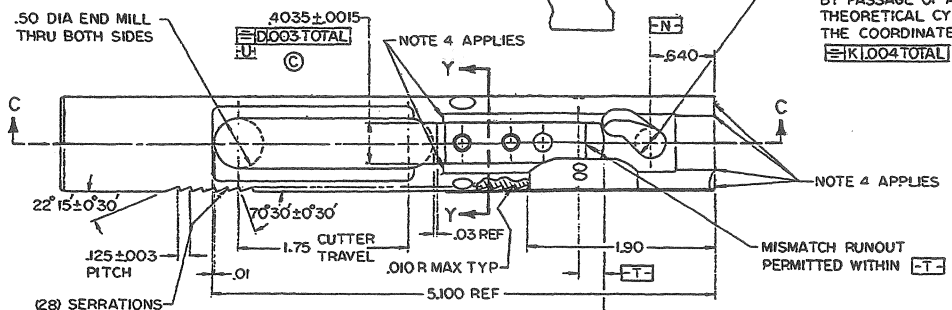


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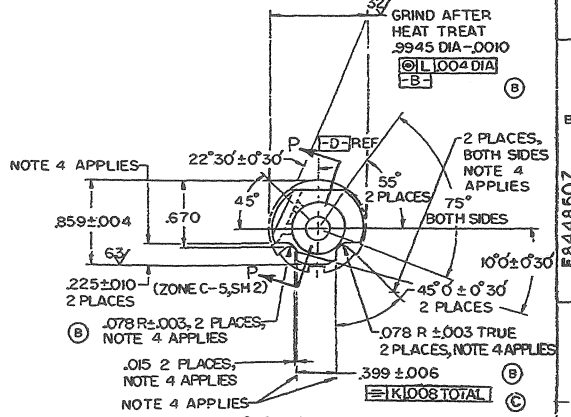
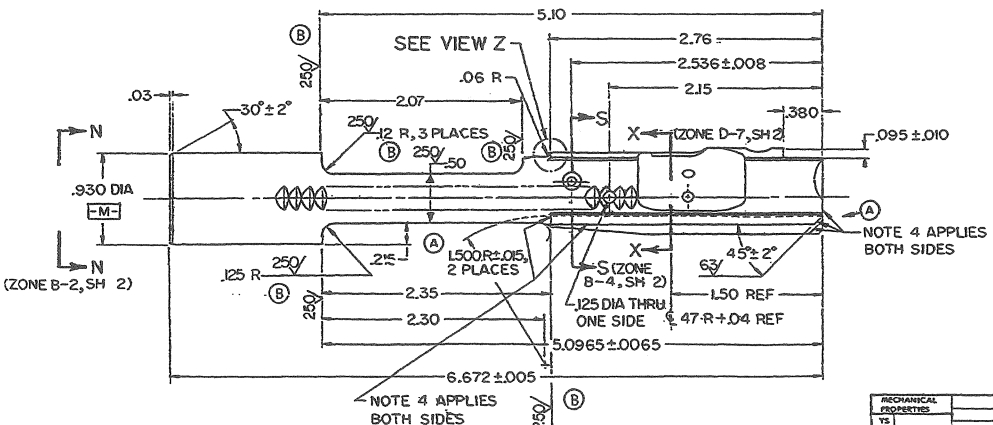
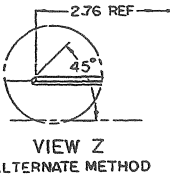
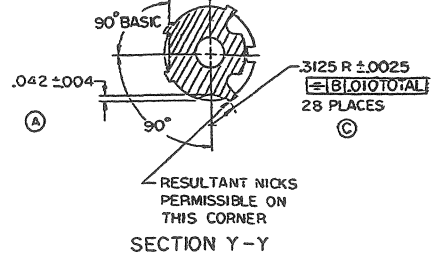
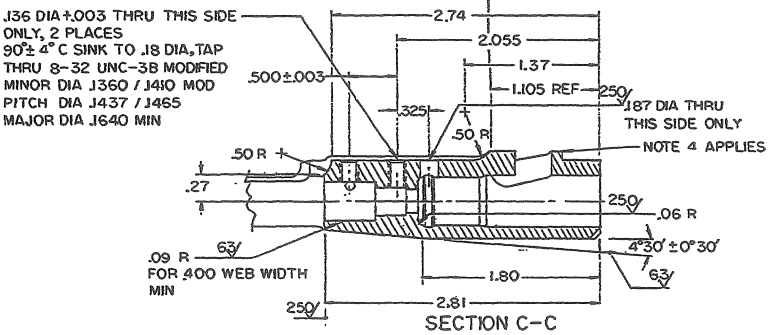
NOTES:

