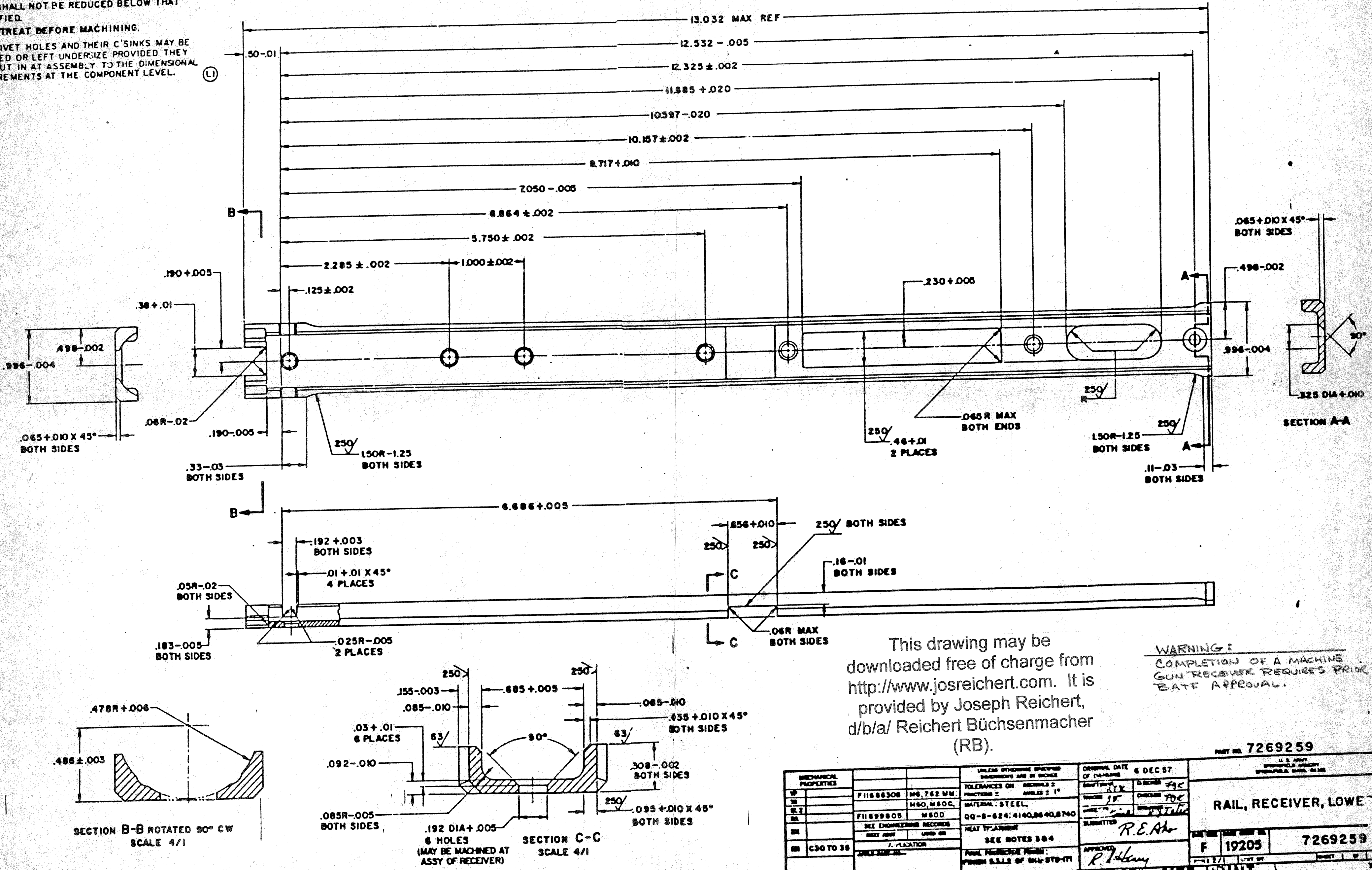




M60 MG

REV	DESCRIPTION	DATE	APPROVED
K	PERMANENT WITH CHANGE		
L	(1) SEE EC WRO 82732	18 SEP 84	

- NOTES:
- FINISH 125 EXCEPT AS NOTED.
 - ALL EDGES SHALL BE BROKEN .005 +.010 UNLESS OTHERWISE SPECIFIED.
 - HEAT TREATMENT: HEAT AT 1535° TO 1565°F OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
 - HEAT TREAT BEFORE MACHINING.
 - ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED OR LEFT UNDER-SIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS AT THE COMPONENT LEVEL.



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WARNING:
COMPLETION OF A MACHINING GUN RECEIVER REQUIRES PRIOR BATE APPROVAL.

PART NO. 7269259

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE 6 DEC 87	
TP	F11686308	M6, 762 MM	TOLEANCES ON DIMENSIONS:	DATE	BY
TS		M60, M80C	FRACTIONS:	DATE	BY
RS		M60	ANGLES: 1"	DATE	BY
SA	F11699805	M60D	MATERIAL: STEEL	DATE	BY
SH			QQ-S-824: 4140, 8640, 8740	DATE	BY
SI			HEAT TREATMENT	DATE	BY
SM			SEE NOTES 3&4	DATE	BY
SN			FINAL RECEIVER FORM: PAPER 8.1.2 OF 84-978-71	DATE	BY
SO				DATE	BY

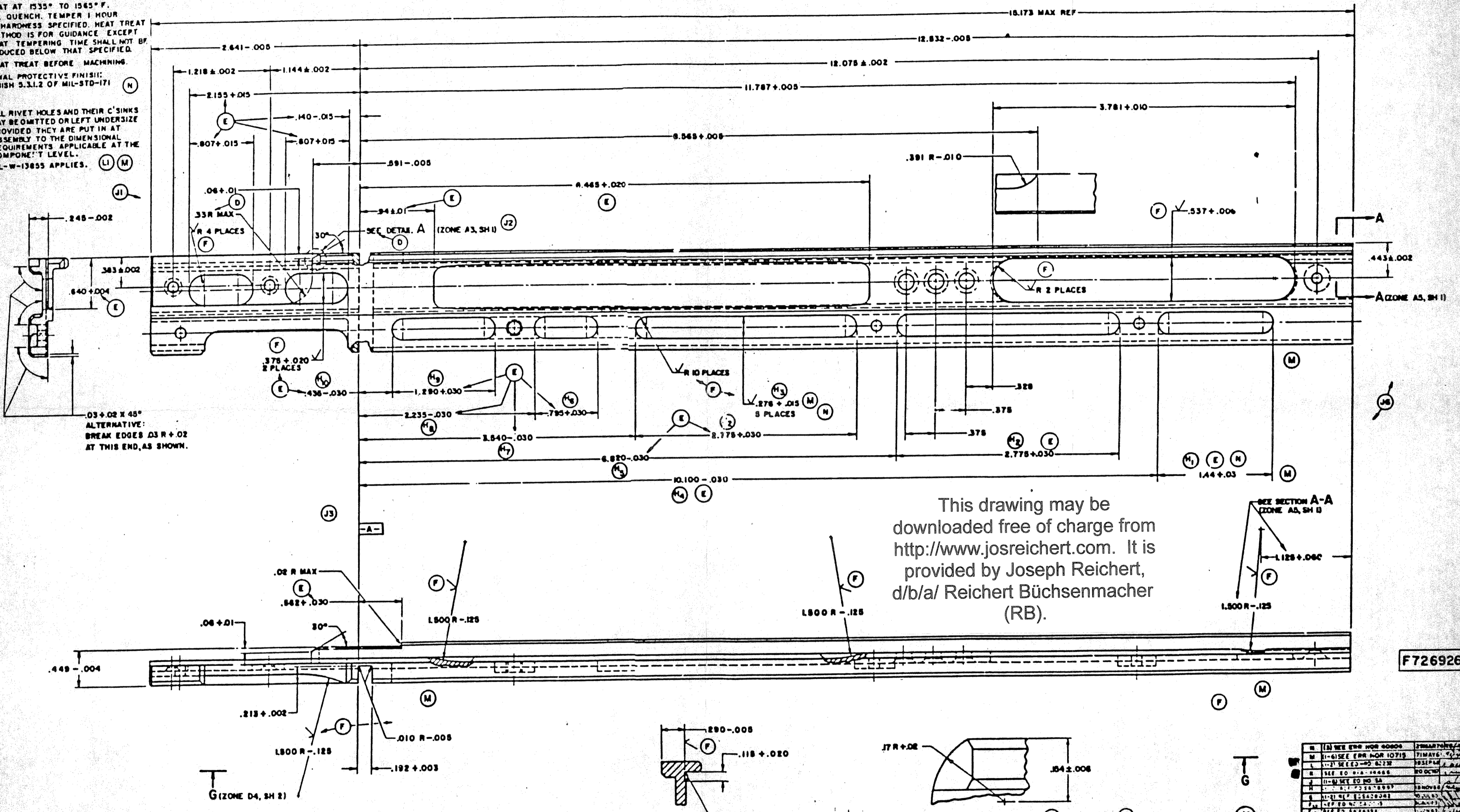
RAIL, RECEIVER, LOWE

F 19205 7269259

REDUCED SIZE PRINT

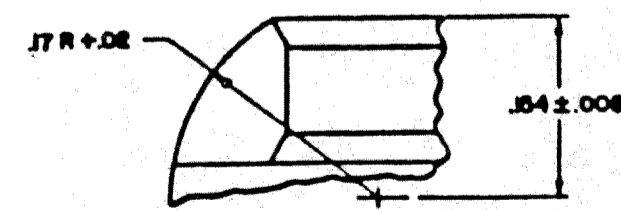
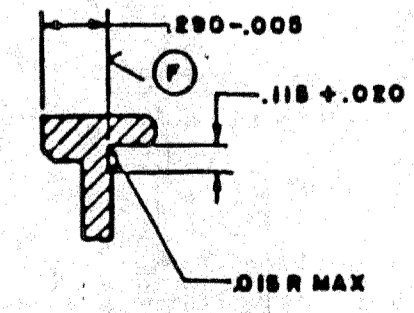
NOTES:

1. FINISH $\sqrt{125}$ EXCEPT SURFACES MARKED $\sqrt{FINISH 250}$.
2. ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
3. HEAT AT 1535° TO 1565° F. OIL QUENCH. TEMPER 1 HOUR TO HARDNESS SPECIFIED. HEAT TREAT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. HEAT TREAT BEFORE MACHINING.
5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171.
6. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED OR LEFT UNDER SIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS APPLICABLE AT THE COMPONENT LEVEL.
7. MIL-W-13855 APPLIES.



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WARNING:
COMPLETION OF A MACHINE GUN RECEIVER REQUIRES PRIOR DATE APPROVAL.



