIRD ANGLE PROJECTION	M16A13	M16A14
THIRD ANGLE PROJECTION	M16A14	M16A15
THIRD ANGLE PROJECTION	M16A15	M16A16
THIRD ANGLE PROJECTION	M16A16	M16A17
THIRD ANGLE PROJECTION	M16A17	M16A18
THIRD ANGLE PROJECTION	M16A18	M16A19
THIRD ANGLE PROJECTION	M16A19	M16A20
THIRD ANGLE PROJECTION	M16A20	M16A21
THIRD ANGLE PROJECTION	M16A21	M16A22
THIRD ANGLE PROJECTION	M16A22	M16A23
THIRD ANGLE PROJECTION	M16A23	M16A24
THIRD ANGLE PROJECTION	M16A24	M16A25
THIRD ANGLE PROJECTION	M16A25	M16A26
THIRD ANGLE PROJECTION	M16A26	M16A27
THIRD ANGLE PROJECTION	M16A27	M16A28
THIRD ANGLE PROJECTION	M16A28	M16A29
THIRD ANGLE PROJECTION	M16A29	M16A30
THIRD ANGLE PROJECTION	M16A30	M16A31
THIRD ANGLE PROJECTION	M16A31	M16A32
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THIRD ANGLE PROJECTION	M16A69	M16A70
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THIRD ANGLE PROJECTION	M16A71	M16A72
THIRD ANGLE PROJECTION	M16A72	M16A73
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THIRD ANGLE PROJECTION	M16A97	M16A98
THIRD ANGLE PROJECTION	M16A98	M16A99
THIRD ANGLE PROJECTION	M16A99	M16A100

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ARMAMENT RESEARCH, DEVELOPMENT & ENGINEERING CENTER

SHEET NO 1

PICATINNY ARSENAL, NEW JERSEY 07806-5000

PARTS LIST : PL-19204-8448500
DOCUMENT NUMBER : F 19204-8448500
NOMENCLATURE : RIFLE ASSEMBLY M16A1
CHANGE CONTROL NO.: L7S3059

REVISION SYMBOL: E
REVISION DATE : 03/13/98
ORIGINAL DATE : 01/24/86

AUTHENTICATION- *A. Davis*

FIND NUMBER	QTY REQD	CAGE	PART/IDENTIFYING DRAWING		DRAWING SIZE	DRAWING/DOCUMENT		NOMENCLATURE OR DOCUMENT TITLE	SUP LIST
			NUMBER	NUMBER		NUMBER	NUMBER		
0001		19200	12011849		D	12011849		BOLT CARRIER ASSEMBLY	X
0001		19200	12624561		C	12624561		SLING, ADJUSTABLE, SMALL ARMS	X
0001		19204	8448517		B	8448517		CHARGING HANDLE ASSY	X
0001		19204	8448522		F	8448522		UPPER RECEIVER AND BARREL ASSEMBLY	X
0001		19204	8448578		F	8448578		LOWER RECEIVER AND BUTTSTOCK ASSY	X
0001		19204	8448670		D	8448670		MAGAZINE ASSY, 30 ROUND	X

TOTAL PAGES TO PARTS LIST: 1

QTY REQD: AR - AS REQUIRED ALT - ALTERNATE, OPT - OPTIONAL, SO - SELECTION OPTIONAL

[illegible]

1. APPLY MIL-L-46000 AT ASSEMBLY OF
B8448537 DETENT AND B8448538 SPRING.
2. MIL-W-13855 APPLIES. (B)

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34	35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52	53	54	55	56	57	58	59	60	61	62	63	64	65	66	67	68	69	70	71	72	73	74	75	76	77	78	79	80	81	82	83	84	85	86	87	88	89	90	91	92	93	94	95	96	97	98	99	100
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SECTION A-A

[illegible]

WF Form 403D 29 Jul 69

NOTES:

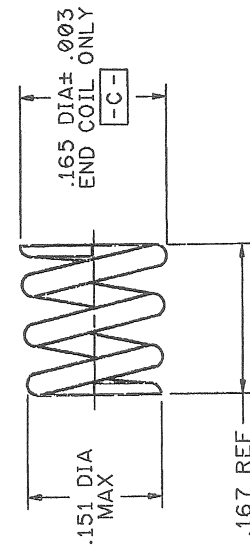
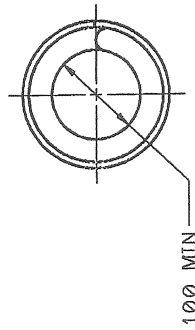
1. WIRE, STEEL, MUSIC SPRING QUALITY PER ASTM-A228 .022 SIZE EXCEPT TENSILE STRENGTH TO BE 363.000 TO 393.000 PSI. STRESS RELIEVE- HOLD AT 450°F ± 25°F FOR 30 MIN.
2. SUGGESTED SOURCE OF SUPPLY:
NATIONAL STANDARD
NILES, MICHIGAN 49120:
MAPES PIANO STRING CO.
ELIZABETHAN, TENN 37644:
JOHNSON WIRE & STEEL
WORCESTER, MASS.
3. MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572.
4. MIL-W-13855 APPLIES.
5. BREAK SHARP EDGES .003 ± .012
6. PRESET- COMPRESS TO SOLID HEIGHT 3 TIMES PRIOR TO CHECKING LOADS.

*7. 3 TIMES PRIOR TO CHECKING LOADS.

SPRING DATA

WIRE DIA	.0220
TOTAL COILS	4 REF
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF .140 IN=	2.0 LB ± 0.2 LB
LOAD AT COMPRESSED LENGTH OF .112 IN=	4.2 LB ± 0.4 LB
ONE END EXPANDED TO DIM.	-C-
TYPE OF ENDS	CLOSED AND GROUND
SOLID LENGTH	.090 MAX

* *



CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

THIS DRAWING HAS BEEN GENERATED
ON A CAD SYSTEM LOCATED AT ARDEC,
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CHANGES MUST BE INCORPORATED
VIA THIS SYSTEM.

