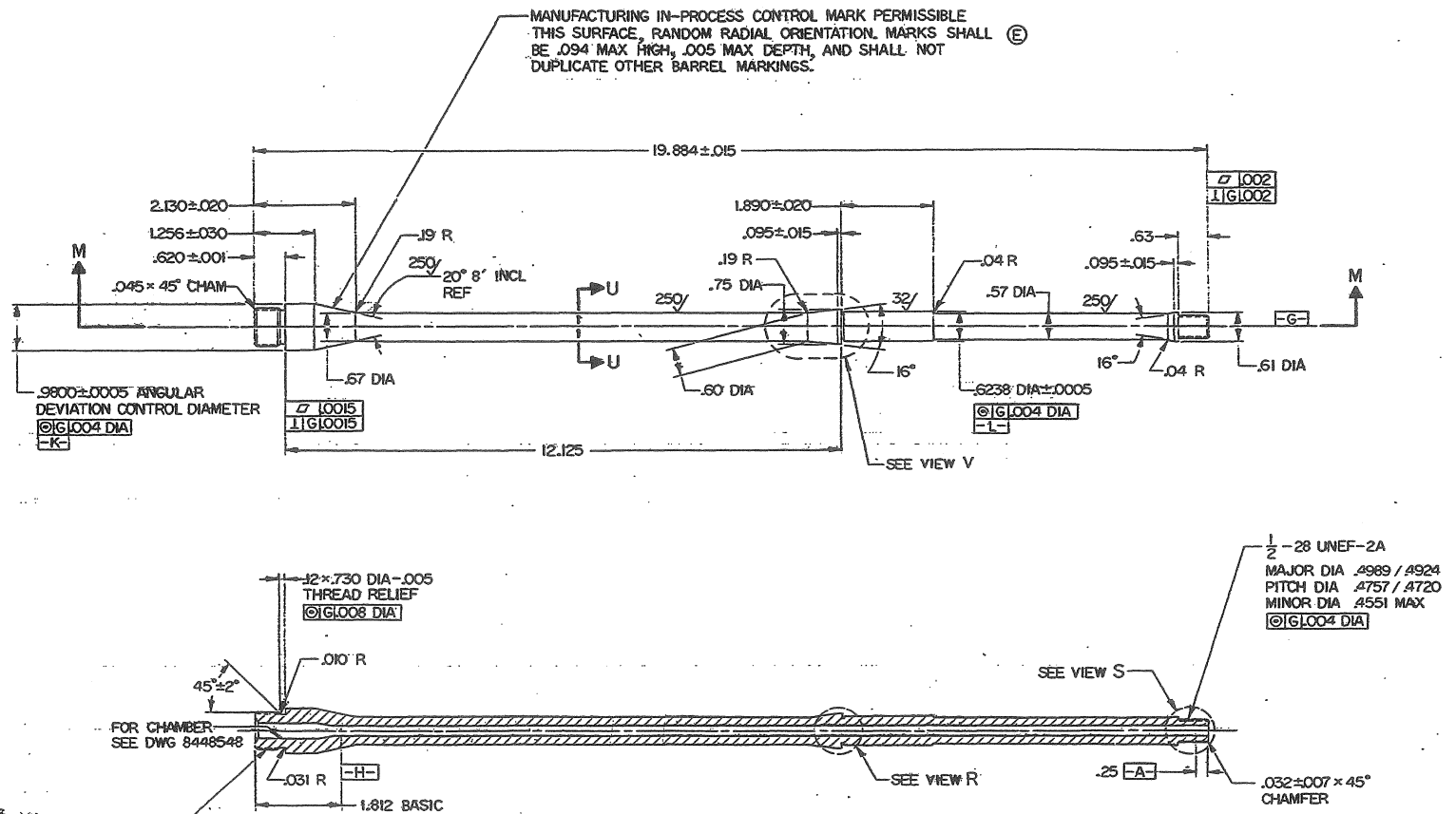


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REV	DATE	DESCRIPTION	APPROVED
D	10 DEC 76	REPLACES REV C W/ CHANGE SEE ERR-NOR 20827	CB
E	2 MAR 77	SEE ERR-NOR 20845	CB
F	26 JAN 77	SEE NOR 77E0005-0000	CB
G	82-05-21	NOR W25 0026	CB
H	83-08-03	NOR G753121 / 870923	CB
J	81-06-12	810612 PF-8-82	CB

