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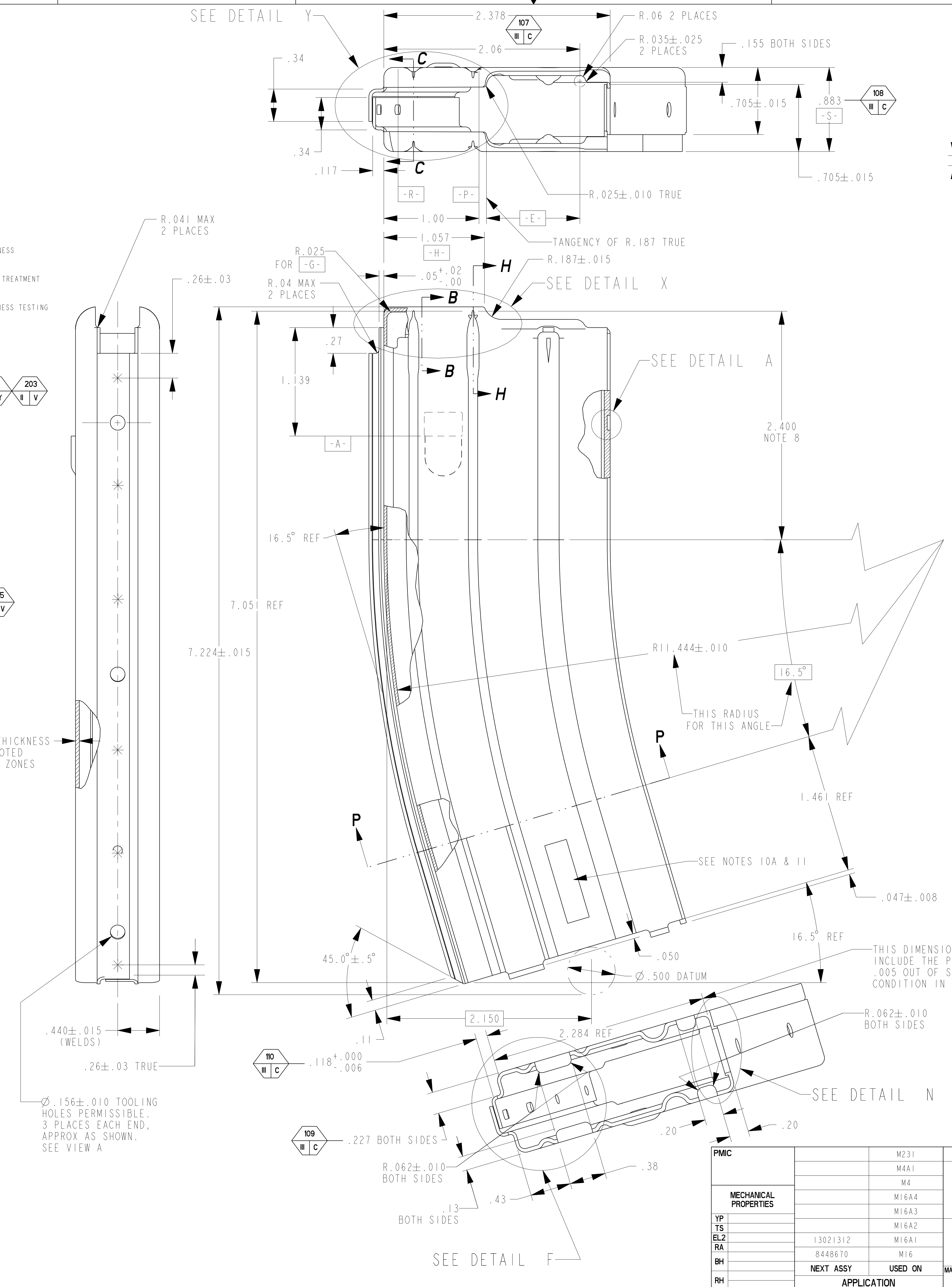
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DUE TO GOVERNMENT GENERATED ENGINEERING CHANGES, THERE MAY BE DATA AND/OR TOLERANCES NOT PROPRIETARY TO COLT'S.

- NOTES
- MATERIAL: ALUMINUM ALLOY 6061 PER ASTM B 209.
 - SURFACE FINISH: 125/
 - ALL DIMENSIONS APPLY BEFORE FINISH.
 - HEAT TREAT TO TEMPER T6 PER AMS 2770, EXCEPT THAT AGING TIME AND TEMPERATURE ARE OPTIONAL. SEE NOTE 6. QUENCHANT TEMPERATURE SHALL START AT 115° F OR LESS AND RISE TO A 135° F MAXIMUM. MINIMUM BRINELL 80 (10MM BALL 500KG LOAD) OR EQUIVALENT (BARCOL 76 MINIMUM).
 - PROTECTIVE FINISH: FINISH 7.5.1 OF MIL-STD-171, EXCEPT THAT THICKNESS SHALL BE .0010±.0002.
 - APPLY SOLID FILM LUBRICANT MIL-L-45983 OR MIL-PRF-46010 OR AS5272. FILM THICKNESS SHALL BE .0002 TO .0005. CAUTION: THE HEAT CURING OF LUBRICANT SHALL BE COINCIDENTAL WITH THE ARTIFICIAL AGING TO TEMPER T6 PER NOTE 4, PROVIDED THAT THE COMPONENT HAS BEEN SOLUTION HEAT TREATED PRIOR TO APPLICATION OF LUBRICANT.
 - SPOT WELD TWELVE SPACES PER MIL-W-45210, SIX WELDS, EQUALLY SPACED TO ±.03, BOTH ENDS, EXCEPT THAT WELD BUTTON SHALL BE Ø.10 MIN. EACH WELD SHALL SUPPORT A STATIC COMPRESSIVE LOAD OF 100 LBS APPLIED WITHIN LENGTH -L- OPPOSITE EACH WELD IN THE DIRECTION OF -M-.
 - SYMMETRY REQUIRED PER .883 DIMENSION APPLIES 2.400 LENGTH ONLY. SEE NOTE 9.
 - MIL-W-13855 APPLIES.
 - INSCRIPTIONS:
 - PRIME CONTRACTOR'S CAGE CODE AND MONTH AND YEAR, +/- TWO MONTHS, OF MANUFACTURE.
 - OPTIONAL MARKING MAY INCLUDE PRIME CONTRACTOR'S NAME, CITY, AND STATE.
 - 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. MARKINGS SHALL NOT EXTEND IN AREA 1.0 INCH FROM TOP OR 0.5 INCH FROM BOTTOM OF MAGAZINE BOX.
 - QUALITY ASSURANCE PROVISION REQUIREMENTS PER DRAWING 12993884 APPLY.

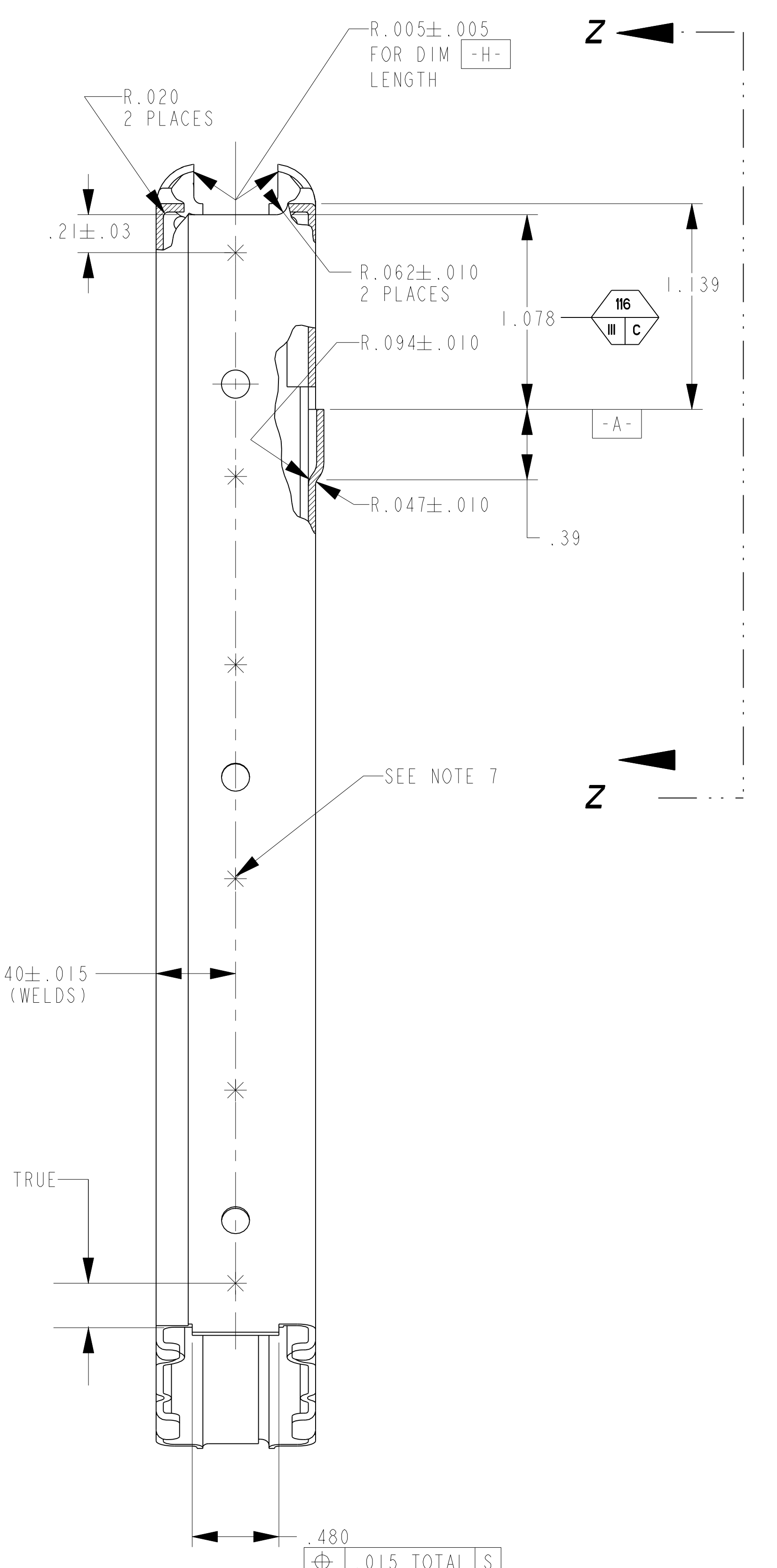
- SPOT WELD TEST/ SEE SHT3
- DESTRUCTIVE TEST/ SEE SHT3
- ANODIC COATING
- BOX, MAGAZINE
- WORKMANSHIP