PART NO. 8448753

PMIC	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMAL 2 PL ± 3 PL ± .005	CONTRACT NUMBER	DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS 61201
MECHANICAL PROPERTIES	8448755 M4	CONTRACTOR	SPRING, EXTRACTOR
TP	B11828591 M231	DRAWN BY 1. D. KNOX 2. J. TIGER 3. J. PRESS 4. J. BRUNTON	DATE(YR-MO-DA) 71-11-04
TS	B8448755 M16	CHECKER S. PRESS L. BRUNTON	ENGINEER A. A. COLE
EL2		DRAWING APPROVAL	SIZE CODE IDENT NO. C19204
RA			8448753
BH	NEXT ASSY USED ON	DESIGN APPROVAL	SCALE 10/1
RH	APPLICATION	R. S. HENRY	UNIT WT. SHEET

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DOD AUTHORITY:
DATE OF DETERMINATION:

SMCAR FORM 67, 1 DEC 87(TEMP). REPLACES SMCAR FORM 67, 1 MAR 87(TEMP),
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5

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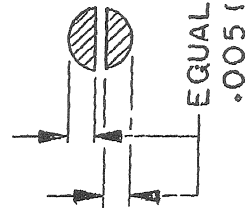
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NOTES

1. FINISH $12\frac{5}{8} \sqrt{}$
2. HEAT TREATMENT: QUENCH AND TEMPER TO HARDNESS (B) SPECIFIED.
3. FINISH 53.12 OF MIL-STD-171.
4. MIL-W-13855 APPLIES.

$$\sqrt[3]{125}$$

SECTION C-C



EQUAL WITHIN
 .005 (TRUE)

REVISIONS

MF ZONE		LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING	27 APR 70	
			C623335 REVISION B		
		A	(2) SEE EO HRD 02197-3	15 JUL 70	JPS
		B	(4) SEE ERR HQR 20778	5 OCT 72	RC
		C	NOR W9S2009 80-02-13	80-05-16	WPS
		D	NOR W2S3258 / 82-12-30	84-09-04	WPS
		E	NOR G1S2018 91-07-08	91-10-11	WPS
		F	NOR G3S2019 / 930701	93-09-01	WPS

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U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER

[illegible]

AMSWE Form 403B, 29 Jul 69

CD₄⁺

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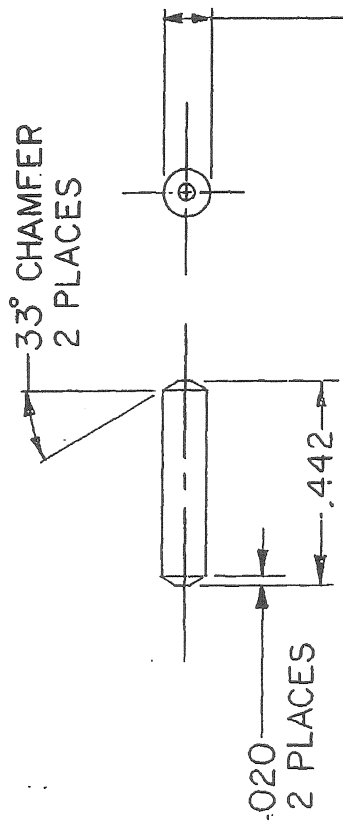
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NOTE:

1. FINISH 125/ EXCEPT AS NOTED.
2. OIL QUENCH FROM 1600°F, TEMPER AT 275°F TO 400°F.
3. AFTER TEMPERING, STEEL SHOT PEEN ALL OVER. S-70 SHOT, .005+0.002-A2 ALMEN, 150% COVERAGE.
4. CLEAN IN ACCORDANCE WITH TT-C-490, METHOD III OR IV. FINISH 5.3.1.2 OF MIL-STD-171.
5. MIL-W-13855 APPLIES.

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ASQNC-AR: 920310.

REVISIONS		DATE		APPROVED	
MF	ZONE	LTR	DESCRIPTION	DATE	APPROVED
			REDRAWN FROM COLT'S DRAWING C61563 REV C	27 APR 70	
		A	(3)SEE ERRHQR 20778	6 OCT 72	RC
		B	NOR W9S2009 80-02-13	80-05-16	RC
		C	ERR Z9Z1251Y (ECP G8S2073/890110	900622	ORF1-COE
		D	NOR G1S2018 91 07 08	91-10-11	RC
		E	NOR G2S3025 920330	920427	RC



.1000 DIA ± .0003
DIAMETER AFTER
FINISH .1001 ± .0010.

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5006

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.		DATE		27 APR 1970		ROCK ISLAND ARSENAL, ROCK ISLAND, ILL 61201	
YS	MIN	8448509	M4	PREP	B.R.S.	A.J.S.	CHK	D.H.W.	H.L.	PIN, EXTRACTOR	
YS	MAX	C9327073	M231	ENGR	D.S.	D.B.	ENGR	D.S.	D.B.	SIZE CODE IDENT NO. DRAWING NO.	
EL 2	RA		M16	TOOL STEEL CLASS S2		ASTM-A681		F.P. GILHOOLY		B 19204 8448513	
RA	BH	C8448509	M16AI	FINAL PROTECTIVE FINISH		SEE NOTE 4		K.S. HENRY		SCALE 4/1 SHEET 1 OF 1	
RH	15N	88.5-90.5	APPLICATION	NEXT ASSY		USED ON		APPROVED			

MIL-W-13855 APPLIES.

INSERT-8448754

INSTALL INSERT INTO EXPANDED END OF SPRING AS SHOWN

SPRING EXTRACTOR-8448753

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

SEE PL 8448755

MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES : ANGLES ± — 3 PLACE DECIMALS ± — 2 PLACE DECIMALS ± — MATERIAL	CONTRACT NO. DA-19-71 DATE 14 NOV 71 PREP <i>T.R. Wilson H. Spickard</i> CHK <i>E. Frazier R. Byrdellows</i> ENGR <i>R. Elbert L. Brunton</i> SUBMITTED <i>D.L. Sode</i> APPROVED <i>R.S. Henney</i>	DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201 SPRING ASSY, EXTRACTOR SIZE CODE IDENT NO. DRAWING NO. B 19204 8448755 SCALE 10/1 SHEET 1 OF 1
YS						
MIN						
YS						
MAX						
EL 2			M 4			
RA			M16			
BH			M16A1			
RH			NEXT ASSY USED ON	FINAL PROTECTIVE FINISH		
			APPLICATION			

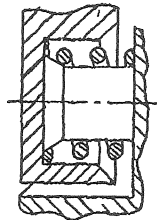
AMSWE Form 403B, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

SCALE 2/11

NOTES:-

1- MIL-W-13855 APPLIES.

VIEW A
SCALE 10/1SPRING ASSY, EXTRACTOR-12972692
FLARED END OF SPRING MUST BE BOTTOMED
IN EXTRACTOR AS SHOWN IN VIEW A.PIN, EXTRACTOR-
8448513

EXTRACTOR-8448512

BOLT- 8448510

EJECTOR-8448515

3- RING, BOLT- 8448511
RING GAPS MUST BE
STAGGERED

PIN, SPRING- MS16562-98

SPRING, EJECTOR AND
SAFETY DETENT- 8448516

PART NO. 12972691

DESIGN ACTIVITY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICA:WY ARSENAL, NEW JERSEY 07806-5000

BOLT ASSEMBLY

SIZE C
CAGE CODE 19200

12972691

SCALE 2/1 PART WT. SHEET

DO NOT SCALE DRAWING
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON
DECIMAL FRACTION2 PL #
3 PL #

THIRD ANGLE PROJECTION

MATERIAL ENGR

MATERIAL ENGR

MATERIAL ENGR

MATERIAL ENGR

MATERIAL ENGR

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PMIC

DISTRIBUTION STATEMENT F:
FURTHER DISTRIBUTION ONLY
AS DIRECTED BY ASQC-AR OR
HIGHER DoD AUTHORITY: 92-06-22.