NO.	REVISION	DATE	BY	CHKD.	APP'D.
1	ISSUED FOR PRODUCTION				
2	CHANGE TO DIMENSIONS				
3	CHANGE TO DIMENSIONS				
4	CHANGE TO DIMENSIONS				
5	CHANGE TO DIMENSIONS				
6	CHANGE TO DIMENSIONS				
7	CHANGE TO DIMENSIONS				
8	CHANGE TO DIMENSIONS				
9	CHANGE TO DIMENSIONS				
10	CHANGE TO DIMENSIONS				

PART NO.	7269260	REV.	0	DATE	26 DEC 87
DESCRIPTION	MG. 7.62 MM. RECEIVER, R H	DESIGNED BY	W. J. B. / J. R. B.	CHECKED BY	W. J. B. / J. R. B.
MATERIAL	STEEL	QUANTITY	1	ISSUED TO	W. J. B. / J. R. B.
HEAT TREATMENT	SEE NOTE 304	APPROVED BY	W. J. B. / J. R. B.	DATE	26 DEC 87
FINAL PROTECTIVE FINISH	SEE NOTE 304	APPROVED BY	W. J. B. / J. R. B.	DATE	26 DEC 87

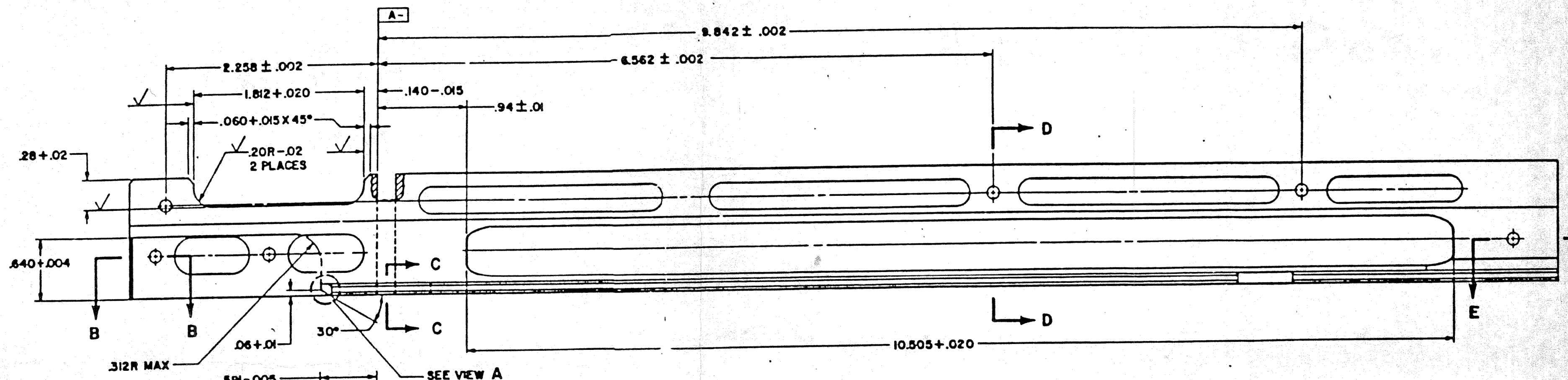
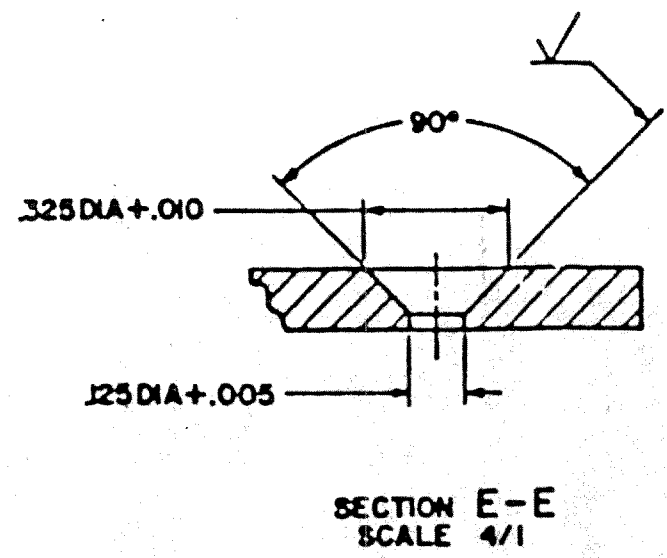
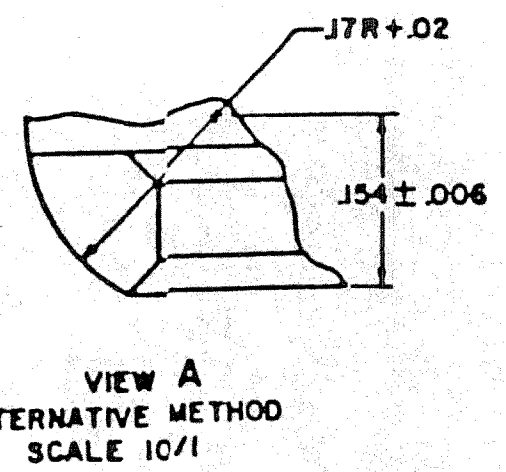
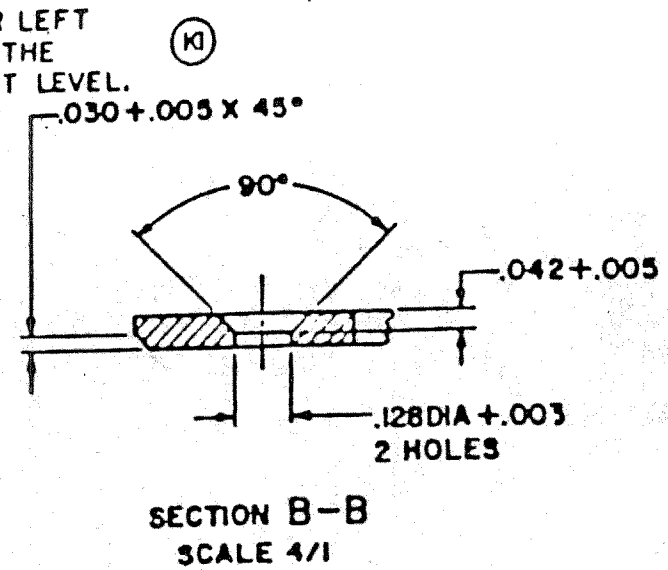
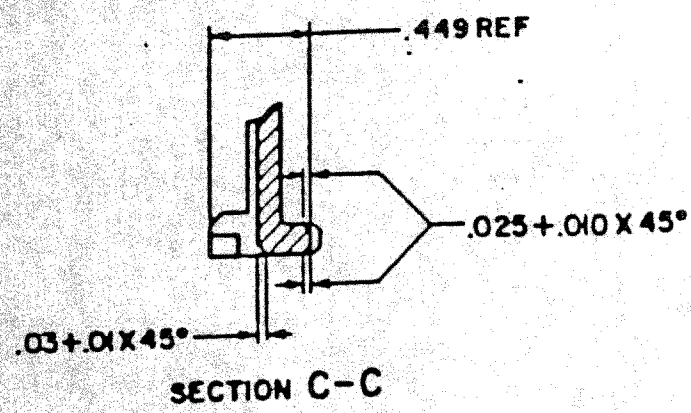
RAIL,
RECEIVER, R H

DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, ILL 6200

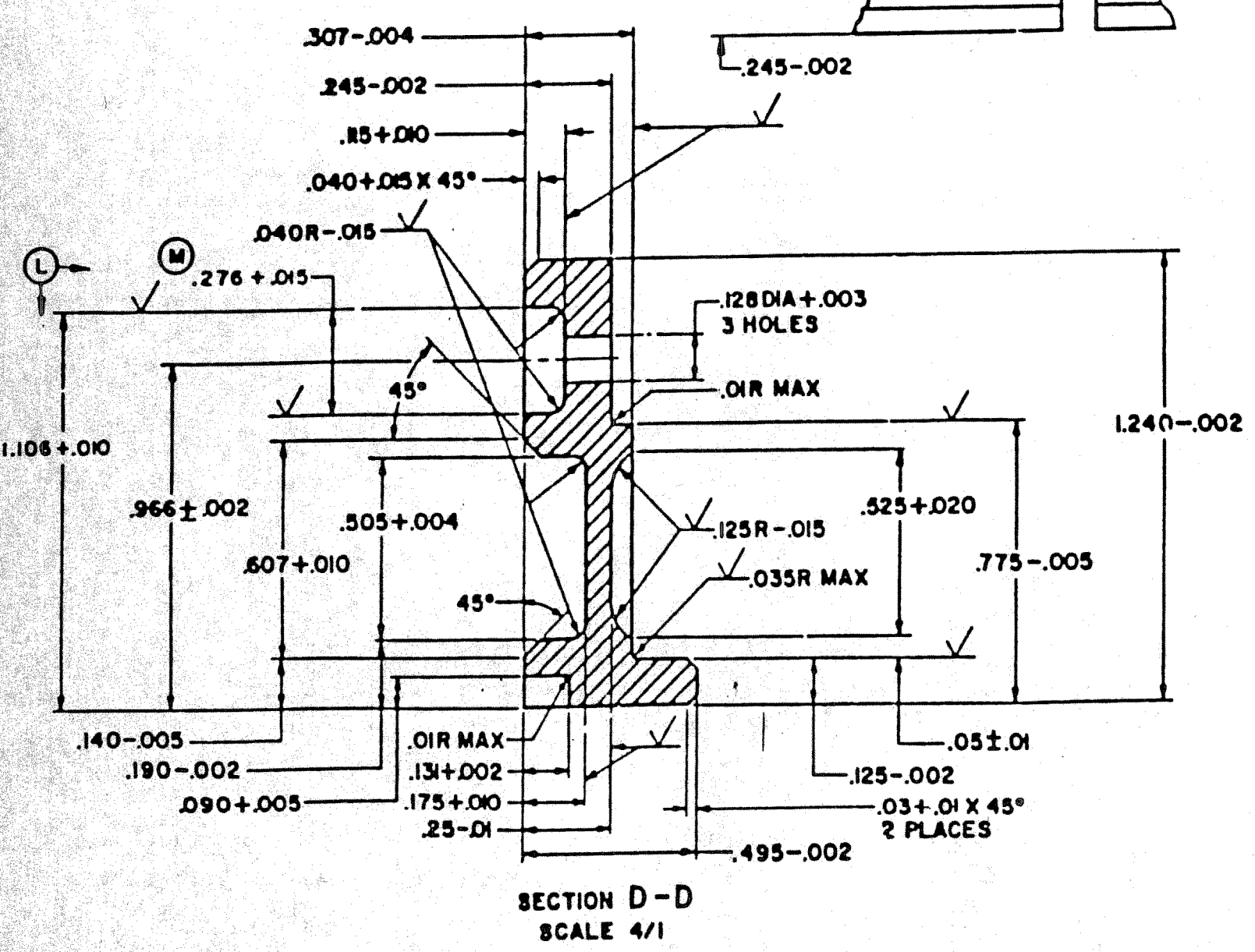
7269260

NOTE:
ALL RIVET HOLES AND THEIR CSINKS MAY BE OMITTED OR LEFT
UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE
DIMENSIONAL REQUIREMENTS APPLICABLE AT THE COMPONENT LEVEL.