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DETAIL J
SCALE 4.000

MODEL REV		DRAWING REV		REVISIONS DESCRIPTION	DATE(YEAR-MO-DA)	APPROVED
N/A	T	NOR	L9S3017	/ 1999-10-06	1999-10-28	BAC
N/A	U	NOR	L0S3023	/ 2000-06-30	2000-08-03	RLV
N/A	V	NOR	L1S2102	/ 2001-08-23	2001-09-26	RLV
-	W	NOR	L2S3028	/ 2002-05-24	2002-07-30	JJW
A	Y	NOR	L2S3063	/ 2002-10-17	2003-03-11	RJC
B	AA	NOR	L2S3089	/ 2003-03-11	2003-04-30	RJC
C	AB	NOR	L3S3161	/ 2004-03-31	2004-08-13	RLV
D	AC	NOR	L04S5160	/ 2005-02-09	2005-03-03	BMG
E	AD	NOR	L0S53064	/ 2005-08-09	2005-09-19	BMG
F	AE	NOR	L0S53081	/ 2005-10-20	2005-11-08	BMG
G	AF	NOR	L0S63007	/ 2006-03-09	2006-03-29	BMG
H	AG	NOR	L0S63024	/ 2006-03-29	2006-04-13	BMG
J	AH	NOR	L0S63042	/ 2006-05-11	2006-06-02	BMG
K	AJ	NOR	L0S63021	/ 2008-03-11	2008-03-18	BMG
L	AK	NOR	L0S63095	/ 2008-08-25	2008-09-04	BMG
M	AL	NOR	L11S3031	/ 2011-04-14	2011-04-21	RLV



REV STATUS OF SHEETS	REV	AL	AL	AL
	SHEET	1	2	3

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

THIS DRAWING WAS GENERATED FROM A SOLID MODEL AND IS CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

PART NO. 8448674

PMIC		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NUMBER		DESIGN ACTIVITY	
MECHANICAL PROPERTIES	M231	TOLERANCES ON ANGLES ± 1° 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005		CONTRACTOR		US ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILLINOIS	
YP	M4A1	THIRD ANGLE PROJECTION		DRAWN BY		BOX, MAGAZINE, 30 ROUND	
TS	M4			CHECKER		SIZE F	
EL2	M16A4	DRAWING APPROVAL		ENGINEER		CAGE CODE 19204	
RA	M16A3	L. BRINTON		ENGINEER		DWG NO. 8448674	
BH	M16A2	R. ELBE		QUALITY ENGINEER		SCALE 2.000	
RH	M16A1	R. ELBE		E. SESE		UNIT WT. 0.185	
	8448670	DESIGN APPROVAL		DATE (YEAR-MO-DA)		SHEET 1 OF 3	
	M16	R. ELBE		1970-06-05			
	8448674	R. ELBE		2002-05-24			
	USED ON	R. ELBE		2002-05-24			
	APPLICATION	R. ELBE		2002-05-24			

