

**DRAWINGS**  
**OF THE**  
**1911-A1**  
**MODEL**  
**GOVERNMENT**  
**PISTOL**

**Note from the publisher**

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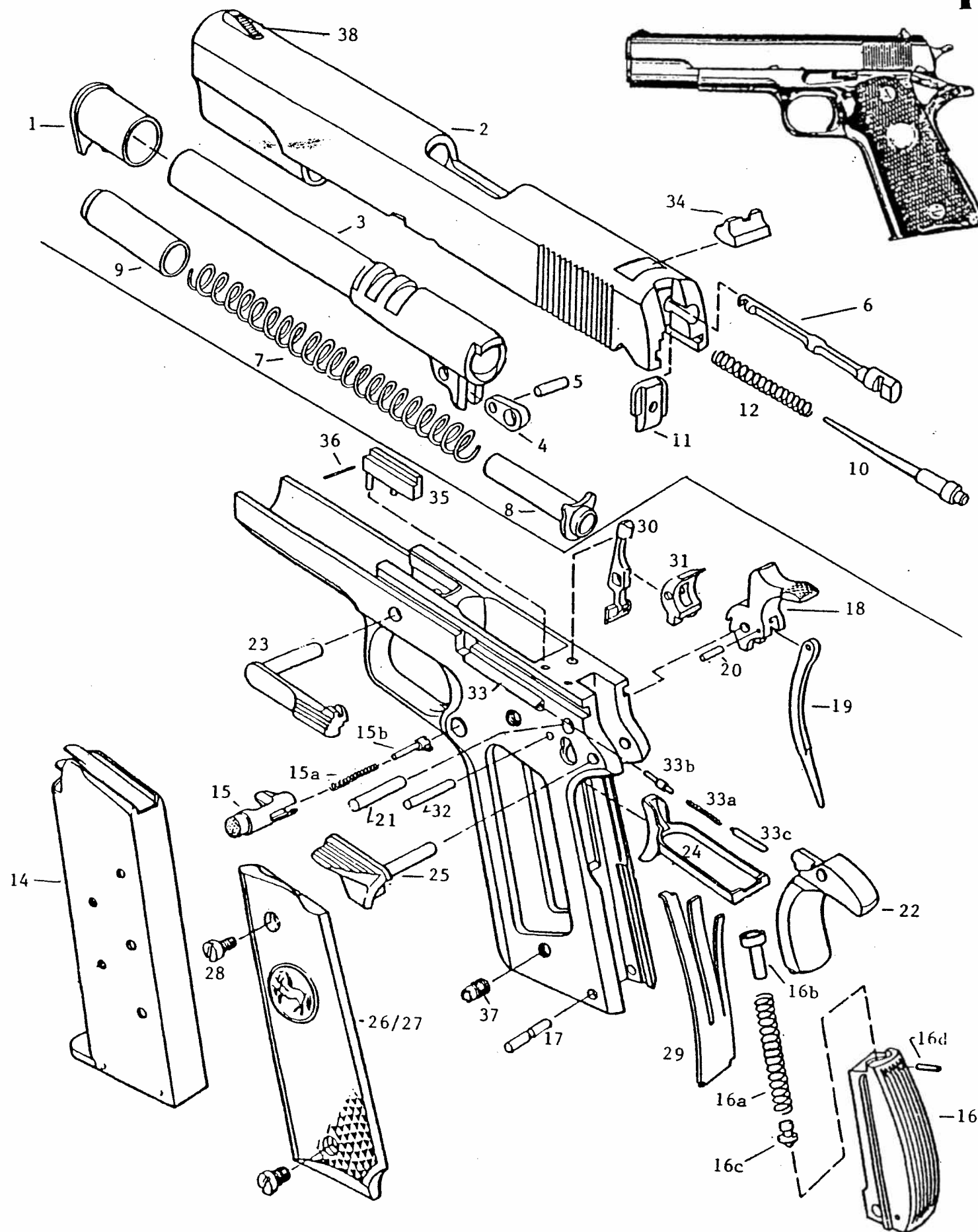
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### Drawings of the Government Model 1911-A1 Pistol

These drawings are primarily from the 1928 update of the Government Model 1911 pistol to the Government Model 1911-A1 version. However, a few of the drawings, primarily of the National Match parts, are from later dates. As with any successful product with a long lifetime, this pistol underwent a variety of changes over the years. Many of the parts have had minor revisions and/or alterations to the dimensions to improve performance of the firearm or to make manufacturing more efficient. Most of the changes can be found as drawings from a facility other than the one that made the original drawings. However, these minor changes do not alter the interaction of the parts.

The reader will no doubt notice that the drawings are not uniform in size or scale. The original drawings coming from a variety of sources naturally were made in different sizes. Some extensive enlarging and shrinking was required in trying to make them fit into a single-size format that could be easily reproduced. For example, the drawings were put two to a page when the originals were close to the 8-1/2 x 11 inch (A size) format. In some cases some of the top, bottom, or one side of a drawing may be missing. The missing areas do not contain any critical information concerning the dimensions or metal treatment.

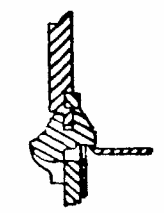
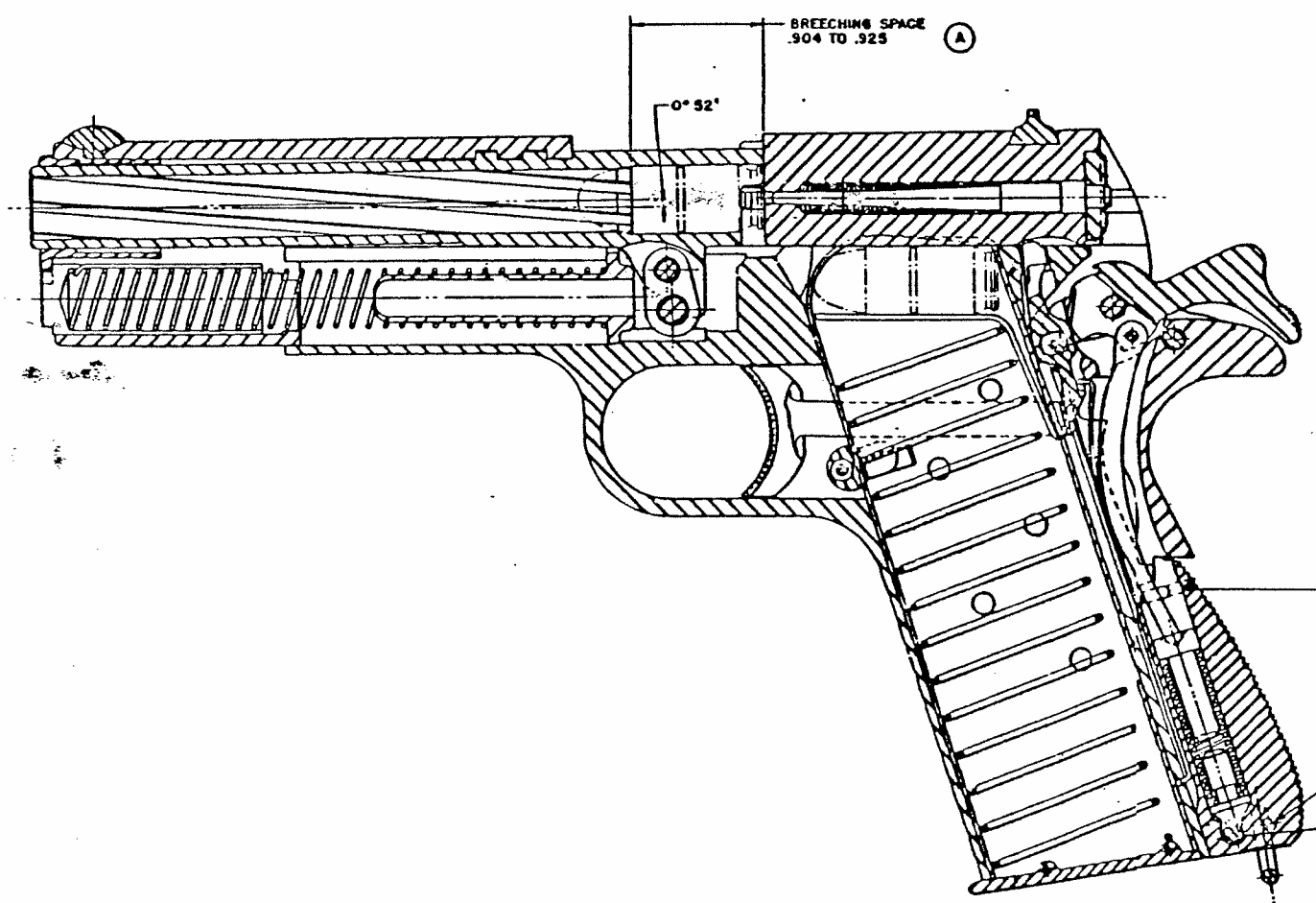
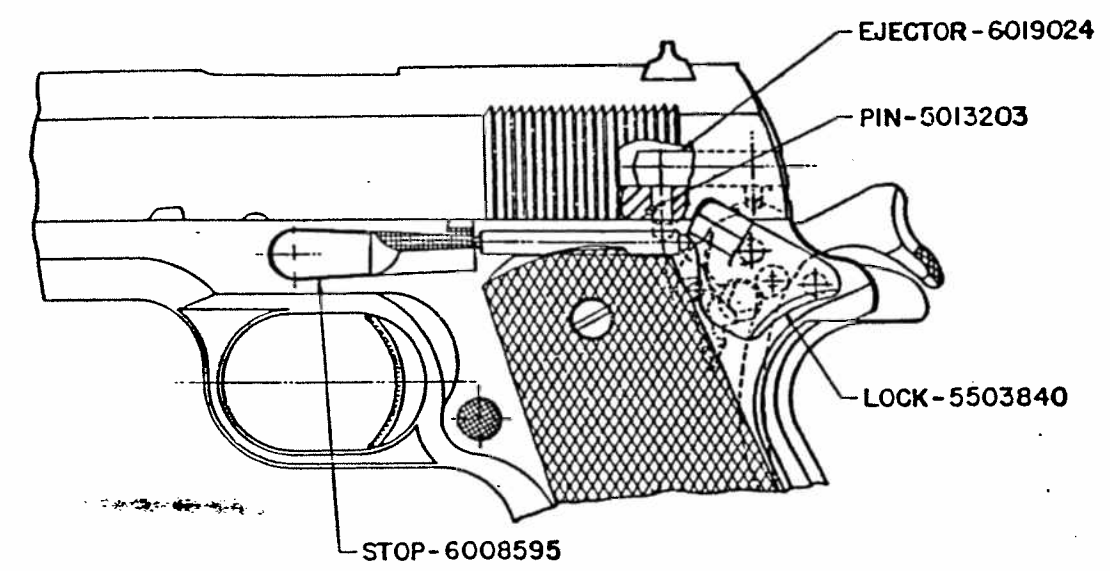
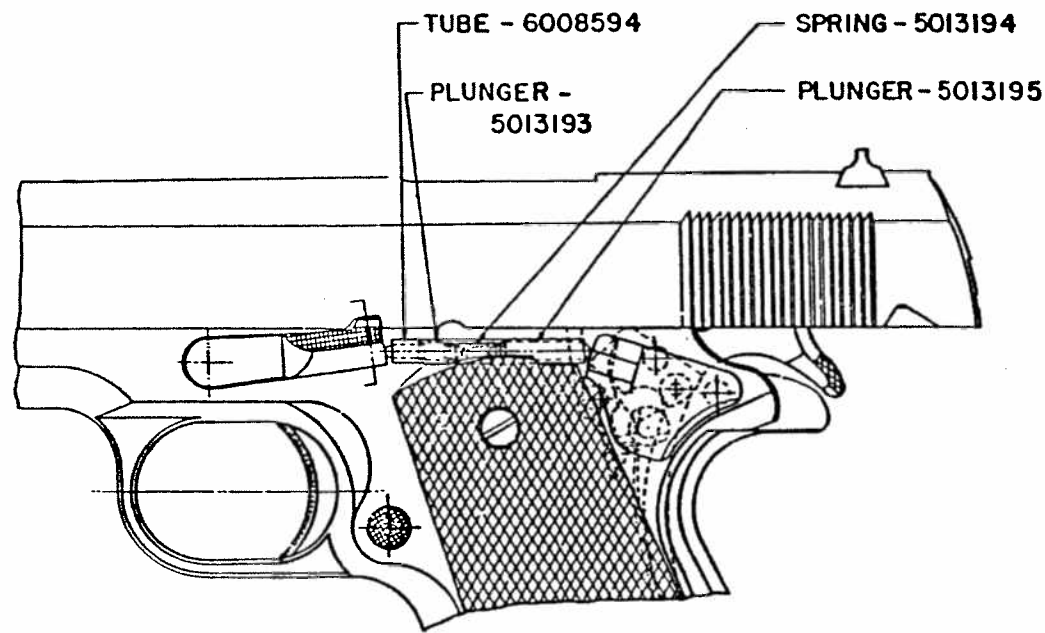
Part numbers used in the exploded view at right should make it easy to locate a specific part. This numbering system was in use by the National Rifle Association in their disassembly manuals many years ago. The numbering system has also been adopted by some suppliers for their parts catalogs.



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F 7265655

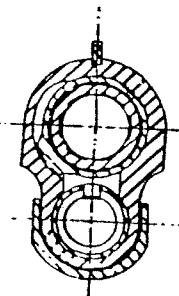
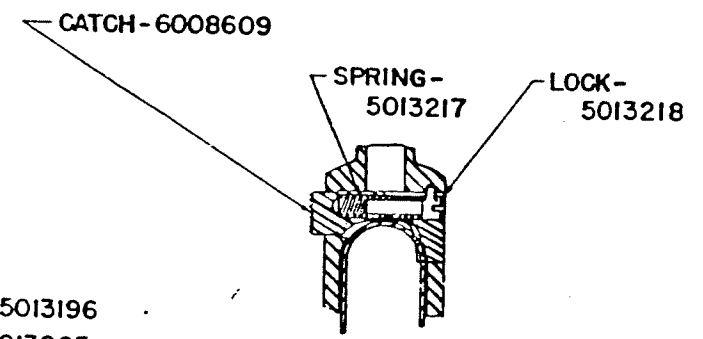
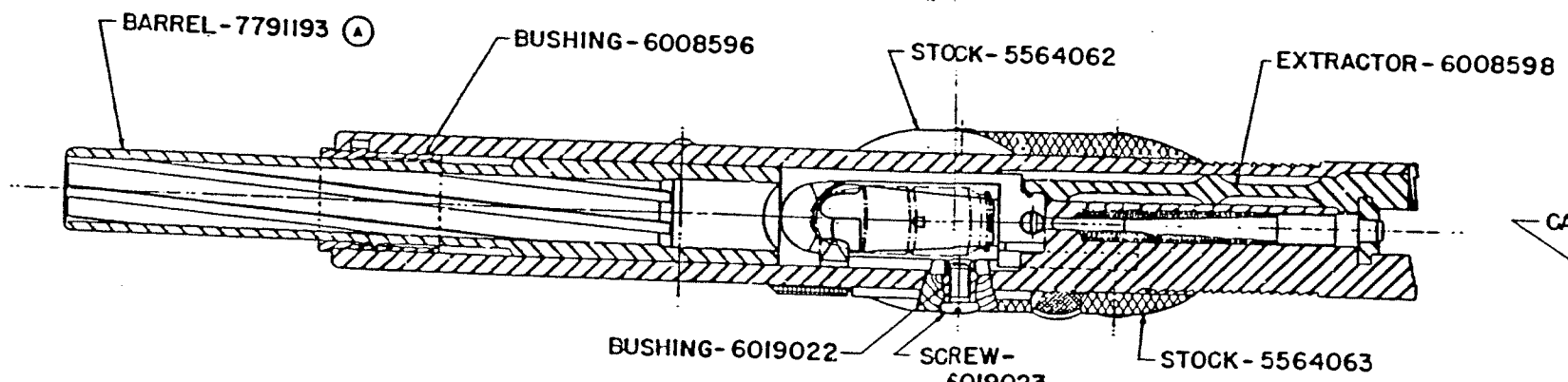


SECTION C-C  
MAGAZINE FOLLOWER IN CONTACT WITH SLIDE STOP

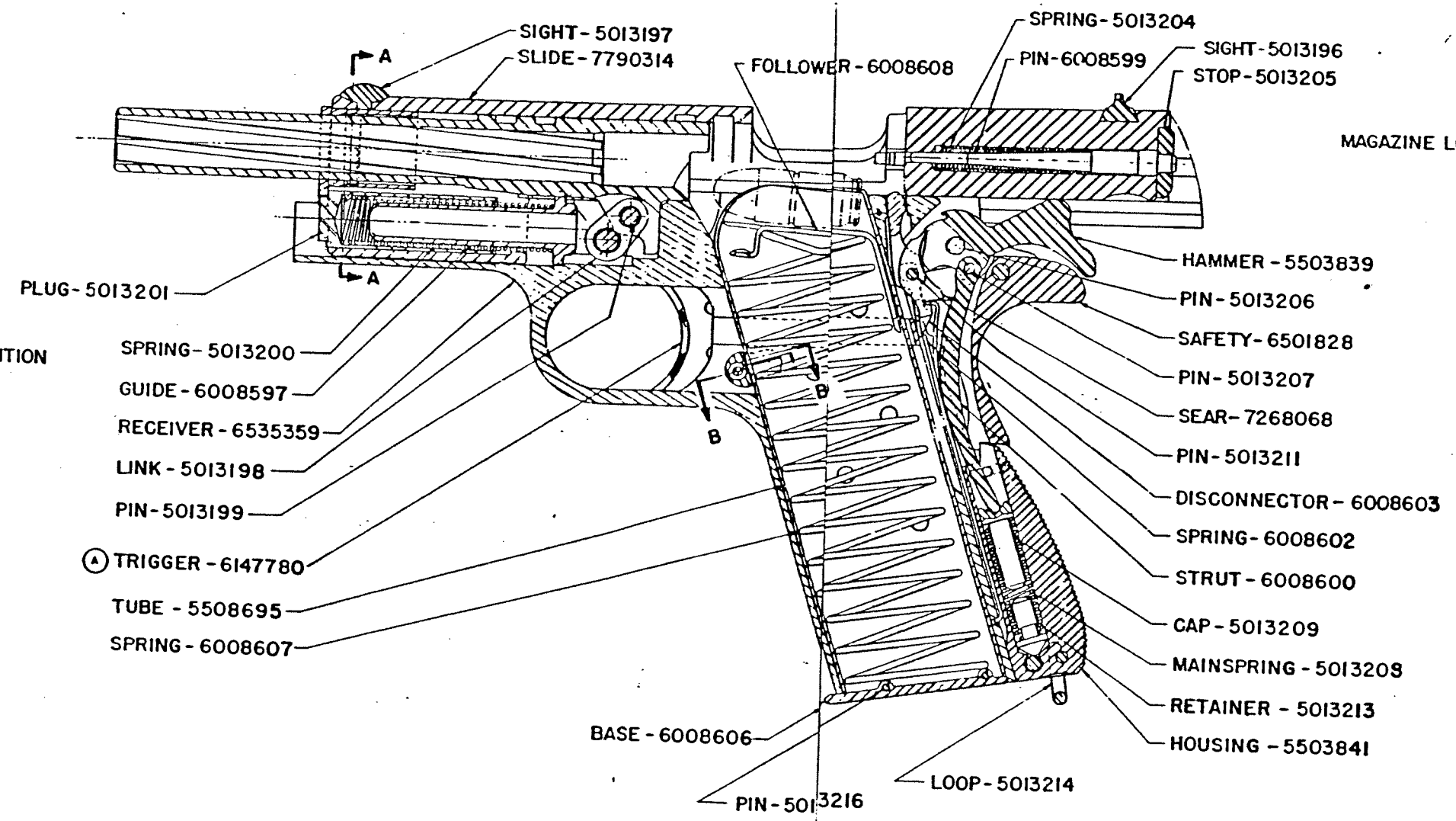
F7265655

PART NO. 7265655

MATERIAL PROPERTY	TOLERANCES ON DIMENSIONS UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE 11 MAR 60	PISTOL, AUTOMATIC, CAL. 45, M1911A1	DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILL. 61201
APPLICATION DO NOT APPLY PART NO.	HEAT TREATMENT FINISH PROTECTIVE FINISH	APPROVED BY <i>[Signature]</i>		
SCALE 2/1			7265655	2 of 3



SECTION A-A  
BARREL BUSHING LOCK IN POSITION



F7265655

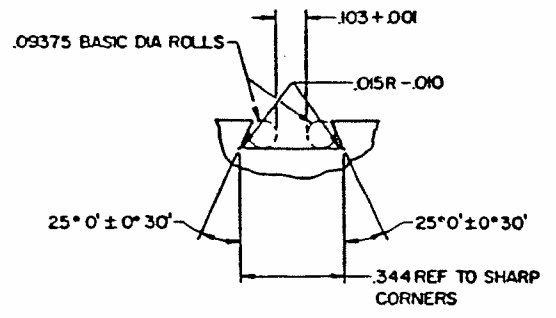
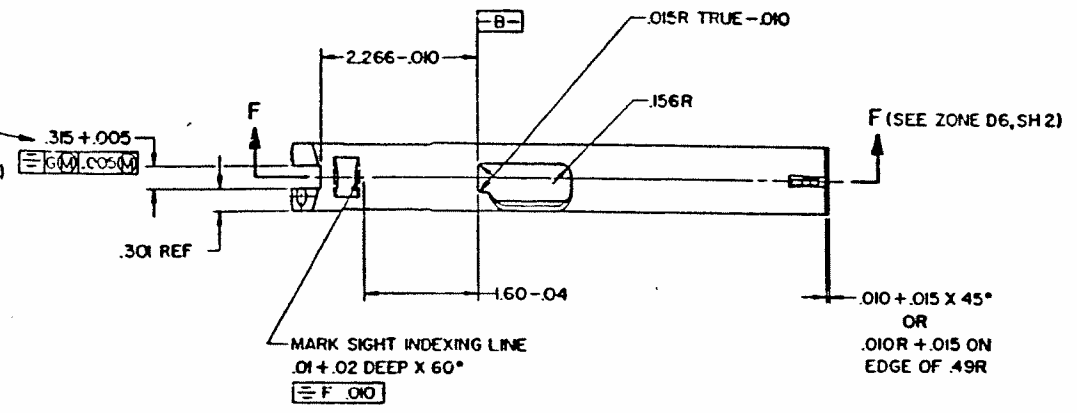
PART NO. 7265655

