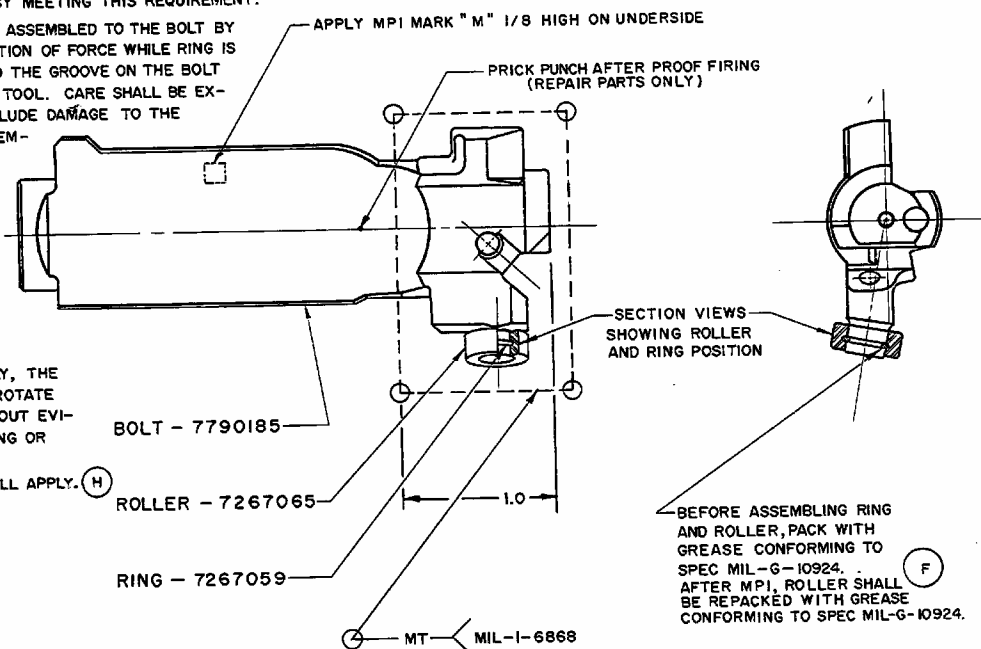


NOTES:

- EACH REPAIR PART BOLT AND ROLLER ASSY SHALL WITHSTAND THE FIRING OF ONE GOVERNMENT STANDARD HIGH PRESSURE TEST CARTRIDGE WITHOUT EVIDENCE OF FAILURE AS DETERMINED BY MAGNETIC PARTICLE INSPECTION FOR CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS, USING A STANDARD 5 TURN MAGNETIZING COIL WITH A CURRENT OF 200 TO 250 AMPERES. APPLY MPI MARK TO ASSY MEETING THIS REQUIREMENT.
- ROLLER SHALL BE ASSEMBLED TO THE BOLT BY GRADUAL APPLICATION OF FORCE WHILE RING IS COMPRESSED INTO THE GROOVE ON THE BOLT WITH A SUITABLE TOOL. CARE SHALL BE EXERCISED TO PRECLUDE DAMAGE TO THE RING DURING ASSEMBLY OPERATION.
- AFTER ASSEMBLY, THE ROLLER SHALL ROTATE SMOOTHLY WITHOUT EVIDENCE OF BINDING OR DRAG.
- MIL-W-13855 SHALL APPLY. (H)



LONGITUDINAL RESIDUAL MAGNETIZATION
WITH WET FLUORESCENT SOLUTION. (SEE NOTE 1)

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

EGOE IDENT NO. 192205

| SYN | DESCRIPTION | DATE | APPROVED |
|-----|---|-----------|----------|
| L | NORG2S2038/921021 ECPG2S2042/921021 | 921230 | sa PR |
| K | ECPW5S2069/1651223 NORW4S2051/840824 | 85012 | SA PR |
| J | NORW8S2022/79-03-26 | 79-04-01 | SA PR |
| H | SEE EO HRD 02138 | 71FEB28 | SA PR |
| G | (1) SEE EO HRD 92078-2 | 25 JUN 83 | SA PR |
| F | SEE EO RIA-14182 | 18MAY87 | SA PR |
| E | SEE EO SA 29261 | 18MAY86 | SA PR |
| D | SEE EO SA 26910 | 26AUG63 | SA PR |
| C | SEE EO SA 26046 | 15FEB 61 | SA PR |
| B | SEE EO SA 25810 | 30SEP60 | SA PR |
| A | SEE EO SA 25232 | 11SEP59 | SA PR |

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FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7790186

| PHYSICAL PROPERTIES | | TOLERANCES ON DECIMALS | | ORIGINAL DATE OF DRAWING | BOLT AND ROLLER ASSEMBLY |
|-----------------------|----------|-------------------------|-----------|--|--------------------------|
| TP | | ANGLES | FRACTIONS | 10 JUL 58 | |
| TS | | MATERIAL | | DRAFTSMAN R.E.K. CHECKER | |
| CL 3 | C7790187 | RIFLE, M14 | | TRACER CHECKER | |
| RA | | HEAT TREATMENT | | ENGINEER W.H. HENRY ENGINEER | |
| BT | | USED ON | | SUBMITTED | |
| AP | | APPLICATION | | R.D. Henry ORD CORPS | |
| DO NOT APPLY PART NO. | | FINAL PROTECTIVE FINISH | | APPROVED BY ORDER OF THE CHIEF OF ARMS | |
| DO | | | | R.D. Henry ORD CORPS | |
| | | | | SCALE 2/1 | UNIT WT |
| | | | | C 7790186 | |
| | | | | RHM | |