DRAWING SIZE F

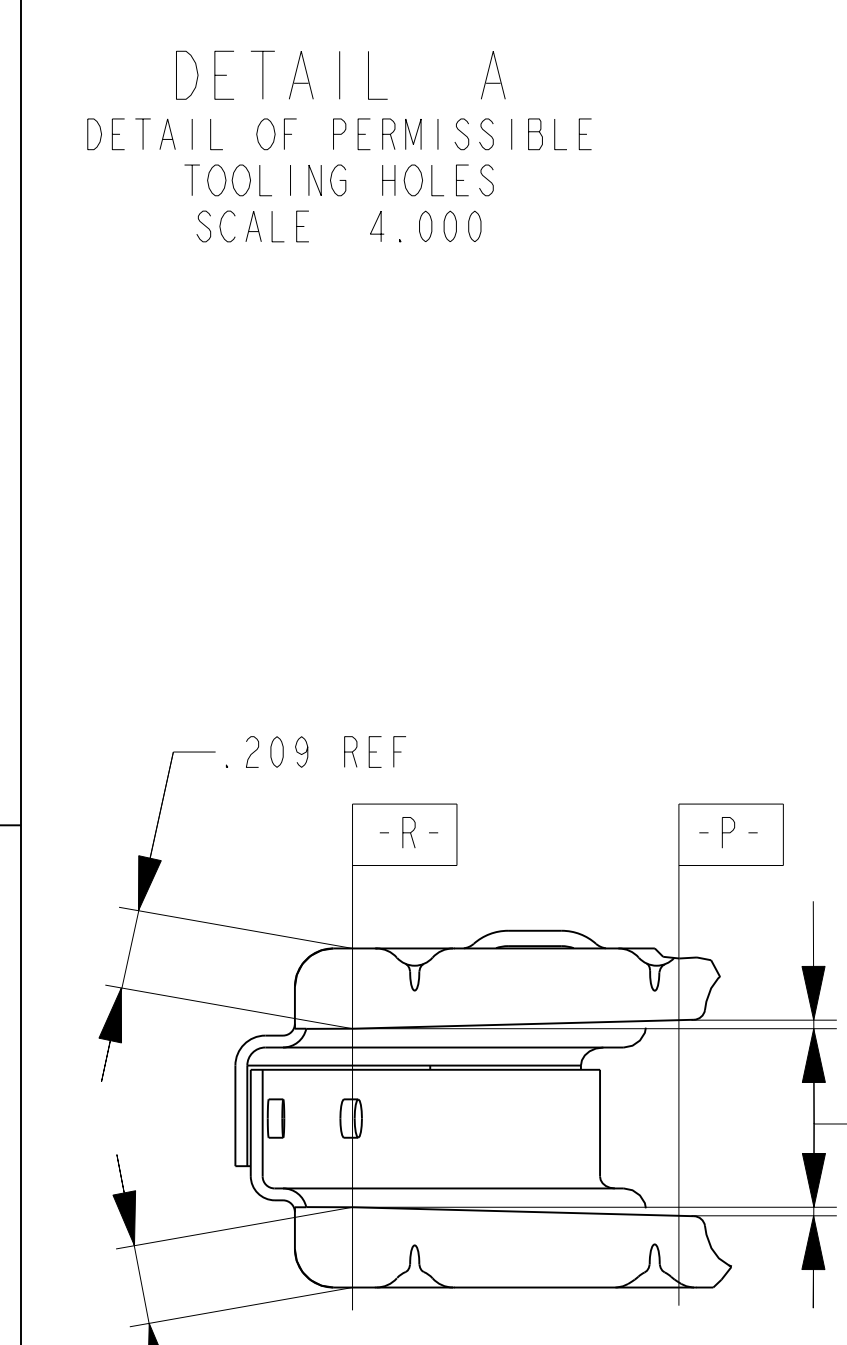
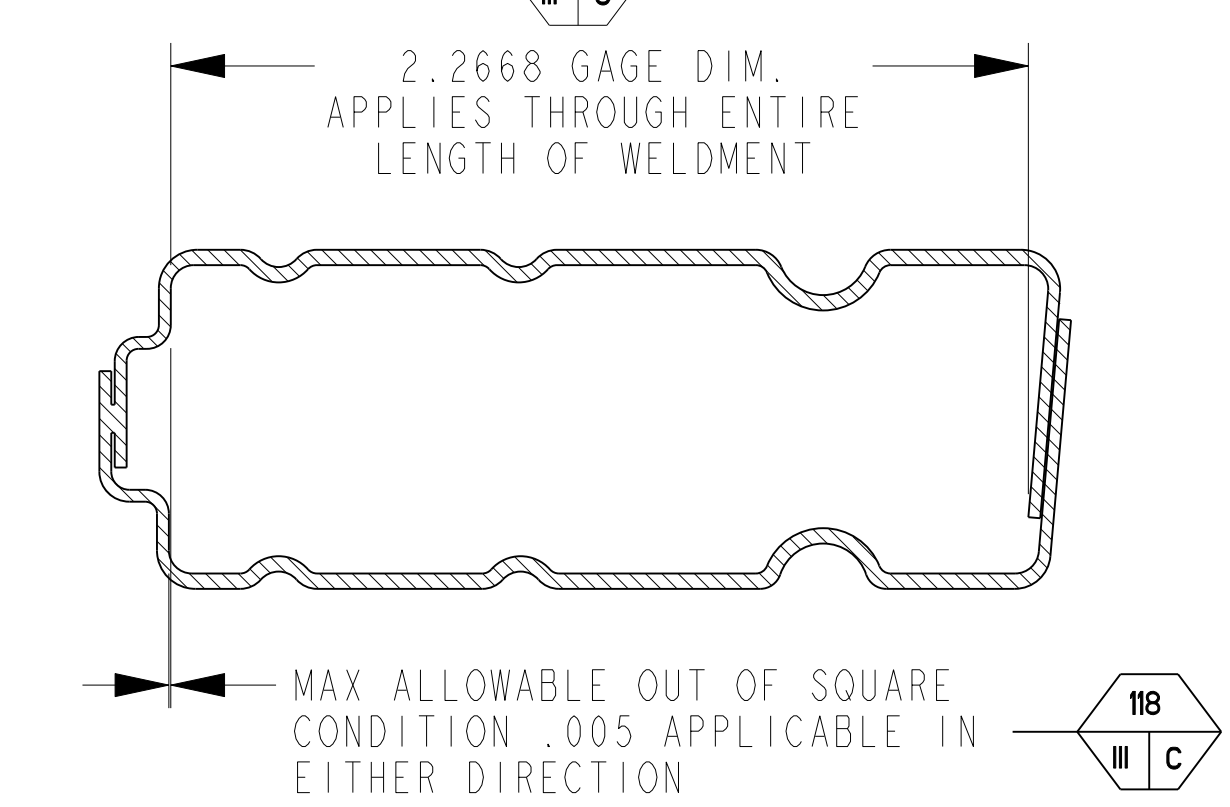
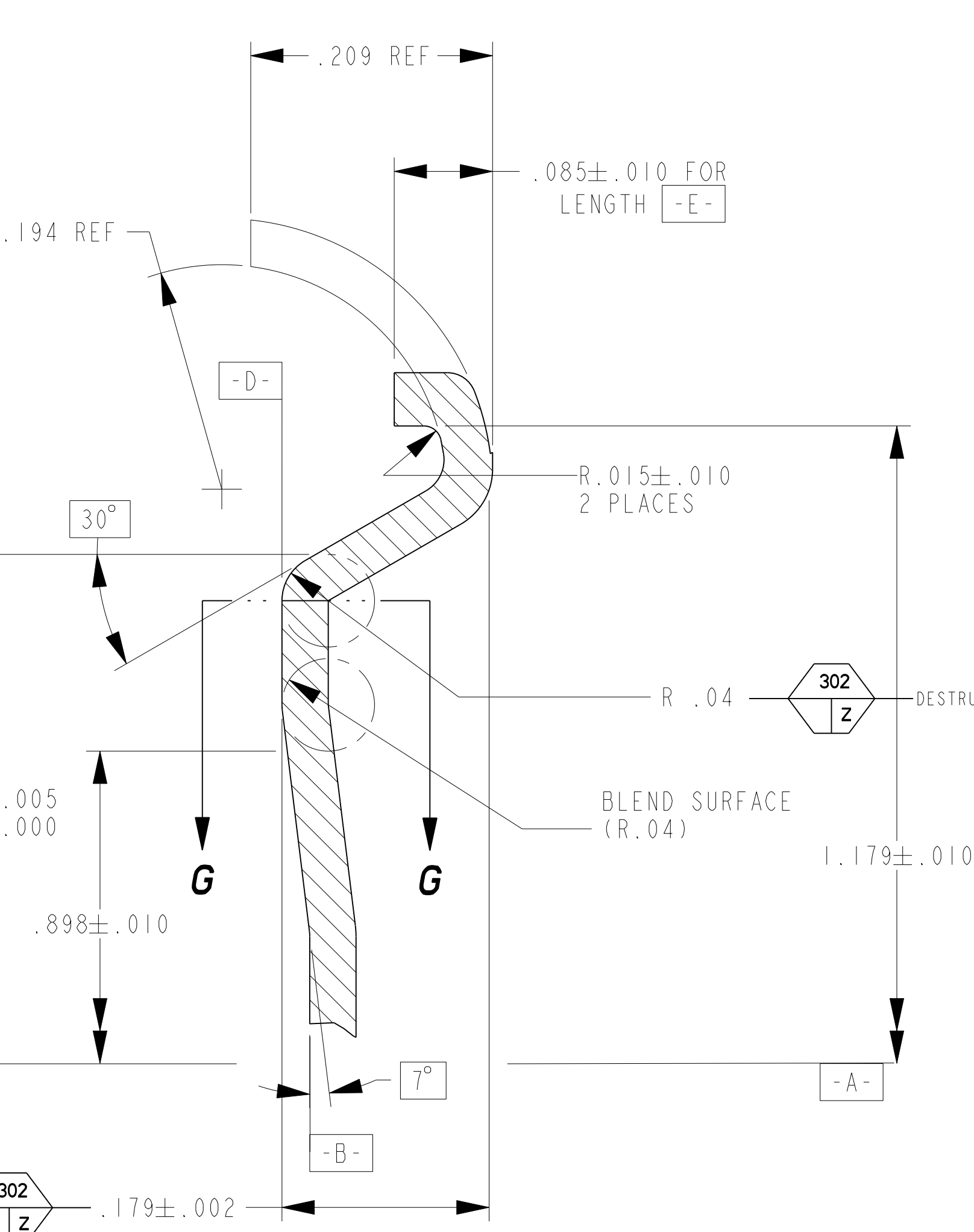
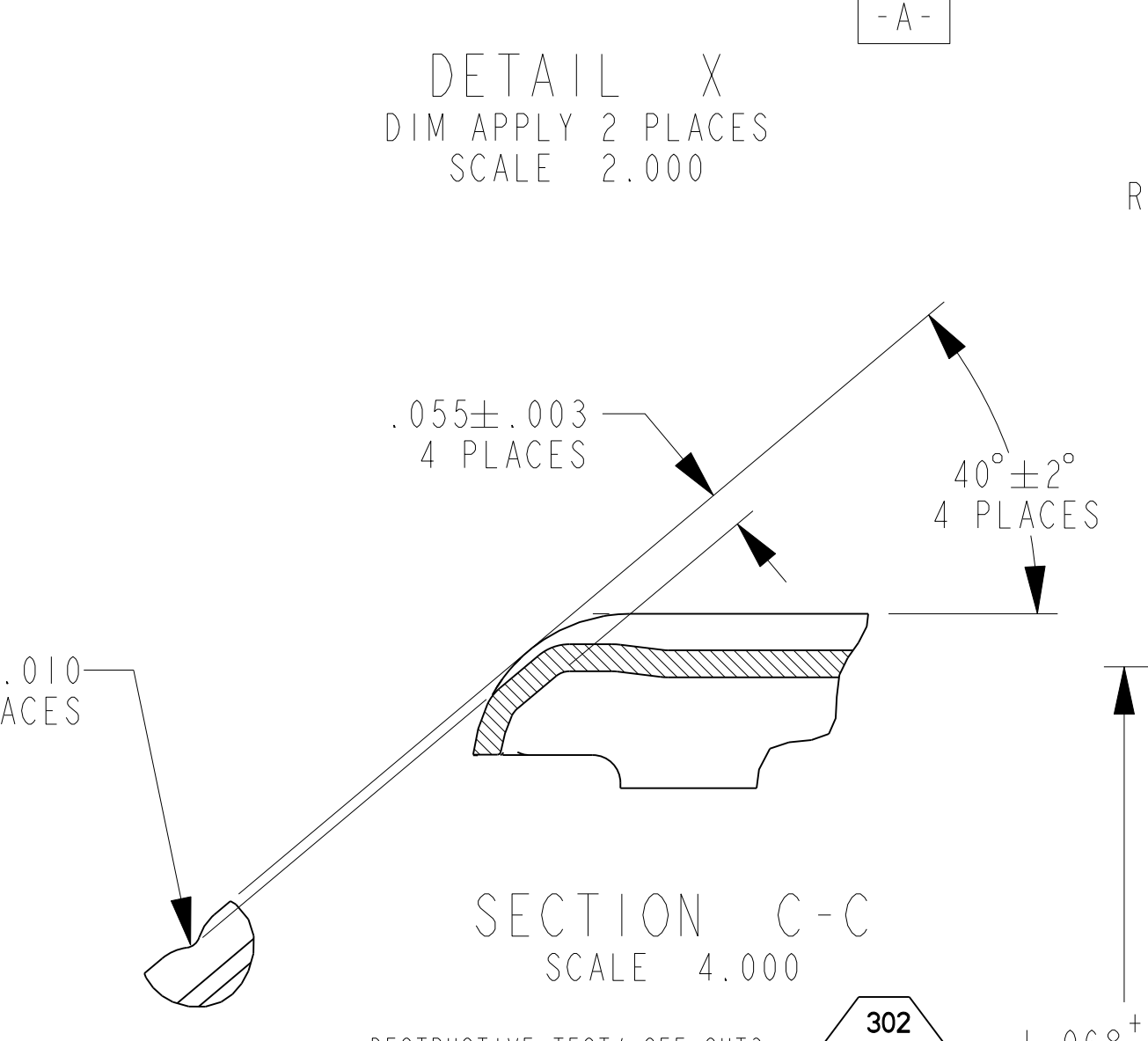
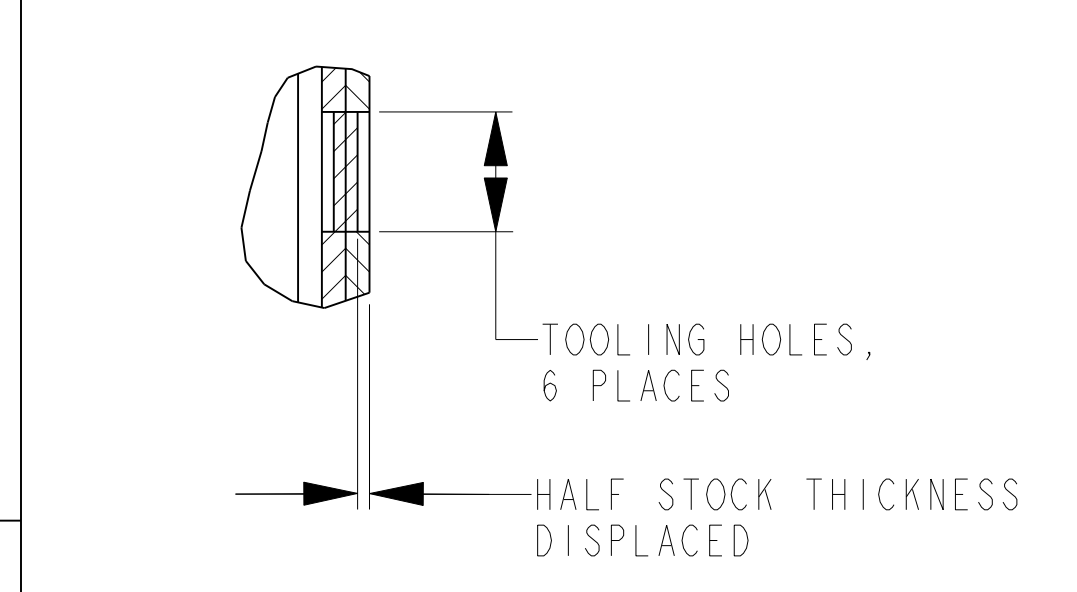
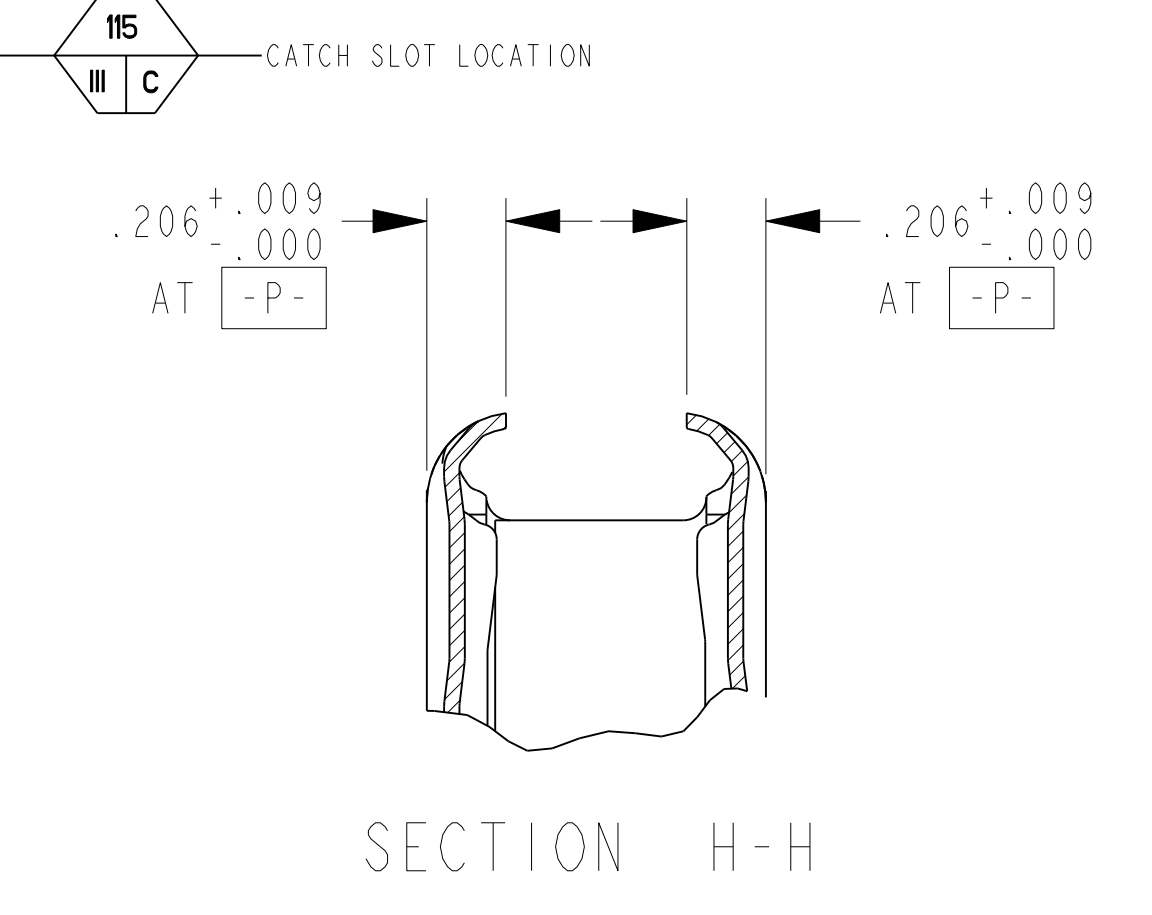
