



- NOTES:
1. WELD SHALL WITHSTAND PEEL TEST PER PAR 7.3.3.1 OF MIL-W-12332 EXCEPT THAT IN LIEU OF MINIMUM BUTTON DIA REQUIREMENT THE WELD SHALL BE SATISFACTORY IF THE PEEL TEST CAUSES TEARING OF THE THINNER BASE METAL AROUND THE PERIPHERY OF THE WELD.
 2. HEAT TREATMENT: HEAT TO 1525°-1550° F. QUENCH IN CIRCULATING OIL. TEMPER 45 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
 3. LOCATION AND SIZE OF BUTTONS ON PLATE AND HOLES IN TUBE SHALL BE ADJUSTED TO MEET ASSY REQUIREMENTS AND SHALL NOT INTERFERE WITH WELDING REQUIREMENTS. SEE ALTERNATIVE DESIGNS IN ZONES B-2 AND A-6.
 4. FINAL PROTECTIVE FINISH: 5.3.1.2. OR 5.3.2.2. OF MIL-STD-171.
 5. MIL-W-13855 SHALL APPLY.

PLATE-7790198

TUBE-7790181

THIS SURFACE SHALL BE FREE OF WELD PROTRUSIONS

ALTERNATIVE METHOD

ALTERNATIVE DESIGN (SEE NOTE 3)

D7790197

BUTTONS SHALL NOT PROTRUDE BEYOND INNER SURFACE OF TUBE.

ORIGINAL FSCM NO. 19205
CURRENT DESIGN ACTIVITY FSCM NO. 19200
U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07801

P	ECWPWS2065	783223	
N	NORW452051/940824	860121	
N	NOR W882022/79-09-28	79-04-01	SA 2544
M	(2) SEE ERR HQR 4066	NOV 74	
K	SEE EO HRD 02139	77FEB 78	
K	(2) SEE EO HRD 92079-2	25 JAN 82	
J	(1) SEE EO 82048	11 MAR 82	
H	(1-10) SEE EO SA 25282	18 MAY 82	
G	SEE EO SA 24221	11 MAR 82	
F	SEE EO SA 25981	15 DEC 82	
E	SEE EO SA 25811	10 SEP 82	
D	SEE EO SA 25657	14 APR 82	
C	SEE EO SA 25441	15 JAN 82	
B	SEE EO SA 25398	11 SEP 82	
A	SEE EO SA 25007	23 JAN 82	
5TH	DESCRIPTION	DATE	APPROVAL

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7790197

PART NO. 7790197

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 12 JUN 1958		DEPT OF THE ARMY	
TP		TOLERANCES ON DECIMALS ± .01		DESIGNED BY P. CHECKER	CHECKED J.K.	ROCK ISLAND ARSENAL	
TR		FRACTIONS ± 1/64		MATERIAL	ENGINEER	ROCK ISLAND MILITARY DEPOT	
SL	D7790183			HEAT TREATMENT	APPROVED BY R.B. Henry	D 7790197	
SA	RIFLE, M14M			SEE NOTE 2	OR CORPS	SCALE 2/1 UNIT WT	
SH				FINAL PROTECTIVE FINISH: SEE NOTE 4		RHM	
SI							
SM	A71-76						
DO NOT	APPLICATION	USED ON					
APPLY PART NO.							