LIB	DESCRIPTION	DATE	APPROVED
J	REDRAWN WITH CHANGE,		
K	SEE EO NO 80131	10 MAY 67	<i>[Signature]</i>
L	SEE ERR NOR 40604	71 MAY 6	<i>[Signature]</i>
M	SEE ERR NOR 40604	29 MAR 67	<i>[Signature]</i>



VIEW F-F
(8H1 ZONES B-2 THRU B-7)



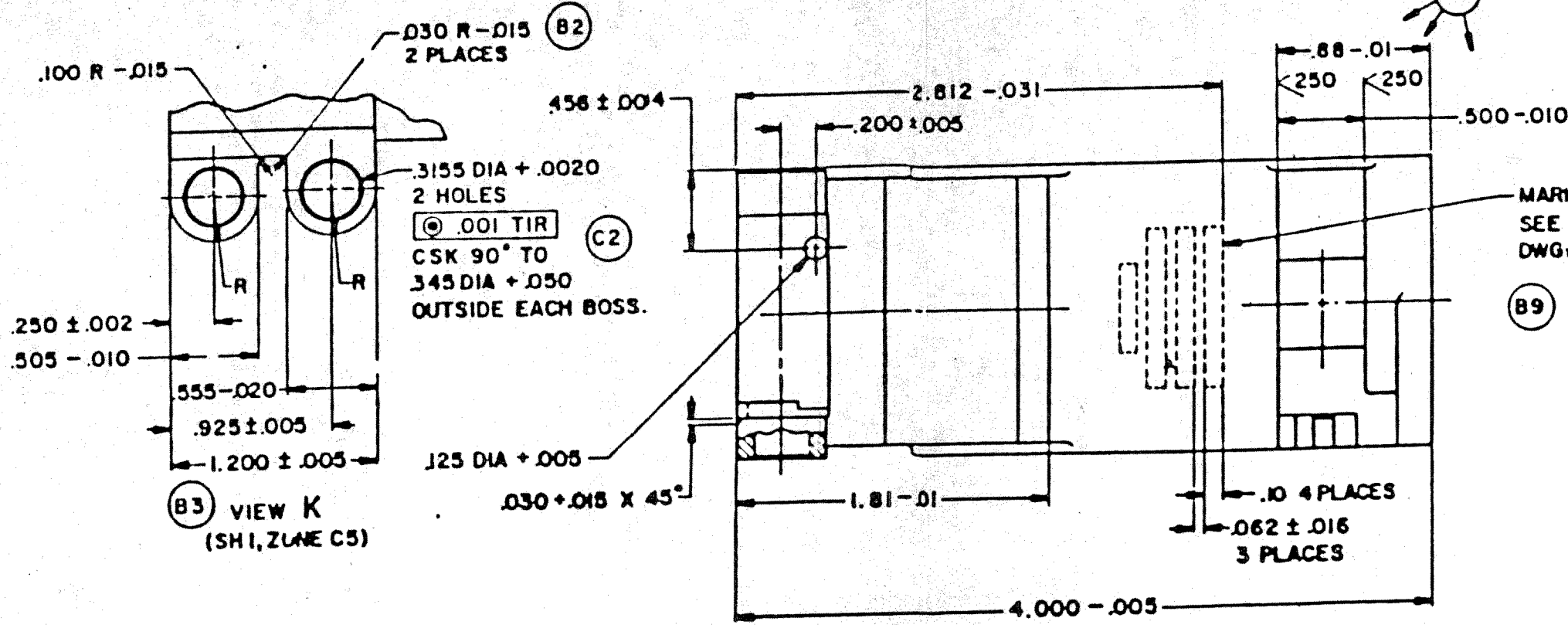
SECTION D-D
SCALE 4/1

WARNING:
COMPLETION OF A MACHINE GUN
RECEIVER REQUIRES PRIOR
BATT APPROVAL.

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provided by Joseph Reichert,
d/b/a/ Reichert Büchsenmacher
(RB).

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 28 DEC 67		DEPT OF THE ARMY	
YP		TOLERANCES ON DECIMALS =		DRAFTSMAN <i>[Signature]</i>	CHECKER <i>[Signature]</i>	ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TS		FRACTIONS =	ANGLES = 1°	TRACER <i>[Signature]</i>	CHECKER <i>[Signature]</i>	RAIL, RECEIVER, LH	
ELI		MATERIAL	SEE SHEET 1	ENGINEER <i>[Signature]</i>	ENGINEER <i>[Signature]</i>		
SA		FINISH TREATMENT	SEE SHEET 1	SUBMITTED <i>[Signature]</i>		PART NO. 7269258	
SH		FINAL PROTECTIVE FINISH	SEE SHEET 1	APPROVED <i>[Signature]</i>		SCALE 2/1 UNIT WT SHEET 2 OF 2	
SH	SEE SHEET 1					F 19204 7269258	

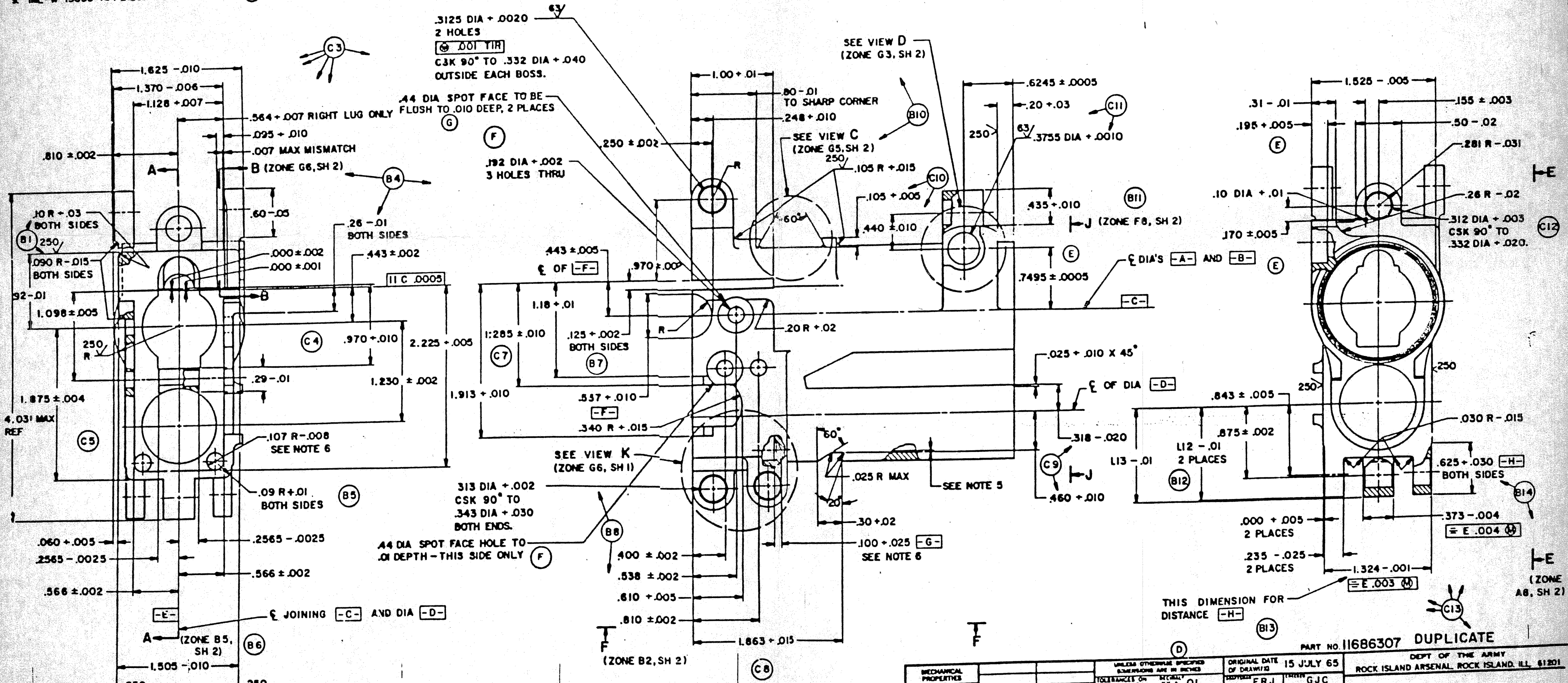
- NOTES: 125
- FINISH $\sqrt{\text{V}}$ EXCEPT AS NOTED.
 - ALL EDGES SHALL BE BROKEN $.005 \pm .010$ UNLESS OTHERWISE SPECIFIED.
 - ALL UNSPECIFIED RADII SHALL BE $.030 \pm .030$.
 - HEAT TREATMENT: HEAT AT 1535° TO 1565° F. OIL QUENCH TEMPER 1 HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
 - BREAK THRU SHALL BE PERMISSIBLE IN THIS AREA PROVIDED RESULTANT BURRS ARE REMOVED.
 - $.215 \text{ DIA} - .015$ (2) HOLES MAY BE MACHINED IN CORNERS FOR DEPTH -G- TO PROVIDE REQUIRED RADIUS.
 - FINISH 5.3.1.2 OF MIL-STD-17L -G-
 - ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS APPLICABLE AT THE COMPONENT LEVEL.
 - MIL-W-13855 APPLIES. -E-



MARKING REQUIREMENTS:
SEE APPLICABLE GUN ASSY
DWG: F7269100-M60
F7792090-M60C
J11699750-M60D

REV	DATE	DESCRIPTION	APPROVED
A	13 APR 65	SEE EO SA 29302	HENRY
B	11-13	SEE EO SA 30032	HENRY
C	11-13	SEE EO B2128	HENRY
D	11-13	SEE EO B2128	HENRY
E	71 MAY 12	SEE ERR MOR 10724	HENRY
F	4 JAN 74	SEE ERR MOR 30781	HENRY
G	3 OCT 75	SEE MOR 75E0036-0002	HENRY

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WARNING:
COMPLETION OF A
MACHINE GUN RECEIVER
REQUIRES PRIOR BATH
APPROVAL.