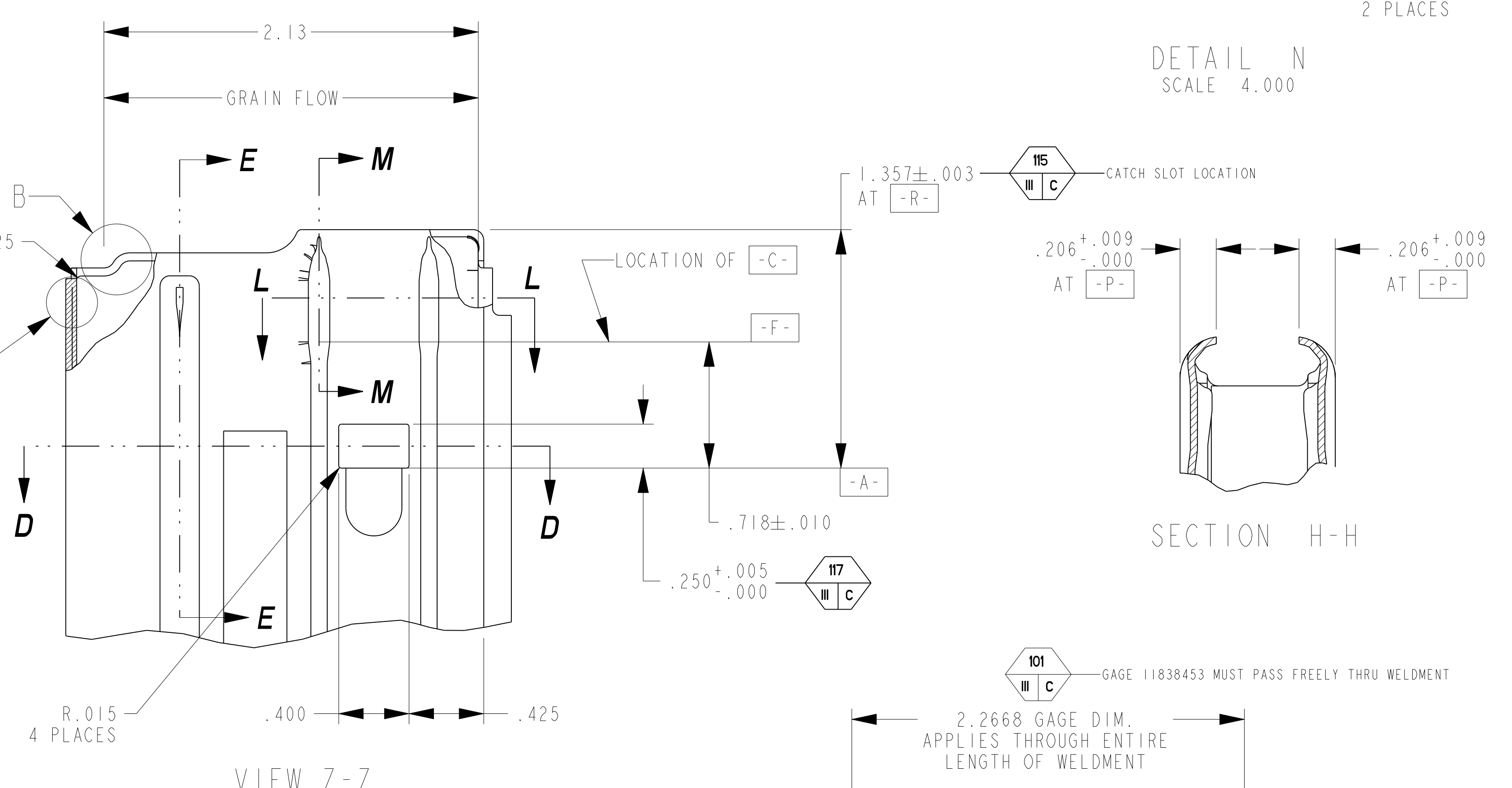
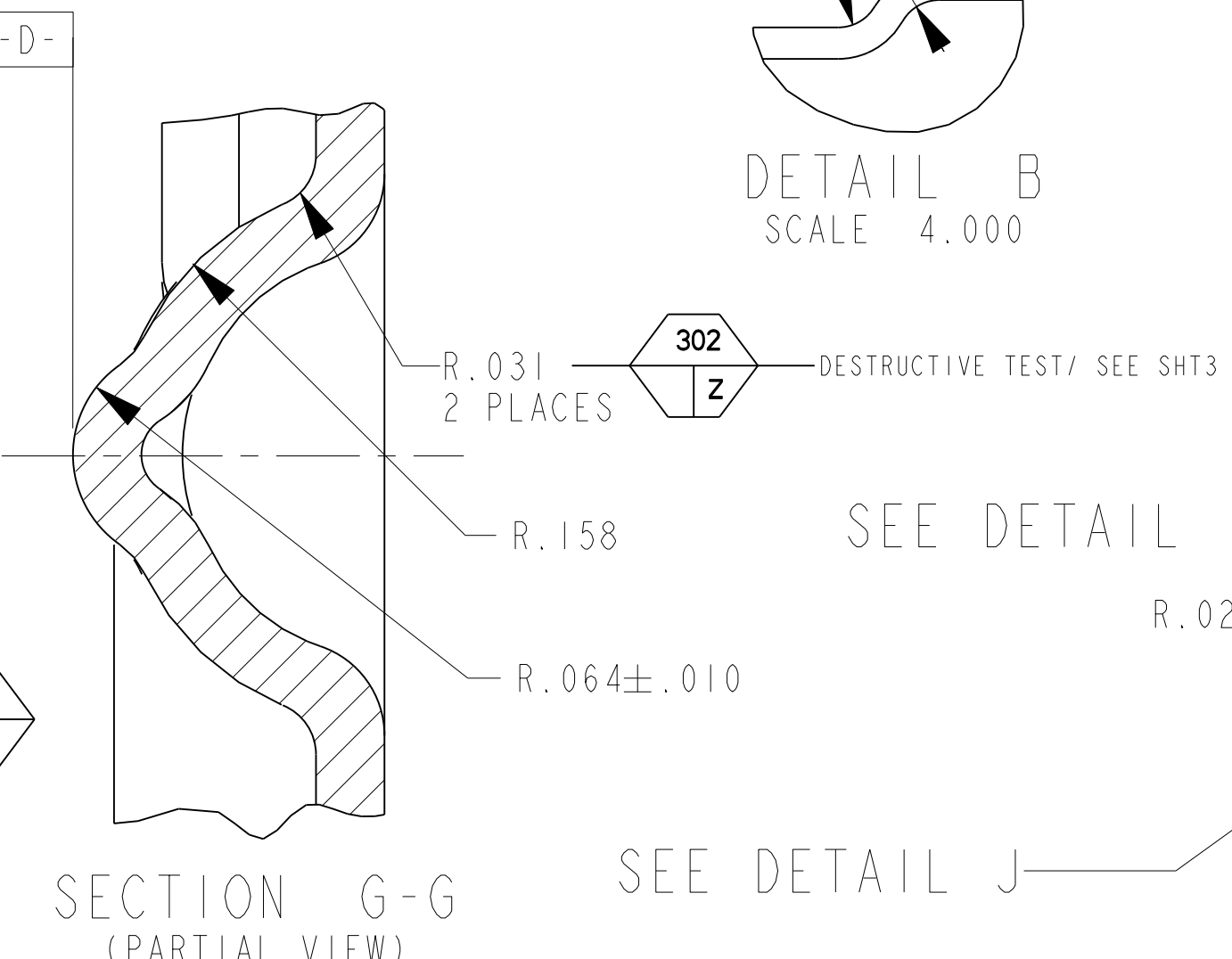
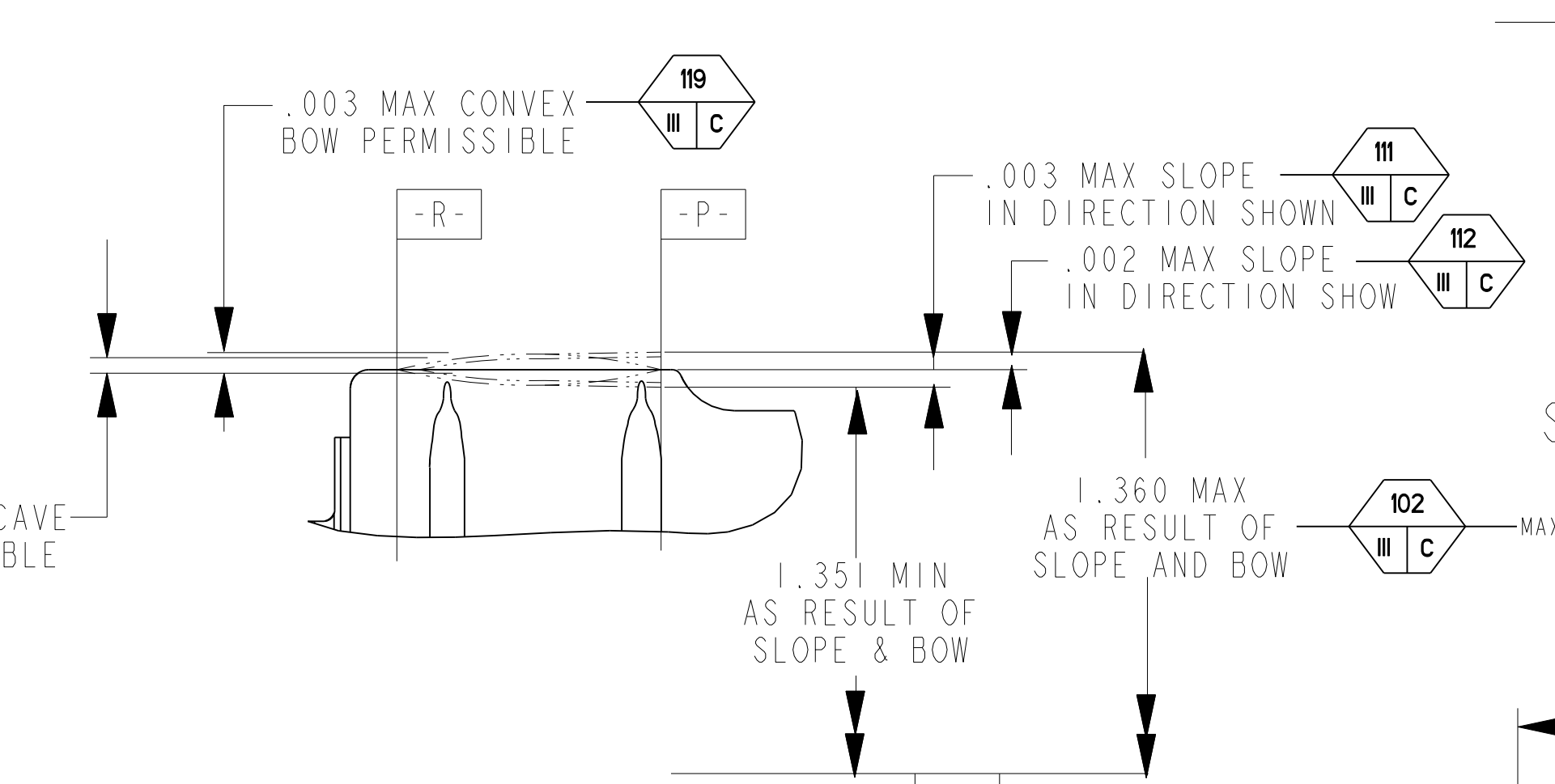
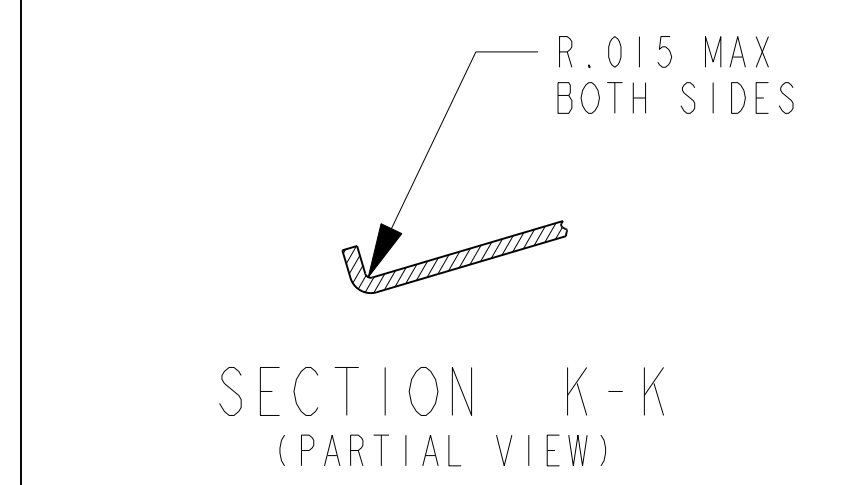
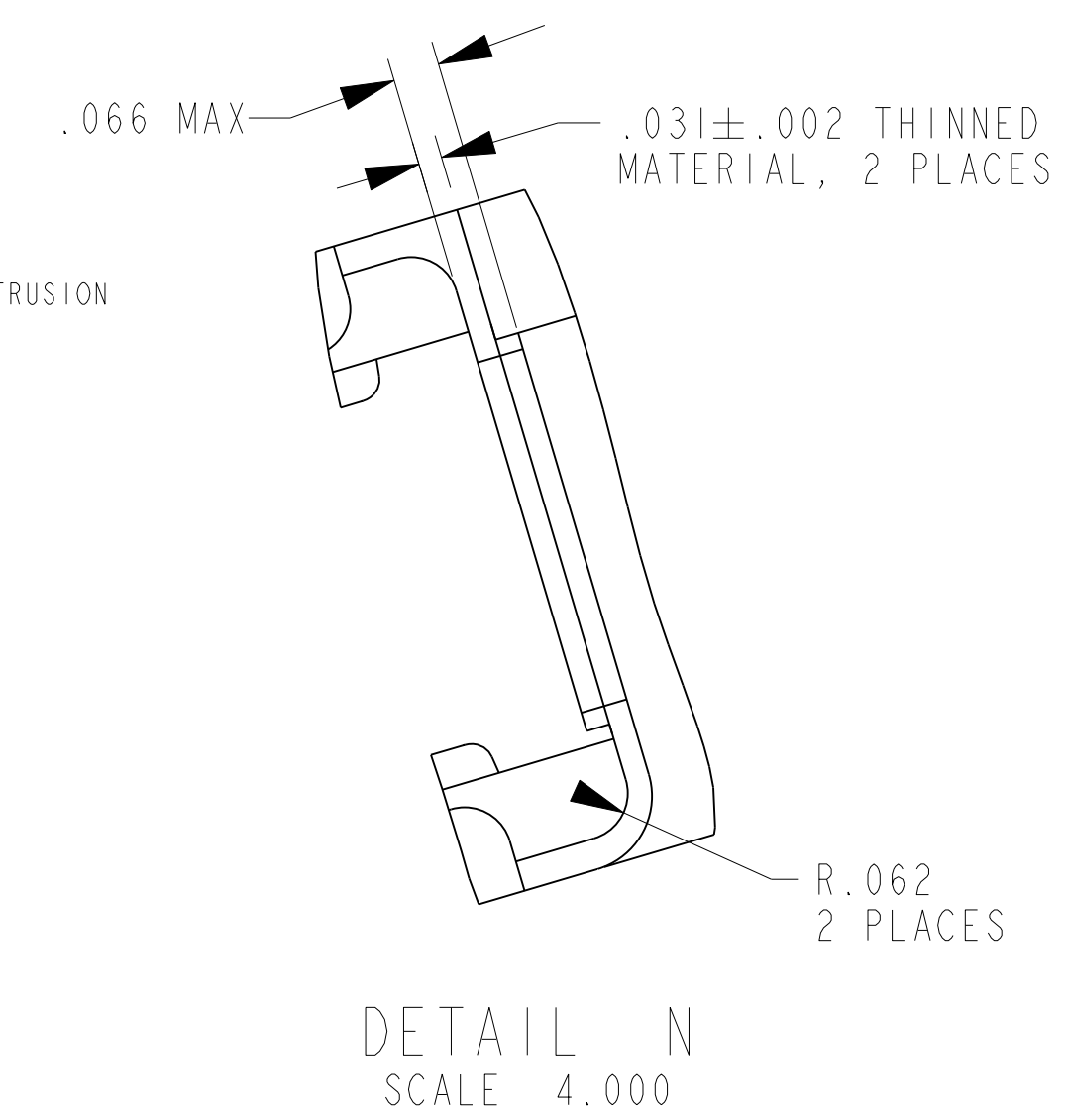
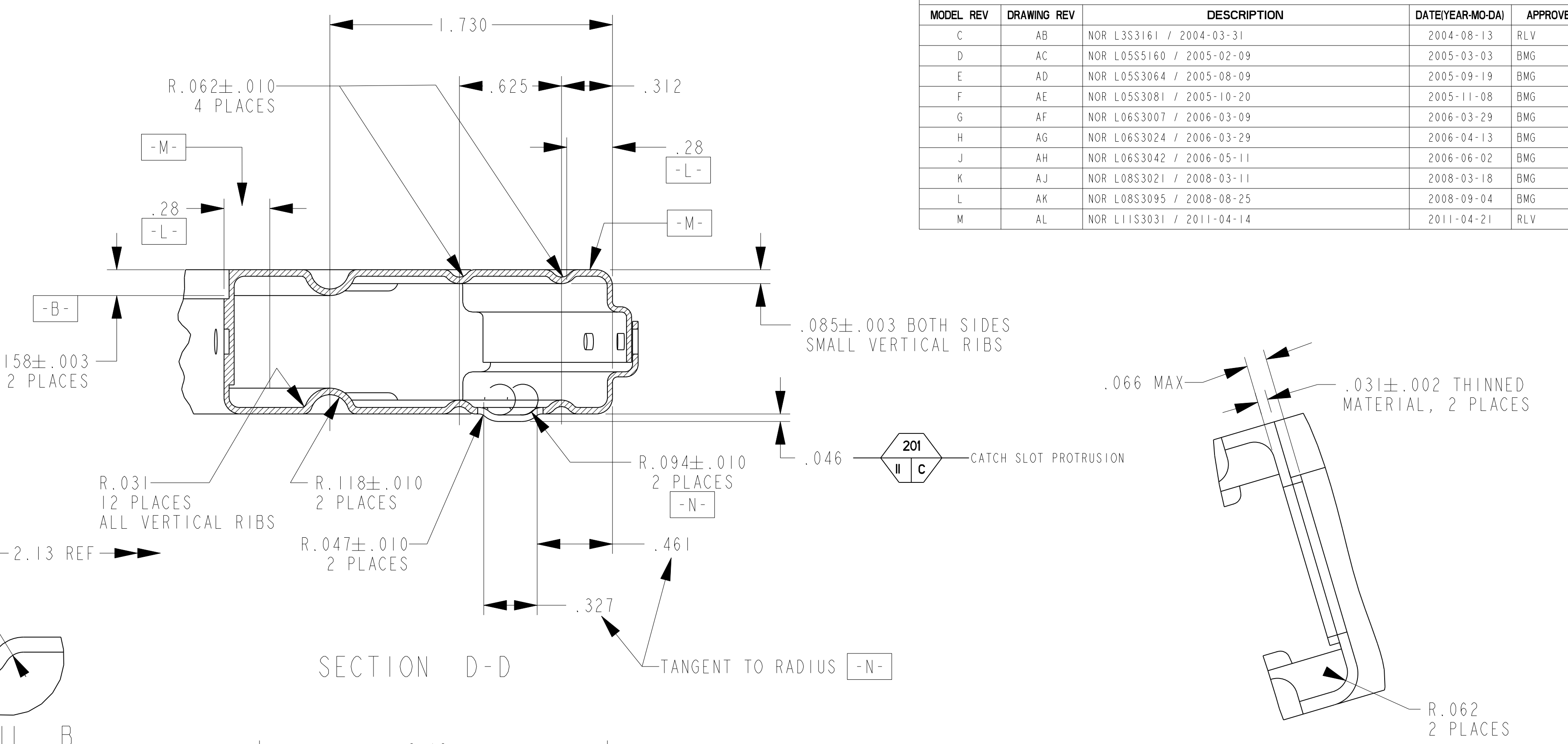