PHYSICAL PROPERTIES		TOLERANCES ON DIMENSIONS		ORIGINAL DATE OF DRAWING	
BY	DATE	ANGLES	FRACTIONS	11 MAR 60	REVISED
BY	DATE	MATERIAL	DECIMALS	FILED	CHANGES
BY	DATE	TREATMENT		SUBMITTED	
DO NOT	APPLY PART NO.	FINAL PROTECTIVE FINISH		APPROVED BY	
DO				<i>[Signature]</i>	

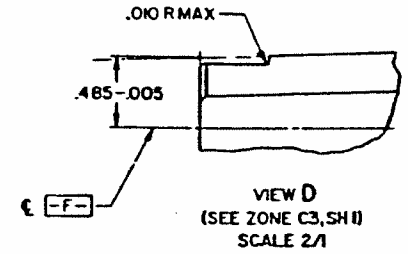
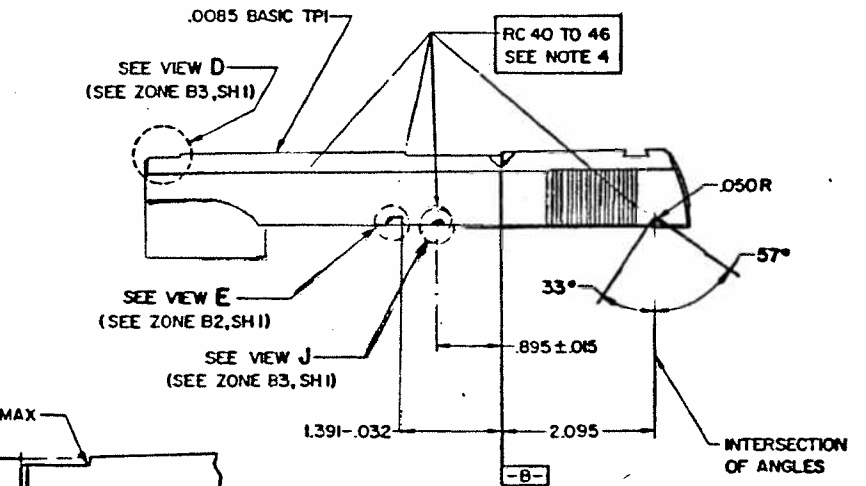
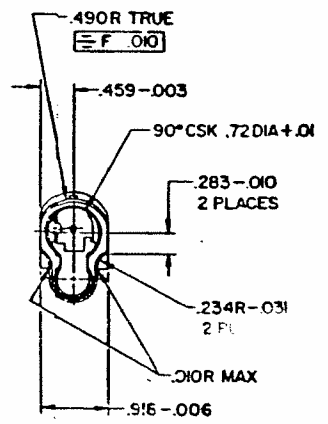
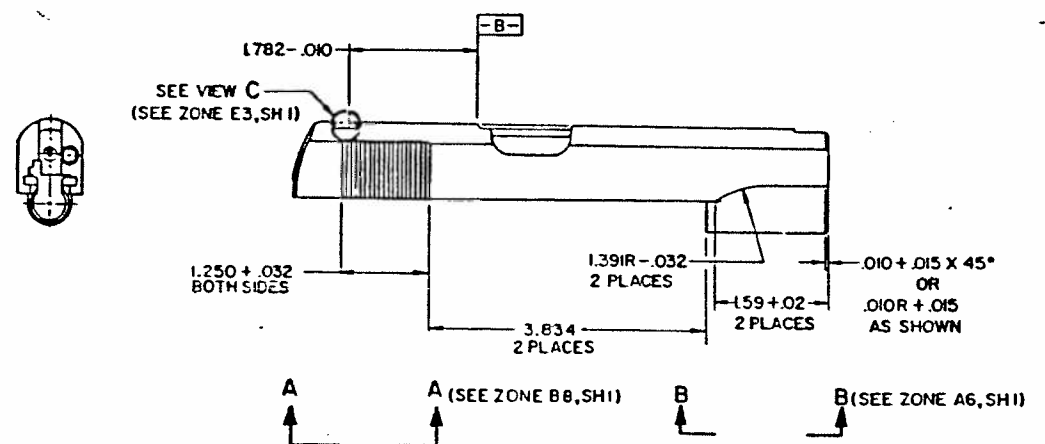
PISTOL, AUTOMATIC, CAL.45, M1911A1 (SECTIONAL VIEWS)  
DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILL. 61204  
F 7265655  
SCALE 2/4 UNIT WT

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
B	REPLACE REVA WITH CHAMFER.	10 DEC 64	W. J. ...
C	SEE ED NO. 342788	1-9-67	...
D	SEE ED NO. 416-15889	1-9-67	...
E	SEE ED NO. 21154	23 MAY 73	...
F	SEE EAR HOR 30687-1		

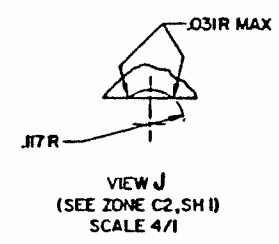
15-  
 FINISH <sup>125</sup> EXCEPT AS NOTED.  
 ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.  
 MATERIAL:  
 STEEL, COMP 8650, 4140, (GUN QUALITY).  
 AUSTENITE GRAIN SIZE NO.5 OR FINER,  
 SPEC QQ-S-624.  
 HEAT TREATMENT:  
 HEAT AT 1540° TO 1580°F. OIL QUENCH.  
 TEMPER TO HARDNESS SPECIFIED. (ZONES B5 & D1)  
 ALTERNATIVE HEAT TREATMENT: HEAT AT 1540° TO 1580°F. ISOTHERMALLY QUENCH IN NEUTRAL SALT. TEMPER AT NOT LESS THAN 400°F FOR ONE HOUR MINIMUM. HEAT TREATMENT METHOD IS FOR GUIDANCE. EXCEPT THAT TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.  
 FOR IDENTIFICATION MARKINGS SEE DWG C5503845.  
 MIL-W-13855 APPLIES.



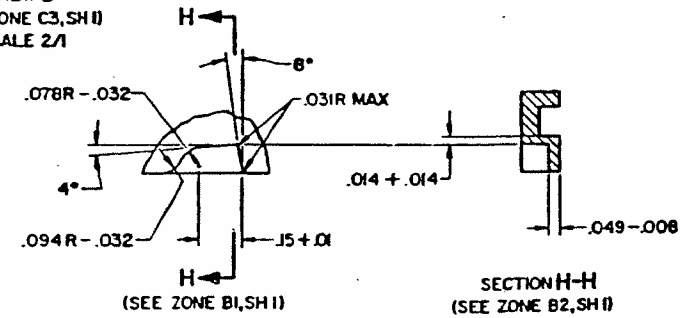
VIEW C  
 (SEE ZONE C6, SH 1)  
 SCALE 4/1



VIEW D  
 (SEE ZONE C3, SH 1)  
 SCALE 2/1

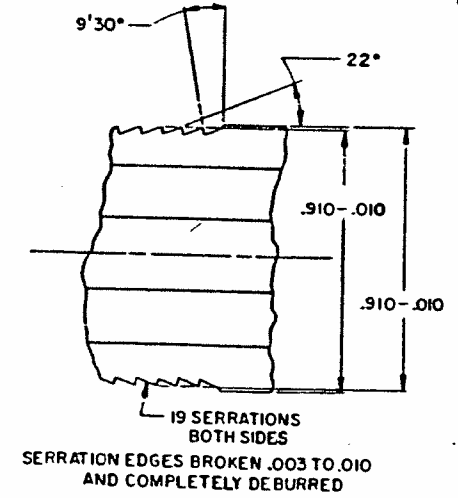


VIEW J  
 (SEE ZONE C2, SH 1)  
 SCALE 4/1

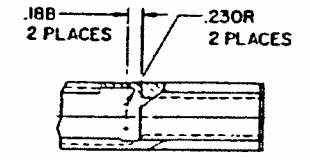
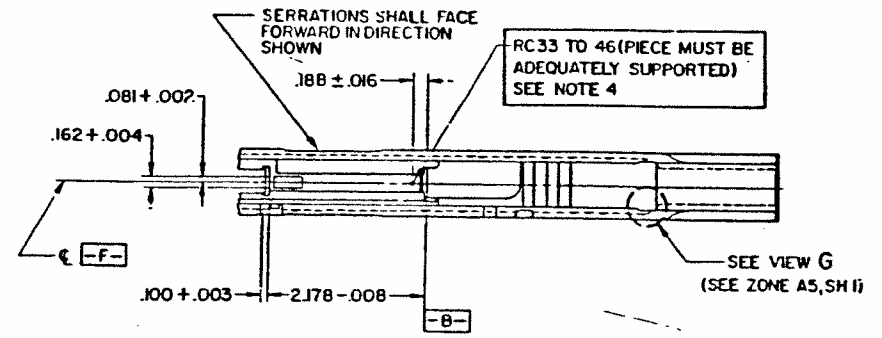


VIEW E  
 (SEE ZONE C2, SH 1)  
 SCALE 4/1

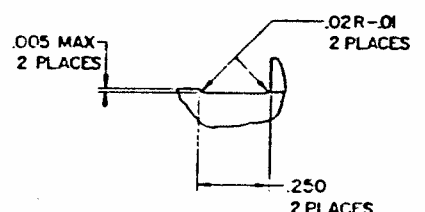
SECTION H-H  
 (SEE ZONE B2, SH 1)  
 SCALE 4/1



VIEW A-A  
 (SEE ZONE C6, SH 1)  
 SCALE 4/1



VIEW B-B  
 (SEE ZONE C5, SH 1)

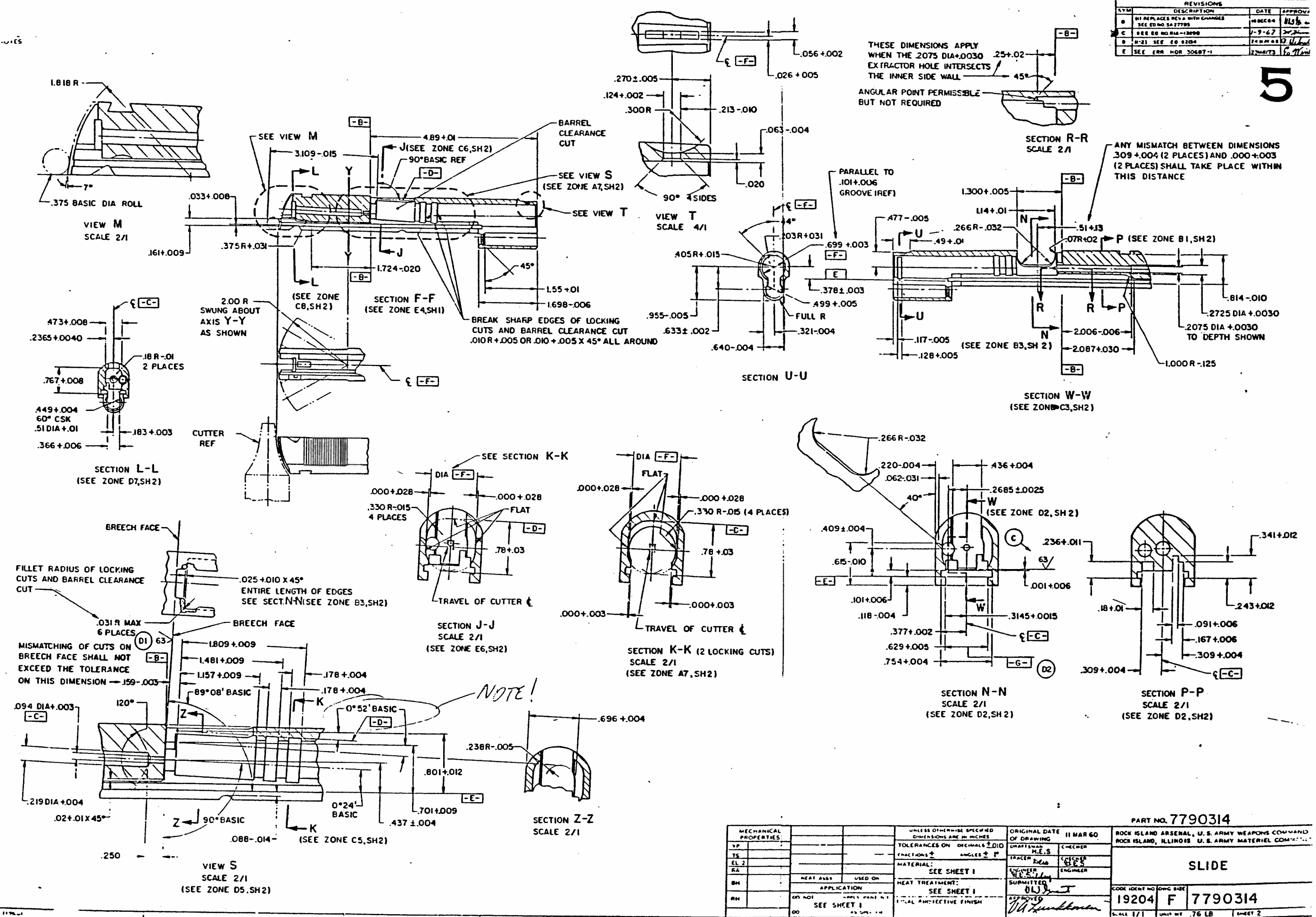


VIEW G  
 (SEE ZONE B5, SH 1)  
 SCALE 4/1

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		PART NO. 7790314	
YP		TOLERANCES ON	DECIMALS ± .010	18 MAR 60	ROCK ISLAND ARSENAL, U.S. ARMY WEAPONS COMMAND	SLIDE	
TS		FRACTIONS ±	ANGLES ± 1°	DRAWN	ROCK ISLAND, ILLINOIS U.S. ARMY MATERIEL COMMAND		
EL 2	C7790353 PISTOL M1911A1	MATERIAL	SEE NOTE 3	CHECKER			
RA	D12006341 PISTOL M15	HEAT TREATMENT	SEE NOTE 4	ENGINEER			
BH	HEAT TREATMENT USED ON	APPLICATION		ENGINEER			
RH	APPLY PART NO SEE NOTE 5 AS SPECIFIED	FINAL PROTECTIVE FINISH		APPROVED		CODE IDENT NO DWG SIZE	19204 F 7790314
				APPROVED		SCALE 1/1	UNIT WT 76 LB SHEET 1 OF 2

SYM	REVISIONS	DESCRIPTION	DATE	APPROV
B	H1	REPLACES REV A WITH CHANGES	18 DEC 64	WLS
C	SEE ED NO 54 27793			
D	SEE ED NO 814-13090		1-9-67	
E	H-21 SEE ED 8204		24 MAR 68	
F	SEE ERN HOR 30687-1		12 MAR 73	

5



MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		PART NO. 7790314	
VP		TOLERANCES ON DECIMALS	.010	11 MAR 60	ROCK ISLAND ARSENAL, U.S. ARMY WEAPONS COMMAND		
TS		FRACTIONS		CHECKER	ROCK ISLAND, ILLINOIS U.S. ARMY MATERIEL COMMAND		
EL 2		ANGLES	± P	ENGINEER	SLIDE		
RA		MATERIAL	SEE SHEET 1	APPROVED	CODE IDENT NO. 19204 F 7790314		
BN		HEAT TREATMENT	SEE SHEET 1	DATE	SCALE 1/1 UNIT WT. 76 LB SHEET 2		
RR		APPLICATION	SEE SHEET 1	APPROVED			
		HEAT TREATMENT	SEE SHEET 1				
		APPROVED	SEE SHEET 1				
		APPROVED	SEE SHEET 1				

1. MATERIAL:  
 A. WHEN FABRICATED FROM WROUGHT MATERIAL: STEEL, CMPSN1060 THRU 1080, SPEC QQ-S-631, OR STEEL, CMPSN 4140, SPEC QQ-S-624. AUSTENITIC GRAIN SIZE 6 OR FINER

B. WHEN FABRICATED FROM CASTING: PRECISION CASTING, CMPSN IC-4140, SPEC ML-S-22141.

2. ALL EDGES SHALL BE BROKEN .005 + .010.

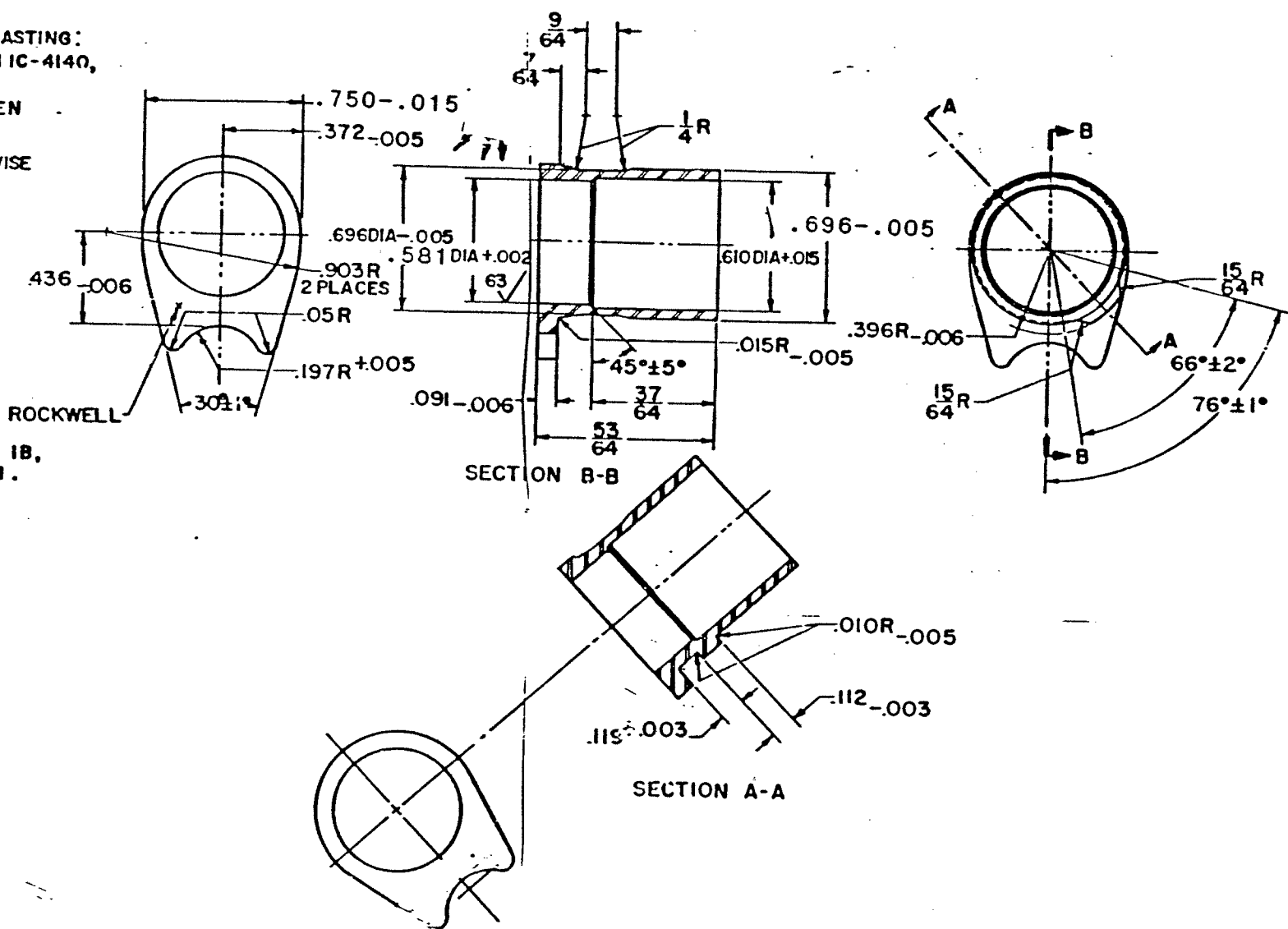
3. FINISH  $\sqrt{125}$  EXCEPT AS OTHERWISE SPECIFIED.