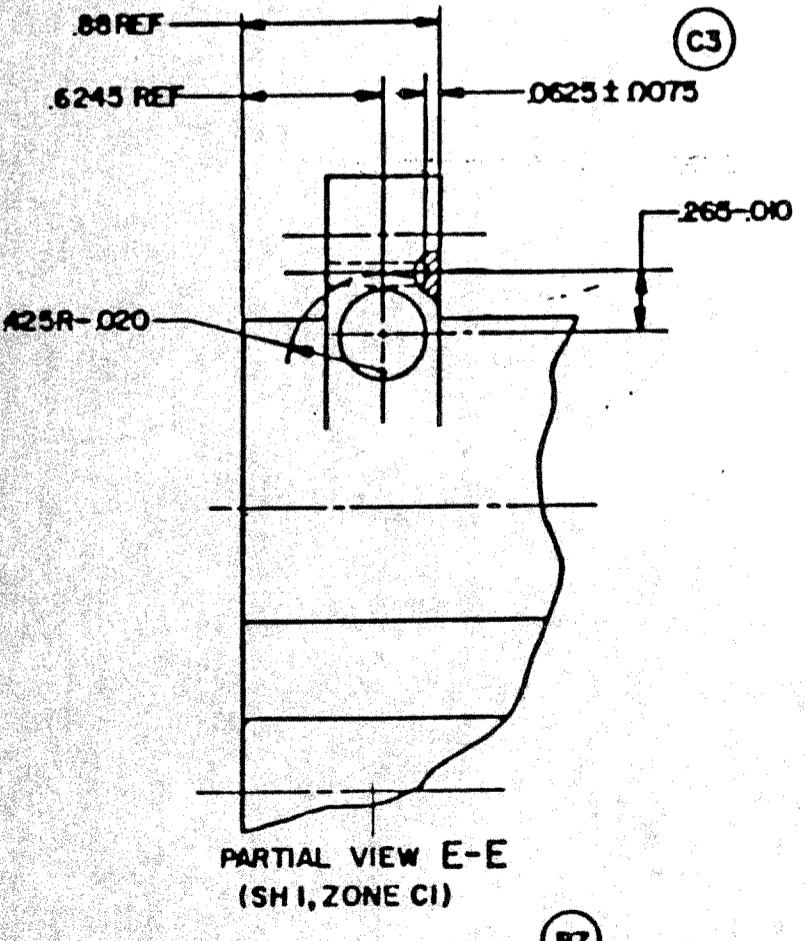
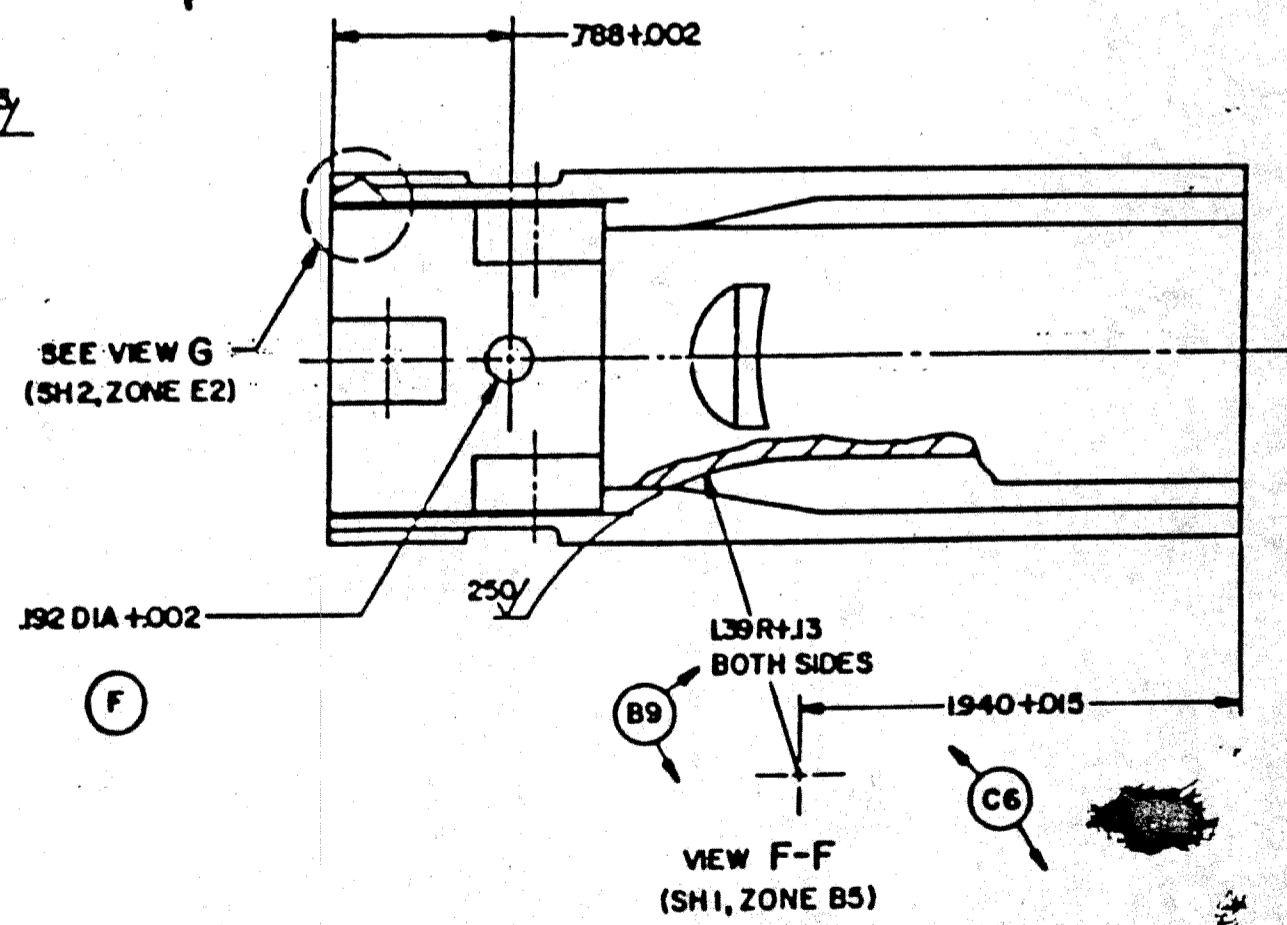
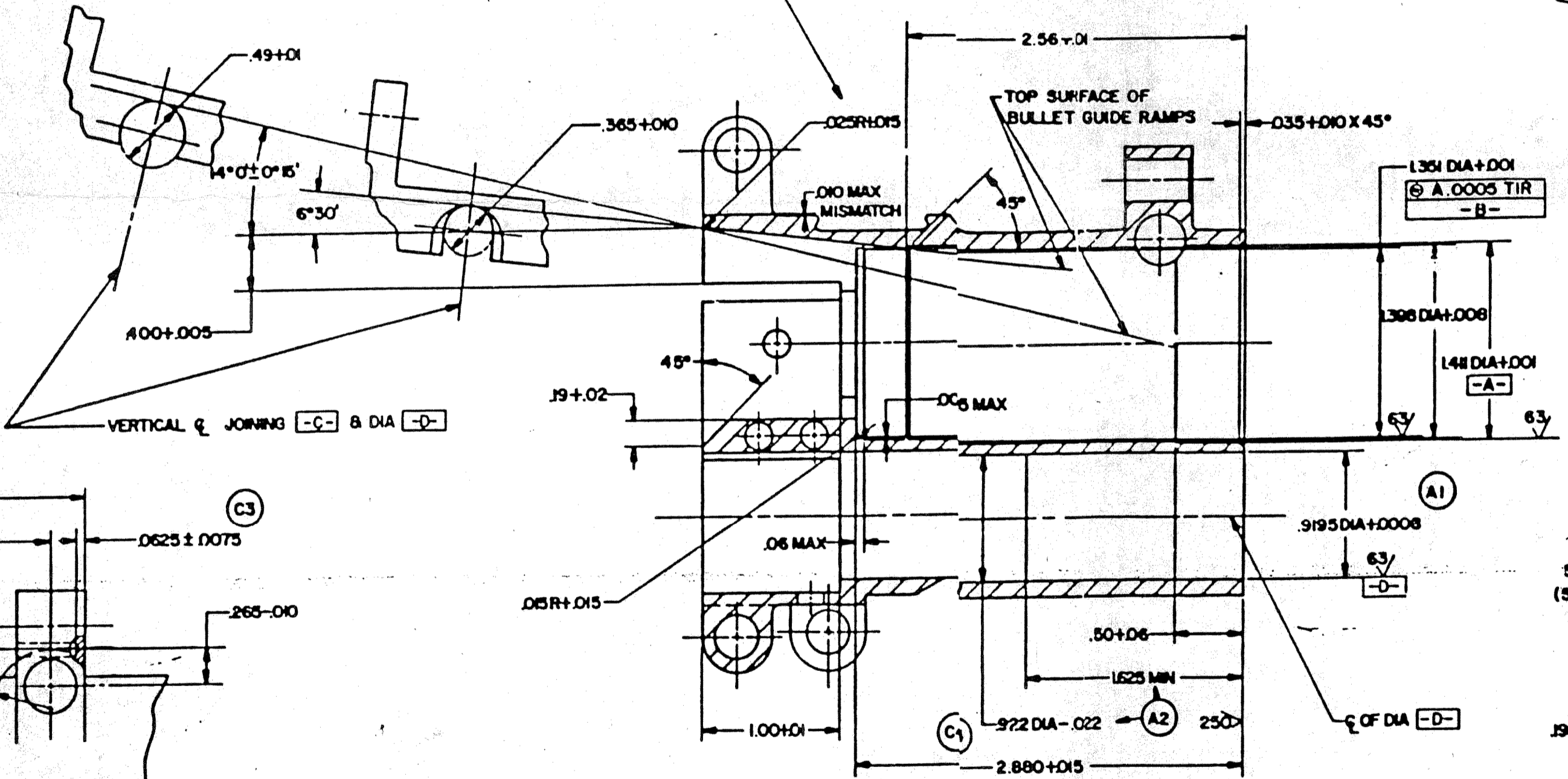
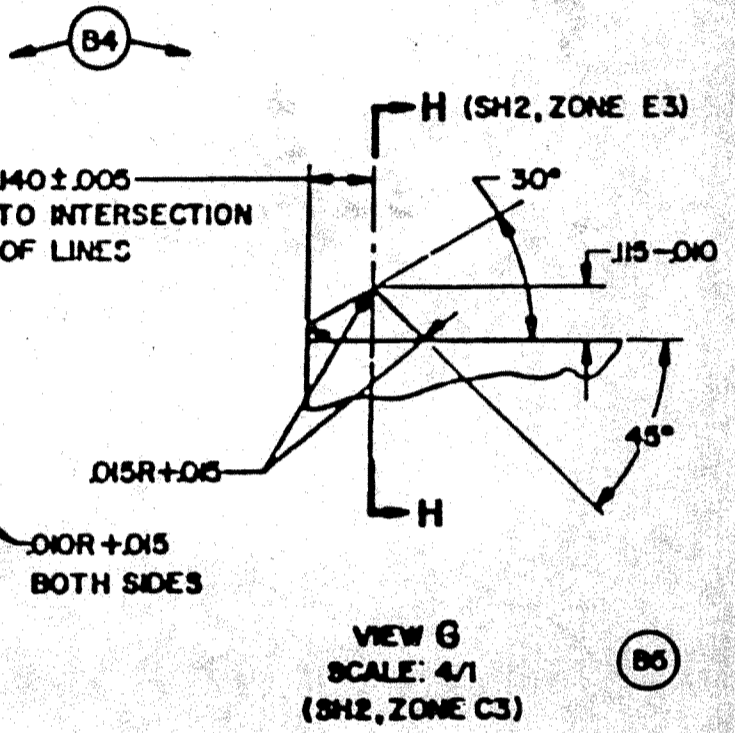
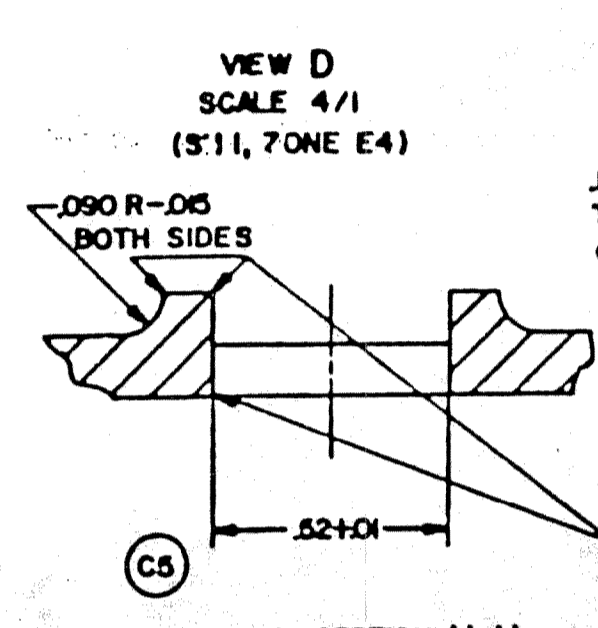