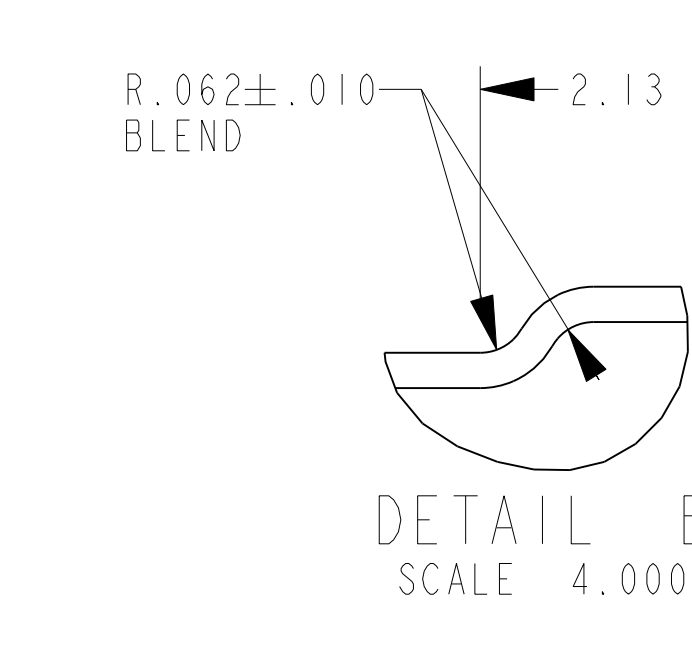
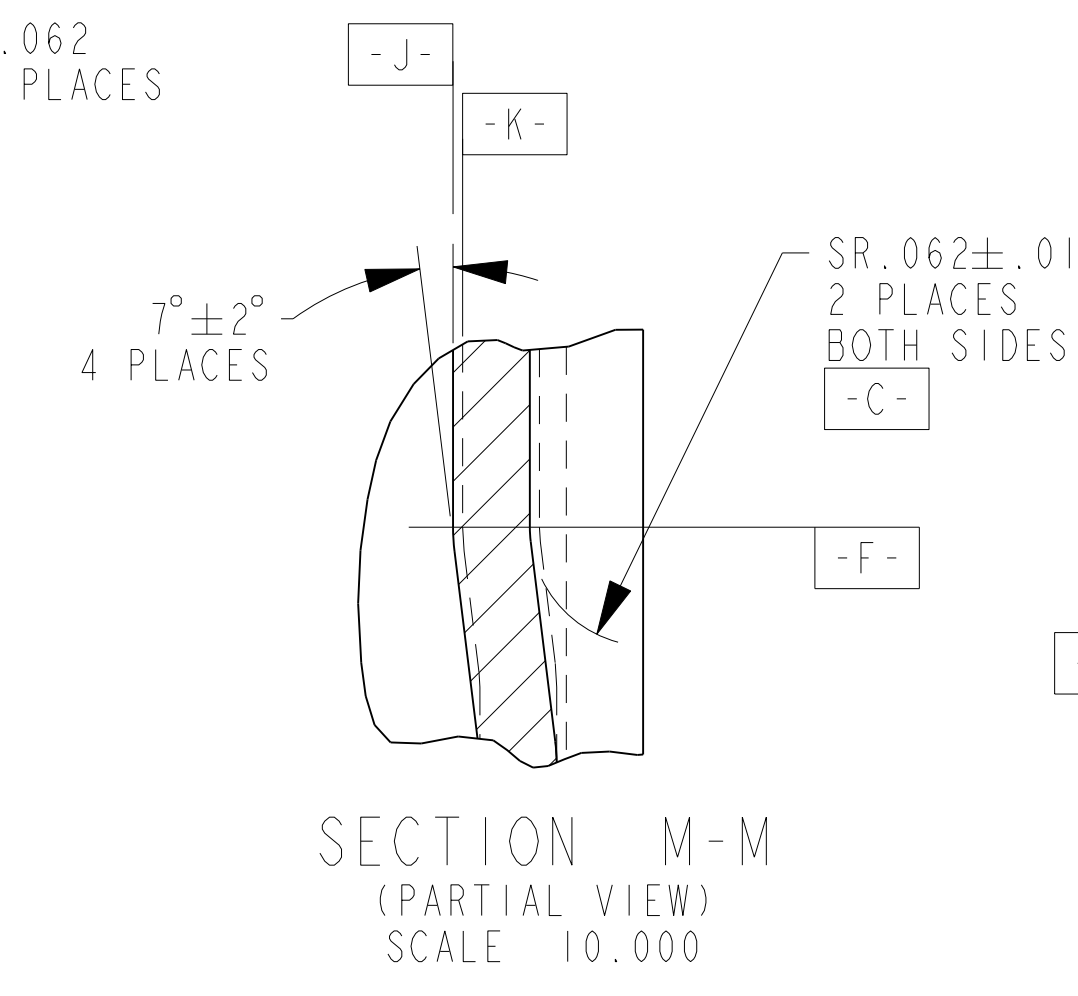
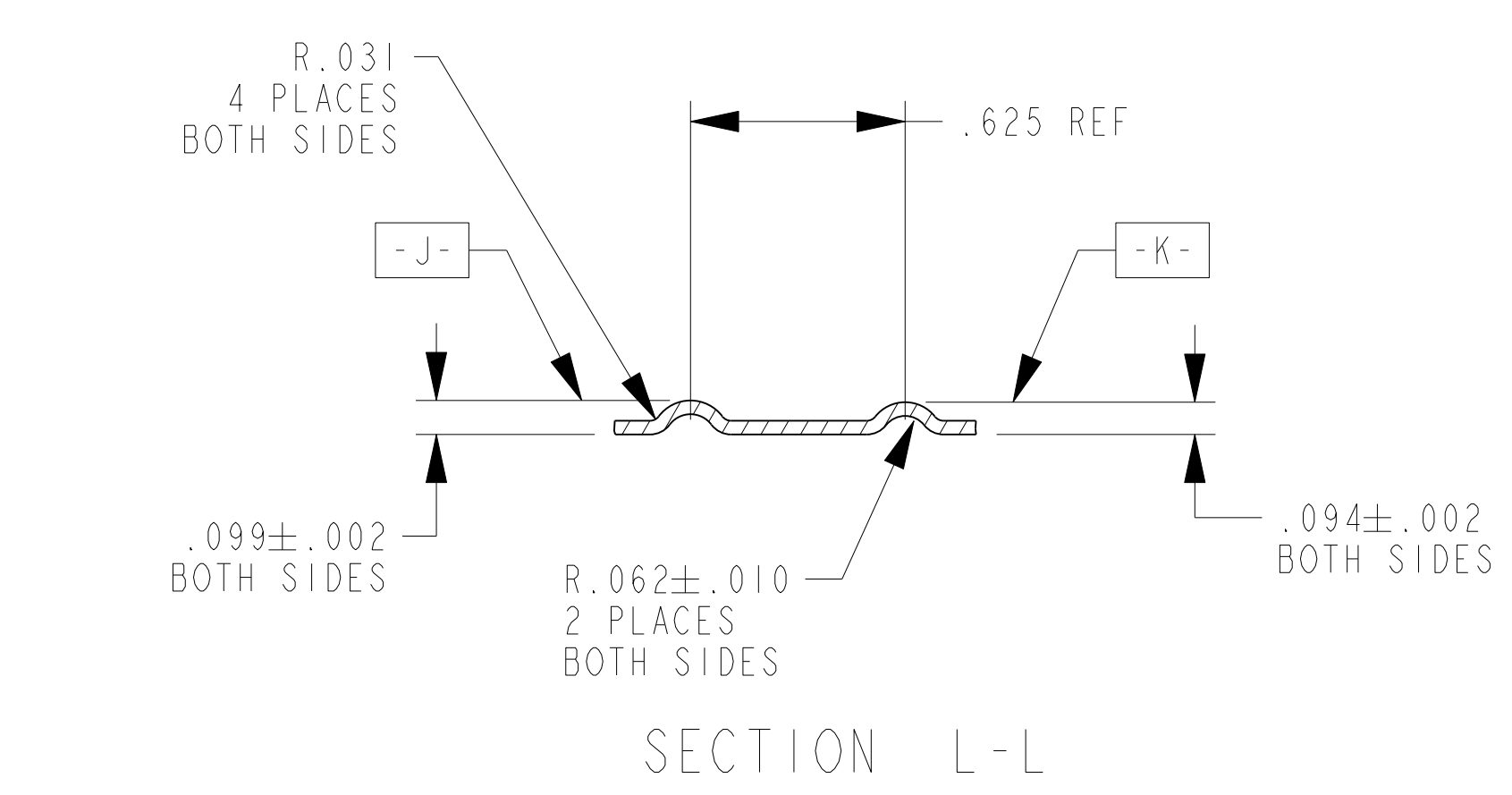
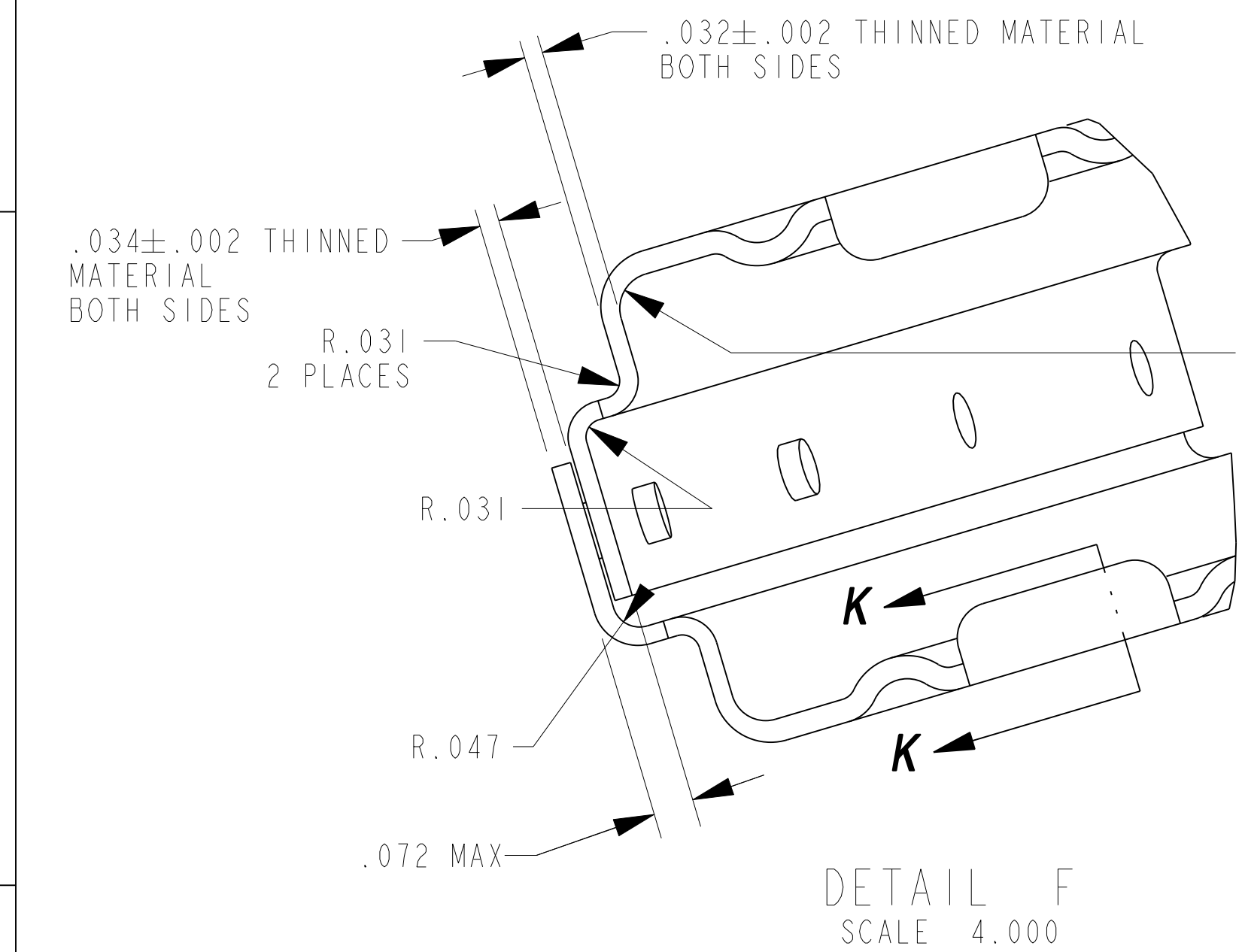
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MODEL REV		DRAWING REV		REVISIONS		
				DESCRIPTION	DATE(YEAR-MO-DA)	APPROVED
C	AB	NOR	L353161 / 2004-03-31		2004-08-13	RLV
D	AC	NOR	L055160 / 2005-02-09		2005-03-03	BMG
E	AD	NOR	L0553064 / 2005-08-09		2005-09-19	BMG
F	AE	NOR	L0553081 / 2005-10-20		2005-11-08	BMG
G	AF	NOR	L0653007 / 2006-03-09		2006-03-29	BMG
H	AG	NOR	L0653024 / 2006-03-29		2006-04-13	BMG
J	AH	NOR	L0653042 / 2006-05-11		2006-06-02	BMG
K	AJ	NOR	L0853021 / 2008-03-11		2008-03-18	BMG
L	AK	NOR	L0853095 / 2008-08-25		2008-09-04	BMG
M	AL	NOR	L1153031 / 2011-04-14		2011-04-21	RLV