4. HEAT TREATMENT: HEAT AT 1525° TO 1575° F. OIL QUENCH. TEMPER TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE.

5. LUBRICATING OIL, SPEC VV-L-800.

6. CASTING SHALL BE CLASSIFIED AND INSPECTED IN ACCORDANCE WITH CLASS 1B, GRADE B, SPEC MIL-C-6021.

7. MIL-W-13855 APPLIES.



THIS NATIONAL MATCH BUSHING DRAWING HAS BEEN MODIFIED TO STANDARD BUSHING DIMENSIONS, NUMBERING AND MARKINGS

SYM	DESCRIPTION	DATE	APPROVAL
E	(2) SEE ERR HQR 50605	10 FEB 75	[Signature]
D	SEE ERR HRD 20623	26 MAY 72	[Signature]
C	(1-4) SEE EO RIA-14180	5-27-67	[Signature]
B	SEE EO NO. 24745	11 MAR 60	[Signature]
A'	SEE ECO NO. 23385	12 JAN 56	[Signature]

PHYSICAL PROPERTIES		APPLICATION	
TP		NEXT ASST	USED ON
TS	C7791469		
EL 2			
RA			
DN			
RN	D55-60	DO NOT APPLY PART NO.	AS SPECIFIED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES  
 TOLERANCES ON DECIMALS ±.010  
 FRACTIONS ±.010  
 MATERIAL SEE NOTE  
 HEAT TREATMENT SEE NOTE 4  
 FINAL PROTECTIVE FINISH SEE NOTE 5

ORIGINAL DATE OF DRAWING 4 FEB 55  
 DRAFTSMAN HES  
 TRACER HES  
 ENGINEER [Signature]  
 SUBMITTED [Signature]  
 APPROVED BY ORDER OF THE CHIEF OF ORDNANCE [Signature] LT COL

**BUSHING, BARREL**

DEPT OF THE ARMY  
 ROCK ISLAND ARSENAL  
 ROCK ISLAND, ILL. 61201  
 DWG SIZE **6008596**





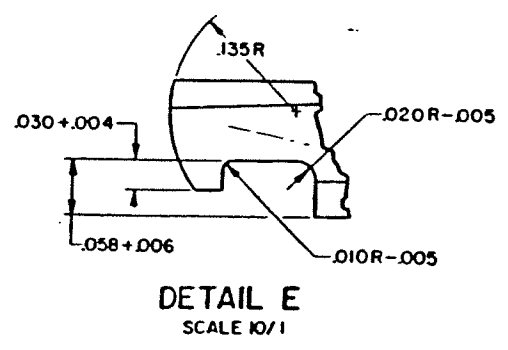
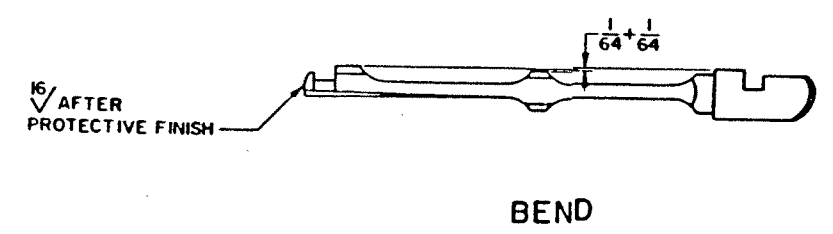
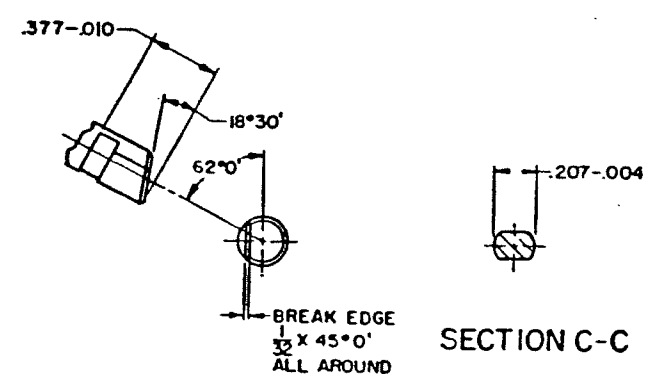
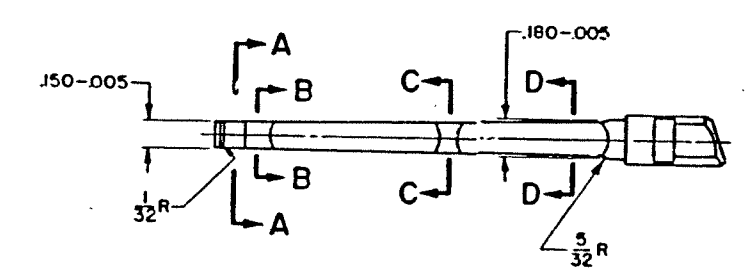
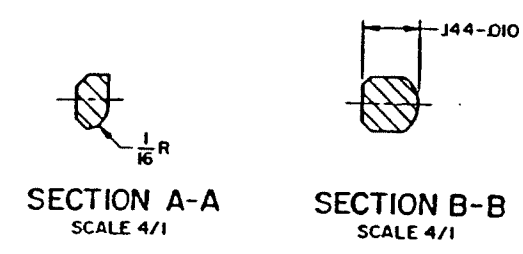
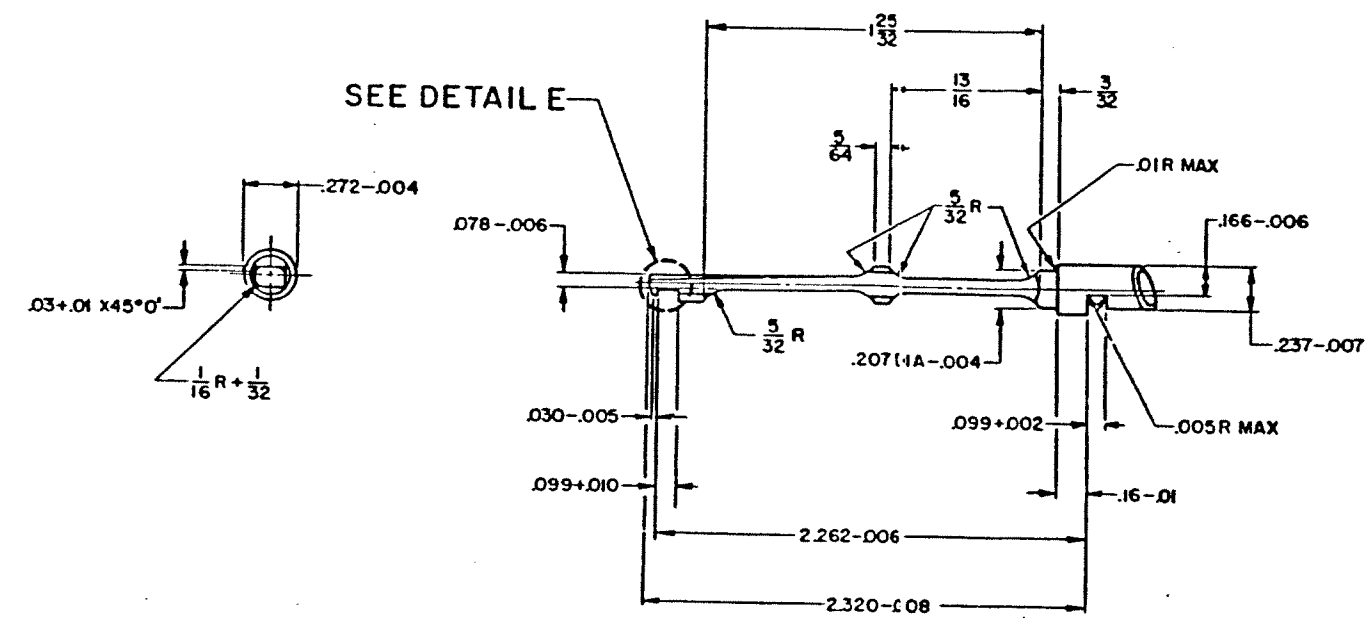


REV	DESCRIPTION	DATE	APPROVED
B		26 MAR 63	
C	REDRAWN AND REVISED WAS 'C' SIZE, SEE EO SA 28316		
D	181SEE ERR MOR 30687-2	19 JUN 75	
E	(2) SEE ERR MOR 50605	10 FEB 75	

D6008598

9

- NOTES:
- FINISH 125 ✓
  - ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
  - STEEL, CMPSN 1060 THRU 1095 SPEC QQ-S-631 OR ASTM A108. AUSTENITIC GRAIN SIZE 7 OR FINER.
  - HEAT TREATMENT: AUSTENITIZE AT 1525° TO 1550°F. AUSTEMPER AT 700°F. TEMPER IF NECESSARY TO HARDNESS SPECIFIED.
  - UNLESS OTHERWISE SPECIFIED, SURFACES REQUIRING 32 AND FINER ROUGHNESS HEIGHT RATING MAY BE PROCESSED AFTER APPLICATION OF FINAL PROTECTIVE FINISH. BRIGHT AREAS RESULTING FROM SUCH PROCESSING ARE PERMISSIBLE.
  - MIL-W-13855 APPLIES.
  - FINISH 5.3.12 OF MIL-STD-171.



D6008598

CODE IDENT No. 19204  
PART NO. 6008598

B12006318	PSTOL M15	PHYSICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING	1 MAY 28
F7791205	PSTOL M15A1	VP	DIMENSIONS ARE IN INCHES	TOLERANCES OF	
F7268381	NATL MATCH	TS	FRACTIONS DECIMALS ANGLES		
F7265655	PSTOL M15A1	ELZ	1/64 2/10 1/2 1/4		
		RA			
		RE	MATERIAL:		
		DM	SEE NOTE 3		
		HT	HEAT TREATMENT:		
		AP	SEE NOTE 4		
		FIN	FINAL PROTECTIVE FINISH:		
		APP	SEE NOTE 7		
		CON			
		QTY			
		APPLY PART NO.			

EXTRACTOR

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILLINOIS  
61201

6008598

SCALE 2:1 UNIT WT .01LB

SHEET 1 OF 1





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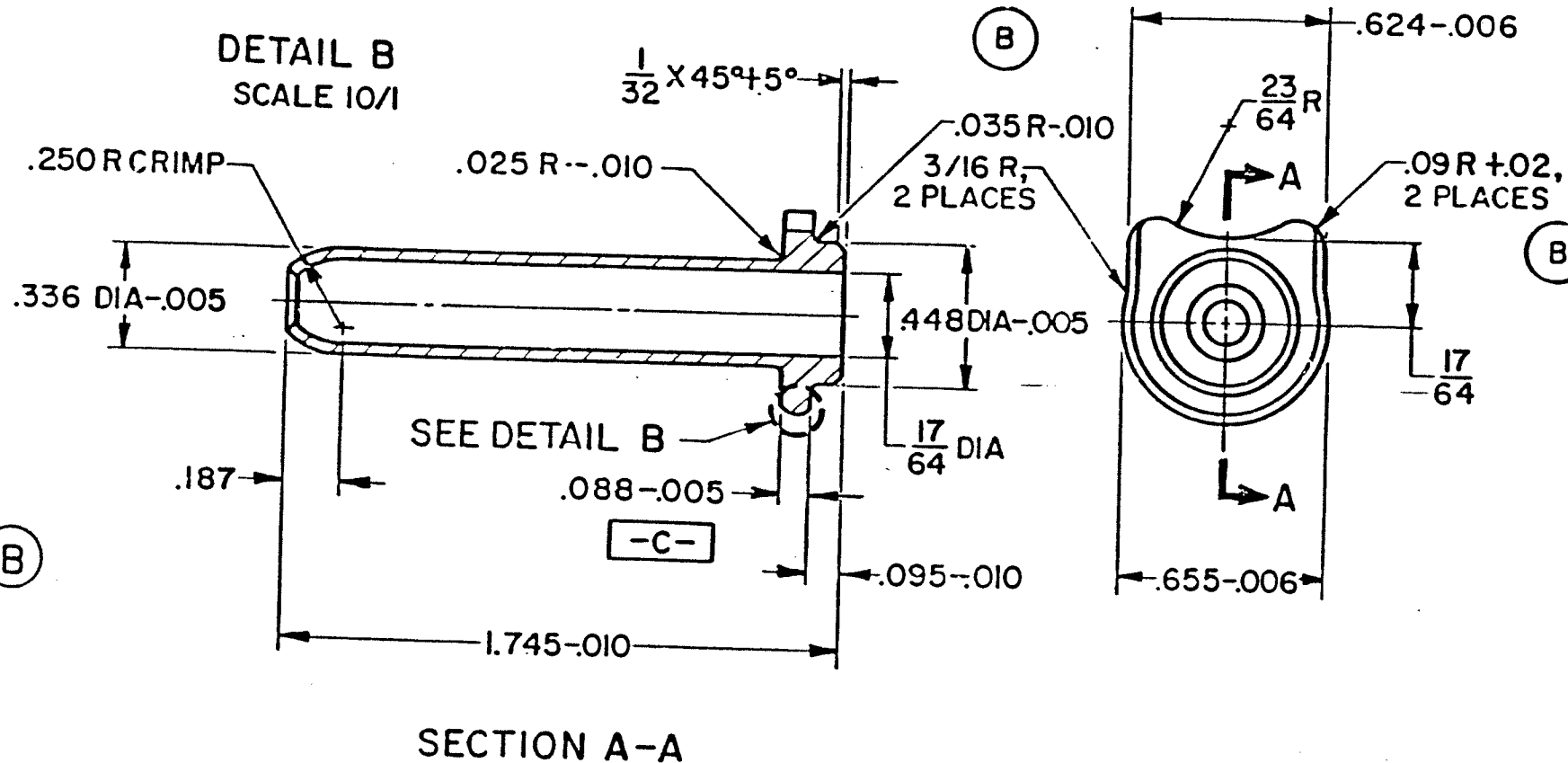
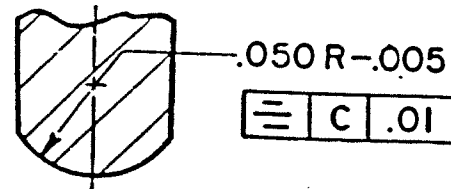
26008597

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
6		24 JAN 50	
A	REDRAWN AND REVISED SEE EO SA 26316	27 NOV 62	<i>[Signature]</i>
B	(6) SEE ERR HQR 20704	26 JUN 72	<i>[Signature]</i>
C	SEE ERR HQR 30687-1	23 MAY 73	<i>[Signature]</i>
D	(3) SEE ERR HQR 50605	10 FEB 75	<i>[Signature]</i>

NOTES:

- FINISH 125  $\sqrt{\hspace{1cm}}$  ALL OVER. (D)
- ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED. (B)
- HEAT TREATMENT: HEAT AT 1500° TO 1550°F; OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. (B)
- STEEL, CMPSN 1045, 1050, PER ASTM A108 OR 1 CMPSN 1137, PER QQ-S-637. (D)
- FINISH 5.3.1.2 OF MIL-STD-171. (D)

MIL-W-13855 APPLIES.



CODE IDENT NO. 19204

PART NO. 6008597

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING		DEPT OF THE ARMY	
F7791205	PISTOL, M1911A1	YP	DIMENSIONS ARE IN INCHES	1 MAY 28		ROCK ISLAND ARSENAL	
F7268381	NATL MATCH	TS	TOLERANCES ON FRACTIONS DECIMALS ANGLES	DRAFTSMAN <i>[Signature]</i>	CHECKER <i>[Signature]</i>	ROCK ISLAND, ILL., 61201	
F7265635	PISTOL, M1911A1	EL2	$\pm 1/64$ $\pm .010$	TRACER <i>[Signature]</i>	CHECKER <i>[Signature]</i>	GUIDE, RECOIL SPRING	
B12006336	PISTOL, M15	RA	MATERIAL:	LT COL <i>[Signature]</i>	ORIG CORPS		
APPLICATION		BN	SEE NOTE 4	SUBMITTED		6008597	
NEXT ARMY		UNED ON	HEAT TREATMENT:	<i>[Signature]</i>			
APPLY PART NO. -AS SPECIFIED		FN	SEE NOTE 3	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE		SHEET 1 OF 1	
			FINAL PROTECTIVE FINISH:	<i>[Signature]</i>			
			SEE NOTE 5	LT COL <i>[Signature]</i>		SCALE 2/1 UNIT WT .02 LB	

B5013200

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
9		13 MAY 49	
A	REDRAWN AND REVISED SEE EO SA 26316	27 NOV 62	
B	(3) SEE ERR-HQR 30778	12 DEC 73	
C	NOR W9S2027 79-12-18	80-09-12	
D	NORWOS2002 81-02-26	82-01-15	

(B)

DIAMETER OF WIRE ..... .043  
 DIAMETER OF COIL (OD) ..... .430 ± .005  
 FREE LENGTH ..... 6.55 REF  
 ACTIVE COILS ..... 29 REF  
 TOTAL COILS ..... 30 REF  
 DIRECTION OF HELIX ..... L H  
 LOAD AT COMPRESSED LENGTH OF 3.72" = 8.00 LB ± 0.50 LB  
 LOAD AT COMPRESSED LENGTH OF 1.81" = 13.55 LB ± 0.60 LB  
 SPRING RATE ..... 2.88 LB/IN REF  
 SOLID LENGTH ..... 1.375 MAX  
 TYPE OF ENDS ..... NOT SQUARED OR CLOSED  
 CRIMP ONE END COIL TO .326 - .010 I D

SPECIAL DATA  
 HOLE DIA INTO WHICH SPRING FITS FREELY ..... .448 MIN  
 ROD DIA OVER WHICH SPRING SLIDES FREELY ..... .336 MAX  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572,  
 TYPE I, GRADE A.

\*EXCEPT FOR CRIMPED END.

(USED WITH GUIDE - 6008597)

(B)

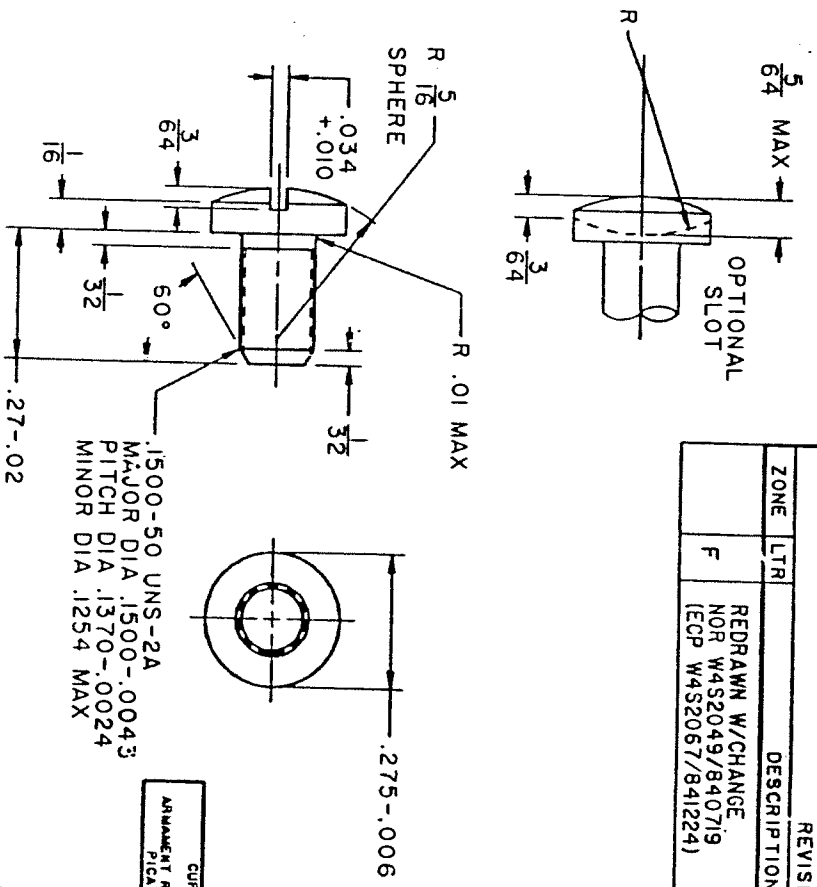
U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND DOVER, NEW JERSEY 07801	
CODE IDENT NO. 19200	CODE IDENT NO. <del>19204</del> PART NO. 5013200
SPRING, RECOIL	
DO NOT APPLY PART NO.	5013200 SHEET 1 OF 1

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING
F7791205	PISTOL M91A1	VP	DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES	1 MAY 26
F7268381	NATL MATCH	TS		ENGINEER E.R.C. CHECKER M.E.K.
F7265655	PISTOL M91A1	SL2	MATERIAL: MUSIC WIRE, STEEL, FED. SPEC QQ-W-470	TRACER R.O.P. CHECKER O.P.L.
SEE ENGRG RECORDS		RA	HEAT TREATMENT: STRESS RELIEVE AT 450 °F FOR 20 MIN, AFTER FORMING	DATE F.E.S. 11/1/73
APPLICATION		SH	FINAL PROTECTIVE FINISH	SUBMITTED
DO NOT APPLY PART NO.		SH		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE

SCALE UNIT WT .02 LB

REVISIONS		
ZONE	LTR	DESCRIPTION
F		REDRAWN W/CHANGE NOR W452049/840719 (ECP W452067/841224)
	870621	ORFI

- NOTES: 1. FINISH 125/ ALL OVER.
2. HEAT TREATMENT: CARBURIZE AT 1600°F ± 25° TO A CASE DEPTH .002 TO .005; OIL QUENCH. TEMPER AT 450°F FOR 20 MINUTES AT HEAT. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
3. STEEL CARBON: GRADE 1018, 1020, 1117; ASTM A108.
4. MIL-W-13855 APPLIES.
5. FINISH 5.3.1.2 OF MIL-STD-171.



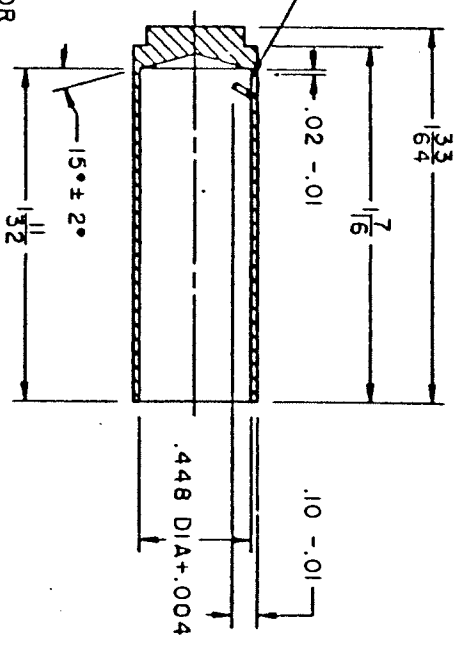
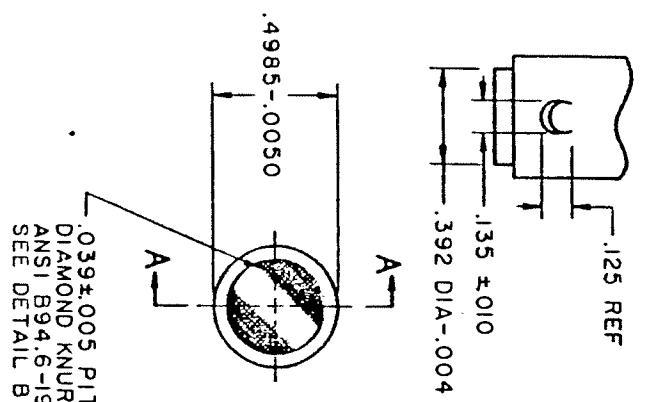
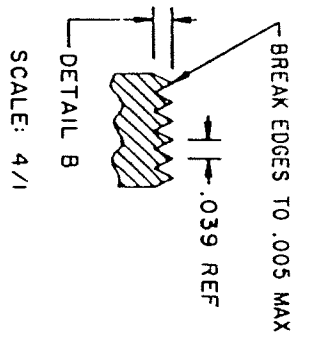
PART NO. 6019023

PMIC		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMAL FRACTION ±1/64	CONTRACT NUMBER		DEPT OF THE ARMY SPRINGFIELD ARMORY SPRINGFIELD, MASS
MECHANICAL PROPERTIES	F7791205 PISTOL.M911A1	THIRD ANGLE PROJECTION	CONTRACTOR		
	F7265655 NATL MATCH		DRAWN BY	J.J.V.	DATE(YR-MO-DA)
	B12006308 PISTOL.M15		CHECKER	L.S.C.	ENGINEER
	NEXT ASSY USED ON		DRAWING APPROVAL	V. A. LUUKKONEN	
	APPLICATION		DESIGN APPROVAL	S. C. SHULTZ	
			SCALE	B 19205	CAGE CODE
			UNIT WT.	4/1	0021 LB
			SHEET		

SMCAR FORM 66, 1 MAR 81(TEMP) REPLACES SMCAR FORM 66, 1 JUL 87(TEMP) WHICH MAY BE USED UNTIL EXHAUSTED

REVISIONS			
ZONE	LTR	DESCRIPTION	DATE (YR MO DA)
F		REDRAWN W/CHANGE NOR G753115/870820	901023
			ORFI

- NOTES:
- FINISH 125/ ALL OVER.
  - MATERIAL: STEEL, COLD DRAWN, SAE 1018 THRU 1025, OR 1018 ASTM A108.
  - HELICAL COMPRESSION SPRING OF .043 DIA WIRE, .430 O.D., .218 PITCH, SHALL ENTER FOR A MINIMUM DISTANCE OF 1/4 OF A COIL.
  - MIL-W-13855 APPLIES.
  - FINISH 5.3.1.2 OF MIL-STD-171.



CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07805-5000

THIS DRAWING HAS BEEN GENERATED ON A CAD SYSTEM LOCATED AT ARDEC, PICATINNY ARSENAL, N.J. CHANGES MUST BE INCORPORATED VIA THIS SYSTEM.

PART NO. 5013201

PMIC		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMAL FRACTION ±1/64	CONTRACT NUMBER		DEPT OF THE ARMY SPRINGFIELD ARMORY SPRINGFIELD, MASS
MECHANICAL PROPERTIES	B12006323 PISTOL.M15	THIRD ANGLE PROJECTION	CONTRACTOR		
	F7791205 PISTOL.M911A1		DRAWN BY	E.R.C.	DATE(YR-MO-DA)
	F7265655 NATL MATCH		CHECKER	K.H.S.	ENGINEER
	NEXT ASSY USED ON		DRAWING APPROVAL	V. A. LUUKKONEN	
			SCALE	B 19205	CAGE CODE
					5013201

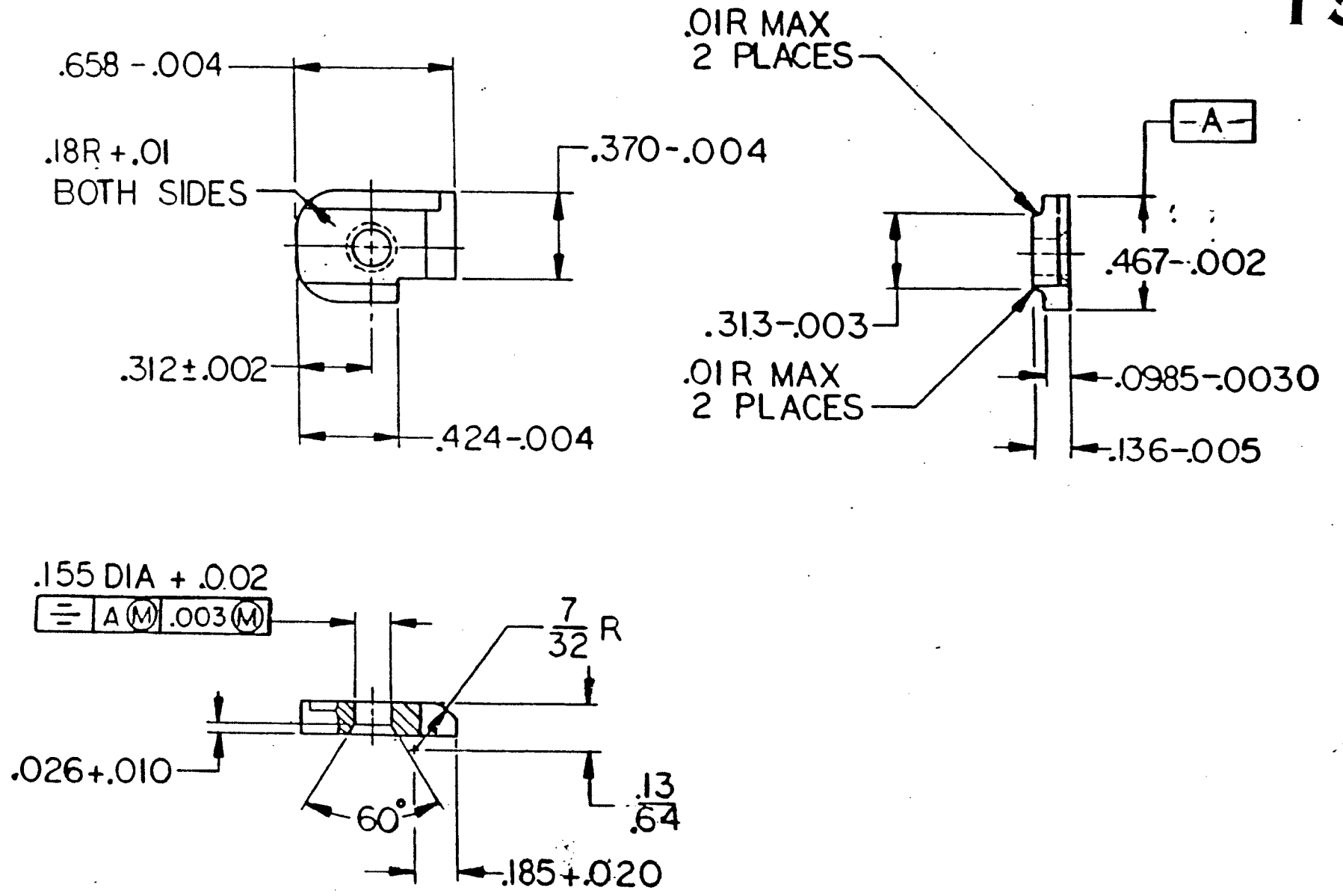
PLUG,  
RECOIL SPRING



NOTES:

1. FINISH ALL OVER.
2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. STEEL, CMPSN I060, I070, PER ASTM A108 OR STEEL, 4140 OR 4150, SPEC QQ-S-624 AUSTENITIC GRAIN SIZE 6 OR FINER. ALTERNATIVE MATERIAL: STEEL, CMPSN IC8640, MIL-S-22141 CLASSIFICATION AND INSPECTION OF INVESTMENT CASTINGS TO BE IN ACCORDANCE WITH CLASS IA, GRADE B, MIL-C-6021. HEAT AT 1520°F TO 1560°F. OIL QUENCH. TEMPER AT APPROXIMATELY 750°F FOR ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. FINISH 5.3.1.2 OF MIL-STD-171. MIL-W-I3855 APPLIES.

(E)



MECHANICAL PROPERTIES				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NO:		PART NO. 5013205	
YS MIN				TOLERANCES:		DATE 1 MAY 28		DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILLINOIS, 61201	
YS MAX				ANGLES ± 5°		PREPARED <i>[Signature]</i>		STOP, FIRING PIN	
EL 2				3 PLACE DECIMALS : 1/64		CHECKED <i>[Signature]</i>			
RA		B12006315	PISTOL, M15	MATERIAL		ENGR'D <i>[Signature]</i>			
BH		F7791205	PISTOL, M1911A1	SEE NOTE 3		SUBMITTED <i>[Signature]</i>			
RH	C43.5 TO 50	F7268381	NATL MATCH	FINAL PROTECTIVE FINISH		APPROVED <i>[Signature]</i>		SIZE C	CODE IDENT NO. 19204
		F7265655	PISTOL, M1911A1					DRAWING NO. 5013205	
		NEXT ASSY	USED ON						

# 16

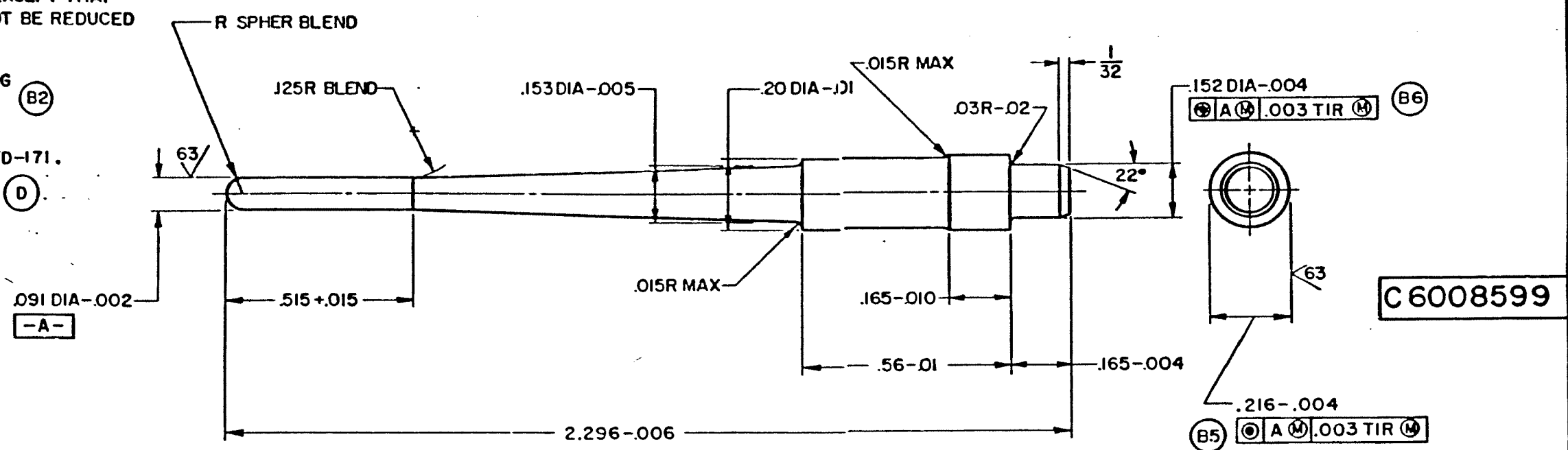
NOTES:

- 1. FINISH  $\sqrt{125}$  EXCEPT AS NOTED.
- 2. ALL EDGES SHALL BE BROKEN .005 +.010 UNLESS OTHERWISE SPECIFIED.
- 3. MATERIAL: STEEL, SPEC QQ-S-631 OR ASTM A108 1060, 1070, 1095. AUSTENITIC GRAIN SIZE 7 OR FINER. (B1)

- 4. HEAT TREATMENT: HEAT AT 1450° TO 1500° F. OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

- 5. TAKE HARDNESS READING ON .20 DIA-.01. (B2)
- 6. MIL-W-13855 APPLIES.
- 7. FINISH 5.3.1.2 OF MIL-STD-171. (D)

(D)



C 6008599

SYB	DESCRIPTION	DATE	APPROVAL
D	(2) SEE ERR HOR 50605	10 FEB 73	
C	(2) SEE ERR HOR 306872	19 JUN 73	
B	(1-6) SEE EO RIA-13863	DEC 21 66	
A	REDRAWN AND REVISED WAS B	27 NOV 62	
7	SIZE, SEE EO SA 26316	11 FEB 52	

CODE IDENT NO. 19204  
PART NO. 6008599

PHYSICAL PROPERTIES		APPLICATION		TOLERANCES ON DECIMALS ± .010		ORIGINAL DATE OF DRAWING		PIN, FIRING	ROCK ISLAND, ILL. 61201 DEPT OF THE ARMY ROCK ISLAND ARSENAL
TP	F7791205	PISTOL, M191A1	DO NOT APPLY PART NO.	ANGLES ± 2°	FRACTIONS ± 1/64	1 MAY 28			
TS	F7268381	NATL MATCH		MATERIAL SEE NOTE 3		TRACER G.S.S.	CHECKER L.S.C.		
EL 2	F7265655	PISTOL, M191A1		HEAT TREATMENT SEE NOTE 4		ENGINEER E.S. [Signature]	CHECKER [Signature]		
BA	F12006306	PISTOL, M15		FINAL PROTECTIVE FINISH: SEE NOTE 7		SUBMITTER [Signature]	ORD CORPS		
PH	A 70.5 T 73.5					APPROVED BY ORDER OF THE CHIEF OF ORDNANCE [Signature]			

(B4)

(C)

C 6008599

(E)

(A)

NOTES:

1. STRESS RELIEVE AT 435° ± 10°F FOR 20 MINUTES AFTER FORMING.
2. MANUFACTURE IN ACCORDANCE WITH MIL-S-13572 TYPE I, GRADE A, EXCEPT DO NOT COMPRESS TO SOLID HEIGHT.
3. MATERIAL: MUSIC WIRE, STEEL, SPEC QQ-W-470.

INSIDE DIA. FREE, NOT LESS THAN ---.091  
 DIAMETER OF WIRE (APPROX) ---.026  
 OUTSIDE DIA. SOLID, NOT MORE THAN ---.149  
 FREE LENGTH (APPROX) ---.708  
 ACTIVE COILS --- II REF  
 TOTAL COILS --- 13 REF  
 DIRECTION OF HELIX --- RH

LOAD AT COMPRESSED LENGTH OF .550 (BASIC) = 5.7 LB ± 0.5 LB  
 LOAD AT COMPRESSED LENGTH OF .456 (BASIC) = 8.5 LB ± 0.7 LB

SOLID LENGTH ---.364 MAX  
 TYPE OF ENDS --- PLAIN (OPEN ENDS NOT GROUND)  
 REDUCE ID OF LAST COIL ON BOTH ENDS TO .085 DIA-.010

SPECIAL DATA  
 HOLE DIA INTO WHICH SPRING FITS FREELY ---.152 MIN

REVISIONS

ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
G		REDRAWN W/CHANGE NOR W4S2049/840719 (ECP W4S2067/841224)	870621	<i>ZH</i> ORFI

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

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 CHANGES MUST BE INCORPORATED  
 VIA THIS SYSTEM.

PART NO. 5013217

PMIC	CONTRACT NUMBER		DEPT OF THE ARMY SPRINGFIELD ARMOY SPRINGFIELD, MASS	
MECHANICAL PROPERTIES	CONTRACTOR		SPRING, MAGAZINE CATCH	
YP	DRAWN BY	DATE (YR-MO-DA)	SIZE	CAGE CODE
TS	E.R.C.	28-05-01	B 19205	B 19205
EL2	CHECKER	ENGINEER	SCALE	UNIT WT. 0.007 LB
RA	M.E.K.	H.E.S.		SHEET 1 OF 1
BH	DRAWING APPROVAL	V. A. LUUKKONEN		
RH	DESIGN APPROVAL	S. C. SHULTZ		

SMCAR FORM 66, 1 MAR 88(TEMP) REPLACES SMCAR FORM 66, 1 JUL 87(TEMP)  
 WHICH MAY BE USED UNTIL EXHAUSTED

ORFI

00 1176



B 5013204

REV	DESCRIPTION	DATE
A	REDRAWN AND REVISED SEE EO SA 26316	21 FEB 57
B	(3) SEE ERR HOR 30687-2	27 NOV 57
C		19 JUN 57
D	NORWOS2002 8402-26	82-01-15
E	REDRAWN W/CHANGE NOR W4S2049/840719 (ECP W4S2067/841224)	870621

NOTES:

1. MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572.

(C)

DIAMETER OF WIRE ---.0260  
 DIAMETER OF COIL (OD) ---.207 ±.003  
 FREE LENGTH ---1.70 REF  
 ACTIVE COILS ---38 REF  
 TOTAL COILS ---40 REF  
 DIRECTION OF HELIX --- OPTIONAL  
 LOAD AT COMPRESSED LENGTH OF --- 1.36 • 1.030 LB ± 0.135 LB  
 LOAD AT COMPRESSED LENGTH OF --- LB ± LB  
 SPRING RATE --- 3.0 LB/IN REF  
 SOLID LENGTH --- 1.066 MAX  
 TYPE OF ENDS --- SQUARED AND GROUND

SPECIAL DATA

HOLE DIA INTO WHICH SPRING FITS FREELY ---.219 MIN  
 ROD DIA OVER WHICH SPRING SLIDES FREELY ---.150 MAX  
 CRIMP ONE END COIL TO .135 ± .010 ID

\*EXCEPT FOR CRIMPED END.

17

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

(USED WITH PIN-6008599)

PHYSICAL IDENTIFIER	UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING
F7791205 PISTOL, M1911A1	FOR DIMENSIONS USE IN RECORDS	1 MAY 28
F7265655 NATL MATCH	FOR DIMENSIONS USE IN RECORDS	
F12006306 PISTOL, M1911A1	FOR DIMENSIONS USE IN RECORDS	
F12006306 PISTOL, M15	FOR DIMENSIONS USE IN RECORDS	
APPLICATOR	FOR DIMENSIONS USE IN RECORDS	

PART NO. 5013204

CAGE CODE 19205

SPRING,  
FIRING  
PIN

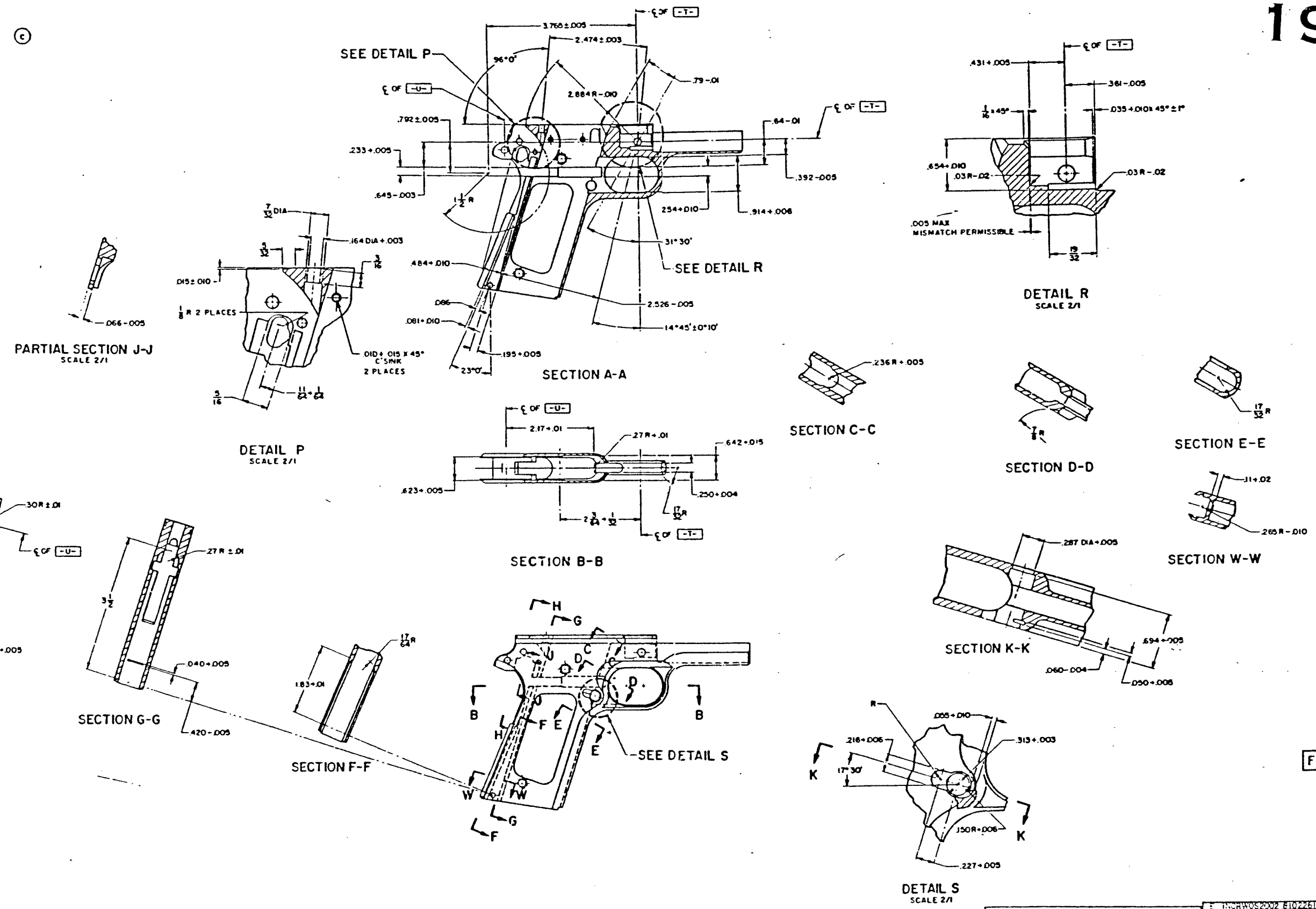
DEPT OF THE ARMY  
SPRINGFIELD ARMOY  
SPRINGFIELD, MASS.