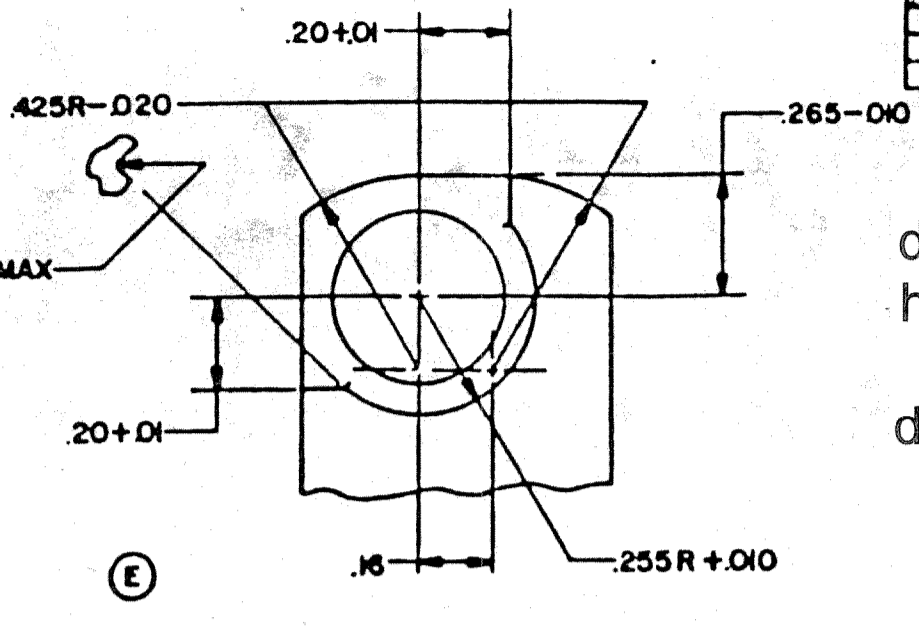
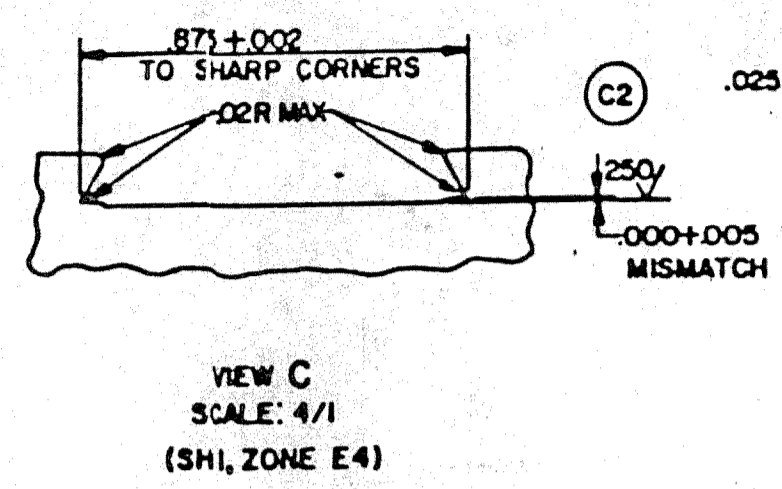
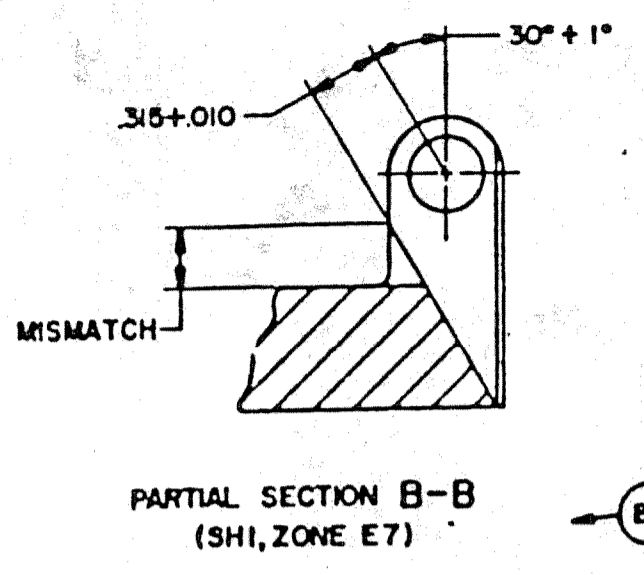
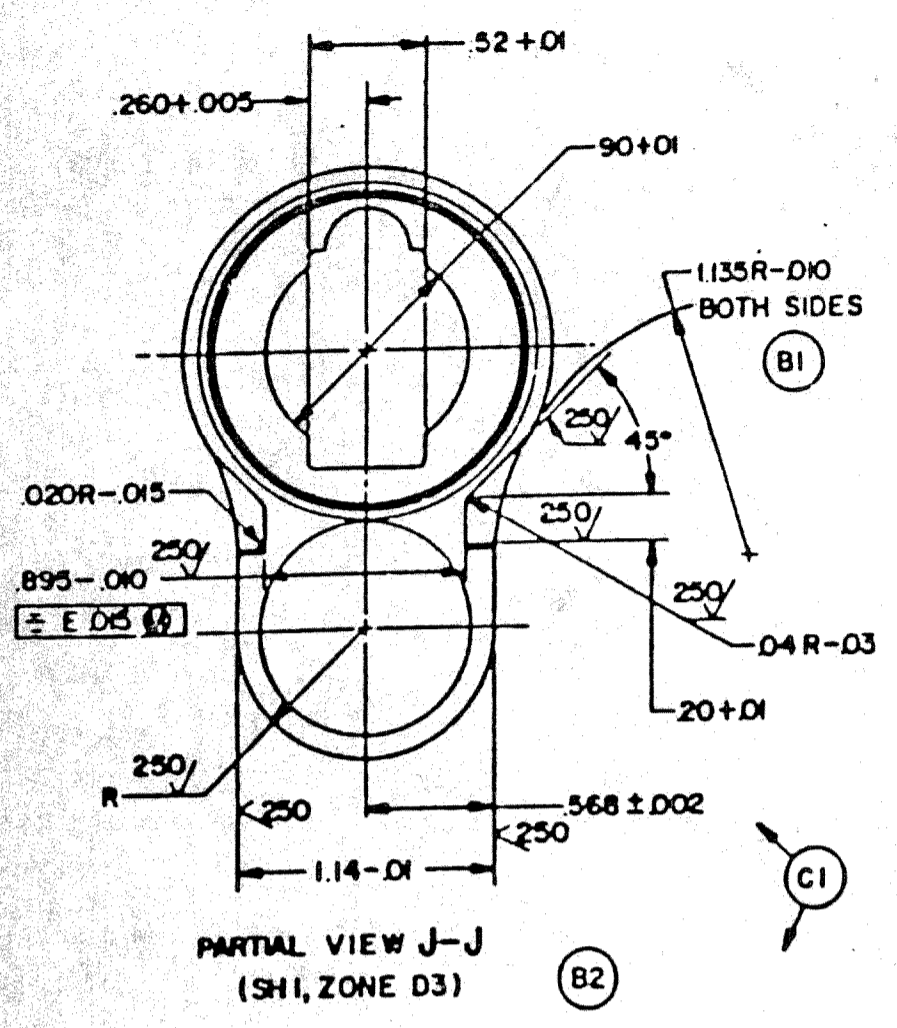
THIS DIMENSION FOR DISTANCE -H- (ZONE A8, SH 2)

