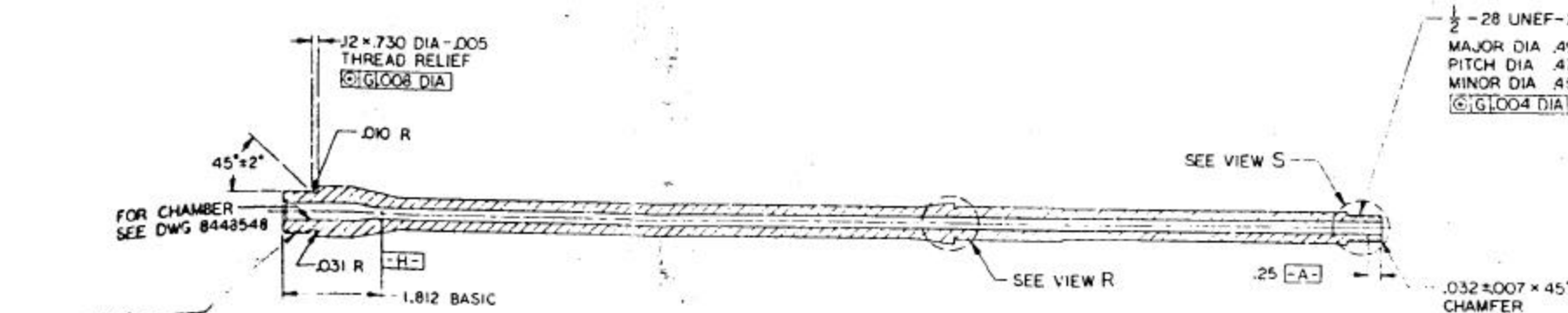
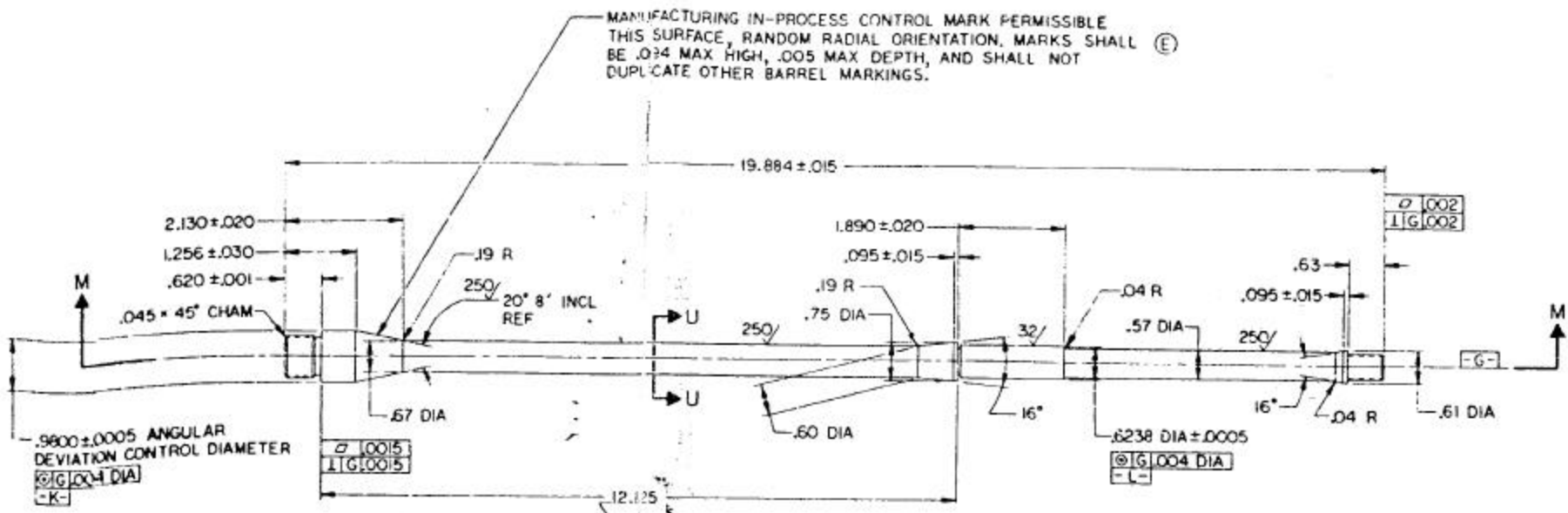


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NOTES:

1. STEEL, CMPSN CHROME-MOLY-VANADIUM, SPEC MIL-S-11595.
2. CENTER LINE [G] ESTABLISHED BY BORE DIAMETER AT MUZZLE AND AT POINT [H]. ALL DIAMETERS [G] UNLESS OTHERWISE SPECIFIED.
3. BREAK SHARP EDGES .005-.010 UNLESS OTHERWISE SPECIFIED.
4. WHERE NOTED, DIMENSIONAL LIMITS AND SURFACE ROUGHNESS DESIGNATIONS APPLY AFTER CHROME PLATING.
5. RIFLING TO BE SIX GROOVES, RIGHT HAND, WITH ONE TURN IN 12.000 ± .125.
6. 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.
7. 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.
8. 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.
9. 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:
  1. DIAMETRAL REDUCTION OF BORE AND GROOVE DIAMETERS SHALL BE .0001 DIA MAX FOR LENGTH [A].
  2. NO BORE DIAMETER SHALL BE MORE THAN .0004 LARGER THAN THE SMALLEST PREVIOUSLY MEASURED BORE DIAMETER.
  3. NO GROOVE DIAMETER SHALL BE MORE THAN .0004 LARGER THAN THE SMALLEST PREVIOUSLY MEASURED GROOVE DIAMETER.
10. MIL-W-13855 APPLIES.



13  
16 - 16 UN - 3A MOD  
MAJOR DIA .8080 / .8000 MOD  
[G] .008 DIA  
PITCH DIA .7719 / .7683  
[G] .004 DIA  
MINOR DIA .7358 MAX

SECTION M-M

REV	DATE	DESCRIPTION	BY	CHKD
D	14 DEC 75	REPLACES REV C W/ CHANGE SEE ERR NOR 20827		
E	2 MAR 75	SEE ERR NOR 30645		
F	26 JAN 77	SEE NOR 77E0005-0002		
G	05 02 03	NOR W/CS 0026 RE-05-01		

MECHANICAL	DATE: 11/20/03	DESIGNER: J. W. W. W.	CONTRACT NO.
DRAWN: J. W. W. W.	SCALE: 1" = 1'-0"	PROJECT: 13855	
CHECKED: J. W. W. W.	DATE: 11/20/03	BY: J. W. W. W.	
APPROVED: J. W. W. W.			

PART NO. 8448549  
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