12011849 M4/M4A1

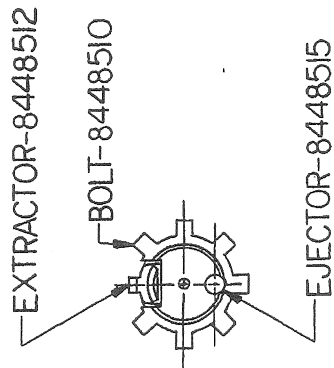
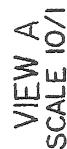
NEXT ASSY USED ON

APPLICATION

SMCAR FORM 67, 1 DEC 87(TEMP). REPLACES SMCAR FORM 67, 1 MAR 87(TEMP),
WHICH MAY BE USED UNTIL EXHAUSTED

THIS ENTIRE DOCUMENT AND ALL INFORMATION THEREON TO COLT'S INC AND SHAW
MAY NOT BE REPRODUCED, DUPLICATED OR COPIED IN WHOLE OR IN PART, DISCLOSED OR MADE AVAILABLE
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NECESSARY FOR AND THEN ONLY IN CONNECTION WITH THE PREPARATION AND/OR SUBMISSION OF
BIDS OR PROPOSALS RELATED TO A PROCUREMENT BEING EFFECTED BY THE UNITED STATES GOVERNMENT
OR IN CONNECTION WITH THE MANUFACTURE IN THE UNITED STATES EITHER BY THE UNITED STATES
OR BY ANOTHER PERSON, FIRM, OR CORPORATION OF A PRODUCT OF THE UNITED STATES GOVERNMENT.
OFFICER UPON COMPLETION OF THE PURPOSE FOR WHICH IT WAS ISSUED.

I. MIL-W-13855 APPLIES.



REVISIONS			DATE	APPROVED
INF	ZONE	LTR	DESCRIPTION	
M		D	REPLACES REV C W/CHANGE SEE COR 102-0678	6 OCT 72 RC
		E	NORW250020 82-06-09	83-02-03 LAH CM
		F	NOR W25 0026 / 82-05-21	83-09-22 WRLA
		G	NOR GIS2018 81-07-08	91-10-11 RSCA
		H	NOR G253059 / 920716 (ECP G253060 / 920630)	92-08-11 AJL SA

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO.:		PART NO. 8448509	
VS		TOLERANCES:		DATE 27 APR 1970	DEPT OF THE ARMY	U.S. ARMY WEAPON AND DEVELOPMENT CENTER	
VS		ANGLES:		PREPARED BY: <i>R. O. Lawrence</i>	US ARMY WEAPON AND DEVELOPMENT CENTER		
VS		2 PLACE DECIMALS:		CHECKED BY: <i>R. O. Lawrence</i>	ROCK ISLAND, ILLINOIS, 61201		
VS		2 PLACE DECIMALS:		ENGINEER: <i>R. O. Lawrence</i>	DOVER, NEW JERSEY 07801		
MAX				SUBMITTED	BOLT ASSEMBLY		
EL 2		MATERIAL		APPROVED	SIZE CODE IDENT NO. DRAWING NO.		
RA				<i>R. O. Lawrence</i>	C 19204 8448509		
BH	8448501	M4			SCALE 2/1		
BH		M16			SHEET OF		
BH	D8448501	M16 AI					
RH		FINAL PROTECTIVE FINISH					
		NEXT ASSY	USED ON				
		APPLICATION					

AMSWE Form 403C, 13 Nov 70

EDITION OF 29 JUL 69 MAY BE USED.

[illegible]

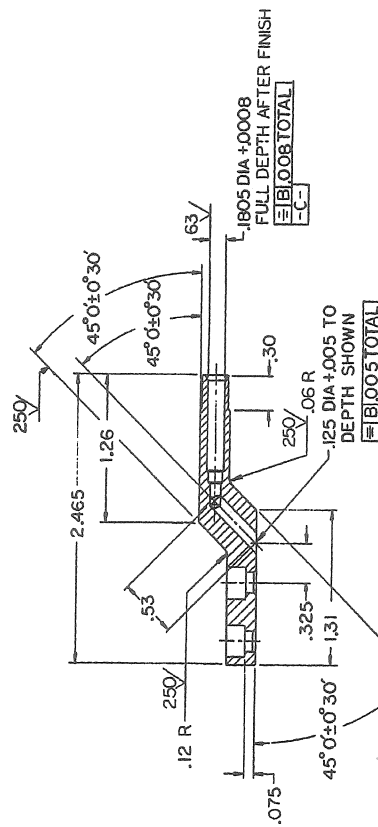
1. FINISH 125/ EXCEPT AS NOTED.
2. SUGGESTED HEAT TREAT PROCEDURE:
OIL QUENCH FROM 1575°F. TEMPER
AT 1100°F FOR 1 HOUR.

3. FINISH 122.2 OF MIL-STD-171 ON DIA
[A] AND [C]. FILM THICKNESS
.0002/.0003.

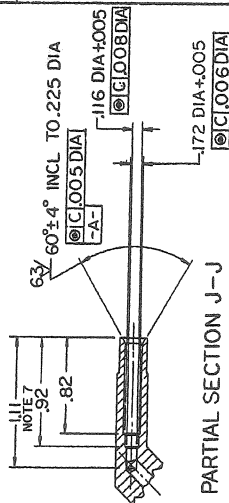
4. ALL OTHER SURFACES TO RECEIVE
FINISH 5.3.1.2 OF MIL-STD-171.

5. BREAK SHARP EDGES .005+.010.
6. MIL-W-13855 APPLIES.

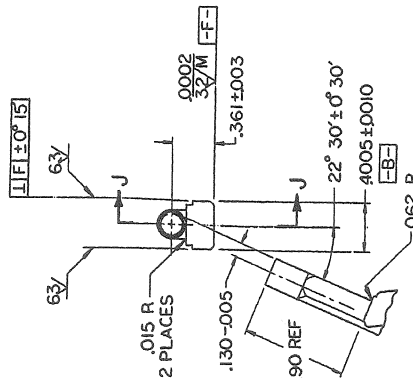
7. FOR GAGING PURPOSED ONLY. THE DEPTH OF PENETRATION OF A .1158 -.0002 GAGE PIN SHALL BE 1.100 MIN TO 1.135 MAX.