B 5013204  
SHEET 1 OF 1

R1M1H



E  
D  
C  
B  
A



F6535

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND LOVER, NEW JERSEY 07061		DRAWING NO. 19200 PART NO. 6535359		REVISIONS	
ORIGINAL DATE 15 JAN 36		SCALE 1/1		UNIT WT. 10 LB	
RECEIVER		F 6535		HM	

8 7 6 5 4 3 2 1



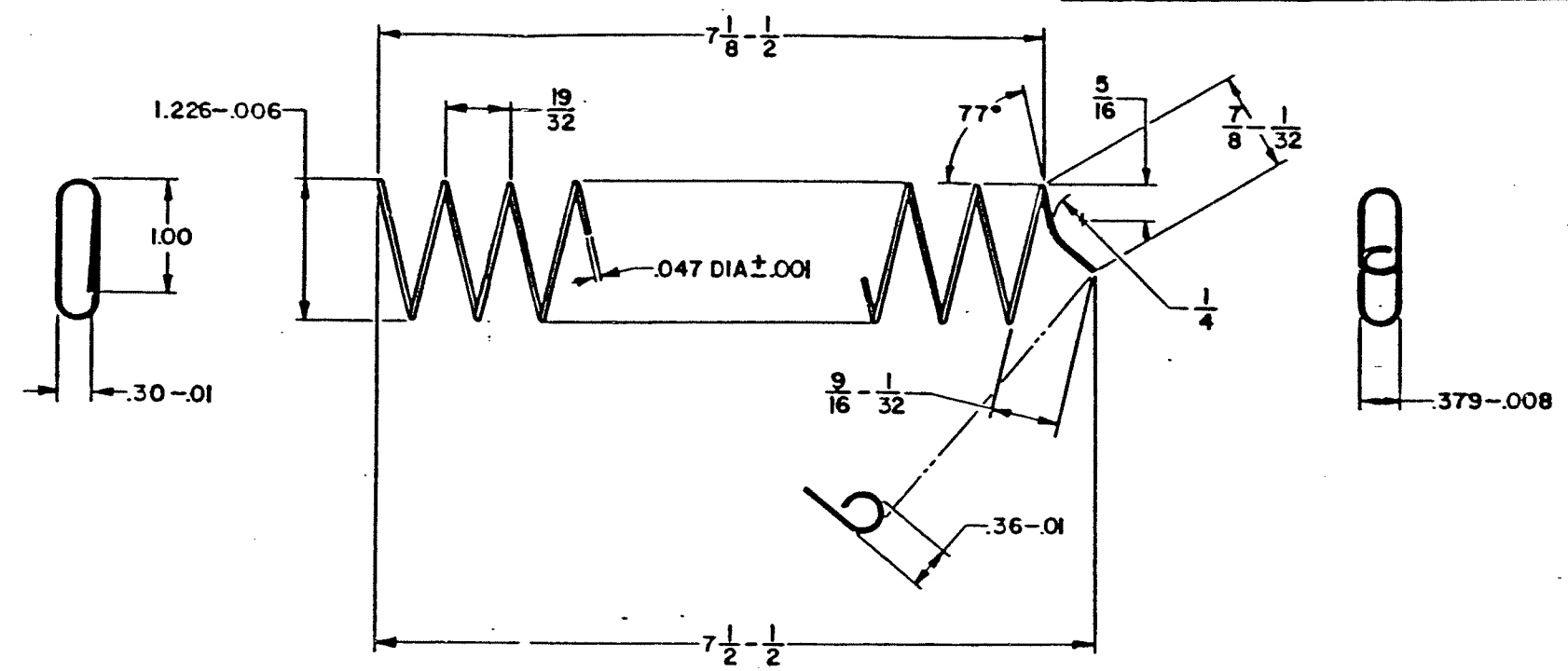


STANDARD DRAWING SYMBOLS AND ABBREVIATIONS  
 1. UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE TO BE TAKEN TO THE CENTER OF THE PART.  
 2. DIMENSIONS ARE TO BE TAKEN TO THE CENTER OF THE PART UNLESS OTHERWISE SPECIFIED.  
 3. DIMENSIONS ARE TO BE TAKEN TO THE CENTER OF THE PART UNLESS OTHERWISE SPECIFIED.  
 4. DIMENSIONS ARE TO BE TAKEN TO THE CENTER OF THE PART UNLESS OTHERWISE SPECIFIED.  
 5. DIMENSIONS ARE TO BE TAKEN TO THE CENTER OF THE PART UNLESS OTHERWISE SPECIFIED.

NOTES:  
 1 - MIL-W-13855 APPLIES.

22 (B)

REV	DESCRIPTION	DATE	APPROVAL
S		23 MAR 68	
A	REDRAWN AND REVISED WAS "B" SIZE, SEE EO SA 28318	27 NOV 68	<i>[Signature]</i>
B	SEE ERR HOR 20742	7 AUG 72	<i>[Signature]</i>
C	SEE ERR HOR 30687-1	23 MAR 73	<i>[Signature]</i>
D	SEE ERR HOR 50631	5 MAY 75	<i>[Signature]</i>
E	NCRWOS2002 81-02-26	82-01-15	<i>[Signature]</i>



C6008607

ASSEMBLED HEIGHT ----- 4.3  
 LOAD AT COMPRESSED LENGTH -----  
 APPROXIMATE NUMBER OF COILS ----- 12.5  
 LOAD AT COMPRESSED LENGTH -----  
 MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A.

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
 DOVER, NEW JERSEY 07801

CODE IDENT NO. ~~19204~~  
 PART NO. 6008607  
 CODE IDENT NO. 19200

PROPERTY	VALUE	PROPERTY	VALUE	PROPERTY	VALUE
SYMBOL	PISTOL M1911A1	TOLERANCES UNLESS OTHERWISE SPECIFIED	FRACTIONS 1/64	DATE OF DRAWING	1 MAY 28
SYMBOL	NATL MATCH	DECIMALS ±.01		DESIGNED BY	J.V.
SYMBOL	C5508694	ANGLES ±1°		CHECKED BY	L.S.C.
SYMBOL	32006351	MATERIAL	MUSIC WIRE, SPEC 00-W-470	ISSUED BY	H.S. [Signature]
SYMBOL		HEAT TREATMENT	STRESS RELIEVE AT 450° ± 20°F FOR 30 MINUTES, AFTER FORMING.	APPROVED BY	[Signature]
SYMBOL		APPLICATION		APPROVED BY	[Signature]
SYMBOL	DO NOT APPLY PART NO.	PROTECTIVE FINISH			

DEPT OF THE ARMY  
 ROCK ISLAND ARSENAL  
 ROCK ISLAND, ILL. 61201  
 6008607

C6008607

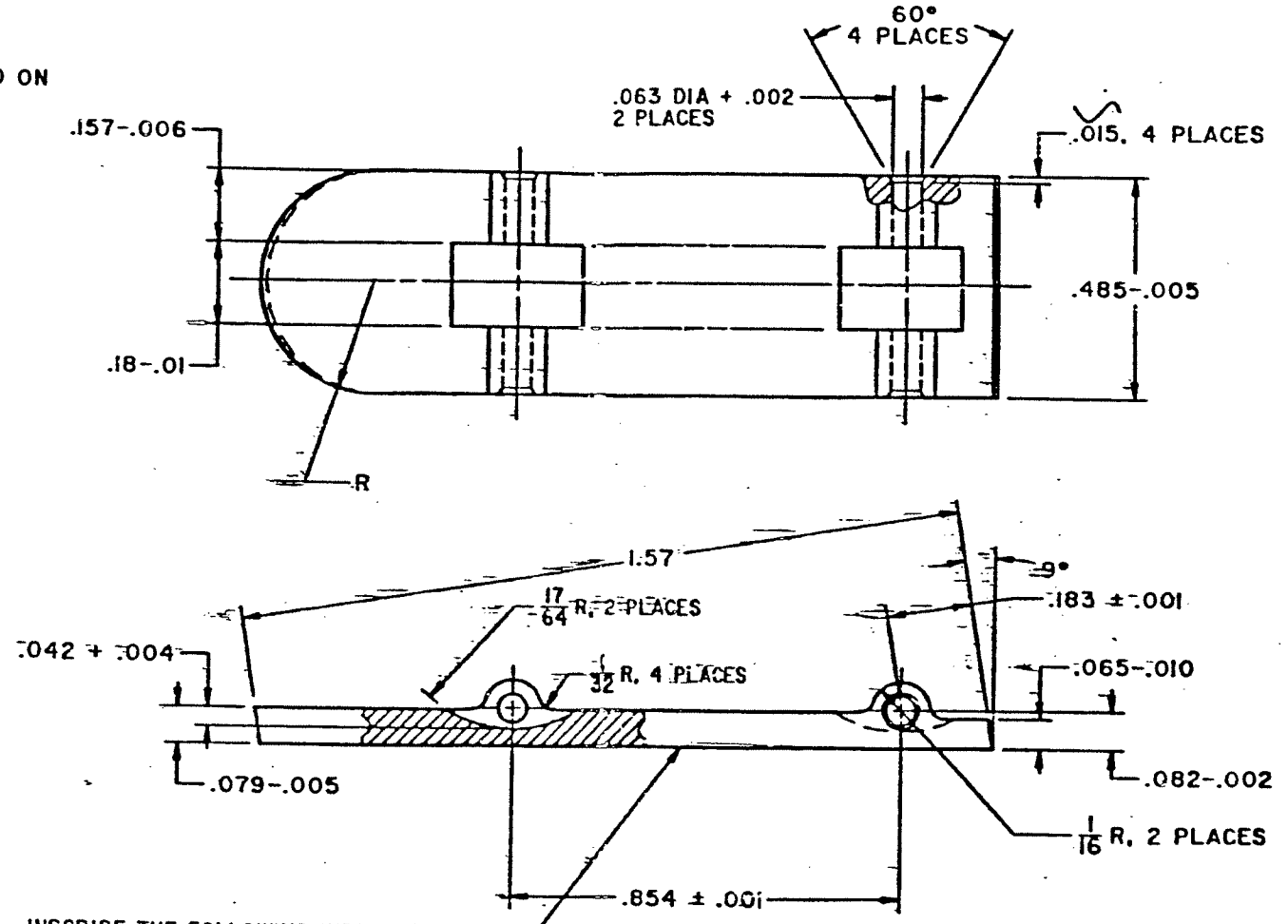


REVISIONS			
ZONE	LTR	DESCRIPTION	DATE (YR MO DA) APPROVED
	J	REDRAWN W/CHANGE NOR G7S2012/87-03-18	90-10-23 as HJS

23

NOTES:

- FOR WROUGHT MATERIAL: STEEL, CARBON SAE 1015 TO 1025; ASTM-A108.
- FOR PRECISION CASTING: STEEL, CMPSN 1C-1020, 1C-1030, MIL-S-22141.
- CLASSIFICATION AND INSPECTION OF INVESTMENT CASTINGS SHALL BE IN ACCORDANCE WITH CLASS 3, GRADE B, MIL-STD-2175.
- FINISH  $125\sqrt{\text{ALL OVER}}$ .
- MIL-W-13055 SHALL APPLY.
- THIS INFORMATION MAY BE INSCRIBED ON PART NO. 6147114 AT ASSEMBLY.



INSCRIBE THE FOLLOWING INFORMATION  
.09 HIGH X .010 ± .005 DEEP PER MIL-STD-130.  
19200-ASSY 5508694

MFR:  (SEE NOTE 6)

CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICATINNY ARSENAL, NEW JERSEY 07606-5000

THIS DRAWING HAS BEEN GENERATED  
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ARDEC, PICATINNY ARSENAL, N.J.  
CHANGES MUST BE ACCOMMODATED  
VIA THIS SYSTEM.

PART NO. 6008606

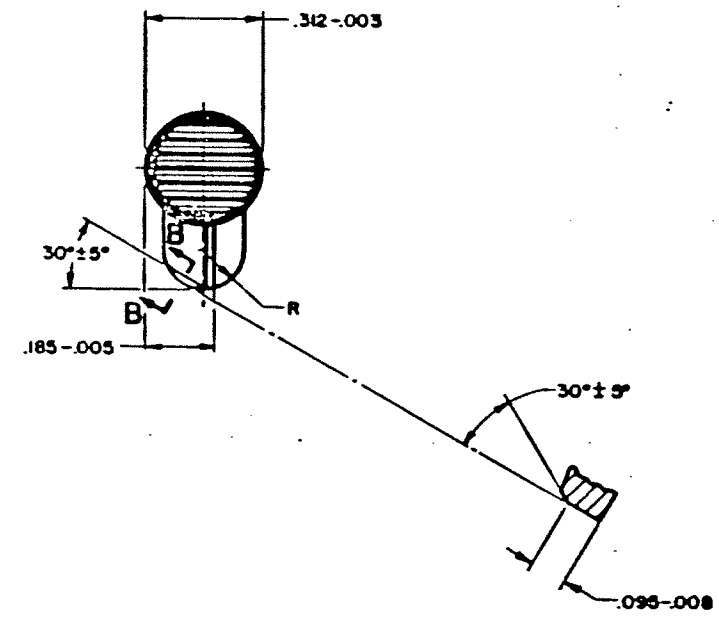
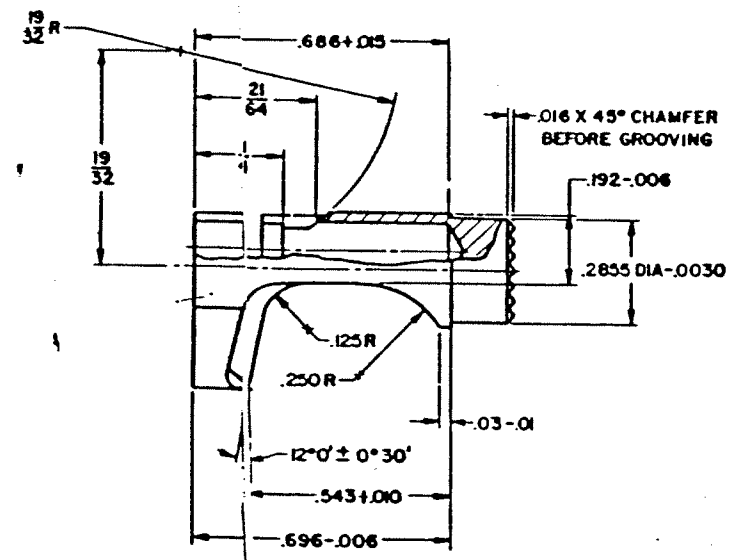
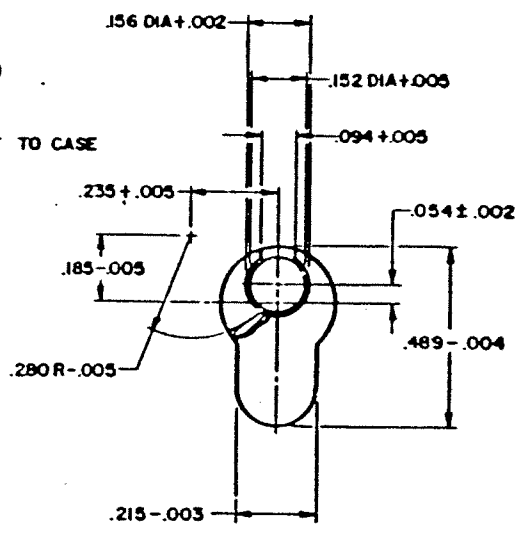
PMIC		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACT NUMBER		DEPT OF THE ARMY SPRINGFIELD ARMOY SPRINGFIELD, MASS	
MECHANICAL PROPERTIES		TOLERANCES ON DECIMAL FRACTION		CONTRACTOR		BASE, MAGAZINE	
YP		2 PL ± .01	± 1/64	DRAWN BY J.J.V.	DATE (YR-MO-DA) 28-05-01	SIZE C	CAGE CODE 19205
TS		3 PL ±	ANGLES ± 1°	CHECKER L.S.C.	ENGINEER H.E.S.	6008606	
EL2		THIRD ANGLE PROJECTION		DRAWING APPROVAL V. A. LUUKKONEN		SCALE 4/1	UNIT WT. .016 LB
RA		MATH ENGR		DESIGN APPROVAL S. C. SHULTZ		SHEET	
BH	B6147114	APPLICATION		CADD5 REV A 263			
RH	NATL MATCH PISTOL, M1911A1 NEXT ASSY USED ON						

24

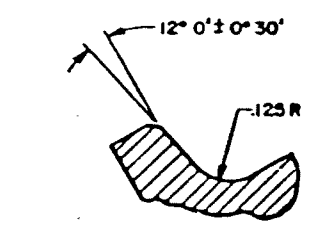
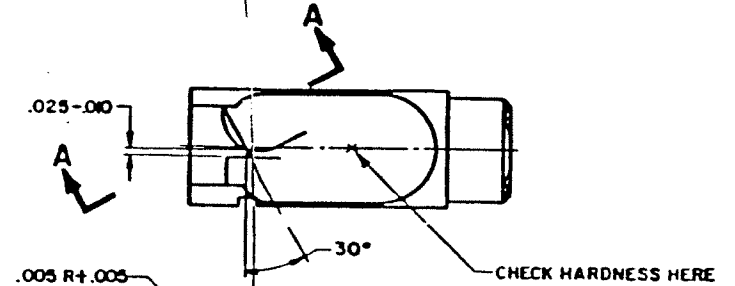
D6008609

REV	DESCRIPTION	DATE	BY
14		14 SEP 68	
A	REDRAWN AND REVISED WAS "C" SIZE, SEE ED SA 24316		
B	SEE EO NO. RIA-13890	1-6-67	asa
C	(7) SEE ERR MOR 30687-2	10 FEB 75	
D	SEE ERR MOR 50603		
E	MOR 1888909	79-02-16	79024 JALB

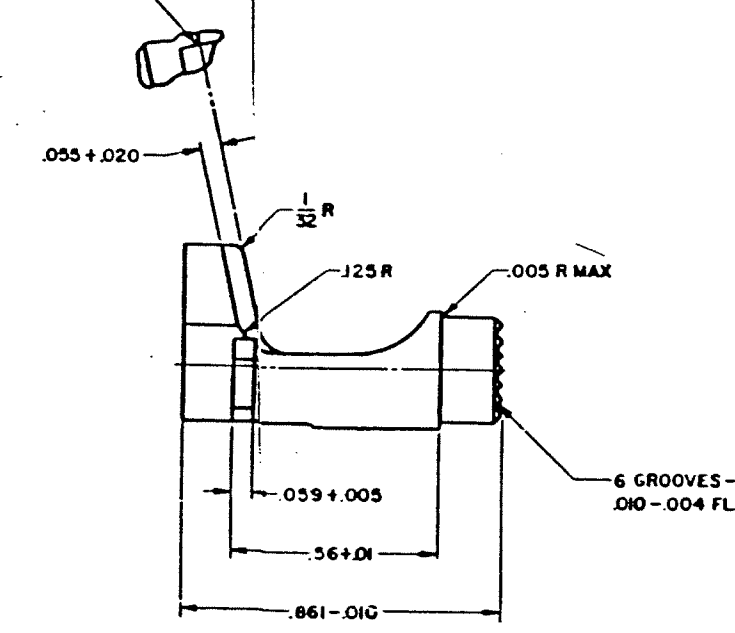
- NOTES:
- FINISH  $125\sqrt{\text{ALL OVER}}$ .
  - ALL EDGES SHALL BE BROKEN  $.005 \pm .010$  UNLESS OTHERWISE SPECIFIED.
  - MATERIAL
    - STEEL CMPSN 1015 THROUGH 1020 ASTM A108
    - STEEL CMPSN 1117 QQ-S-637
  - HEAT TREATMENT: CARBURIZE AT  $1575^{\circ}\text{F}$  TO  $1600^{\circ}\text{F}$  TO CASE DEPTH  $.003$  TO  $.006$ . OIL QUENCH. TEMPER AT  $350^{\circ}\text{F}$  MINIMUM FOR 30 MINUTES. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. (BOTH A & B ABOVE)
  - INVESTMENT CASTING IC8620, CLASS 2 GRADE B SPEC MIL-C-6021.
    - HEAT TREATMENT: CARBURIZE AT  $1575^{\circ}\text{F}$  TO  $1600^{\circ}\text{F}$  TO CASE DEPTH  $.003$  TO  $.005$ . OIL QUENCH. TEMPER AT  $350^{\circ}\text{F}$  MINIMUM FOR ONE HOUR, HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
    - MIL-W-13855 APPLIES.
    - FINISH 5.3.1.2 OF MIL-STD-171.