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING	15 JULY 65
W		TOLERANCES UNLESS OTHERWISE SPECIFIED	FRJ	GJC
TS		FRAMES .01		
BA		STEELE, FED SPEC		
DI		00-9-624, 1140, 8640, 8740		
DI		SEE NOTE 4		
DI		SEE NOTE 7		
DI		SEE NOTE 7		

PART NO. 11686307 DUPLICATE
DEPT OF THE ARMY
ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201
RECEIVER
F 19204 11686307

NO	DATE	BY	DESCRIPTION	DATE	APPROVED
A	11-21	SEE EO	BA PROOF	13 APR 66	SEE EO
B	11-21	SEE EO	BA PROOF	13 APR 67	SEE EO
C	8-61	SEE EO	82118	18 MAY 68	SEE EO
D		NO CHANGE		4 SEP 68	SEE EO
E	111	SEE ERR MOR	10724	7 MAY 72	SEE EO
F		SEE ERR MOR	30721	4 JAN 74	SEE EO
G		NO CHANGE		3 OCT 75	SEE EO

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WARNING:
COMPLETION OF A MACHINE GUN RECEIVER REQUIRES PRIOR BATF APPROVAL.

MECHANICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING	DEPT OF THE ARMY
VP	TOLERANCES ON ANGLES ± 1° UNLESS OTHERWISE SPECIFIED <td>15 JULY 65 <td>ROCK ISLAND ARSENAL ROCK ISLAND ILL 61201 </td></td>	15 JULY 65 <td>ROCK ISLAND ARSENAL ROCK ISLAND ILL 61201 </td>	ROCK ISLAND ARSENAL ROCK ISLAND ILL 61201
TS	SEE SHEET 1 <td>JAK</td> <td>GJC</td>	JAK	GJC
CL 2	SEE SHEET 1 <td></td> <td></td>		
SA	MFG 7.62MM <td></td> <td></td>		
SH	F11686308 M60, M60C <td></td> <td></td>		
SH	F11686309 M600 <td></td> <td></td>		
SH	SEE SHEET 1 <td></td> <td></td>		
SH	SEE SHEET 1 <td></td> <td></td>		

MECHANICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING	DEPT OF THE ARMY
VP	TOLERANCES ON ANGLES ± 1° UNLESS OTHERWISE SPECIFIED <td>15 JULY 65 <td>ROCK ISLAND ARSENAL ROCK ISLAND ILL 61201 </td></td>	15 JULY 65 <td>ROCK ISLAND ARSENAL ROCK ISLAND ILL 61201 </td>	ROCK ISLAND ARSENAL ROCK ISLAND ILL 61201
TS	SEE SHEET 1 <td>JAK</td> <td>GJC</td>	JAK	GJC
CL 2	SEE SHEET 1 <td></td> <td></td>		
SA	MFG 7.62MM <td></td> <td></td>		
SH	F11686308 M60, M60C <td></td> <td></td>		
SH	F11686309 M600 <td></td> <td></td>		
SH	SEE SHEET 1 <td></td> <td></td>		
SH	SEE SHEET 1 <td></td> <td></td>		

MECHANICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING	DEPT OF THE ARMY
VP	TOLERANCES ON ANGLES ± 1° UNLESS OTHERWISE SPECIFIED <td>15 JULY 65 <td>ROCK ISLAND ARSENAL ROCK ISLAND ILL 61201 </td></td>	15 JULY 65 <td>ROCK ISLAND ARSENAL ROCK ISLAND ILL 61201 </td>	ROCK ISLAND ARSENAL ROCK ISLAND ILL 61201
TS	SEE SHEET 1 <td>JAK</td> <td>GJC</td>	JAK	GJC
CL 2	SEE SHEET 1 <td></td> <td></td>		
SA	MFG 7.62MM <td></td> <td></td>		
SH	F11686308 M60, M60C <td></td> <td></td>		
SH	F11686309 M600 <td></td> <td></td>		
SH	SEE SHEET 1 <td></td> <td></td>		
SH	SEE SHEET 1 <td></td> <td></td>		

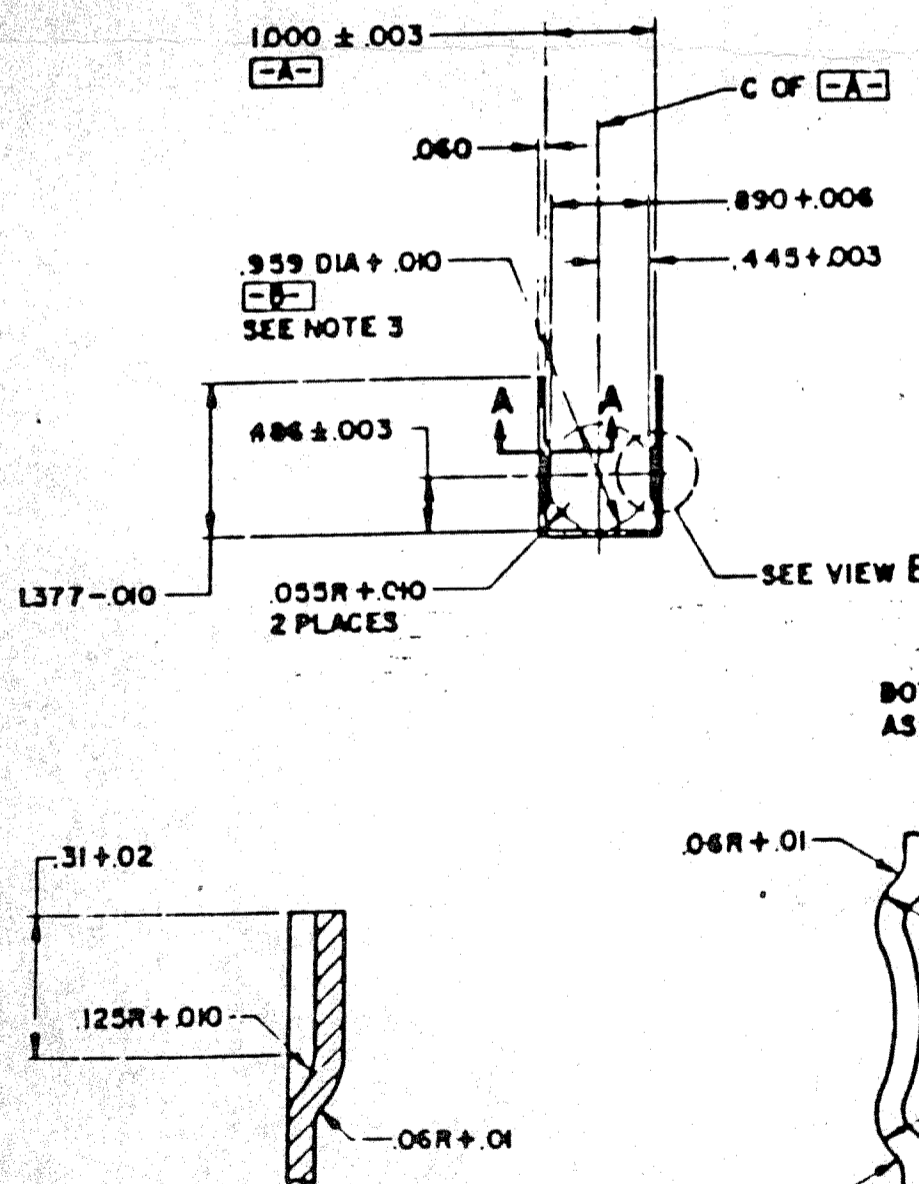
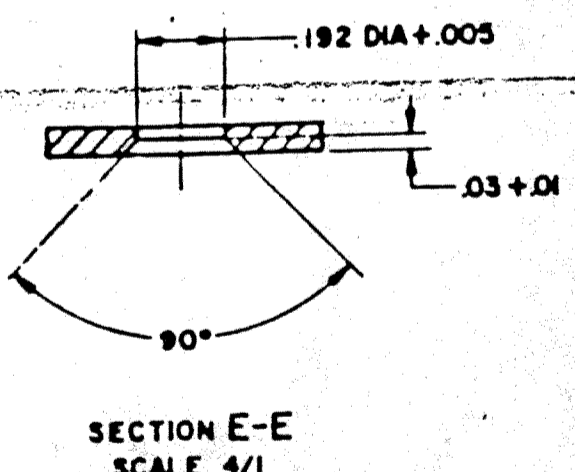
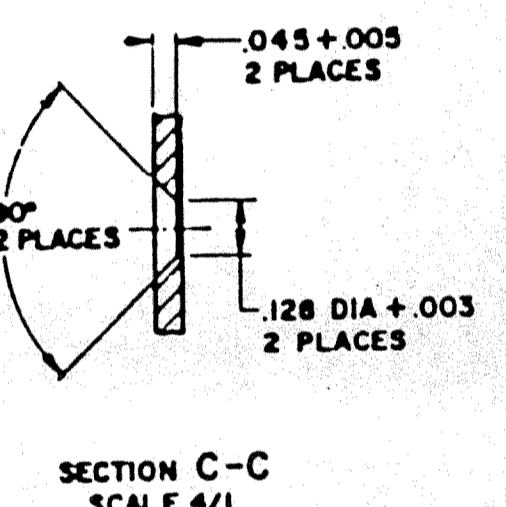
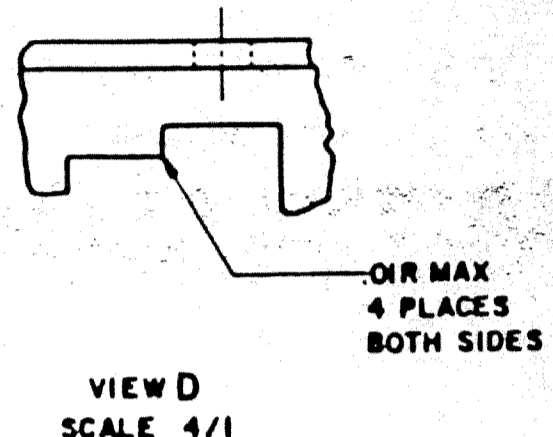
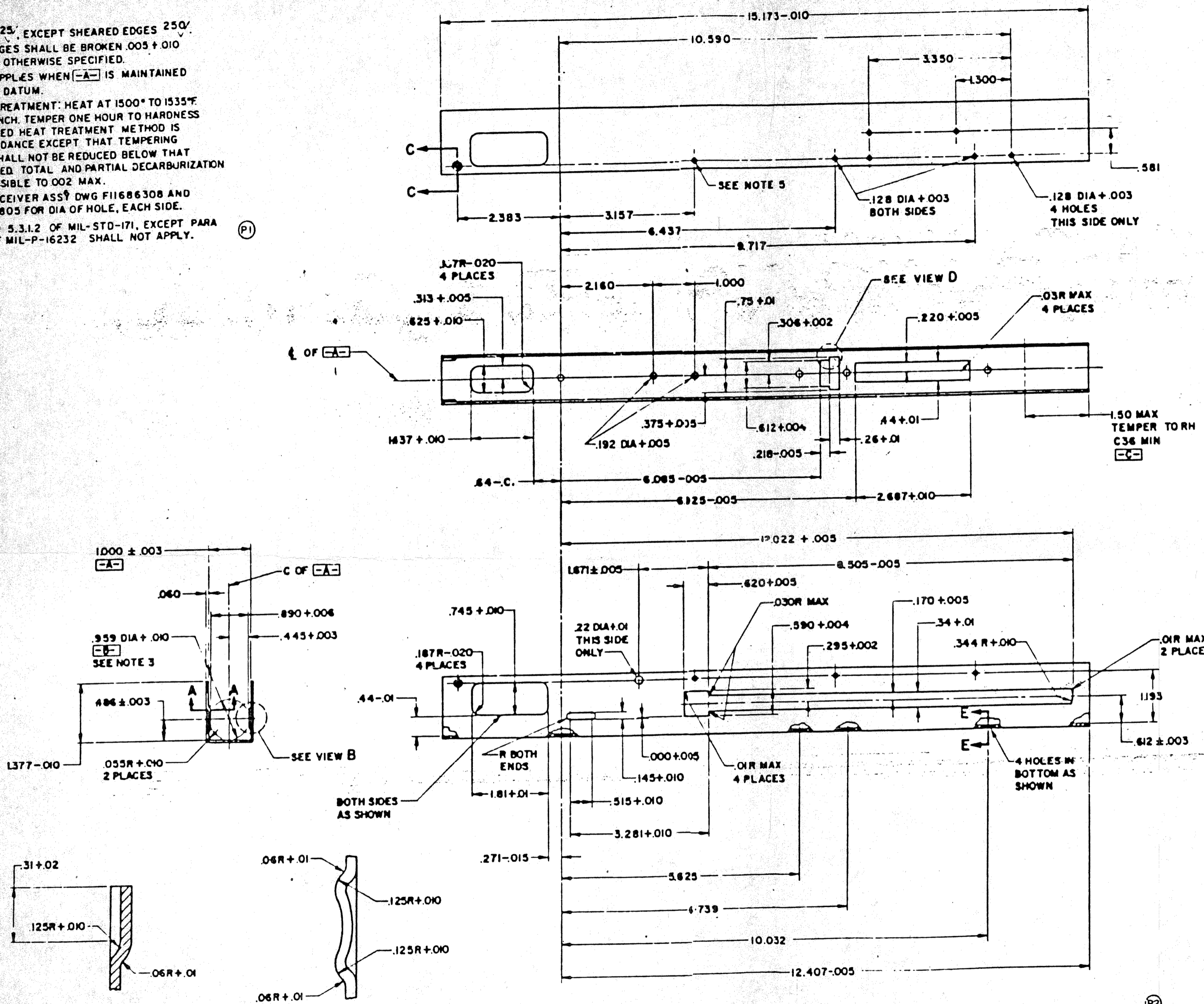
RECEIVER
F 19204 11686307

F 11686307

- NOTES:
- 1 FINISH 125, EXCEPT SHEARED EDGES 250.
 - 2 ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
 - 3 \square APPLIES WHEN \square IS MAINTAINED AT 100 DATUM.
 - 4 HEAT TREATMENT: HEAT AT 1500° TO 1535°F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. TOTAL AND PARTIAL DECARBURIZATION PERMISSIBLE TO .002 MAX.
 - 5 SEE RECEIVER ASSY DWG F11686308 AND F11699805 FOR DIA OF HOLE, EACH SIDE.
 - 6 FINISH 5.3.1.2 OF MIL-STD-171, EXCEPT PARA 3.3 OF MIL-P-16232 SHALL NOT APPLY.