SECTION E-E



PARTIAL SECTION J-J



SECTION E-E

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		CONTRACT NO.		U.S. ARMY AMMUNITION RESEARCH AND DEVELOPMENT CENTER BURLINGTON, NEW JERSEY 07001	
TOLERANCES:		3 PLACE DECIMALS		DATE 27 APR 1970		DEPT. OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS 61201	
Y _T	UTS	STEEL AISI 4130	PREPARED BY	DATE	KEY, BOLT CARRIER	SIZE (LOCK DRAWING NO.)	
Y ₁₀	UTS	GUN QUALITY	CHECKED	INSPECTED		D	19204
Y ₂	UTS	MAX BHN 229	INSPECTED	SUPPLEMENTED		8448506	
Y ₃	UTS	MAX BHN 229	APPROVED	APPROVED	APPROVED		SHEET 21 OF
Y ₄	UTS	MAX BHN 229	APPROVED	APPROVED	APPROVED		
Y ₅	UTS	MAX BHN 229	APPROVED	APPROVED	APPROVED		
Y ₆	UTS	MAX BHN 229	APPROVED	APPROVED	APPROVED		
Y ₇	UTS	MAX BHN 229	APPROVED	APPROVED	APPROVED		
Y ₈	UTS	MAX BHN 229	APPROVED	APPROVED	APPROVED		
Y ₉	UTS	MAX BHN 229	APPROVED	APPROVED	APPROVED		
Y ₁₁	UTS	MAX BHN 229	APPROVED	APPROVED	APPROVED		
Y ₁₂	UTS	MAX BHN 229	APPROVED	APPROVED	APPROVED		
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Y ₅₀	UTS	MAX BHN 229	APPROVED	APPROVED	APPROVED		

DOVER, NEW JERSEY 07801
DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

KEY,
BOLT CARRIER

SIZE	CODE IDENT NO.	DRAWING NO.
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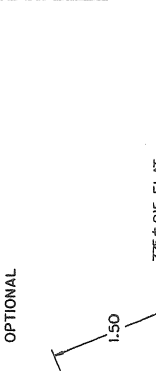
SCALE	2/1				SHEET	OF
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CDI

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REV	DATE	DESCRIPTION	APPROVED
1	27 APR 70	REDRAWN FROM COLT'S DRAWING	
2	27 APR 70	REVISION 1	
3	27 APR 70	REVISION 2	
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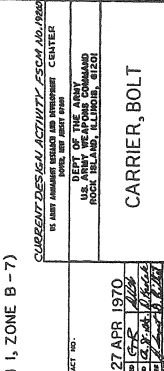
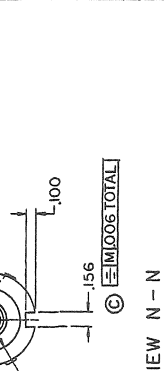
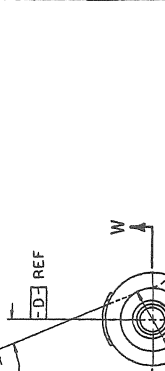
AM	LINE	DISCRIPTION	REVISIONS	DATE	APPROVED
		REDRAWN FROM COLL'S DRAWING		27 APR 70	
		J65274 REV E			
	A	(2) SEE EO HQD 1097-3		2 MAY 70	99%
	B	(3) SEE EO HQD 1097-3		20 FEB 71	99%
	C	(3) SEE EO HQD 200718		6 MAY 72	99%
	D	NO CHANGE		5 FEB 73	99%
	E	NOIR 225 00526	02-05-21	18-03-03	99%
	H	NOIR 6253059 920716		30-08-11	99%
	I	REC7 6253060 320650		21 JAN 74	99%
	K	NOIR 1553040 000106		000217	RLV



3.03 ± 0.05 in. FLA (A)

.47 R+D4
2 PLACES

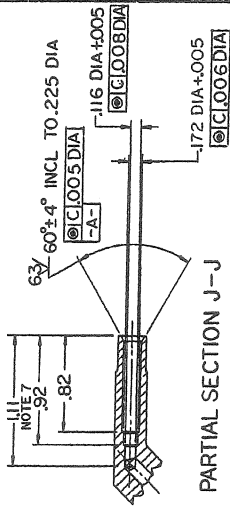
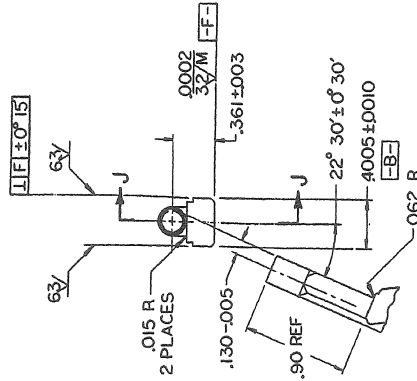
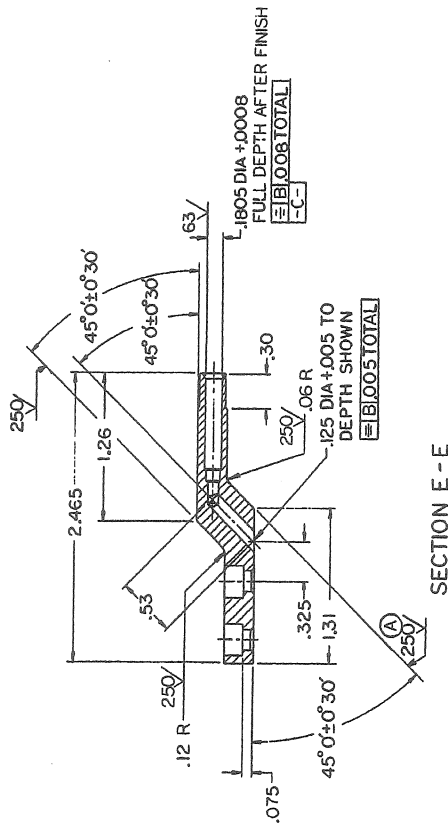
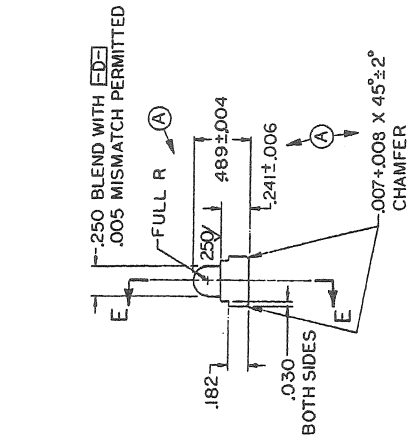
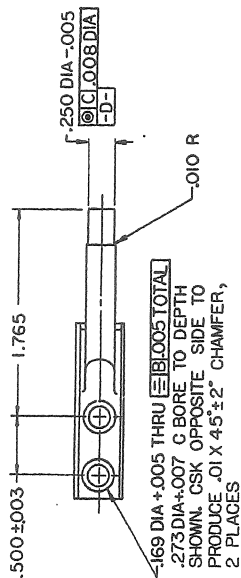
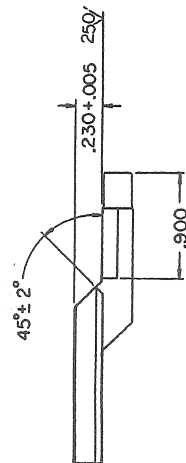
.184 REF