SECTION B-B



PARTIAL SECTION A-A



D6008609

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DUNEL, NEW JERSEY 07801

CODE IDENT NO.  
19200

CODE IDENT NO. 19-204  
PART NO. 6008609

QTY	DESCRIPTION	UNIT	SCALE	UNIT WT	SCALE	UNIT WT
1	CATCH, MAGAZINE	01 LB	4/1	01 LB	4/1	01 LB

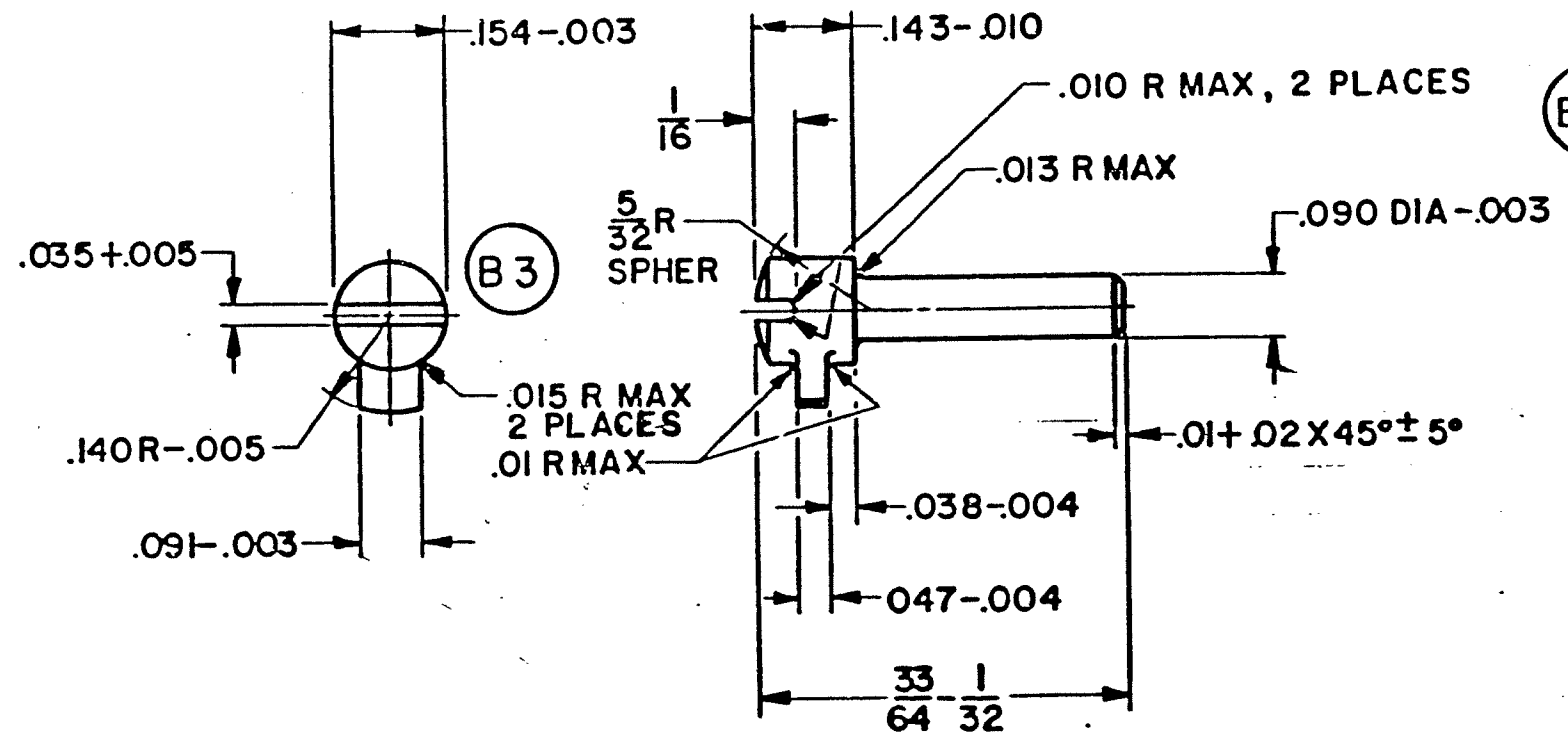
DEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILLINOIS  
6008609  
D SHEET 1

B5013218

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
5		9 JUN 50	
A	REDRAWN AND REVISED WAS "A" SIZE, SEE EO SA 26316	27 NOV 50	<i>W. J. ...</i>
B	(1-4) SEE EO RIA 13998	2-16-67	<i>M. ...</i>
C	(1-2) SEE EO HRD 92161	18 AUG 68	<i>R. ...</i>
D	(2) SEE ERR HQR 30687-2	19 JUN 73	<i>D. ...</i>
E	(2) SEE ERR HQR 50605	10 FEB 75	<i>S. ...</i>

NOTES:

- STEEL, CMPSN 1018 THRU 1020, ASTM A108 (C1)  
OR  
STEEL, CMPSN 1117 SPEC QQ-S-637. (B1) (E)
- FINISH  $\sqrt{25}$  ALL OVER.
- CARBURIZE AT 1575° TO 1600° F TO CASE DEPTH OF .003 TO .005. OIL QUENCH. TEMPER 450° FOR 20 MINUTES. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- REMOVE ALL BURRS AND SHARP EDGES, .005 R MAX.
- MIL-W-13855 APPLIES.
- FINISH 5.3.1.2 OF MIL-STD-171. (E)



CODE IDENT NO. 19204  
PART NO. 5013218

F7791205 PISTOL, M191A1		PHYSICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING 1 MAY 28	<p style="text-align: center;"><b>LOCK, MAGAZINE CATCH</b></p>	<p>DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 51201</p>
F7268381	NATL MATCH	YP	DIMENSIONS ARE IN INCHES TOLERANCES OR FRACTIONS DECIMALS ANGLES ±1/64	DRAWN: <i>C.S.S.</i> CHECKED: <i>S.C.</i>		
F7265655	PISTOL, M191A1	TS	MATERIAL: SEE NOTE 1	TRACED: <i>R.P.</i> CHECKED: <i>C.P.D.</i>		
B12006309	PISTOL, M15	EL2	HEAT TREATMENT: SEE NOTE 3	SIGNATURE: <i>W. J. ...</i>		
APPLICATION		EN	FINAL PROTECTIVE FINISH: SEE NOTE 6	APPROVED BY ORDER OF THE <i>J. C. ...</i> LT COL GSG CORPS		
NEXT REV		FILE HARD		SCALE 4/1	UNIT WT .0012 LB	<p>5013218</p> <p>SHEET 1 OF 1</p>

NOTICE—When Government drawings, specifications, or other data are used for any purpose other than in connection with a definitely related Government procurement operation, the United States Government thereby incurs no responsibility or any obligation whatsoever; and the fact that the Government may have formulated, furnished, or in any way supplied the said drawings, specifications or other data is not to be regarded by implication or otherwise as in any manner favoring the holder or any other person or organization, or conveying any rights or privileges to manufacturers, use, or sell any patented invention that may in any way be related thereto.

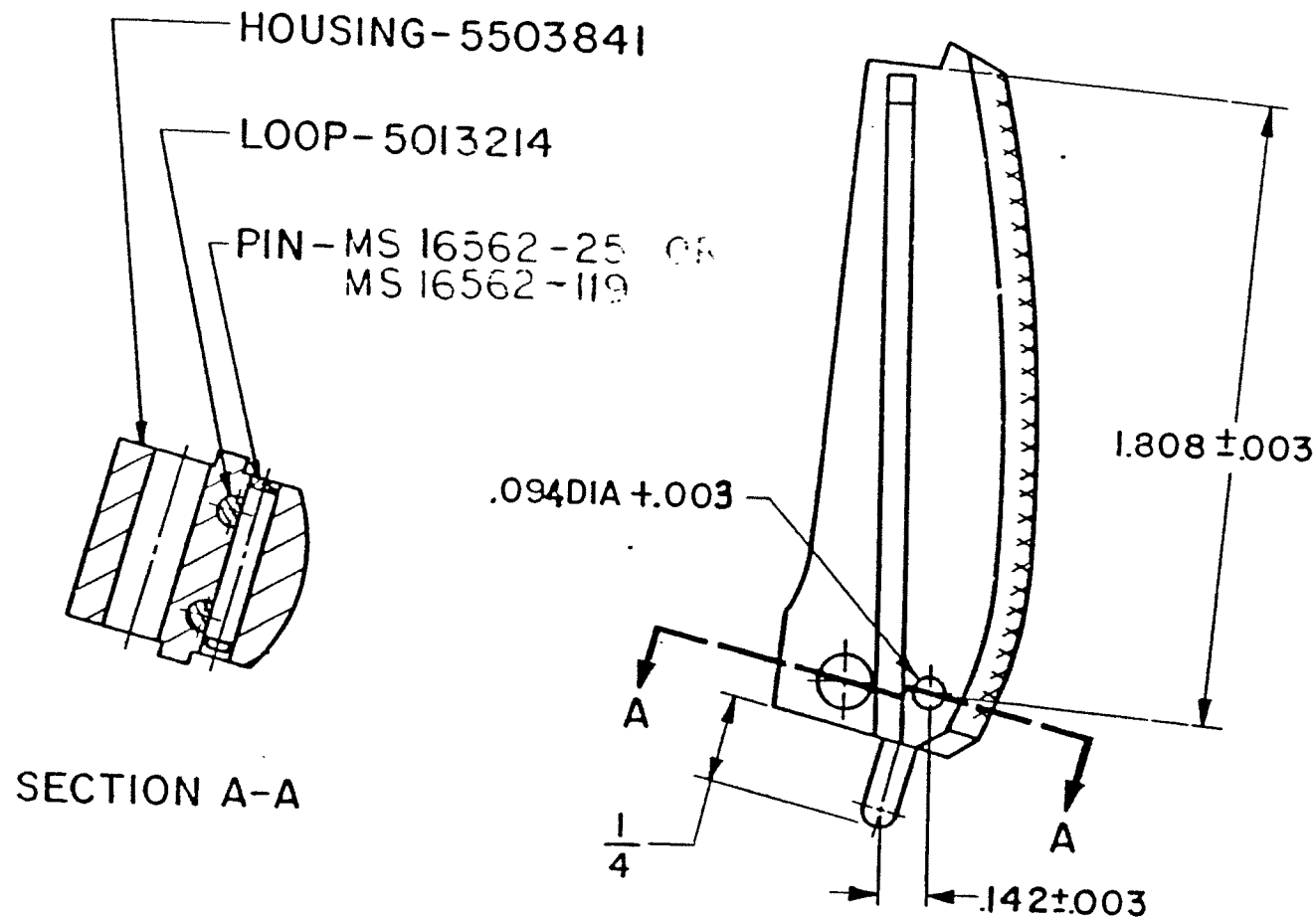
B5564058

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
3		24 MAY 49	
A	REDRAWN AND REVISED WAS "C" SIZE, SEE EO SA 26316	27 NOV 62	<i>b.w. Grant</i>
B	NORWOS2002 81-02-26	82-01-15	<i>S. S. B. R. H.</i>
C	NOR W350046/83-09-26	84-02-10	<i>R. H. H.</i>

NOTES:

1. MIL-W-13855 APPLIES.

26



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

ORIGINAL DESIGN ACTIVITY FSCM NO. 19200

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 5564058

CODE IDENT NO. 000000

ORD PART NO. 5564058

FSCM NO. 19200

F7791205 45 AP, MIIAI		PHYSICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING 15 JAN 36	HOUSING, MAINSPRING, ASSEMBLY	SPRINGFIELD ARMORY ORDNANCE CORPS DEPT OF THE ARMY SPRINGFIELD 1, MASS	
F7268381 NATL MATCH			YP	DIMENSIONS ARE IN INCHES				DRAFTSMAN G.S.S. CHECKER L.S.C.
F7265655 45 AP, MIIAI			1/2	TOLERANCES ON FRACTIONS DECIMALS ANGLES				TRACER R.A.P. CHECKER G.J.I.
SEE ENGRG RECORDS			EL2	± 1/64				ENG. E. S. S. SUBMITTED BY W. Grant
NEXT ARMY	USED ON	RA	MATERIAL		APPROVED BY ORDER OF THE CHIEF OF ENGINEERING	SCALE 2/1 UNIT WT .09 LB	DWG SIZE B 5564058 SHEET 1 OF 1	
APPLICATION		BH	HEAT TREATMENT		LT COL ORD CORPS			
DO NOT	APPLY PART NO.	RH	FINAL PROTECTIVE FINISH:					
GO	-AS SPECIFIED		FINISH 5.3.1.2 OF MIL-STD-171					

RMH



REVISIONS

REV	DESCRIPTION	DATE	APPROVAL
E	REDRAWN W/CHANGE NOR W4S2049/840719 (ECP W4S2067/841224)	870621	RSM

- NOTES:-
- 1-MATERIAL:-WIRE, MUSIC, STEEL, SPEC QQ-W-470.
  - 2-HEAT TREATMENT:-STRESS RELIEVE AT 450°F FOR 20 MINUTES, MINIMUM.
  - 3-ROD DIA OVER WHICH SPRING SLIDES FREELY---.174 MAX\*
  - 4-CRIMP BOTH END COILS .160 + .008 ID.
  - 5-MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572.

WIRE DIAMETER ----- .045  
 COIL DIAMETER (OD)----- .273-.003  
 FREE LENGTH ----- 2.156  
 TOTAL COILS ----- 21.5 REF  
 DIRECTION OF HELIX ----- L.H.  
 LOAD AT COMPRESSED LENGTH OF ----- 1.312=  
 22.0±2.0 LBS  
 LOAD AT COMPRESSED LENGTH OF ----- 1.062=  
 29.5±2.0 LBS  
 SPRING RATE ----- 27.69 LBS  
 SOLID LENGTH ----- .968  
 TYPE OF ENDS ----- CLOSED & GROUND

\*EXCEPT FOR CRIMPED ENDS: CHECK AT A STAGE OF MANUFACTURE OR BY CUTTING OFF CRIMP IN SAMPLE.

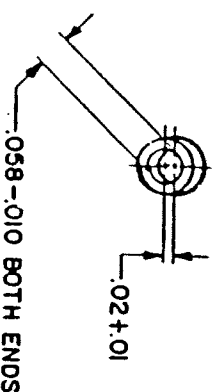
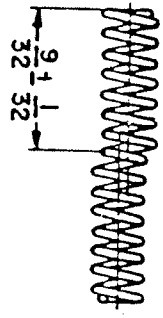
(USED WITH CAP-5013209)

PART NO. 5013208

DEPT OF THE ARMY SPRINGFIELD ARMORY SPRINGFIELD, MASS		ORIGINAL DATE OF DRAWING 28-05-01	
DRAWING NO. 5013208 TITLE: SPRING, HELICAL COMPRESSION		DRAWN BY: G.S.S. CHECKED BY: M.E.K. ENGR: G.L.RANDOZZO ENGR: D.L.WILSON	
APPLICATION: USED ON:		CADDS REV. _____	
M1		PHILIP E. HEBERLE R.S.HENRY	
SIZE: B CAGE CODE: 19205		DEPT OF THE ARMY SPRINGFIELD ARMORY SPRINGFIELD, MASS	
UNIT WT. _____		SHEET 1 OF 1	



NOTES:  
 1. MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-13572.



SPECIAL DATA  
 HOLE DIA INTO WHICH SPRING FITS FREELY----- .109 MIN  
 ROD DIA OVER WHICH SPRING SLIDES FREELY----- MAX

DIAMETER OF WIRE ----- .018  
 DIAMETER OF COIL (OD) ----- .104 ± .003  
 FREE LENGTH ----- .593 REF  
 ACTIVE COILS ----- 12.5 REF  
 TOTAL COILS ----- 14.5 REF  
 DIRECTION OF HELIX ----- L.H  
 LOAD AT COMPRESSED LENGTH OF ----- .400 ± 2.500 LB ± 0.500 LB  
 LOAD AT COMPRESSED LENGTH OF ----- LB ± LB  
 SPRING RATE ----- .160 LB/IN REF  
 SOLID LENGTH ----- .279 MAX  
 TYPE OF ENDS ----- SQUARED AND GROUND

(USED WITH PLUNGERS 5013193 AND 5013195)

PART NO. 5013194

CAGE CODE 19205

F7791205 PISTOL,M911A1 NATL MATCH F7265655 PISTOL,M911A1 F12006306 PISTOL,M15	PHYSICAL PROPERTIES UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS OR DECIMALS ANGLES MATERIAL: MUSIC WIRE STEEL, FED. SPEC QQ-W-470 HEAT TREATMENT STRESS RELIEVE AT 450 ° F AFTER FORMING FOR 20MIN. FINAL PROTECTIVE FINISH	ORIGINAL DATE OF DRAWING MAY 28 1962 DESIGNED BY: G.S.S. DRAWN BY: G.S.S. CHECKED BY: M.E.K. ENGR: G.L.RANDOZZO ENGR: D.L.WILSON
--	--	---

DEPT OF THE ARMY SPRINGFIELD ARMORY SPRINGFIELD, MASS		CAGE CODE 19205
TITLE: SPRING, HELICAL COMPRESSION PART NO. 5013194	SCALE: 4/1 UNIT WT. 0.0002 LB	SHEET 1 OF 1

00  
 B  
 2

CURRENT DESIGN ACTIVITY CAGE CODE 19205  
 ARMAJUNT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
 PICATINNY ARSENAL, NEW JERSEY 07806-5000

CURRENT DESIGN ACTIVITY CAGE CODE 19208  
 ARMAJUNT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
 PICATINNY ARSENAL, NEW JERSEY 07806-5000

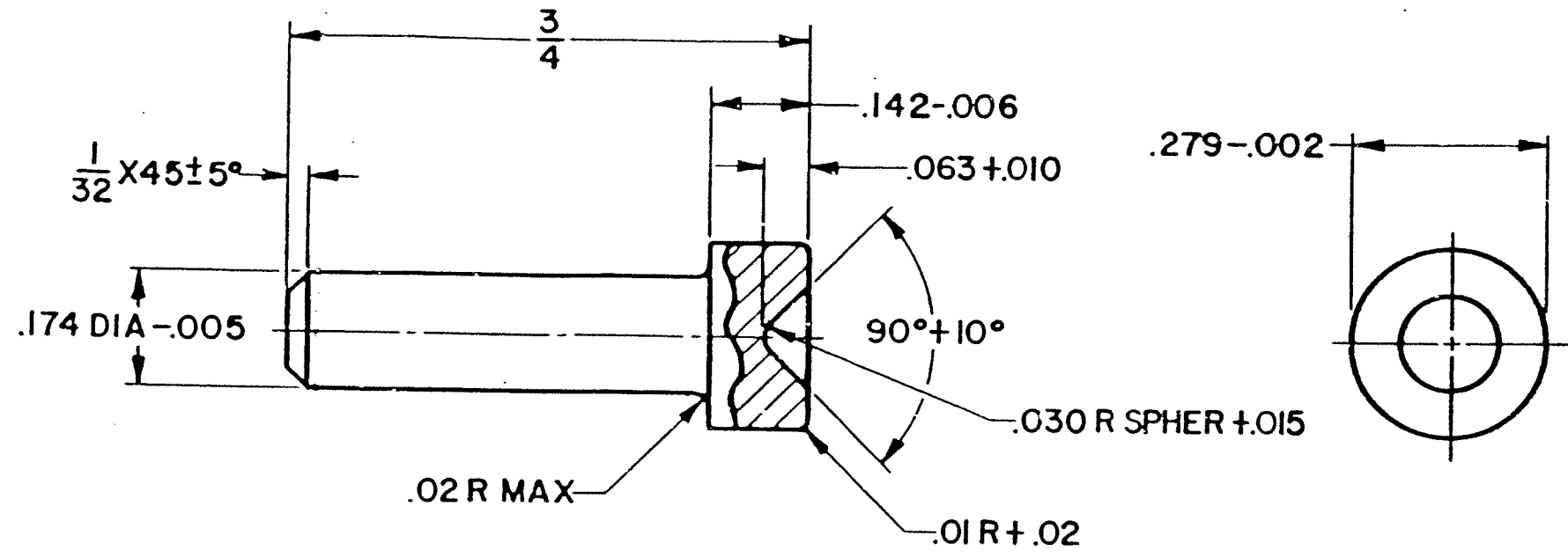
602E109B

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
6		29 MAY 48	
A	REDRAWN AND REVISED WAS "A" SIZE, SEE EO SA 26316	27 NOV 51	<i>W. J. ...</i>
B	(2) SEE ERR HQR 30687-1	23 NOV 53	<i>F. ...</i>
C	(2) SEE ERR HQR 50605	10 FEB 55	<i>...</i>
D	NORWOS2002 81-02-26	82-01-15	<i>...</i>

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NOTES:

- 1. FINISH  $\sqrt{25}$  ALL OVER.
- 2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
- 3. HEAT TREATMENT: CARBURIZE TO CASE DEPTH .003 TO .005. OIL QUENCH. TEMPER AT 350°F MINIMUM FOR 30 MINUTES. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- 4. STEEL, CMPSN 1018 THRU 1020, SPEC ASTM A576 OR ASTM A108 OR CMPSN 1117, SPEC QQ-S-637.
- 5. MIL-W-13855 APPLIES.



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

CODE IDENT NO. ~~19204~~

PART NO. 5013209

CODE IDENT NO.  
19200

C12006347	PISTOL, M15	PHYSICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING	CAP, MAINSPRING	DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201
F7791205	PISTOL, M15A1	YP	DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES: ±1/64	1 MAY 28		
F7268381	NATL MATCH	TS	MATERIAL: SEE NOTE 4	DRAFTSMAN: EGD. CHECKER: SC		
F7265655	PISTOL, M1911A1	EL2	HEAT TREATMENT SEE NOTE 3	TRACER: R.A.P. CHECKER: R.A.P.		
		RA	FINAL PROTECTIVE FINISH	ENGINEER: E.S. ...		
		BH		SUBMITTED: <i>W. J. ...</i>		
		FILE HARD		APPROVED BY ORDER OF THE CHIEF OF COMMAND: <i>L.C. ...</i>		
		SEE NOTE 5		LT COL ORD CORPS	SCALE 4/1	UNIT WT 0061R
DO NOT APPLY PART NO. AS SPECIFIED						SIZE B
						5013209

30

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
6		19MAY48	
A	REDRAWN AND REVISED WAS "A" SIZE, SEE EO SA 26316	27MAY48	<i>[Signature]</i>
B	(2) SEE ERR HQR 30687-1	23MAY48	<i>[Signature]</i>
C	(2) SEE ERR HQR 50605	10FEB75	<i>[Signature]</i>
D	NORWOS2002 81-02-26	82-01-15	<i>[Signature]</i>

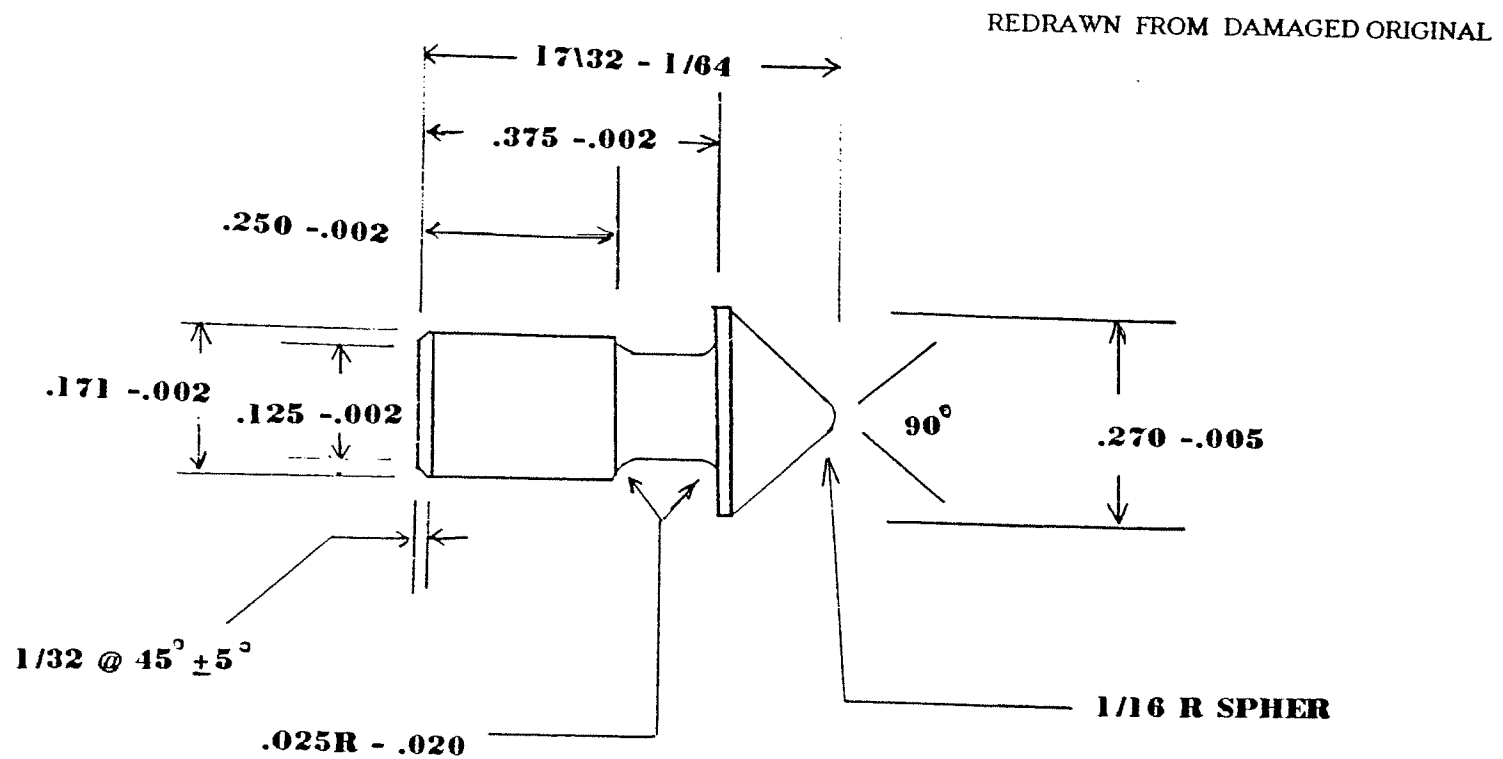
NOTES:

- FINISH  $\sqrt{.125}$  ALL OVER.
- ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
- HEAT TREATMENT: CARBURIZE TO CASE DEPTH .003 TO .005. OIL QUENCH. TEMPER AT 350°F MINIMUM FOR 30 MINUTES. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
- STEEL, CMPSN 1018 THRU 1020, SPEC ASTM A576 OR ASTM A108 OR CMPSN 1117, SPEC QQ-S-637.
- MIL-W-13855 APPLIES.