REV	DESCRIPTION	DATE	APPROVED
1	REDESIGNED W/O CHANGE	26 DEC 57	
2	SEE EO NO SA 1012		
3	SEE EO HMO 8232		

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WARNING:
COMPLETION OF A MACHINE GUN RECEIVER REQUIRES PRIOR BATT APPROVAL.

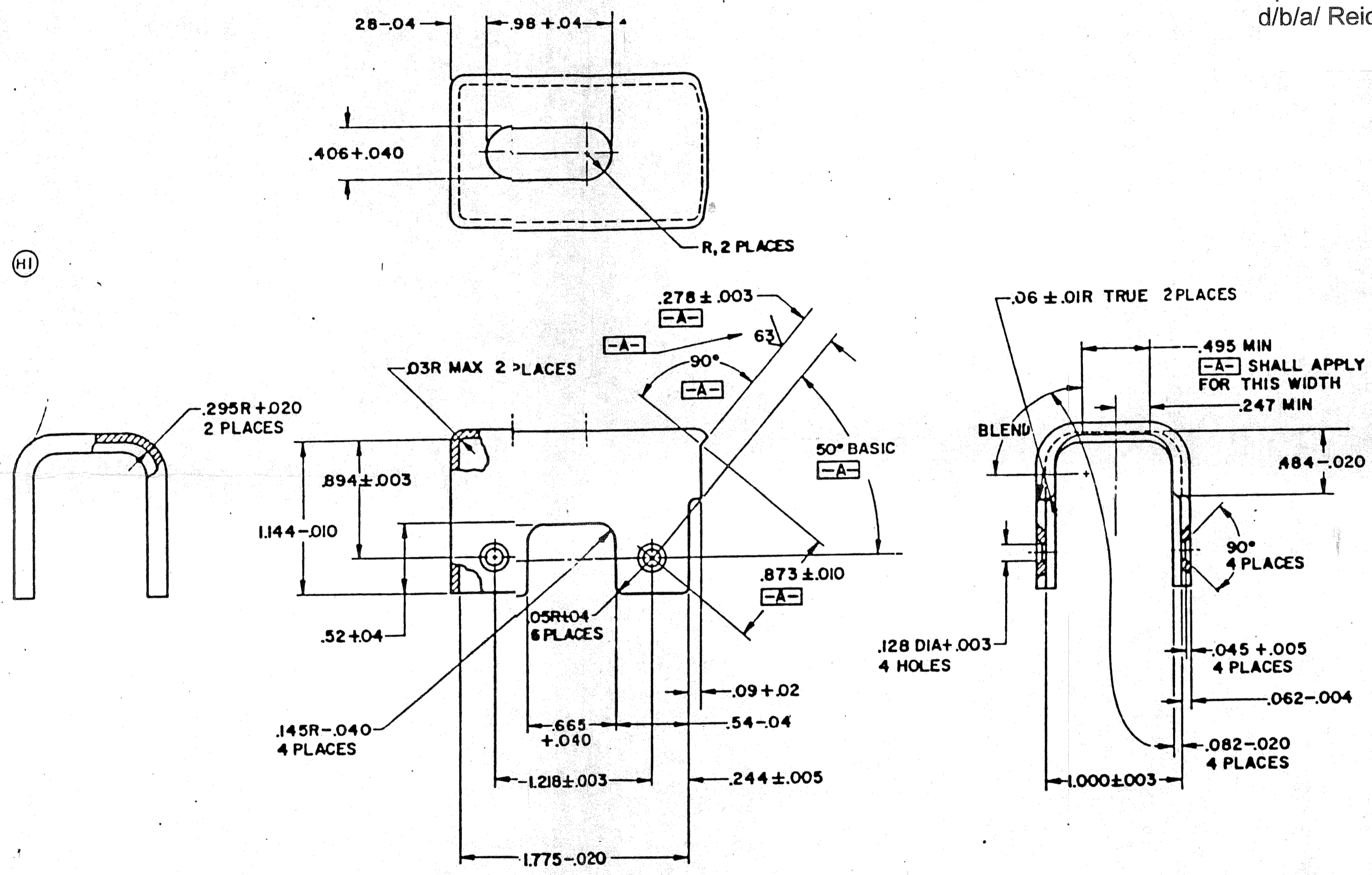
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		PART NO. 7269254	
TP	F11686308	WG. 762 MM	TOLERANCES ON DIMENSIONS: .002	DATE	26 DEC 57	ENGINEER	SPRINGFIELD ARMOY
TS		M60, M60C,	FRACTIONS: 1/16"	CHECKER	952	DRAWN	SPRINGFIELD, MASS. 01106
EL2		M60D	MATERIAL: STEEL,	TRACER	3 V	CHECKER	
RA	F11699805	M60D	QQ-S-777 1060, 1065, 1075	ENGINEER		ENGINEER	
BN		SEE ENGINEERING RECORDS	HEAT TREATMENT	ENGINEER		ENGINEER	
IN	C437D 48	HEAT ARMY	SEE NOTE 4	ENGINEER		ENGINEER	
SEE	\square	APPLICATION	FINAL PROTECTIVE FINISH:	ENGINEER		ENGINEER	
			SEE NOTE 6	ENGINEER		ENGINEER	

REDUCED SIZE PRINT

REVISIONS			
LTN	DESCRIPTION	DATE	APPROVAL
6	REDRAWN WITH CHANGE.		
	SEE EO HQ SA 30118	4 MAY 67	<i>[Signature]</i>
H	(1) SEE EO HQD 82237	18 SEP 68	<i>[Signature]</i>

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- NOTES:
- FINISH 125 EXCEPT AS NOTED. SHEARED SURFACES 250.
 - ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
 - MATERIAL: STEEL, QQ-S-698: CARBON .17 TO .24, MANGANESE .30 TO .60 DRAWING QUALITY KILLED.
 - HEAT TREATMENT: CARBURIZE AT 1600°F FOR .005 TO .010 CASE DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350°F. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENT ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBONITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
 - FILEHARD TEST IN ACCORDANCE WITH SA-STD-104. (H1)



WARNING:
COMPLETION OF A MACHINE GUN RECEIVER REQUIRES PRIOR BATH APPROVAL.