TO Explosives	UNIT CODE UNIT NO. STAMPEL NO.	F 19204 8448507	DATE 2 / 1	SHEET 2 OF 2
BY J. J. Henry				

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1. FINISH 12/1 EXCEPT AS NOTED.
2. SUGGESTED HEAT TREAT PROCEDURE:
OIL QUENCH FROM 1575°F. TEMPER
AT 1100°F FOR 1 HOUR.
3. FINISH 12.2.2 OF MIL-STD-171 ON DIA
[E] AND [E]. FILM THICKNESS
0.002/0.003.
4. ALL OTHER SURFACES TO RECEIVE
FINISH 5.3.1.2 OF MIL-STD-171.
5. BREAK SHARP EDGES .005+0.010.
6. MIL-W-13855 APPLIES.
7. FOR GAGING PURPOSED ONLY. THE DEPTH
OF PENETRATION OF A .1158 - .0002 GAGE
SHALL BE 1.100 MIN TO 1.135 MAX.

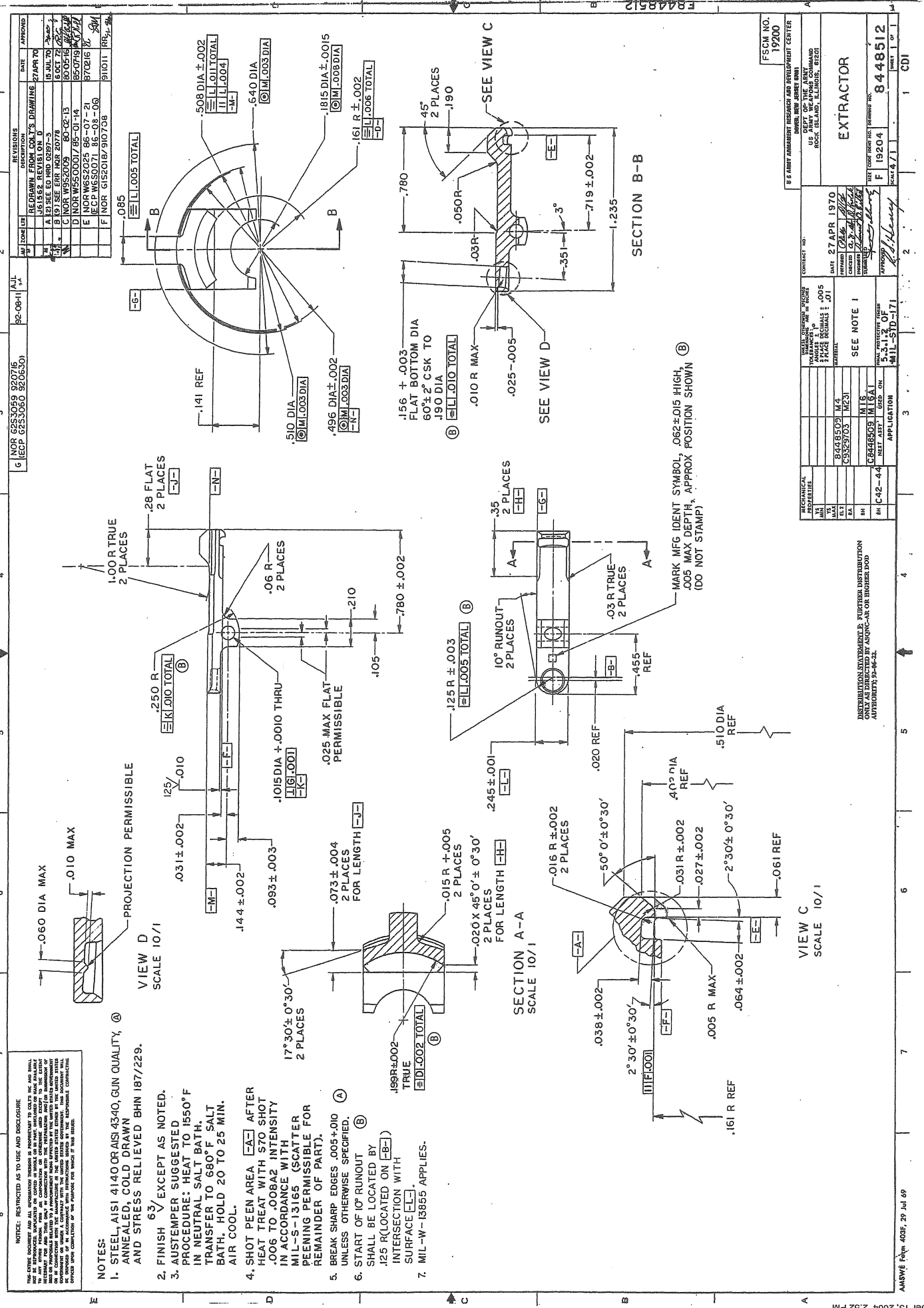


INF	ZONE	LIT	REVISIONS		DATE	APPROVED
			DESCRIPTION			
			REDRAWN FROM COLT'S DRAWING		27 APR 70	
			D 616-47 REV D			
	A	(B)	SEE CD HQR 106331		20 FEB 71	W229
	B	(C)	SEE ERHQR 200718		6 OCT 72	ORC
	C	(E)	SEE HQR 50604		5 FEB 73	ORC
	D	(D)	100E HQR 50606	82-05-21	25 DEC 73	W229
	E	ERR 2792095F			961108	W41
	F	NOR 6053460 / 900709)				W45
	G	NOR 6053466 / 901011			910130	FC 64
	F	NOR GIS2018			91-10-11	FC 64
	H	NOR 62534089 920716				FC 64
		(ECP 62534060 920630)			92-08-11	FC 64
	J	NOR 66535242 960204			961215	JB

CURRENT DESIGN ACTIVITY FSCM NO. 19200
U S ARMY ANTIMANIPULANT RESEARCH AND DEVELOPMENT CENTER

MECHANICAL SPECIFICATIONS		NOMENCLATURE		DRAWING NO.		SHEET NO.	
Y5	MIN	8448505	M4	8448505	19204	21	OF
Y6	MAX		M16A2				
EL	2		M16				
BA			M16				
BH							
BH							
C26-32		APPLICATION		SEE NOTES 3 & 4		APPROVED	
						R. J. Kneiss	
						DATE 27 APR 1970	
						KEY, BOLT CARRIER	
						U.S. ARMY ROCK ISLAND, ILLINOIS, 61204	
						DOWNEY NEW JERSEY 07801	

DISTRIBUTION STATEMENT E: FURTHER DISTRIBUTION ONLY AS DIRECTED BY ASQC-AR OR HIGHER DOD AUTHORITY; 92-06-22.