(C)

(C)

(B)



U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

CODE IDENT NO. ~~19200~~

(B)

CODE IDENT NO.

PART NO. 5013213

19200

C12006347	PISTOL, M15	PHYSICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING	<p><b>MAINSRING HOUSING PIN RETAINER</b></p> <p>SCALE 4/1 UNIT WT .006 LB</p>	<p>DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201</p> <p>5013213</p> <p>SHEET 1 OF 1</p>
F7791205	PISTOL, M1911A1	YP	DIMENSIONS ARE IN INCHES	1 MAY 28		
F7258381	NATL MATCH	TS	TOLERANCES ON FRACTIONS DECIMALS ANGLES			
F7265655	PISTOL M1911A1	EL2	± 1/64			
		RA	MATERIAL:			
		BH	SEE NOTE 4			
			HEAT TREATMENT			
			SEE NOTE 3			
			FINAL PROTECTIVE FINISH			

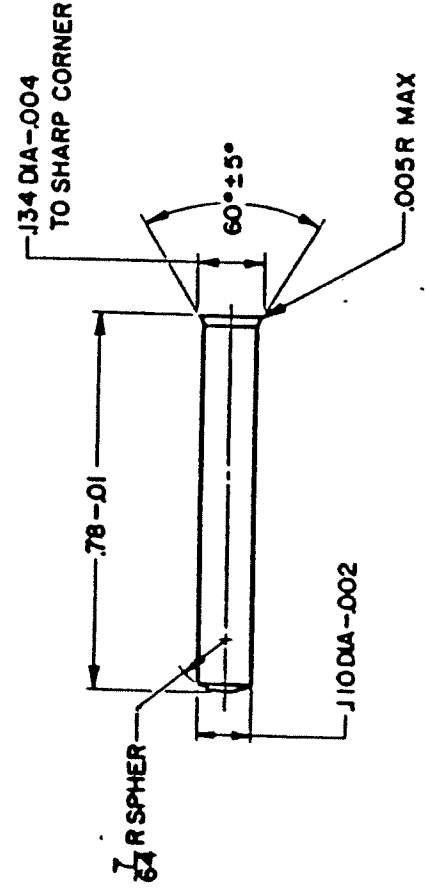
DML



1123109B

REV	DESCRIPTION	DATE	BY
5	REVISIONS		
A	REDRAWN AND REVISED WAS 'A' SIZE, SEE ED 8423316	1 APR 62	6/8/62
B	(3) SEE ERR HOR 30687-2	19 JUN 62	6/9/62
C	(2) SEE ERR HOR 50605	30 FEB 63	6/9/62
D	REDRAWN W/ CHANGE NOR W4S2049/840719 (ECP W4S2067/841224)	870621	AM

- NOTES:
- FINISH 125 <sup>(C)</sup> ALL OVER.
  - HEAT TREATMENT: HEAT AT 1450° TO 1500°F; OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. <sup>(B)</sup>
  - MIL-W-13855 APPLIES. <sup>(C)</sup>
  - FINISH 5.3.1.2 OF MIL-STD-171.



CURRENT DESIGN ACTIVITY CASE CODE 19205  
 ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
 PICATINNY ARSENAL, NEW JERSEY 07874-5000

CAGE CODE  
 19205

DEPT OF THE ARMY  
 SPRINGFIELD ARMOY  
 SPRINGFIELD, MASS

5013211  
 B SHEET 1 OF 1  
 RMH

PART NO. 5013211

PIN, SEAR

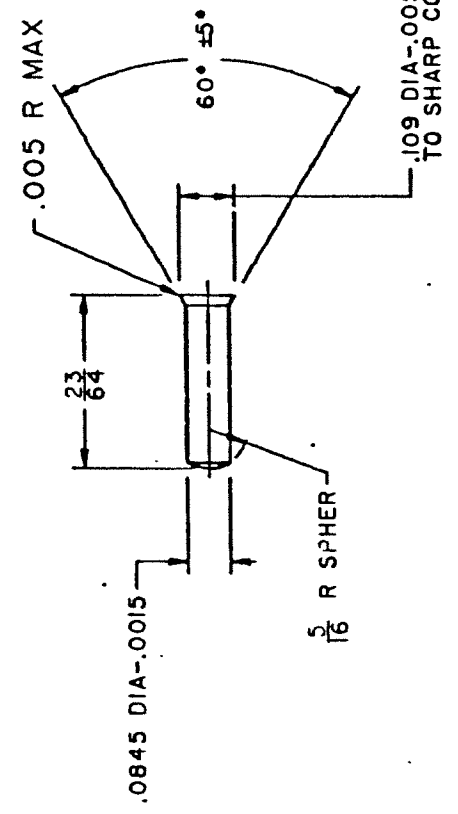
SCALE 4/1 UNIT WT .002 LB

F7791205	PISTOL, M1911A1	1 MAY 28
F7265655	NATL MATCH	
812006307	PISTOL, M15	

SEE NOTE 2  
 SEE NOTE 4

ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
E		REDRAWN W/CHANGE NOR W4S2049/840719 (ECP W4S2067/841224)	870621	ORFI

- NOTES:
- FINISH 125 <sup>(V)</sup> ALL OVER.
  - HEAT TREATMENT: CARBURIZE TO CASE DEPTH .003 TO .005. OIL QUENCH. TEMPER AT 350°F MINIMUM TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE. EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
  - MIL-W-13855 APPLIES.
  - MATERIAL: STEEL, CARBON; SAE 1018 THRU 1020. 1117; ASTM A108 OR ASTM A576
  - FINISH 5.3.1.2 OF MIL-STD-171.



CURRENT DESIGN ACTIVITY CASE CODE 19205  
 ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
 PICATINNY ARSENAL, NEW JERSEY 07874-5000

THIS DRAWING HAS BEEN GENERATED ON A CAD SYSTEM LOCATED AT ARDEC, PICATINNY ARSENAL, N.J. CHANGES MUST BE INCORPORATED VIA THIS SYSTEM.

PART NO. 5013210

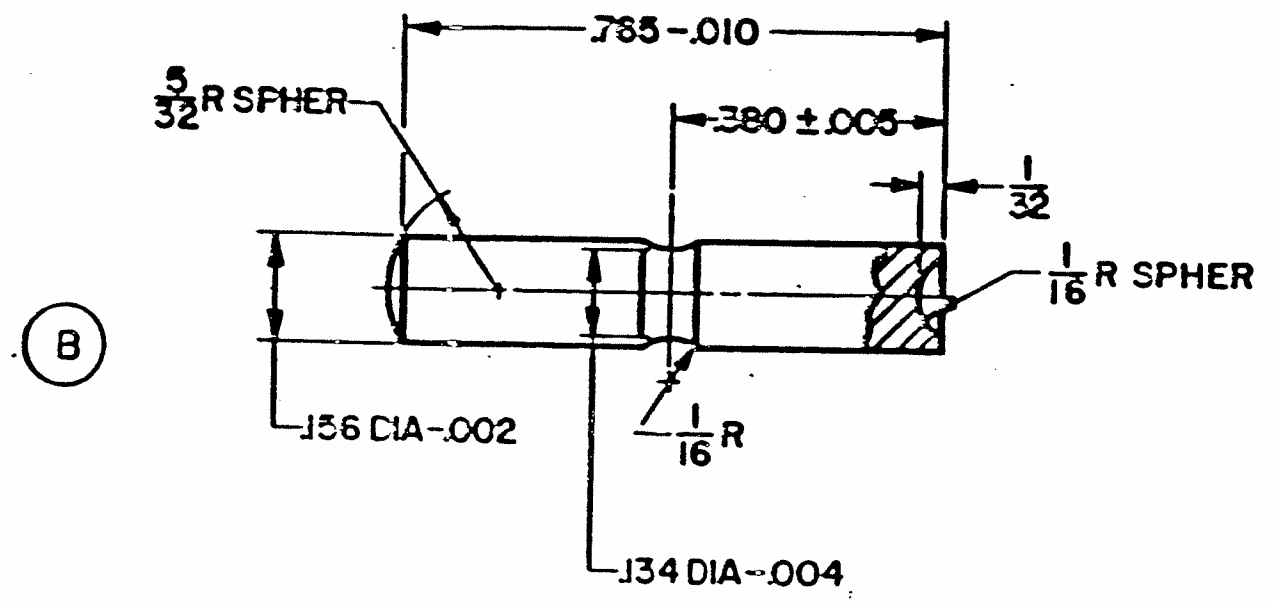
PMIC	CONTRACT NUMBER	CONTRACTOR	DEPT OF THE ARMY SPRINGFIELD ARMOY SPRINGFIELD, MASS
MECHANICAL PROPERTIES	DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMAL FRACTION	DRAWN BY S.E.L. ENGINEER	PIN MAINSPRING CAP
YP	2 PL * 1/84	CHECKER L.S.C. ENGINEER	SIZE CAGE CODE B 19205
TS	3 PL *	DRAWING APPROVAL V. A. LUUKKONEN	SCALE 4/1 UNIT WT. 0.005 LB SHEET 1 OF 1
EL2	THIRD ANGLE PROJECTION	DESIGN APPROVAL S. C. SHULTZ	
RA			
BH	NATL MATCH		
RH	FILE HARD		
	NEXT ASSY USED ON APPLICATION		

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B5013212

REVISIONS			
TYPE	DESCRIPTION	DATE	APPROVAL
4		3 APR 62	
A	REDRAWN AND REVISED WAS "A" SIZE, SEE 20 3A 23316	UNKNOWN	<i>[Signature]</i>
B	(3) SEE ERR HGR 3C887-2	20 JUN 73	<i>[Signature]</i>
C	(2) SEE ERR HGR 5C605	10 FEB 75	<i>[Signature]</i>
D	REDRAWN W/ CHANGE NOR W452049 / 840719 (ECP W452067 / 841224)	870621	<i>[Signature]</i>

- NOTES:
- FINISH  $125\sqrt{\text{ALL OVER}}$ . (C)
  - HEAT TREATMENT: HEAT AT 1450° TO 1500°F; OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
  - MIL-W-13855 APPLIES.
  - FINISH 5.3.1.2 OF MIL-STD-171. (C)



CURRENT DESIGN ACTIVITY CASE CODE 19000  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PALM BEACH, FLORIDA 33415-5000

PART NO. 5013212

CAGE CODE  
19205

PIN, MAINSPRING  
HOUSING

DEPT OF THE ARMY  
SPRINGFIELD ARMORY  
SPRINGFIELD, MASS

APPLICATION		PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING	
F7791205	PISTOL, M1911A1	YP		DIMENSIONS ARE IN INCHES TOLERANCES ON FRACTIONS DECIMALS ANGLES ±1/64		1 MAY 28	
	NATL MATCH	TS		MATERIAL: TOOL STEEL, DRILL ROD, SPEC QQ-T-580		DRAWN BY: G.S.S. CHECKER: L.S.C.	
F7263635	PISTOL, M1911A1	IL2		HEAT TREATMENT: SEE NOTE 2		TRACER: J.S. CHECKER: J.L.	
B12006311	PISTOL, M15	RA		FINAL PROTECTIVE FINISH: SEE NOTE 4		EMER: S. J. CHECKER: J. J.	
		BN				SUBMITTED BY: <i>[Signature]</i>	
		RM	C43.3 TO 30			APPROVED BY ORDER OF THE CHIEF OF BRANCH: <i>[Signature]</i> LT COL	

SCALE: 4/1 UNIT WT .004LB

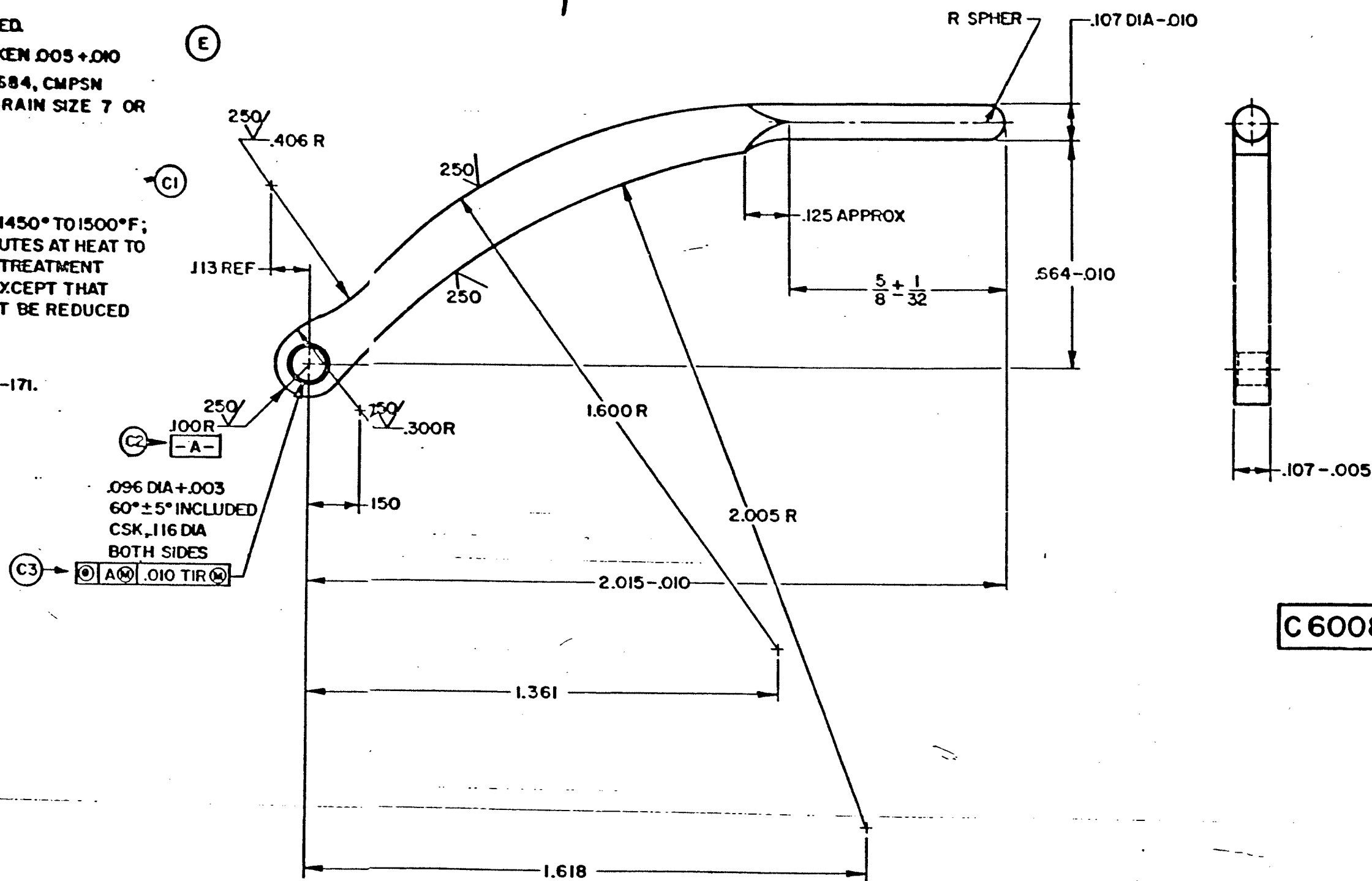
5013212  
SHEET 1 OF 1

RMH



NOTES:

1. FINISH  $\sqrt{125}$  EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005 +.010
3. MATERIAL: STEEL, ASTM A684, CMPSN 1065, 1095. AUSTENITIC GRAIN SIZE 7 OR FINEER
4. HEAT TREATMENT: HEAT AT 1450° TO 1500°F; OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. MIL-W-13855 APPLIES.
6. FINISH 5.3.1.2 OF MIL-STD-171.



C 6008600

CODE IDENT NO. 19204  
PART NO. 6008600

REV	DESCRIPTION	DATE	APPROVAL
E	(1) SEE ERR HOR 50605	10 FEB 73	[Signature]
D	(2) SEE ERR HOR 30687-2	26 JUN 73	[Signature]
C	(1-3) SEE EO RIA-13876	12-30-66	[Signature]
B	REDRAWN AND REVISED	27 NOV 63	[Signature]
A	SEE EO SA 26316	2 APR 52	[Signature]

PROPERTY	VALUE	UNIT
TEMPERATURE	F7791205	PISTOL, MISIAI
TEMPERATURE	F7268381	NATL MATCH
TEMPERATURE	F7265655	PISTOL, MISIAI
TEMPERATURE	F12005306	PISTOL, M15

ORIGINAL DATE OF DRAWING	1 MAY 28
DRAFTER	H.E.S.
CHECKER	R.B.D.
TRACER	E.S.S.
ENGINEER	E.S.S.
SUBMITTER	[Signature]

STRUT, HAMMER

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILL. 61201



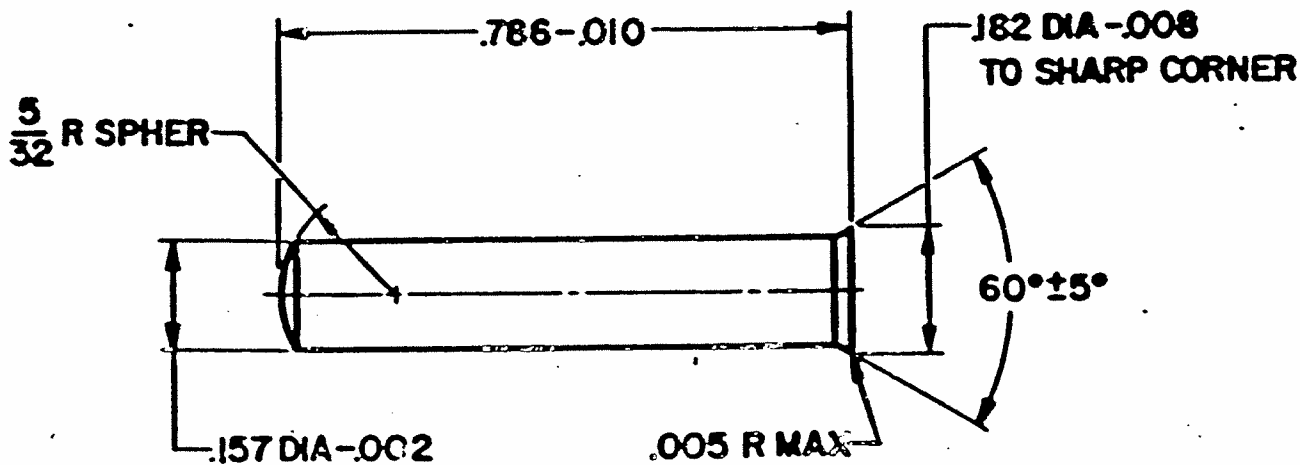
85013206

36

REVISIONS			
REV	DESCRIPTION	DATE	APPROVAL
5		4 APR 62	
A	REDRAWN AND REVISED WAS "A" SIZE, SEE EQ SA 80316		<i>[Signature]</i>
B	(3) SEE ERR NOR 30667-2		<i>[Signature]</i>
C	(1) SEE ERR NOR 57456	10 FEB 61	
D	REDRAWN W/CHANGE NOR W4S2049/840719 (ECP W4S2067/841224)	870621	<i>[Signature]</i>

NOTES:

1. FINISH  $125\sqrt{\text{C}}$  ALL OVER.
2. HEAT TREATMENT: HEAT AT 1450° TO 1500°F; OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
3. MIL-W-13855 APPLIES.
4. FINISH 5.3.1.2 OF MIL-STD-171.



CURRENT DESIGN ACTIVITY CASE CODE 10000  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PLATONIC ARMORY, BELT ROAD STATION, WASHINGTON, D.C.

PART NO. 5013206

CAGE CODE  
19205

DEPT OF THE ARMY  
SPRINGFIELD ARMORY  
SPRINGFIELD, MASS.

