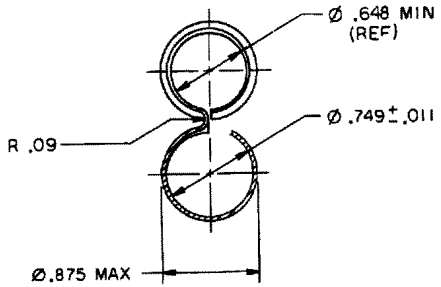
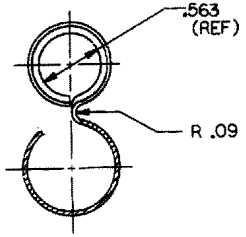
DRAWING SIZE D (ARRADCOM# 70-12)

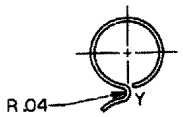
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
L	REDRAWN WITH CHANGE, ERB Z9Z1285R (ECP M752063, 87-11-19)	90-10-03	
R	NOR R8S2034 981209	990201	JB



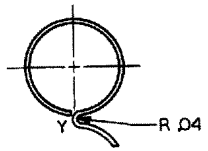
SECTION A-A



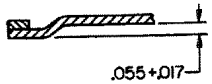
SECTION B-B



VIEW C-C
(NECK RING)
(SEE NOTE 5)



VIEW D-D
(BODY RING)
(SEE NOTE 5)



SECTION E-E
SCALE: 4/1

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

DISTRIBUTION STATEMENT A.
APPROVED FOR PUBLIC RELEASE;
DISTRIBUTION IS UNLIMITED.

PART NO. 7140393

FINAL / NEXT ASSY	CAL .50 / USED ON	MECHANICAL PROPERTIES: YP, TS, ELG, RA, BH, RH	DO NOT SCALE DRAWING. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON DECIMALS ± FRACTIONS ± ANGLES ± THIRD ANGLE PROJECTION	ORIGINAL DATE OF DRAWING 49-10-21	SPRINGFIELD ARMORY, SPRINGFIELD, MA
APPLICATION		C-41/49		DRAFTSMAN JB / CHECKED ECS; ENGR; CHIEF	LINK, CARTRIDGE, METALLIC BELT, CAL .50: M9
				W.M. GIBSON; R.S. HENRY	SIZE D; FSCM NO. 19205; 7140393
					SCALE 2/1; UNIT WT.; SHEET 2

DRAWING SIZE D (ARRADCOM 70-12) B

NOTES:-

1- SPEC MIL-W-13855 AND ANSI Y14.5M-1982 , AND MIL-L-45923 APPLY.

2- STEEL, CARBON, STRIP, 1050 TO 1065 INCLUSIVE, OR 1050 TO 1065 INCLUSIVE MODIFIED TO .45 TO .75 PERCENT MANGANESE; COILD ROLLED & SPHEROIDIZED ANNEALED (NO EVIDENCE OF LAMELLAR PEARLITE) NUMBER 1 FINISH (PREFERRED), OR NUMBER 2 FINISH (ACCEPTABLE ALTERNATE); IN ACCORDANCE WITH ASTM A684; THICKNESS .043"-.004".

3- SURFACE FINISH- FINISH 125 EXCEPT 250 ON SHEARED SURFACES.

4- ALL CARTRIDGE CONTACTING EDGES, UNLESS OTHERWISE SPECIFIED, SHALL BE BROKEN .003 + .012. REMAINING EXTERIOR AND INTERIOR EDGES SHALL BE BROKEN .002 + .008.

5- SECTIONS OF LINK MAY BE FOLDED AT "Y" TO CONTACT OR LEFT WITH GAPS NOT TO EXCEED .06.

6- WITH CONNECTING AND BODY RINGS TANGENT TO A FLAT SURFACE, THE EDGES OR WINGS MUST NOT TOUCH SURFACE.

7- HEAT TREAT TO HARDNESS SPECIFIED. METHOD OPTIONAL. MICRO-STRUCTURE SHALL BE ESSENTIALLY UNIFORM. TOTAL DECARBURIZATION SHALL NOT EXCEED .001. NO LAYER WITH CARBON OVER .60% WILL BE PERMITTED.
FINISH 5.3.1.3. OR 5.3.2.3 OF MIL-STD-171, EXCEPT WITH SUPPLEMENTARY WAX COATING SHALL BE 20 MILIGRAMS (MG) ± 5MG.
ALTERNATE FINISH TO BE IN ACCORDANCE WITH MIL-DTL-16232, TYPE Z, CLASS 1, UTILIZING CORROSION PREVENTIVING COMPOUND MIL-C-40084 OR DRAWING 12990886.

8- LINKS MUST MEET THE EXTRACTION REQUIREMENT OF MIL-L-45923. PRODUCEP IS NOTIFIED THAT MEETING THIS REQUIREMENT INVOLVES COMPLEX RELATIONSHIPS BETWEEN THE SPECIFIED PARAMETERS. REGULAR PROCESS CONTROL AND ADJUSTMENT WILL BE NECESSARY TO OBTAIN SATISFACTORY PERFORMANCE.

9- FINISHED LINK MUST FALL FREELY OF ITS OWN WEIGHT THROUGH APERTURE OF PROFILE GAGE C6057840.