1. STEEL, CORROSION-RESISTANT,
PER AMS 5906 OR 5913,
THICKNESS .016±.001.

2. FINISH ^{125/}✓ EXCEPT AS NOTED IN NOTE 4.

3. EDGES TO BE SHARP TO
.005 R MAX.

4. MAX DIE BREAK ON -B- TO BE 50%. FINISH ON SHEARED SURFACE TO BE $63\sqrt{V}$.

5. FINISH 5.4.1 OF
MIL-STD-171.

6. MIL-W-13855 APPLIES.

DISTRIBUTION STATEMENT F.

FURTHER DISTRIBUTION ONLY AS

950610
DIRECTED BY ANDERSON, AMSTUTZ, AN-CUL-A

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES:
3 ANGLES $\pm$ _____
2 PLACE DECIMALS $\pm$.01
MATERIAL

SEE NOTE 1

FINAL PROTECTIVE FINISH

SEE NOTE 5

CONTRACT NO:		DATE 27 APR 1970	
PREP	PER NO	99	10
CHK	BY	W. S. Williams	
ENGR	FOR	W. S. Williams	
SUBMITTED	F. P. Williams		
APPROVED	W. S. Williams		

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

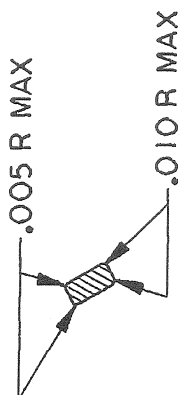
DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

RING, BOLT

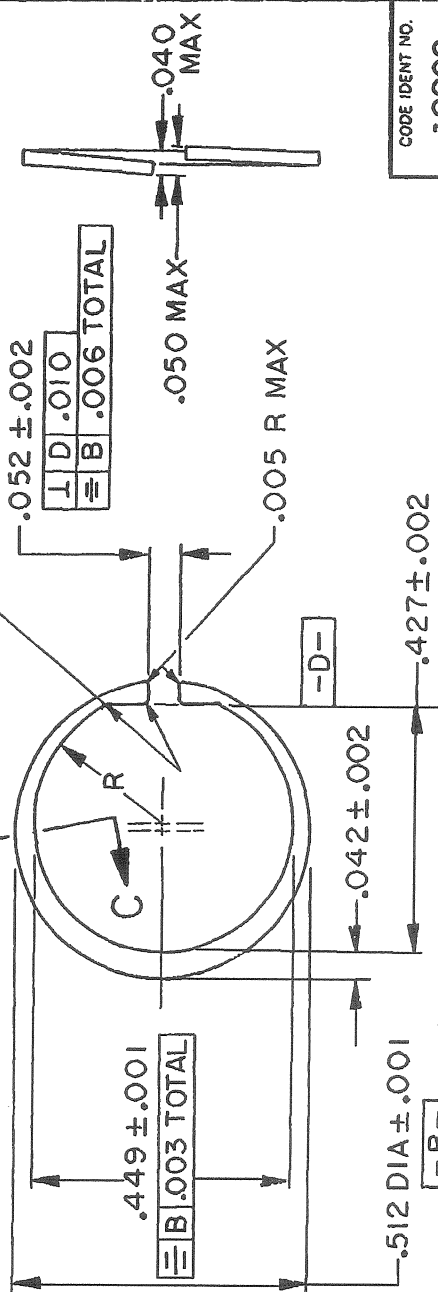
SIZE	CODE IDENT NO.	DRAWING NO.
B	19204	844851

SCALE 5 / 1	SHEET 1	OF 1
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100



SECTION C-C
SCALE 10/1
TYPICAL



CODE IDENT NO.
19200

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
F	NOR G5S3007 950303	951023	RLV

NOTE:

- STEEL, CORROSION-RESISTANT, PER AMS 5906 OR 5913, THICKNESS .016 ± .001.
- FINISH $\sqrt{125}$ EXCEPT AS NOTED IN NOTE 4.
- EDGES TO BE SHARP TO .005 R MAX.
- MAX DIE BREAK ON $\boxed{-B-}$ TO BE 50% FINISH ON SHEARED SURFACE TO BE $\sqrt{63}$.
- FINISH 5.4.1 OF MIL-STD-171.
- MIL-W-13855 APPLIES.