- NOTES:
- STEEL, CMPSN CHROME-MOLY-VANADIUM, SPEC MIL-S-11595.
 - CENTER LINE [G] ESTABLISHED BY BORE DIAMETER AT MUZZLE AND AT POINT [H]. ALL DIAMETERS [G] [G] [G] UNLESS OTHERWISE SPECIFIED.
 - BREAK SHARP EDGES .005-.010 UNLESS OTHERWISE SPECIFIED.
 - WHERE NOTED, DIMENSIONAL LIMITS AND SURFACE ROUGHNESS DESIGNATIONS APPLY AFTER CHROME PLATING.
 - RIFLING TO BE SIX GROOVES, RIGHT HAND, WITH ONE TURN IN 12.000 ± .125.
 - STRESS RELIEVE AFTER FORMING RIFLING AND PRIOR TO FURTHER MACHINING. SUGGESTED PROCEDURE: PLACE BARRELS IN A CLOSED RETORT VERTICALLY. HEAT IN A NEUTRAL ATMOSPHERE TO 1020° F. HOLD AT HEAT FOR 15-MINUTES. COOL IN RETORT TO 300° F. REMOVE AND AIR COOL.
 - A CYLINDRICAL PLUG WITH A GAGING LENGTH OF 6.000 AND A DIAMETER OF .2173 / .2174 MUST DROP THROUGH THE BORE OF ITS OWN WEIGHT.
 - A SELF ALIGNING PLUG INSERTED 3.000 INTO THE BORE AT THE MUZZLE MAY HAVE AN ANGULAR DEVIATION FROM A THEORETICAL AXIS ESTABLISHED BY [K] AND [L] OF 0°-3' MAXIMUM.
 - BORE AND GROOVE DIAMETERS SHALL BE WITHIN THE DIMENSIONAL LIMITS SPECIFIED AND, WHEN MEASURED FROM THE CHAMBER END TOWARD THE MUZZLE END, SHALL MEET THE FOLLOWING REQUIREMENTS:
 - DIAMETRAL REDUCTION OF BORE AND GROOVE DIAMETERS SHALL BE .0001 DIA MAX FOR LENGTH [A].
 - NO BORE DIAMETER SHALL BE MORE THAN .0004 LARGER THAN THE SMALLEST PREVIOUSLY MEASURED BORE DIAMETER.
 - NO GROOVE DIAMETER SHALL BE MORE THAN .0004 LARGER THAN THE SMALLEST PREVIOUSLY MEASURED GROOVE DIAMETER.
 - MIL-W-13855 APPLIES.



15
16 UN-3A MOD
MAJOR DIA .8080 / .8000 MOD
[G] [G] [G]
PITCH DIA .7719 / .7683
[G] [G] [G]
MINOR DIA .7358 MAX

REV STATUS OF SHT'S	
SH 1	SH 2
U	U

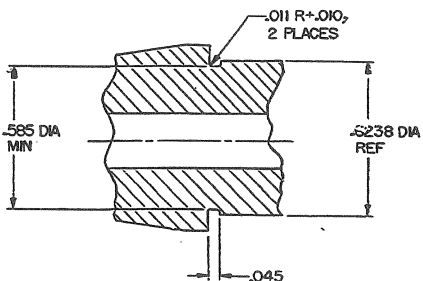
MECHANICAL PROPERTIES		TOLERANCES UNLESS OTHERWISE SPECIFIED		CONTRACT NO.	
MS		FRACTIONS 3 PLACE DECIMALS 2 PLACE DECIMALS 201		DATE 27 APR 70	
VS		ANGLES 1° 0'		DRAWN [Signature]	
VE		3 PLACE DECIMALS 2 PLACE DECIMALS 201		CHECKED [Signature]	
EC2		MATERIAL		APPROVED [Signature]	
EA		SEE NOTE 1		DATE 27 APR 70	
SH		NEXT ASSY USED ON		PART NO. 8448549	
RN	C26-32	APPLICATION		DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILLINOIS, 61201	
APPLICATION				SCALE 1:1	
DRAWING NO. F19204				8448549	
DRAWING TITLE BARREL				SIZE CODE 100-10, DRAWING NO. F 19204	
DRAWING DATE 27 APR 70				DRAWING NO. 8448549	
DRAWING BY [Signature]				DRAWING NO. 8448549	
DRAWING CHECKED [Signature]				DRAWING NO. 8448549	
DRAWING APPROVED [Signature]				DRAWING NO. 8448549	