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PMIC	M231 M4A1 M4	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	CONTRACT NUMBER	DESIGN ACTIVITY
MECHANICAL PROPERTIES	M16A4 M16A3 M16A2 M16A1	TOLERANCES ON ANGLES ± 1° 2 PLACE DECIMALS ± 01 3 PLACE DECIMALS ± 005	CONTRACTOR	US ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILLINOIS
YP		THIRD ANGLE PROJECTION	DRAWN BY	BOX, MAGAZINE, 30 ROUND
TS			CHECKER	
EL2	13021312		ENGINEER	
RA	8448670		ENGINEER	SIZE
BH	NEXT ASSY	USED ON	QUALITY ENGINEER	CAGE CODE
RH			DESIGN APPROVAL	DWG NO.
	APPLICATION	MATL ENGR		8448674
		MODELED BY		SCALE
				2.000
				UNIT WT.
				0.185
				SHEET
				2 OF 3

8 7 6 5 4 3 2 1

DRAWING SIZE F

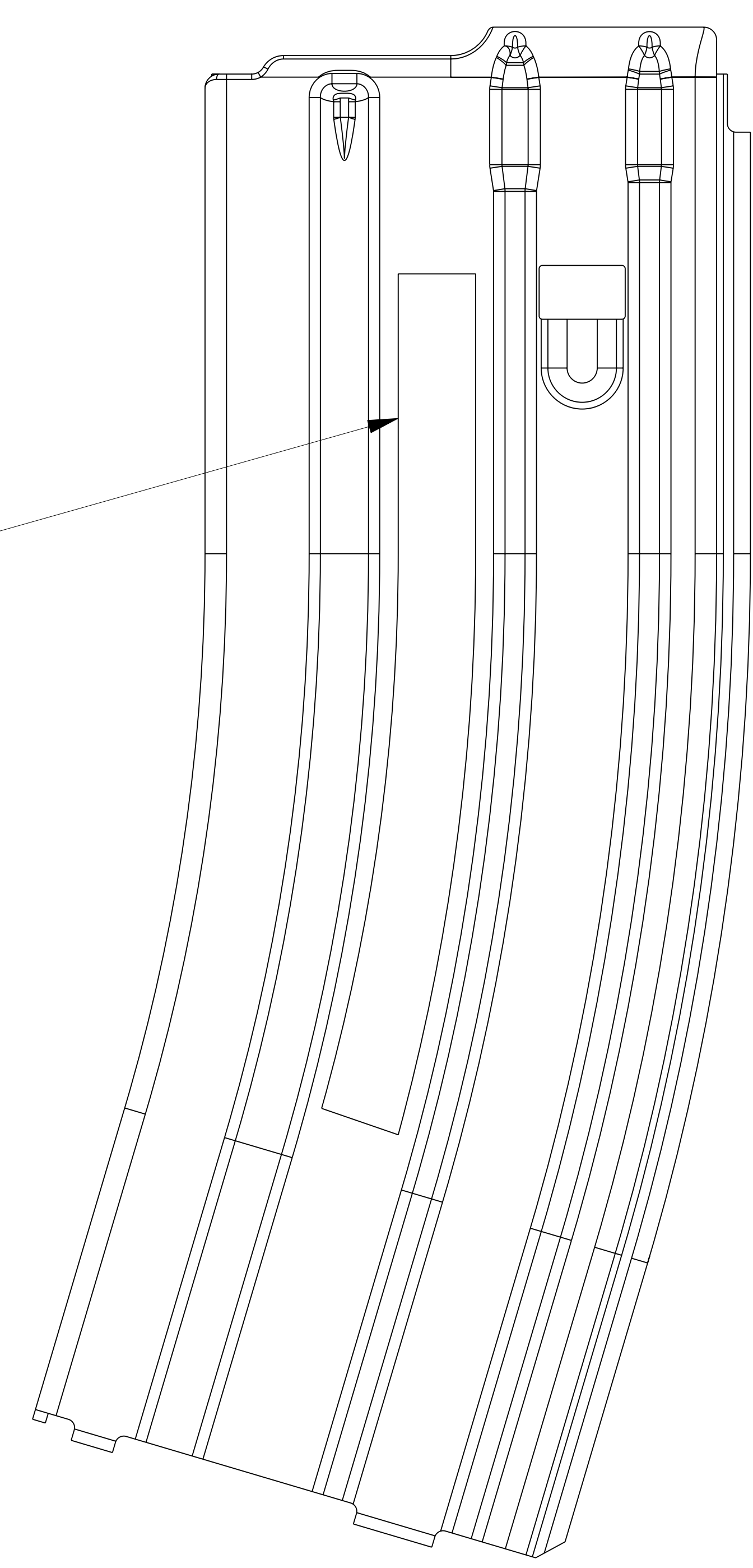
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REVISIONS				
MODEL REV	DRAWING REV	DESCRIPTION	DATE(YEAR-MO-DA)	APPROVED
C	AB	NOR L353161 / 2004-03-31	2004-08-13	RLV
D	AC	NOR L0555160 / 2005-02-09	2005-03-03	BMG
E	AD	NOR L0553064 / 2005-08-09	2005-09-19	BMG
F	AE	NOR L0553081 / 2005-10-20	2005-11-08	BMG
G	AF	NOR L0653007 / 2006-03-09	2006-03-29	BMG
H	AG	NOR L0653024 / 2006-03-29	2006-04-13	BMG
J	AH	NOR L0653042 / 2006-05-11	2006-06-02	BMG
K	AJ	NOR L0853021 / 2008-03-11	2008-03-18	BMG
L	AK	NOR L0853095 / 2008-08-25	2008-09-04	BMG
M	AL	NOR L1153031 / 2011-04-14	2011-04-21	RLV



STM-301: SPOT WELD TEST.
APPLY UNIFORM STATIC LOAD OF 100 POUNDS PRESSURE TO EACH WELD (12) USING GAGE NUMBER 11837923. THE PRESSURE SHALL BE APPLIED WITHIN LENGTH -L- OPPOSITE EACH WELD IN THE DIRECTION OF -M-. EACH SPOT WELD SHALL BE INSPECTED APPLYING A .004 FEELER GAGE OR EQUIVALENT THROUGHOUT LENGTH OF MAGAZINE; NO PASSAGE OF THE FEELER GAGE THROUGH THE SPOT WELD WILL BE ALLOWED. FAILURE OF ANY SPOT WELD SHALL BE CAUSE FOR REJECTION OF THAT INDIVIDUAL MAGAZINE. REJECTION OF MAGAZINES IN EXCESS OF THAT ALLOWED BY THE AOL SPECIFIED SHALL BE CAUSE FOR REJECTION OF THE LOT QUANTITY REPRESENTED.

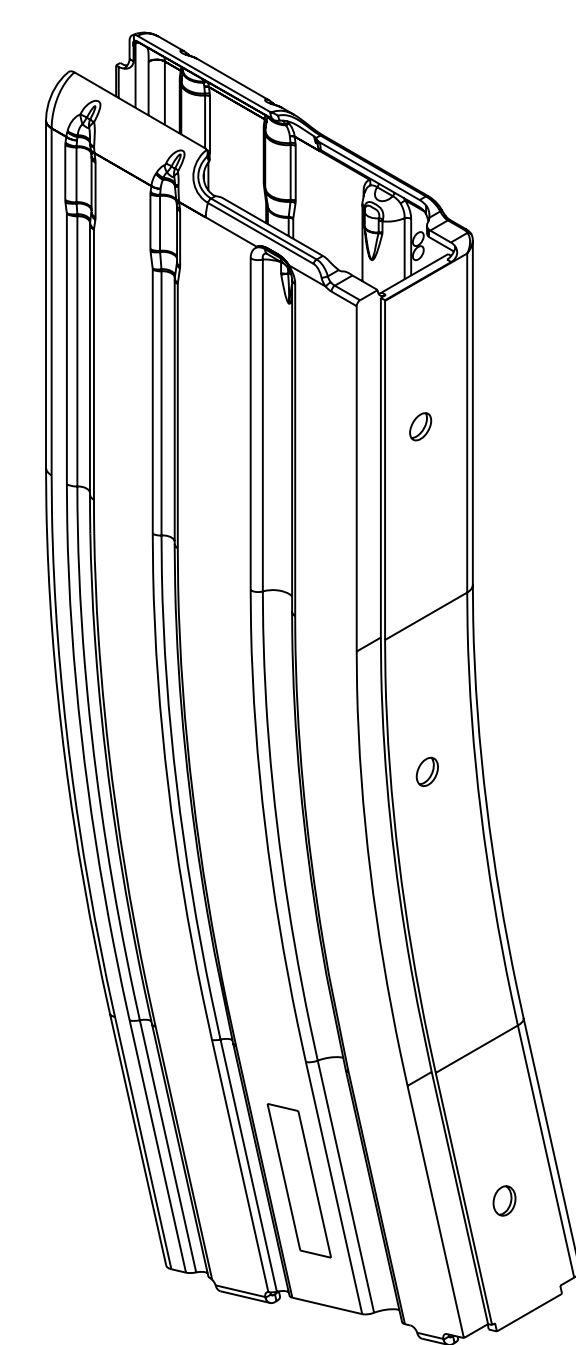
THE FOLLOWING IS THE SPOT WELD DEFECT CRITERIA:

- (A) CRACKS IN THE WELD:
- (1) CRACKS IN THE WELD AREA SHALL NOT EXCEED 50 PERCENT OF THE DIAMETER OF THE WELD.
 - (2) CRACKS SHALL BE WITHIN THE WELD DIAMETER ONLY.
- (B) POROSITY IN THE WELD:
- (1) POROUS HOLES (SEVERAL SMALL HOLES WITHIN A SMALL AREA) SHALL NOT EXCEED 50 PERCENT OF THE DIAMETER OF THE WELD.
 - (2) THE POROSITY SHALL BE WITHIN THE WELD DIAMETER ONLY.
- (C) BURN HOLES IN THE WELD:
- (1) BURN HOLES (ONE HOLE IN WELD) SHALL NOT EXCEED 25 PERCENT OF THE WELD AREA.
 - (2) BURN HOLES SHALL BE WITHIN THE WELD DIAMETER ONLY AND SHALL NOT PENETRATE THROUGH BOTH LAYERS OF THE WELDED METAL.
- (D) LIMITS:
- (1) EACH WELD THAT CONTAINS A DEFECT SHALL PASS THE 100 POUND LOAD TEST OF NOTE 7 OF DRAWING 8448674.
 - (2) THERE SHALL BE NO MORE THAN TWO WELD DEFECTS PER SIDE OF THE MAGAZINE BOX ASSEMBLY AND NOT MORE THAN THREE WELD DEFECTS PER MAGAZINE BOX ASSEMBLY TOTAL.
 - (3) THE DEFECTS DESCRIBED IN PARAGRAPH 1A, 1B, AND 1C ARE CUMULATIVE, I.E. ONE CRACK AND ONE BURN HOLE ON A MAGAZINE BOX ASSEMBLY COUNTS AS TWO DEFECTS.

STM-302: DESTRUCTIVE TEST.
ONE MAGAZINE FROM EACH INSPECTION LOT SHALL BE RANDOMLY SELECTED BY A GOVERNMENT REPRESENTATIVE AND INSPECTED FOR THE FOLLOWING DIMENSIONAL REQUIREMENTS OF DRAWING F8448674, SHEET 2 OF 3.

- (A) R.04 AT 1.068 LOCATION (SECTION E-E).
- (B) 1.068±.005 (SECTION E-E).
- (C) .179±.002 (SECTION E-E).
- (D) R.031±.005 (SECTION G-G).

BOTH HALVES OF THE MAGAZINE SHALL BE INSPECTED. A GOVERNMENT REPRESENTATIVE SHALL WITNESS THE INSPECTION.



ISOMETRIC VIEW
SCALE 1:000

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

PART NO. 8448674

DESIGN ACTIVITY		
US ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILLINOIS		
BOX, MAGAZINE, 30 ROUND		
SIZE	CAGE CODE	DWG NO.
F	19204	8448674
SCALE	UNIT WT.	SHEET
2.000	0.185	3 OF 3