DISTRIBUTION STATEMENT F.
FURTHER DISTRIBUTION ONLY AS DIRECTED BY ARDEC, AMSTA-AR-CCL-A
950610

MECHANICAL PROPERTIES

YS MIN	YS MAX	EL 2	RA	BH	RH
8448509	M 4	C9327073	M 231	M 16	M 16A1
NEXT ASSY USED ON APPLICATION					

UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES

ANGLES	3 PLACE DECIMALS	2 PLACE DECIMALS
SEE NOTE 1	± .01	± .01

FINAL PROTECTIVE FINISH SEE NOTE 5

CONTRACT NO. DATE 27 APR 1970

PREP *Q. N. 19. 1970* CHK *W. J. 1970* ENGR *W. J. 1970* SUBMITTED *W. J. 1970* APPROVED *W. J. 1970*

DEPT OF THE ARMY
U.S. ARMY WEAPONS COMMAND
ROCK ISLAND, ILLINOIS 61201

RING, BOLT

SIZE CODE IDENT NO. DRAWING NO.
B 19204 8448511

SCALE 5/1 SHEET 1 OF 1

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

CODE IDENT NO. 19200

REVISIONS

SYM	DESCRIPTION	DATE	APPROVAL
F	NOR G5S3007 950303	951023	RLV

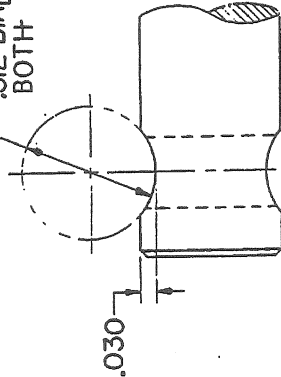
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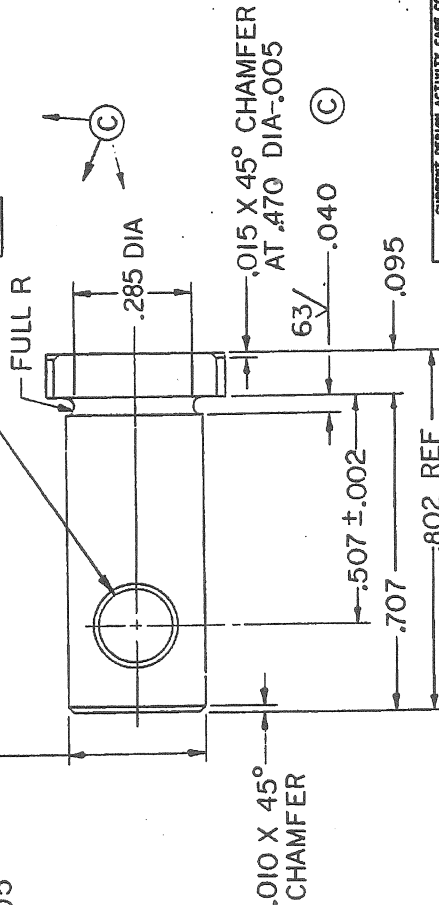
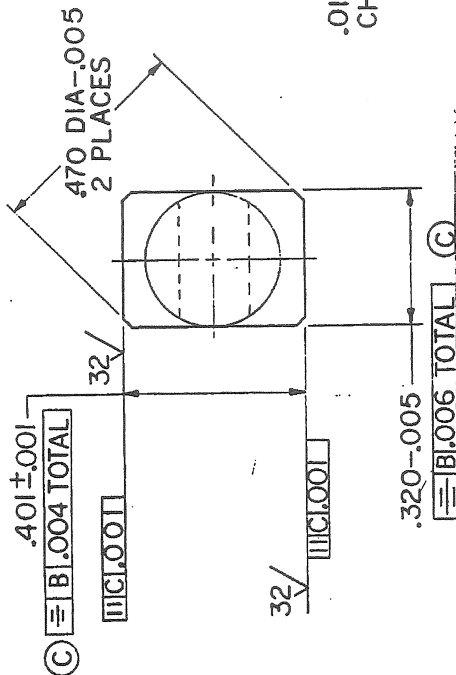
NOTE:

1. FINISH 125/ EXCEPT AS NOTED.
2. BREAK ALL SHARP EDGES .005+ .005.
3. APPLY DRY FILM LUBRICANT MIL-L-46010. ^(C) FILM THICKNESS .0002-.0004. CURE ONE HOUR AT 375° F. OR USE EVERLUBE 626 OR 626S. FILM THICKNESS .0002-.0004. CURE FOR 1 HOUR AT 375° F.
4. SUGGESTED HEAT TREATMENT:
QUENCH IN OIL FROM 1500° F TO 1550° F. TEMPER AT 625° F TO 675° F FOR ONE HOUR.
5. MIL-W-13855 APPLIES.

3/2 DIA BOTH SIDES



32/ 3/105 DIA-.0005
GRIND AFTER HEAT TREAT
-B- .164 DIA +.003
-C- ≡ BLOO4 TOTAL



CURRENT DESIGN ACTIVITY CARE CODE 19000
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PILGRIM AVENUE, NEW JERSEY 07100-5100

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED TOLERANCES ARE IN INCHES		CONTRACT NO.		-DEPT OF THE ARMY- US ARMY WEAPONS COMMAND FOOT ISLAND, ILLINOIS, 61201-	
YS MIN		TOLERANCES		DATE 27 APR 1970			
YS MAX		ANGLES		PREPARED	PA.B	Q.Y. At	
EL 2		3 PLACE DECIMALS		CHECKED	PA.B	Q.Y. At	
RA		2 PLACE DECIMALS		ENGINEER	PA.B	Q.Y. At	
DH				SUBMITTED	PA.B	Q.Y. At	
PH	C45-48	MATERIAL	STEEL ALLOY E4340, SPEC MIL-S-5000	APPROVED	PA.B	Q.Y. At	
		FINAL PROTECTIVE FINISH	5.3.1.3 OF MIL-STD-171				
		APPLICATION					
		NEXT ASSY					
		USED ON					
		SIZE	C 19204	DRAWING NO. 8448502			
		SCALE	5/1				

(A)

(B)

[illegible]

1. FOR FINISHED CHAMBER DIMENSIONS AFTER PLATING SEE DWG 8249649 AND SECTION A-A. FOR FINISHED BORE DIMENSIONS AFTER PLATING SEE DWG 8448549.
2. TORQUE BARREL AND BARREL EXTENSION TO 150 LB FT $\pm$ 5 LB FT. .283 DIMENSION APPLIES AFTER TORQUING TO REQUIRED LOAD.

3. FINISH: REAM-CHAMBER AFTER ASSEMBLY.

PROTECTIVE FINISH:
A. INTERIOR: CHROMIUM PLATE CHAMBER AND BORE FINISH 12.22 OF MIL-STD-171, FILM THICKNESS BETWEEN POINTS 5B1 AND 5C100.03 TO 0.005-FILM THICKNESS BETWEEN 5E3 AND 5E1 0.004 TO 0.005.
B. CHROMIUM PLATING SOLUTION TO HAVE A CONCENTRATION OF CHROMIUM TRIOXIDE OF 50 TO 55 G/L. CHROMIUM TRIOXIDE SHOULD BE SUSPENDED ON PAPER SHALL BE 50 TO 55 G/L. CHROMIUM TRIOXIDE SHALL BE MAINTAINED SO THE DENSITY IS TO BE 0.01. THE CURRENT DENSITY SHALL BE MAINTAINED 0.01 WHEN VENTED UNDER ESSENTIALLY OF A DENSE CRACK-FREE CHARACTER WHEN VENTED UNDER

c. EXTERIOR: 5.312 OF MIL-STD-71,
100% MAGNIFICATION,
AFTER CHROME PLATING CHAMBER AND BORE, EACH BARREL ASSEMBLY SHALL
WITHSTAND THE FIRING OF ONE HIGH PRESSURE TEST CARTRIDGE M197,
WITHOUT EVIDENCE OF FAILURE.

5. AFTER PROOF FIRING, EACH BARREL ASSEMBLY SHALL BE MAGNETIC PARTICLE INSPECTED FOR CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS USING A CURRENT OF 400 TO 500 AMPERES FOR CIRCULAR CONTINUOUS MAGNETIZATION.

• AFTER PROOF FIRING AND MAGNETIC PARTICLE INSPECTION, GRIT BLAST EXTERIOR PRIOR TO FINAL PROTECTIVE FINISH, TO PRODUCE NONREFLECTIVE MATTE FINISH. MASK CHAMBER, FEED CONE, BORE AND CROWN (MUZZLE END).

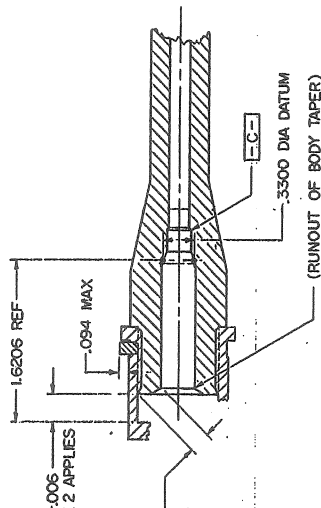
5. AFTER PROOF LOAD FIRING AND MAGNETIC PARTICLE INSPECTION EACH BARREL SHALL BE MARKED AS FOLLOWS:

MFG IDENT, MAGNETIC PARTICLE INSPECTION /: PROOF-
LOAD FIRING SYMBOL, AND "CHROME BORE" SHALL
BE .094±.015 HIGH IN AREA SHOWN VISUALLY
IN LINE WITH THE .092 DIA GAS PORT.