October 13, 2004 3:34 PM

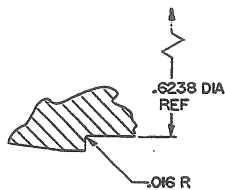
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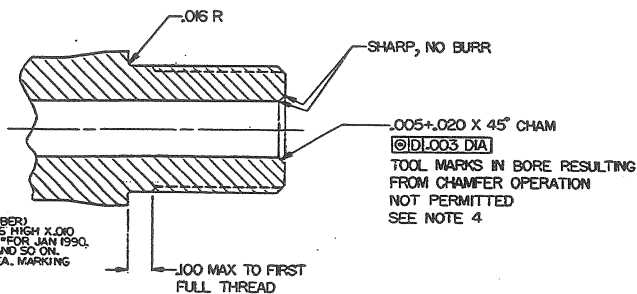
REVISIONS			
NO	DATE	DESCRIPTION	APPROVED
1	D	REPLACES REV C W/ CHANGE SEE ERR MOR 20827	18 DEC 72 ATB
2	E	ADD SEE ERR MOR 30645	2 MAR 73 JEC
3	F	ADD SEE NOR 175005-0000	25 MAR 73 JEC
4	G	ADD SEE NOR 175005-0000	25 MAR 73 JEC
5	H	ADD SEE NOR 675312/ 870923	18 OCT 73 JEC
6	J	ADD SEE NOR 6153039/ 910510	01 OCT 76 JEC



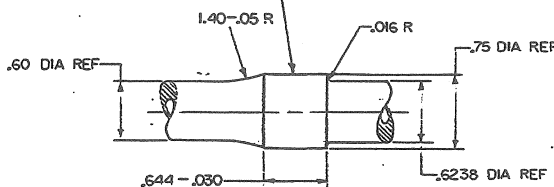
VIEW R
SCALE 5/1



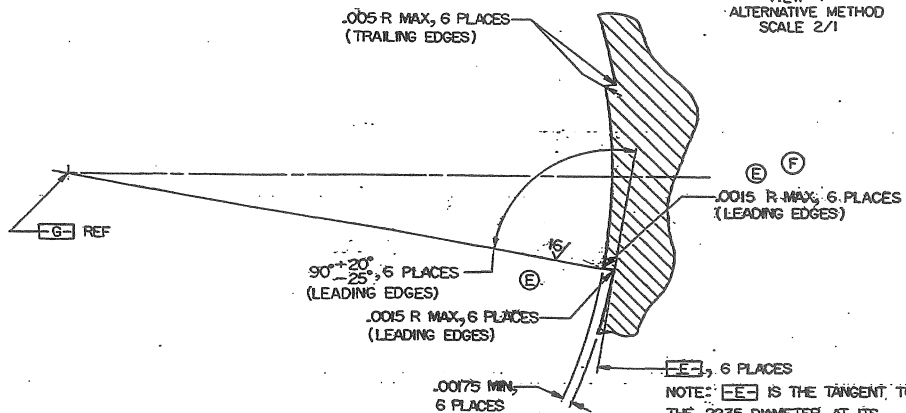
VIEW R
ALTERNATIVE DESIGN
SCALE 5/1



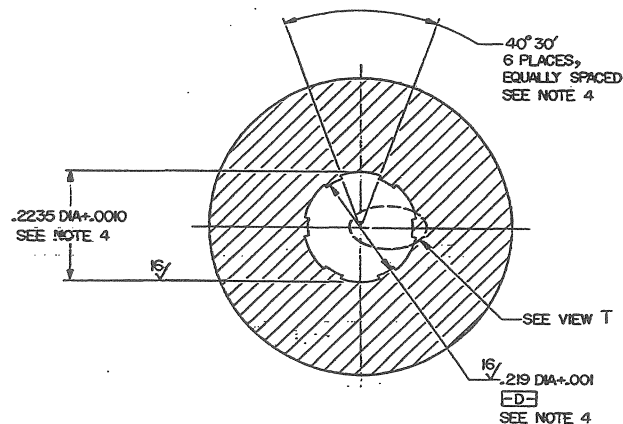
VIEW S
SCALE 5/1



VIEW V
ALTERNATIVE METHOD
SCALE 2/1



VIEW T
SCALE 100/1
NOTE 4 APPLIES TO ALL
DIMENSIONS IN THIS VIEW.



SECTION U-U
RIFLING DETAIL
SCALE 10/1

CURRENT DESIGN ACTIVITY (CON) NO. 19204
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DUVER, NEW JERSEY 07801

PART NO. 8448549

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

BARREL

MECHANICAL PROPERTIES		TOLERANCES UNLESS OTHERWISE SPECIFIED		CONTRACT NO.		PART NO.	
MS		DIMENSIONS ARE IN INCHES		DATE 27 APR 70		8448549	
MS		TOLERANCES:		DRAWN BY [Signature]		US ARMY WEAPONS COMMAND	
MS		ANGLES 5° TO 30°		CHECKED BY [Signature]		ROCK ISLAND, ILLINOIS, 61201	
MS		3 PLACE DECIMALS ±.005		APPROVED BY [Signature]		BARREL	
MS		2 PLACE DECIMALS ±.01		DATE 27 APR 70		SCALE 1/1	
MS		GENERAL		NEXT ASSY USED ON		DESIGNED NO. 8448549	
MS		FORMAL PROTECTIVE FINISH		APPLICATION		SHEET 2 OF 2	