PART NO. 7269252

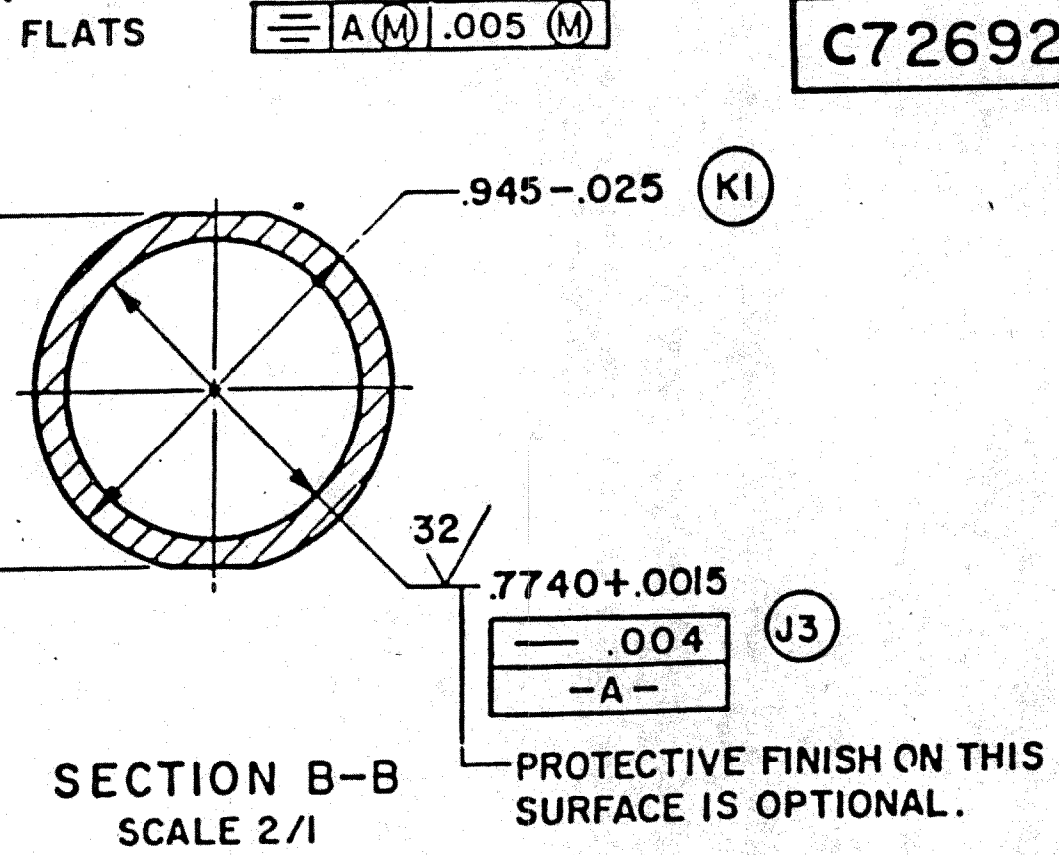
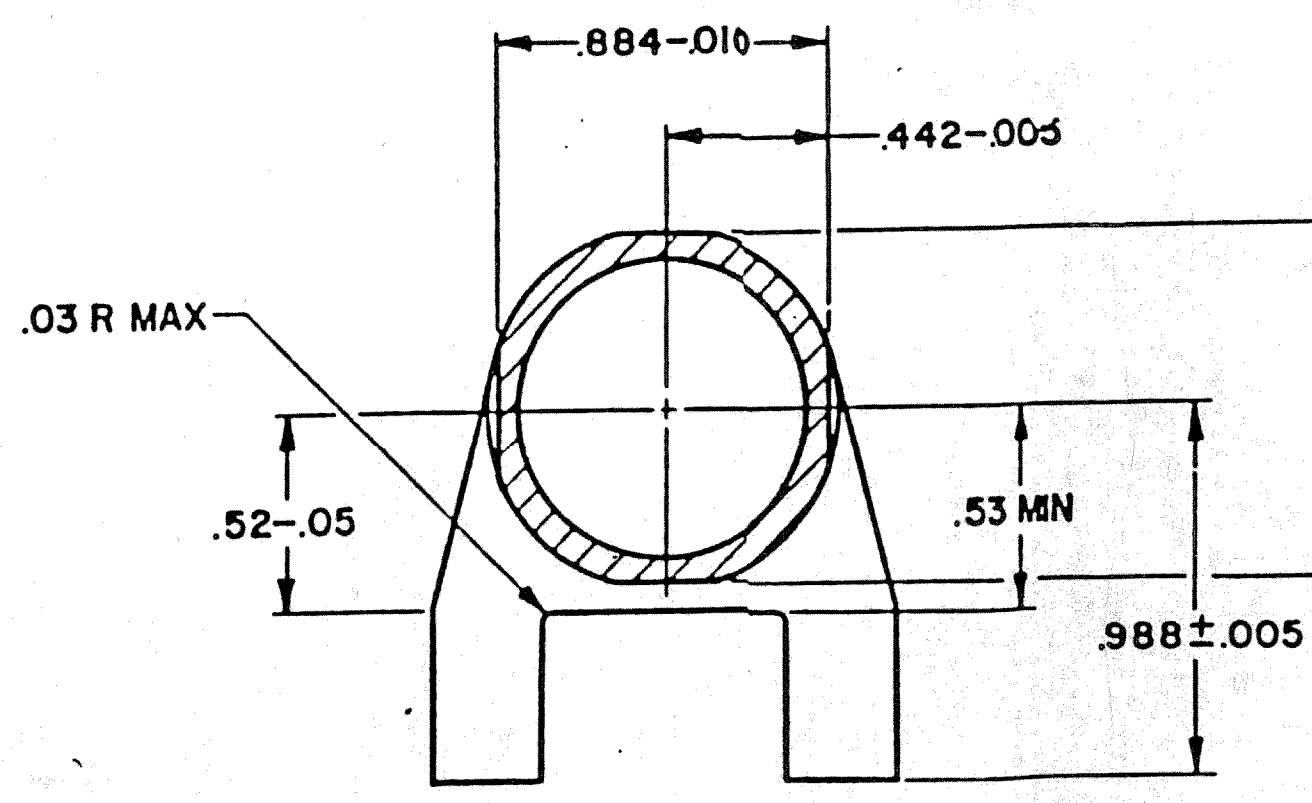
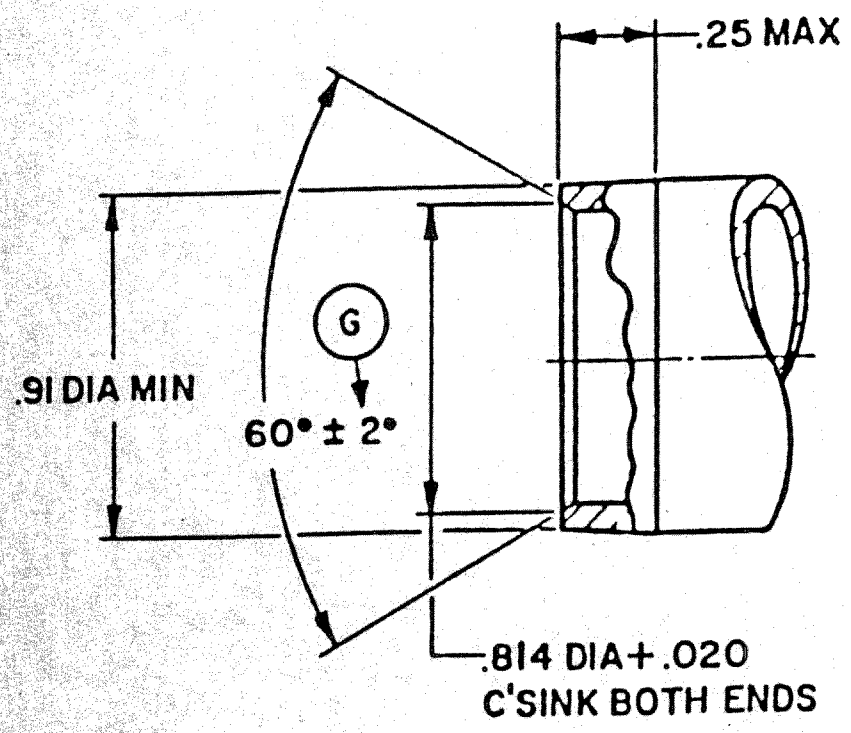
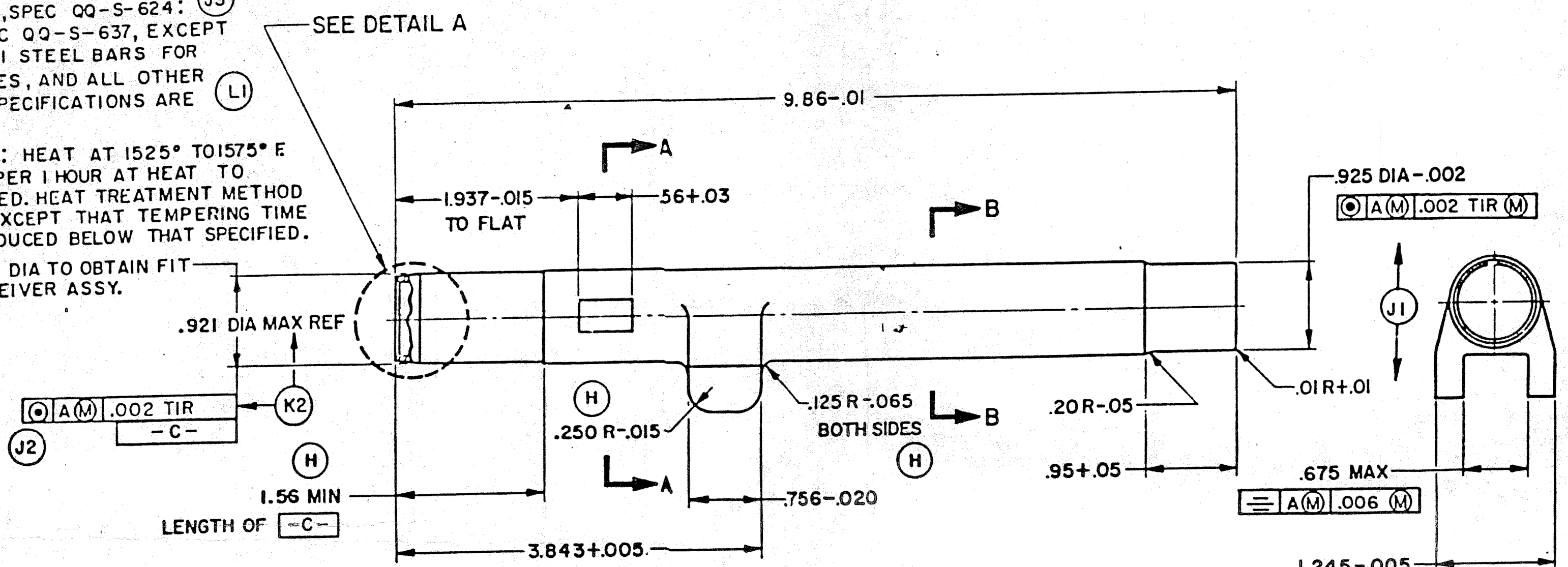
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING 26 DEC 57		U. S. ARMY SPRINGFIELD ARMOY SPRINGFIELD, MASS. 01101	
YP	F11686308	MG, 762 MM:	TOLERANCES ON DECIMALS -	DRAFTSMAN	CHKR	BRIDGE, RECEIVER	
TS	F11699805	M60, M60C,	FRACTIONS - ANGLES - 1°	TRACER	CHECKER		
EL 2		M60D,	MATERIAL	ENGINEER	ENGINEER		
RA		M60D	SEE NOTE 3	ENGINEER	ENGINEER		
BH		SEE ENGINEERING RECORDS	HEAT TREATMENT	ENGINEER	ENGINEER		
RH		NEXT ASSY USED ON	SEE NOTE 4	APPROVED		DWG SIZE D	CODE IDENT NO 19205
		APPLICATION	FINAL PROTECTIVE FINISH:			7269252	7269252
			FINISH 5.3.12 OF MIL-STD-171			SCALE 2/1	UNIT WT
							SHEET 1 OF 1

REDUCED SIZE PRINT

NOTES: 1. FINISH 125 EXCEPT AS NOTED. FORGED SURFACES 250 .
 2. MATERIAL: STEEL, COMP 4140, SPEC QQ-S-624: (J5) OR COMP 1141, SPEC QQ-S-637, EXCEPT HOT FINISHED 1141 STEEL BARS FOR FORGING PURPOSES, AND ALL OTHER CONDITIONS OF SPECIFICATIONS ARE COMPLIED WITH. (L1)
 3. HEAT TREATMENT: HEAT AT 1525° TO 1575° F OIL QUENCH. TEMPER 1 HOUR AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
 USE SELECTIVE DIA TO OBTAIN FIT SHOWN ON RECEIVER ASSY. (K3)

This drawing may be downloaded free of charge from <http://www.josreichert.com>. It is provided by Joseph Reichert, d/b/a Reichert Büchsenmacher (RB).

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
E		2 DEC 59	
F	REDRAWN AND REVISED SEE EO SA 26085	10 APR 62	<i>R. J. Henry</i>
G	REF EO NO. SA 27115	30 AUG 63	<i>R. J. Henry</i>
H	REF EO NO. SA 27297	18 MAR 65	<i>R. J. Henry</i>
J	(1-5) REF EO SA 28042	15 JUL 65	<i>R. J. Henry</i>
K	(1-3) SEE EO SA 29002	13 APR 66	<i>R. J. Henry</i>
L	(1) SEE EO HRD 82370	3-12-69	<i>R. J. Henry</i>



WARNING: COMPLETION OF A MACHINE GUN RECEIVER REQUIRES PRIOR BATH APPROVAL.

PHYSICAL PROPERTIES		TOLERANCES ON DECIMALS		ORIGINAL DATE OF DRAWING 18 DEC 57		GUIDE, OPERATING ROD		SPRINGFIELD ARMOY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD 1, MASS.		
VP	F11686308	MG, 7.62 MM:	ANGLES	DRAFTSMAN H.M.F.	CHECKER L.S.M.	SCALE 1/1		DWG NO. C 7269256		
TS	F11699805	M60, M60C,	FRACTIONS	TRACER R.P.F.	CHECKER <i>R. J. Henry</i>					
EL 3	SEE ENGR RECORDS	M60C	MATERIAL: SEE NOTE 2		ENGINEER <i>R. J. Henry</i>	UNIT WT		SHEET OF		
RA	SEE ENGR RECORDS		HEAT TREATMENT: SEE NOTE 3		SUBMITTED <i>R. J. Henry</i>	ORD CORPS				
DN	NEXT ASSY	USED ON	FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF I -STD-171		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE <i>H. J. Lynch</i>	ORD CORPS				
BN	C23 TO 30	DO NOT APPLY PART NO								

C 7269256

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CODE IDENT NO. 19205
 ORD PART NO. 7269256 (H)