1. ABOVE MARKINGS SHALL BE LEGIBLE AND PERMANENT SO AS TO BE CAPABLE OF WITHSTANDING THE ENVIRONMENTAL AND CLEANING REQUIREMENTS FOR THE ASSEMBLY.

SINGLE LETTER-CHROME PLATE VENDOR IDENT.
PERMISSIBLE THIS AREA ONLY.

MIL-W-13855 APPLIES



SECTION A-A
SCALE: 2/1

092 DIA +/- .001 THRU THIS SIDE.
ONLY. BREAK EXTERNAL SHARP
EDGE .015 MAX. INTERNAL BURR
NOT PERMITTED.

43
NOTE
PIN, BARREL INDEXING -
8448551

BARREL-8448549

EXTENSION, BARREL-8448550

Technical drawing of a shaft assembly. The shaft has a central section labeled "CHROME BORE" and a section labeled "MP". Dimensions are given as $125 \pm .015$ for the MP section and 100 APPROX for the chrome bore section. A dimension of $125 \pm .015$ is also shown for the total length of the MP section. A note indicates "PLATING FADE OUT TO TERMINATE ANYWHERE IN THIS AREA." with an arrow pointing to the end of the shaft. A dimension of $125 \pm .015$ is also shown for the total length of the shaft.

VIEW: B.
SCALE: 2X

REV	DATE	LINE	REVISIONS	DESCRIPTION	DATE	APPROVED
1		J	PER ACCESS RCV IN 70 CHANGE		10 JUN 74	W/S
2		K	SEE EPR FOR 30050		3 FEB 75	W/S
3		L	SEE EPR FOR 30050		3 FEB 75	W/S
4		M	200R 67530358/870611		18 DEC 83	W/S
5		N	EPP 230182ZAR		18 DEC 83	W/S
6			ERR 685307		18 DEC 83	W/S
7			ERR 685307		18 DEC 83	W/S

COLETYPE 04-00250		PART NO. 8448548		DEPT OF THE ARMY ROCK ISLAND Arsenal, ROCK ISLAND, ILL. 61201	
PRIORITY		27 APR 70		BARREL AND BARREL EXTENSION ASSEMBLY	
NR	NR	ORIGINAL DATE		TYPE SIZE CODE RIGHT IN	
NR	NR	ROUTED TO		F 19204	
NR	NR	ROUTED BY		8448548	
NR	NR	ROUTED TO		SCALE 1/1 1/2 1/4 1/8 1/16 1/32 1/64 1/128 1/256 1/512 1/1024 1/2048 1/4096 1/8192 1/16384 1/32768 1/65536 1/131072 1/262144 1/524288 1/1048576 1/2097152 1/4194304 1/8388608 1/16777216 1/33554432 1/67108864 1/134217728 1/268435456 1/536870912 1/1073741824 1/2147483648 1/4294967296 1/8589934592 1/17179869184 1/34359738368 1/68719476736 1/137438953472 1/274877906944 1/549755813888 1/1099511627776 1/2199023255552 1/4398046511104 1/8796093022208 1/17592186044416 1/35184372088832 1/70368744177664 1/140737488355328 1/281474976710656 1/562949953421312 1/1125899906842624 1/2251799813685248 1/4503599627370496 1/9007199254740992 1/18014398509481984 1/36028797018963968 1/72057594037927936 1/144115188075855872 1/288230376151711744 1/576460752303423488 1/1152921504606846976 1/2305843009213693952 1/4611686018427387904 1/9223372036854775808 1/18446744073709551616 1/36893488147419103232 1/73786976294838206464 1/147573952589676412928 1/295147905179352825856 1/590295810358705651712 1/1180591620717411303424 1/2361183241434822606848 1/4722366482869645213696 1/9444732965739290427392 1/18889465931478580854784 1/37778931862957161709568 1/75557863725914323419136 1/151115727451828646838272 1/302231454903657293676544 1/604462909807314587353088 1/1208925819614629174706176 1/2417851639229258349412352 1/4835703278458516698824704 1/9671406556917033397649408 1/19342813113834066795298816 1/38685626227668133590597632 1/77371252455336267181195264 1/154742504910672534362390528 1/309485009821345068724781056 1/618970019642690137449562112 1/1237940039285380274899124224 1/2475880078570760549798248448 1/4951760157141521099596486896 1/9903520314283042199192973792 1/19807040628566084398385947584 1/39614081257132168796771895168 1/79228162514264337593543790336 1/158456325028528675187087580672 1/316912650057057350374175161344 1/633825300114114700748350322688 1/1267650600228229401496700645376 1/2535301200456458802993401290752 1/5070602400912917605986802581504 1/10141204801825835211973605163008 1/20282409603651670423947210326016 1/40564819207303340847894420652032 1/81129638414606681695788841304064 1/162259276829213363391577682608128 1/324518553658426726783155365216256 1/649037107316853453566310730432512 1/1298074214633706907132621460865024 1/2596148429267413814265242921730048 1/5192296858534827628530485843460096 1/10384593717069655257060971686920192 1/20769187434139310514121943373840384 1/41538374868278621028243886747680768 1/83076749736557242056487773495361536 1/16615349947311448411297554699072272 1/33230699894622896822595109398144544 1/66461399789245793645190218796289088 1/132922799578491587290380437592578176 1/265845599156983174580760875185156352 1/531691198313966349161521750370312704 1/1063382396627932698323043500740625408 1/2126764793255865396646087001481250816 1/4253529586511730793292174002962501632 1/8507059173023461586584348005925003264 1/17014118346046923173168696011850006528 1/34028236692093846346337392023700013056 1/68056473384187692692674784047400026112 1/136112946768375385385349568094800052224 1/272225893536750770770699136189600104448 1/544451787073501541541398272379200208896 1/1088903574147003083082796544758400417792 1/2177807148294006166165593089516800835584 1/4355614296588012332331186179033601671168 1/8711228593176024664662372358067203342336 1/17422457186352049329324744716134406684672 1/34844914372704098658649489432268813369344 1/6968982874540819731729897886453762678688 1/13937965749081639463459795772907525357376 1/27875931498163278926919591545815050714752 1/55751862996326557853839183091630101429504 1/111503725992653115707678366182600202859008 1/223007451985306231415356732365200405718016 1/446014903970612462830713464730400811436032 1/89202980794122492566142692946080162872064 1/178405961588244985132285385892160325744128 1/356811923176489970	