1. STEEL, AISI 8620, GUN QUALITY, COLD DRAWN, STRAIN RELIEVED BAR MAX BRINELL HARDNESS 241. AIM FOR 217/229.
2. FINISH - I25 EXCEPT AS NOTED.
3. FILLET RADIUS .010 EXCEPT AS NOTED.
4. .015 EDGE BREAK AT POINTS INDICATED.
5. SUGGESTED HEAT TREAT PROCEDURE: STRAIN RELIEVE AT 850°F FOR ONE HOUR. LIQUID CARBURIZE AT 1550°F FOR ONE HOUR 20 MIN APPROX. TOTAL CASE DEPTH REALIZED MUST BE .010/.015. OIL QUENCH. SUGGESTED DRAW TEMP 350 / 375°F AT HEAT FOR ONE HOUR.
6. FINISH 1.2.22 OF MIL-STD-171, FILM THICKNESS .0002 / .0003 ON SURFACES INDICATED.
7. FINISH 5.3.1.2 OF MIL-STD-171, EXCEPT SURFACES WITH 1.2.22 FINISH (SEE NOTE 6).
8. ALL DIMENSIONS APPLY BEFORE FINISH.
9. BREAK SHARP EDGES .005 x .010 UNLESS OTHERWISE SPECIFIED.
10. MIL-W-13855 APPLIES.

MARK MFR'S IDENT
 SYMBOL, .094 ± .015 HIGH, .005
 MAX DEPTH, IN APPROX
 POSITION SHOWN (C)



REV	DATE	DESCRIPTION	BY	APP'D
1	27 APR 1970	REDRAWN FROM COLT'S DRAWING J62274 REV E		
2	15 JUL 70	SEE BRF NOR 6097-3		
3	20 FEB 71	SEE ERF NOR 20778		
4	15 SEP 75	SEE BRF NOR 50504		
5	82-05-21	SEE NOR W25002		
6	30 10 61	NOR G053109 900705		
7	31 10 11	NOR G152018/910708		
8	32 08 11	NOR G253059/920716 RECR G253050/920630		
9	960229	NOR G553118 / 960117		
10	000217	NOR L953040 000106		



SH 1	SH 2
K	K

MECHANICAL PROPERTIES	TOLERANCES	PATRICAL	DATE
YS RMT TS MAX EL2	FRACTIONS SPECIFIED THROUGHOUT THE DRAWING TOLERANCES: ANGLES ± 1° 3 PLACE DECIMALS ± .005 2 PLACE DECIMALS ± .01	8448505 - M4	27 APR 1970
EA BR BRN	SEE NOTE 1	M1815	APPROVED: [Signature]
		8448505 (MIL-A-8842)	DATE: [Signature]
		MIL ASSY / USED ON	APP'D: [Signature]
		APPLICATION	REVISOR: [Signature]

CURRENT DESIGN ACTIVITY ESCM NO. 19200	
CONTRACT NO.	
DEPT OF THE ARMY US ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 62451	
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER DOVER, NEW JERSEY 07801	
CARRIER, BOLT	
SEE (CON) DRAWING NO. 8448507 FORM 19204	FORM 1 92