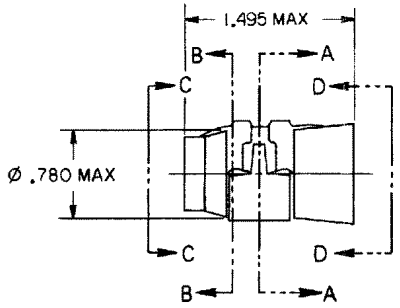
10- CLEANING PRIOR TO PHOSPHATE MAY BE ACHIEVED BY METHODS I, III, V, OR VI OF FEDERAL SPECIFICATION, TT-C-490.

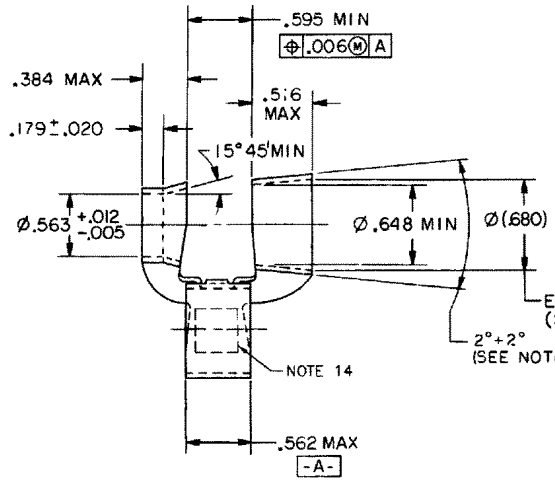
11- TESTING FOR RELIEF OF STRESS AND HYDROGEN EMBRITTLEMENT SHALL BE PERFORMED IN ACCORDANCE WITH MILITARY SPECIFICATION MIL-DTL-16232, PARAGRAPHS 4.7.2.A THRU 4.7.2.B., EXCEPT THAT THE MATERIAL FOR THE TEST SPECIMEN- RC 49 MINIMUM- SHALL BE THE SAME AS THE LINKS. THE TEST SHALL BEGIN 72-73 HOURS AFTER THE SAMPLE HAS BEEN PHOSPHATED AND RINSED IN CHROMIC ACID; TEST RESULTS SHALL BE INCLUDED IN FIRST ARTICLE TEST REPORT; TEST SHALL BE REPEATED AGAIN (NOT LESS THAN 30 DAYS AND NOT MORE THAN 60 DAYS AFTER FIRST ARTICLE APPROVAL) TO VERIFY PROCESS.

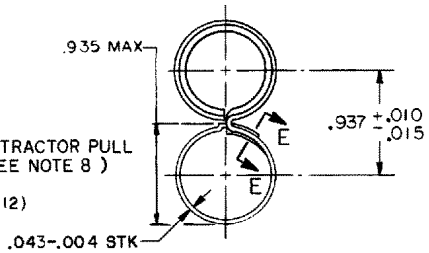
12- ADVISORY – THE 2° CONICAL TAPER CAN BE INSPECTED IN THE RESTRAINED CONDITION ON A MANDREL HAVING A CONICAL TAPER OF ⟹ .042 ± .005: I.

13-BLANK DIMENSIONS ON DRW. 9362726 ARE ADVISORY.

14-MARKING: STEEL, STAMP USING .125 HIGH X .005+.005 DEEP CHARACTERS IN AREA DEPICTED. SHOWING (1) MODEL NR M9, (2) MANUFACTURER'S ID, AND (3) ALPHA/NUMERIC MARKING TO IDENTIFY DIE NR. OTHER OPTIONAL MARKINGS MAY BE ADDED TO IDENTIFY TOOL STATION NR/PRESS NR/PROCESS.







REVISIONS				
SYM	DESCRIPTION	DATE	APPROVAL
L	REDRAWN WITH CHANGE, ERR Z9Z1285R (ECP M7S2063, 87-11-19) (ECP M9S3048, 89-09-26) (ECP M9S3062, 89-10-10)	90-10-03	
M	NOR MOS3103 910128	91-03-11	AJL
N	NOR M1S2026 910813	010911	PFS
P	NOR M2S2010 920603	920625	GK
R	NOR R8S2034 981209	990201	JB
T	NOR R0S3004 000321	000424	RLV
U	NOR R1S3042 020124	020211	RLV
V	NOR R3S9000/030214	040917	HJS
W	NOR R04S3031/040913	041015	HJS

R	W
SH 2	SH 1
REVISION STATUS OF SHEETS	

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

PART NO. 7140393

DISTRIBUTION STATEMENT A.
APPROVED FOR PUBLIC RELEASE;
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		MECHANICAL PROPERTIES	DO NOT SCALE DRAWING	ORIGINAL DATE OF DRAWING 49-10-21	SPRINGFIELD ARMORY, SPRINGFIELD, MA		
		YP	UNLESS OTHERWISE SPECIFIED	DRAFTSMAN RS	CHECKER JB	LINK, CARTRIDGE, METALLIC BELT, CAL .50:M9	
		TS	DIMENSIONS ARE IN INCHES	ENGR JB	ENGR		
		CL2	TOLERANCES ON DECIMALS ±.010	ENGR	ENGR		
		RA	FRACTIONS ± ANGLES ±				
		BH	THIRD ANGLE PROJECTION	W.M. GIBSON		SIZE D	FSCM NO. 19205	7140393
FINAL	CAL .50	RH	C-41/49	R.S. HENRY		SCALE 2/1	UNIT WT.	SHEET 1 OF 2
NEXT ASSY	USED ON						
APPLICATION							

ARRADCOM FORM 86 AUG 77 REPLACES SARPA FORM 1041 NOV 73 WHICH MAY BE USED UNTIL EXHAUSTED