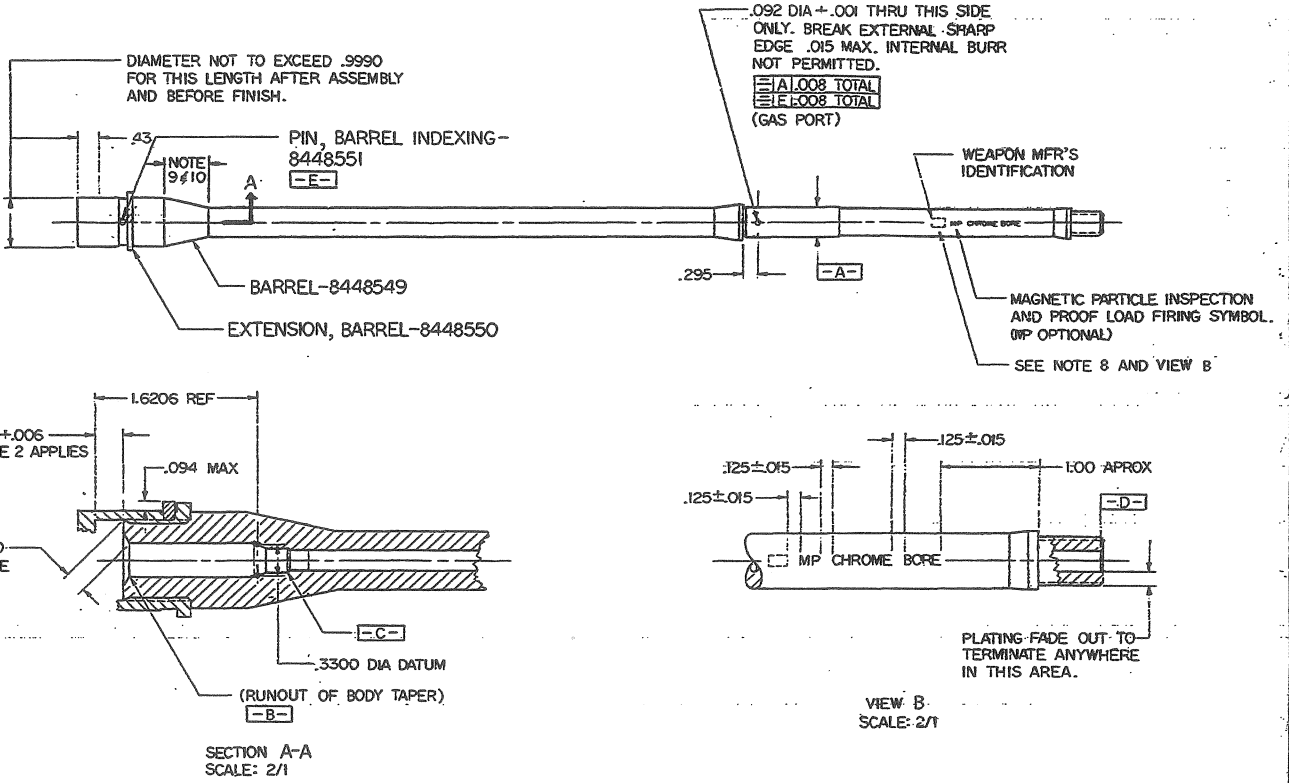


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REVISIONS				
REV	DATE	DESCRIPTION	BY	APP'D
1		REPLACES REV H W/ CHANGE		
2		SEE BAR MFR 3079		
3		SEE BAR MFR 3079		
4		SEE BAR MFR 3079		
5		SEE BAR MFR 3079		
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18		SEE BAR MFR 3079		
19		SEE BAR MFR 3079		
20		SEE BAR MFR 3079		

- NOTES:
- FOR FINISHED CHAMBER DIMENSIONS AFTER PLATING SEE DWG 8448649 AND SECTION A-A. FOR FINISHED BORE DIMENSIONS AFTER PLATING SEE DWG 8448549.
 - TORQUE BARREL AND BARREL EXTENSION TO 150 LB FT ± 5 LB. FT. .283 DIMENSION APPLIES AFTER TORQUING TO REQUIRED LOAD.
 - FINISH REAM CHAMBER AFTER ASSEMBLY.
 - PROTECTIVE FINISH:
 - INTERIOR: CHROMIUM PLATE CHAMBER AND BORE FINISH 1222 OF MIL-STD-171 FILM THICKNESS BETWEEN POINTS EEE AND EEE0005 TO .0015 FILM THICKNESS BETWEEN EEE AND EEE0005 TO .0015.
 - CHROMIUM PLATING SOLUTION TO HAVE A CONCENTRATION OF CHROMIUM TRIOXIDE (CrO₃) 50 TO 56 OUNCES PER GALLON; CHROMIC ACID TO SULPHATE ION RATIO SHALL BE 824 TO 924. THE OPERATING TEMPERATURE SHALL BE MAINTAINED AT 150° TO 155° F. THE CURRENT DENSITY SHALL BE MAINTAINED SO THE DEPOSIT IS ESSENTIALLY OF A DENSE CRACK-FREE CHARACTER WHEN VIEWED UNDER 100X MAGNIFICATION.
 - EXTERIOR: 5.3.1.2 OF MIL-STD-171.
 - AFTER CHROME PLATING CHAMBER AND BORE EACH BARREL ASSEMBLY SHALL WITHSTAND THE FIRING OF ONE HIGH PRESSURE TEST CARTRIDGE M197, WITHOUT EVIDENCE OF FAILURE.
 - 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).
 - 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.
 - 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.



CURRENT DESIGN ACTIVITY (CDA) 12/2000
 U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
 DOWRIE, NEW JERSEY 07003

SEE PL-8448548		PART NO. 8448548	
MECHANICAL PROPERTIES		DEPT OF THE ARMY ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TS		UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE
YS		ENGINEERING AND ALL DIMENSIONS ARE IN INCHES	OF DRAWING
RAK		TOLERANCES UNLESS OTHERWISE SPECIFIED	
EL.2		FRACTIONS <math>1/16, 1/32, 1/64, 3/16, 1/8, 3/32, 1/4, 1/2, 3/4, 1, 2, 3, 4, 6, 8, 12, 16, 24, 32, 48, 64, 96, 128, 192, 256, 384, 512, 768, 1024, 1536, 2048, 3072, 4096, 6144, 8192, 12288, 16384, 24576, 32768, 49152, 65536, 98304, 131072, 196608, 262144, 393216, 524288, 786432, 1048576, 1572864, 2097152, 3145728, 4194296, 6286432, 8378560, 12568832, 16759104, 25138624, 33518144, 50277248, 67016352, 100524800, 134033216, 201024000, 268014816, 402028800, 536032640, 804048640, 1072058496, 1608117760, 2144177024, 3216236288, 4284295552, 6426444800, 8568594048, 12868888064, 17169182080, 25770076160, 34270970240, 51432464384, 68193958464, 102294952704, 136095950720, 204191901440, 272087852160, 408183802880, 536179753600, 804275704320, 1072281655040, 1608341162240, 2144400669440, 3216460176640, 4288519683840, 6430579190080, 8572638696320, 12872738202624, 17172837708864, 25772937215008, 34273036721248, 51473136227488, 68673235733728, 102473335240000, 136273434746240, 204473533752480, 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