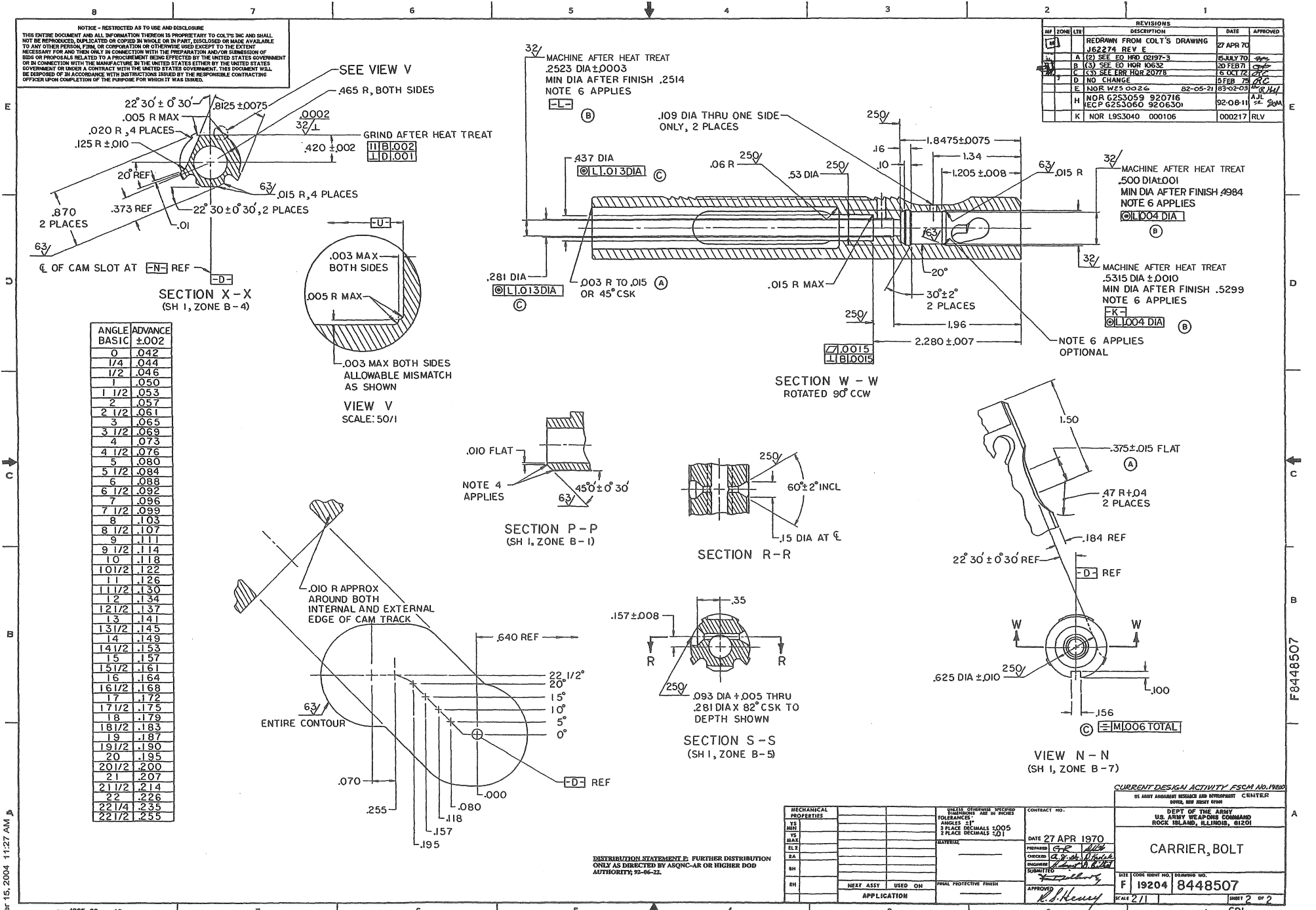
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REV	ZONE	LIB	DESCRIPTION	DATE	APPROVED
1			REDRAWN FROM COLT'S DRAWING J62274 REV E	27 APR 70	
2	A	(2)	SEE ED HFD 02197-3	25 JULY 70	
3	B	(3)	SEE ED HFD 10632	20 FEB 71	
4	C	(3)	SEE ED HFD 20778	15 OCT 72	
5	D		NO CHANGE	19 FEB 73	
6	E		NOR WFS 0026	82-05-21	83-02-03
7	H		NOR 6253059 920716 REC P 6253060 920630	92-08-11	AJL 2-20
8	K		NOR 1953040 000106		000217 RLV



ANGLE BASIC	ADVANCE ±.002
0	.042
1/4	.044
1/2	.046
1	.050
1 1/2	.053
2	.057
2 1/2	.061
3	.065
3 1/2	.069
4	.073
4 1/2	.076
5	.080
5 1/2	.084
6	.088
6 1/2	.092
7	.096
7 1/2	.099
8	.103
8 1/2	.107
9	.111
9 1/2	.114
10	.118
10 1/2	.122
11	.126
11 1/2	.130
12	.134
12 1/2	.137
13	.141
13 1/2	.145
14	.149
14 1/2	.153
15	.157
15 1/2	.161
16	.164
16 1/2	.168
17	.172
17 1/2	.175
18	.179
18 1/2	.183
19	.187
19 1/2	.190
20	.195
20 1/2	.200
21	.207
21 1/2	.214
22	.226
22 1/4	.235
22 1/2	.255

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MECHANICAL PROPERTIES	WELD, OTHER OR PREPARED FINISHES ARE IN NOTES	CONTRACT NO.
VS	ANGLES - 5°	DATE 27 APR 1970
MS	2 PLACE DECIMALS ±.005	PREPARED BY <i>CLP</i>
DR	2 PLACE DECIMALS SDI	CHECKED BY <i>CLP</i>
SA		ENGINEERED BY <i>CLP</i>
SH		SUBMITTED BY <i>CLP</i>
RI		APPROVED BY <i>CLP</i>
	NEXT ASSY USED ON APPLICATION	

CURRENT DESIGN ACTIVITY (FSCM NO. 1980)	
US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER ROCK ISLAND, ILLINOIS, 61201	
DEPT OF THE ARMY US ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
CARRIER, BOLT	
SIZE CODE (RIGHT NO.)	DRAWING NO.
F 19204	8448507
SCALE 2/1	SHEET 2 OF 2

F8448507

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