PIN, HAMMER

5013206

B  
SHEET 1 OF 1

SCALE 4/1 UNIT WT .004 LB

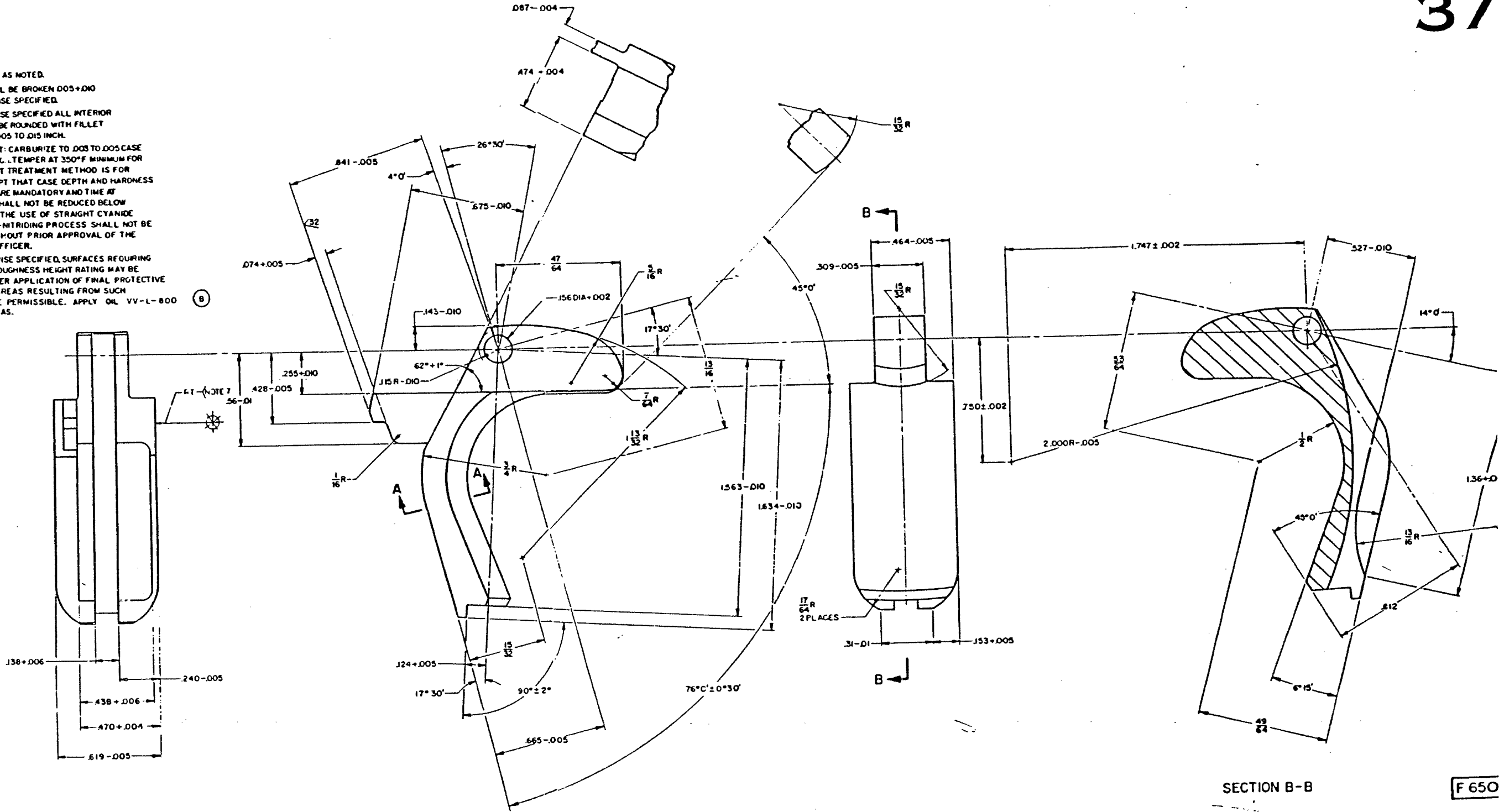
RMH

PHYSICAL PROPERTIES		MIL. ETC. OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING
F7791205	PISTOL M51A	YP	MEASUREMENTS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	1 MAY 28
	NATL MATCH	TS	FRACTIONS OR DECIMALS AND ANGLES	
F7265655	PISTOL M51A	BL	± 1/64	
B12006312	PISTOL M15	BA	RETURN TO STOCK STEEL, DRILL ROD, SPEC QQ-T-880	
		BH	HEAT TREATMENT	
			SEE NOTE 2	
		BH	FINAL PROTECTIVE FINISH:	
			SEE NOTE 4	

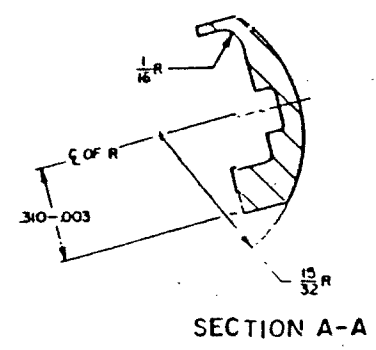
APPROVED BY ORDER OF THE  
DRYER OF DRAWING  
*[Signature]* LT COL  
840 0000

B

- NOTES:
1. FINISH  $\nabla$  EXCEPT AS NOTED.
  2. ALL EDGES SHALL BE BROKEN .005+.000 UNLESS OTHERWISE SPECIFIED.
  3. UNLESS OTHERWISE SPECIFIED ALL INTERIOR CORNERS SHALL BE ROUNDED WITH FILLET RADIUS OF FROM .005 TO .015 INCH.
  4. HEAT TREATMENT: CARBURIZE TO .003 TO .005 CASE DEPTH. OIL QUENCH. TEMPER AT 350°F MINIMUM FOR 30 MINUTES. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
  5. UNLESS OTHERWISE SPECIFIED, SURFACES REQUIRING 32 AND FINER ROUGHNESS HEIGHT RATING MAY BE PROCESSED AFTER APPLICATION OF FINAL PROTECTIVE FINISH. BRIGHT AREAS RESULTING FROM SUCH PROCESSING ARE PERMISSIBLE. APPLY OIL VV-L-800 TO BRIGHT AREAS.



- NOTES:
6. MIL-W-13855 APPLIES.
  7. MATERIAL:
    - A. STEEL CMPSN 1018 THRU 1020, ASTM A108.
    - B. STEEL CMPSN 1117, SPEC QQ-S-637.
    - C. INVESTMENT CASTING IC8620 SPEC MIL-S-22141 CLASS 2, GRADE B AND C PER MIL-C-6021.
  8. FINISH 5.3.1.2 OF MIL-STD-171.



SECTION B-B F 650

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER, NEW JERSEY 07001

1	WORK BASED ON 79-0710 1750311
2	SEE ERR HOR 50405 107 03 72
3	4715 SEE ERR HCR 30887-2 25 MAR 7
4	SEE ERR HOR 20808 10 NOV
5	RE-DRAWN AND REVISED WAS 27 MAR 78
6	SIZE, SEE 80 SA 29316

CODE IDENT NO. ~~197134~~  
PART NO. 6501828

PHYSICAL PROPERTIES	81200E313 PISTOL M15 F7791205 PISTOL MENTAL F726E381 NATL MATCH F726E655 STD MENTAL	TOLERANCES UNLESS OTHERWISE SPECIFIED DIMENSIONS IN INCHES FRACTIONS DECIMALS	ORIGINAL DATE 1 MAY 28
MATERIAL	SEE NOTE 7	HEAT TREATMENT SEE NOTE 4	APPROVED BY <i>[Signature]</i>
DO NOT SCALE	APPLY PART NO.	FINAL PROTECTIVE FINISH: SEE NOTE 5 & 8	SCALE 4/1 UNIT WT 07 LB

SAFETY, GRIP

6501



NOTES:  
 125/ FINISH  $\sqrt{\text{ALL OVER}}$ . (B1)

ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.

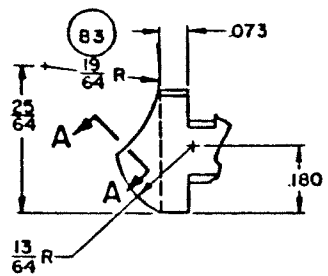
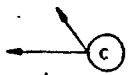
STEEL, CMPSN 1060, ASTM576 OR CMPSN 4140 ASTM A322 OR A331 AUSTENTIC GRAIN SIZE 8 OR FINER. (B2)

(B6) FINISH 5.3.1.2 OF MIL-STD-171.

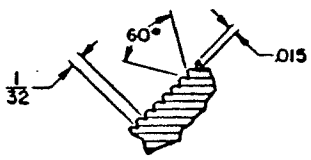
MIL-W-13855 APPLIES.

REV	DESCRIPTION	DATE	APPROVED
12			
A	REDRAWN AND REVISED WAS "B" SIZE, SEE CO SA 24316	20MAY68	
B	6-61 SEE EO M1A-M058	3 21-67	
C	(S) SEE ERR HOR 30687-2	18 JUN 73	
D	SEE ERR HOR 50605	10 FEB 75	
E	(I) SEE NOR 76E0062-0002	7 OCT 76	

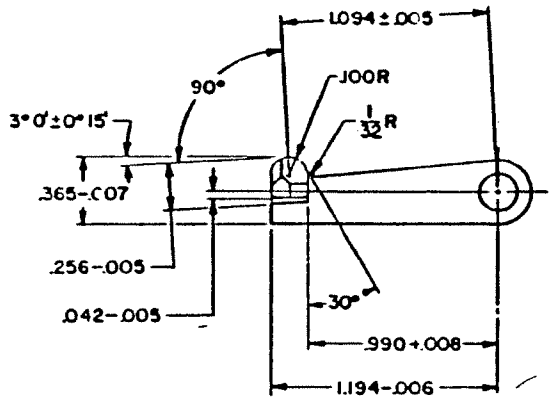
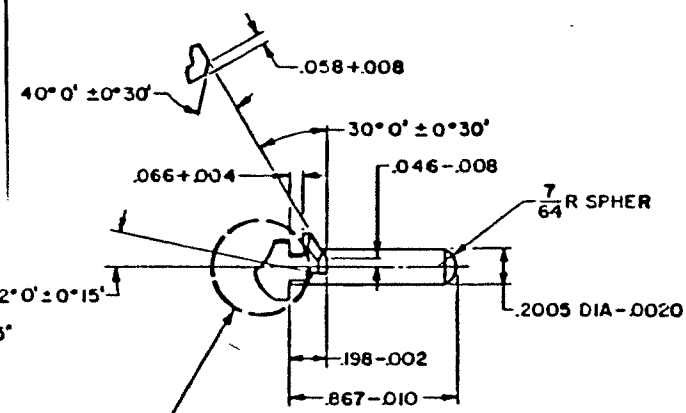
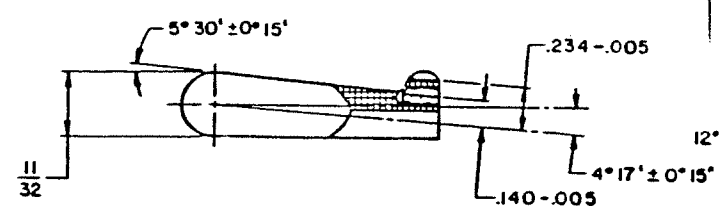
D 6008595



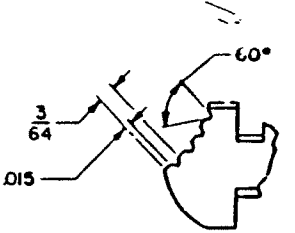
DETAIL B  
SCALE 4/1



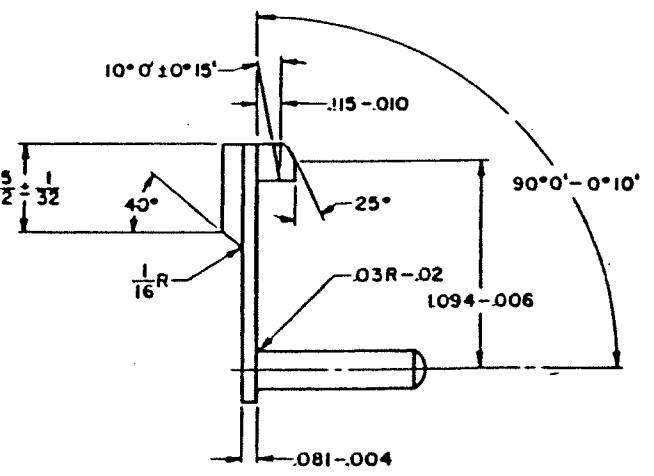
PARTIAL SECTION A-A  
SECTION APPLIES TO SERRATIONS IN BOTH DIRECTIONS (90° APART). (B5)  
SCALE 4/1



SEE DETAIL B



(B4) ALTERNATIVE METHOD  
SERRATIONS APPLY IN ONE DIRECTION ONLY.  
SCALE 4/1



D 6008595

CODE IDENT NO. 19204  
PART NO. 6008595

ITEM NO.	DESCRIPTION	QUANTITY	UNIT	REMARKS
B12006321	PISTOL M15			
F7791205	PISTOL M15A			
F7268381	NATL MATCH			
F7265655	PISTOL M15A1			

UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING	MAY 28
DIMENSIONS ARE IN INCHES	DRAWN BY	SC
FRACTIONS ON DECIMALS	CHECKED BY	SC
1/16 1/32 1/64 1/128	DATE	5/28/68
MATERIAL:	APPROVED	
SEE NOTE 3		
HEAT TREATMENT:		
AUSTEMPER		
APPLICATION:		
C435		
NO. 1050		
FINAL PROTECTIVE FINISH:		
SEE NOTE 4		

STOP, SLIDE

ROCK ISLAND ARSENAL  
DEPT OF THE ARMY  
ROCK ISLAND, ILLINOIS

6008595

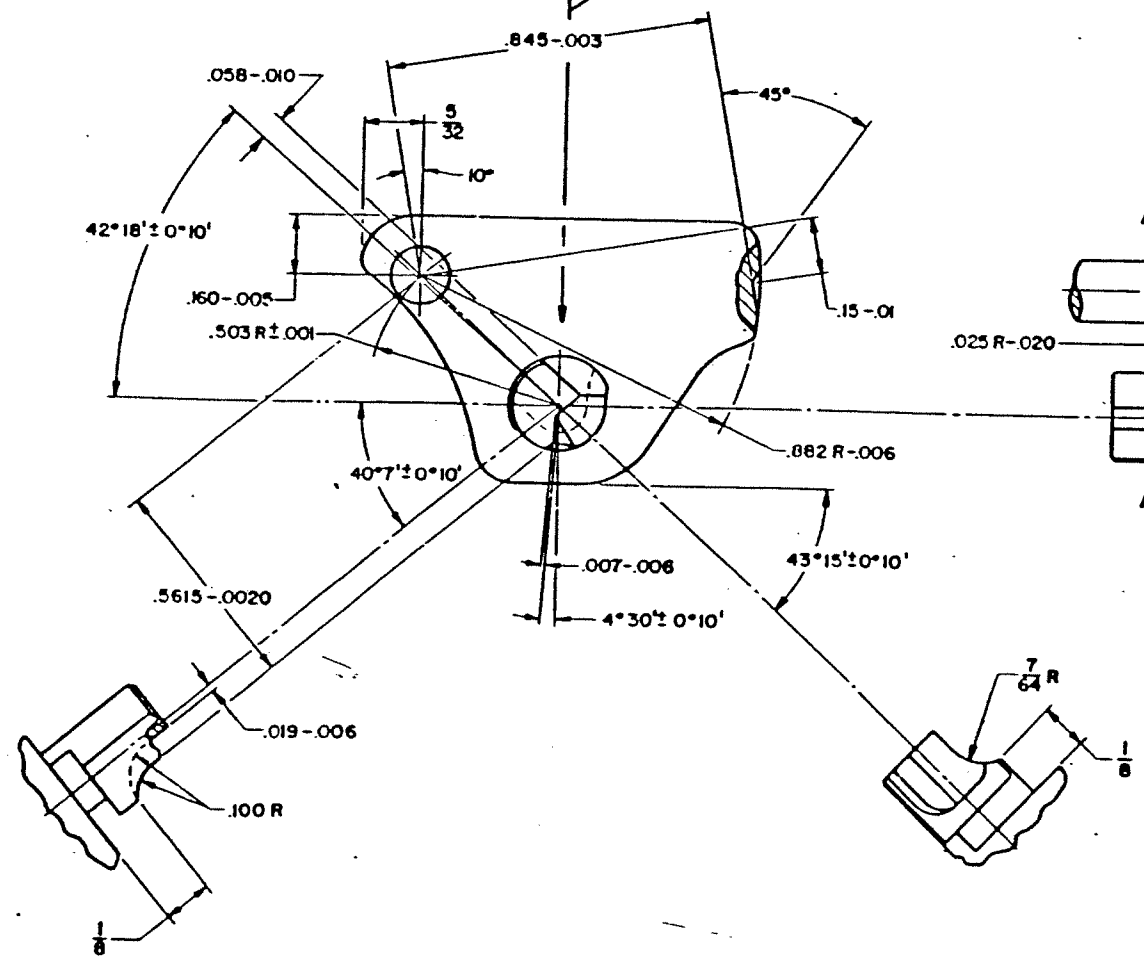
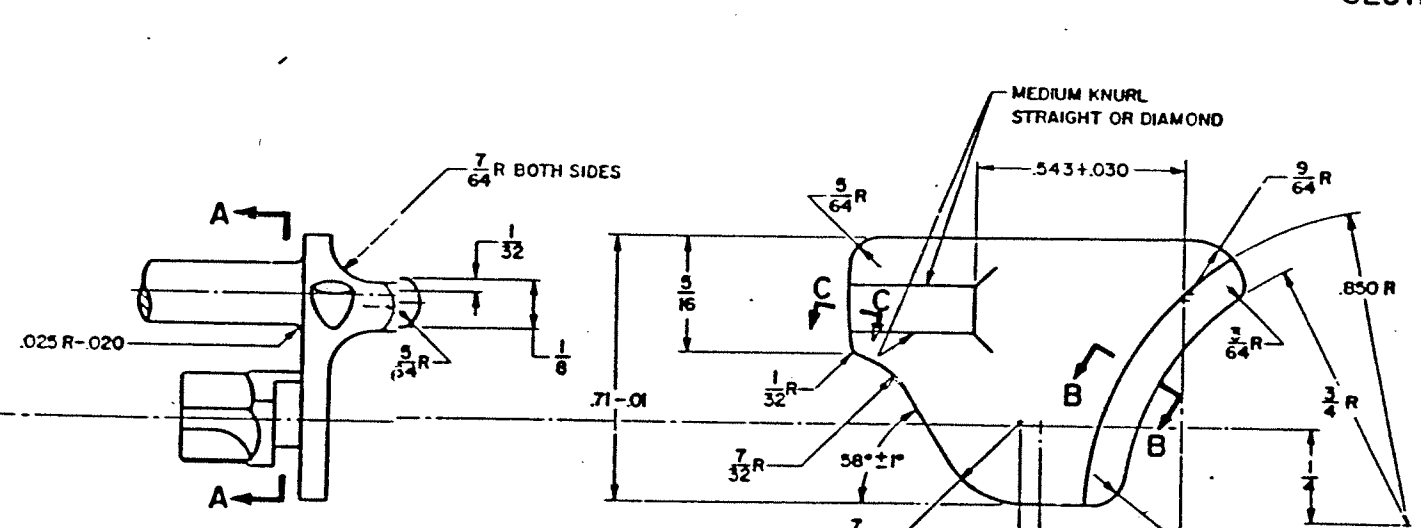
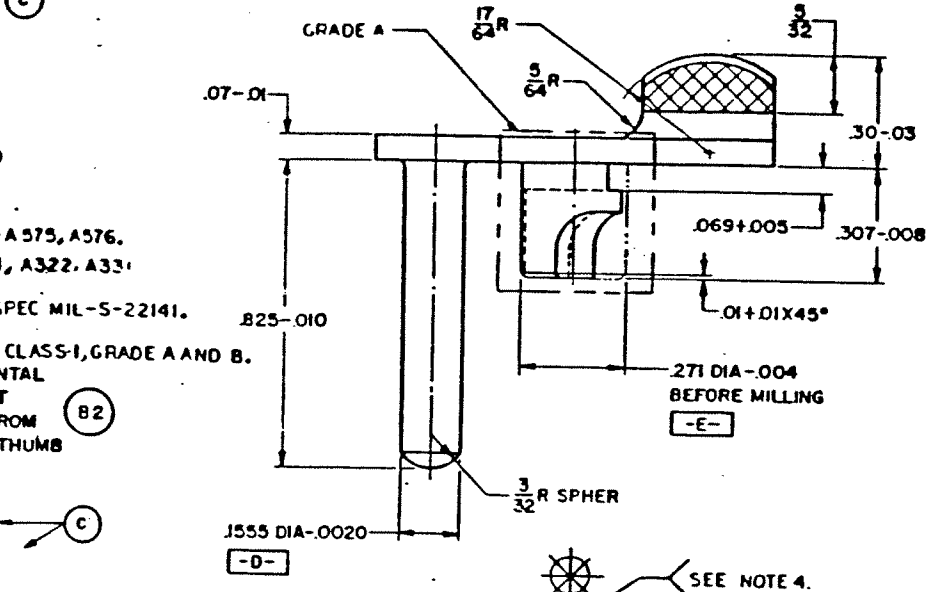
D SHEET 1 OF 1

SCALE 2/1 UNIT WT .02LB



REV	DESCRIPTION	DATE	BY
A	REDRAWN AND REVISED WAB		
B	C SIZE, SEE EUSA 2838		
C	(1) SEE ERR HQA-13046		
D	(2) SEE ERR HQA 30687-2		
E	(3) SEE ERR HQA 50405		
	HQA WBS 8000 79-02-15		

FINISH:  $\sqrt{125}$   
 ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.  
 MATERIAL:  
 A. STEEL, CMPSM 1060, 1080, ASTM-A 575, A576.  
 B. STEEL, CMPSM 4140, ASTM-A304, A322, A331, AUSTENITIC GRAIN 6 OR FINER.  
 C. INVESTMENT CASTING IC4140, SPEC MIL-S-22141.  
 INSPECT CASTING PER MIL-C-6021, CLASS I, GRADE A AND B. THIS METHOD PROVIDES FOUR HORIZONTAL SERRATIONS, EACH SIDE; THE LOWEST SERRATION TO BE LOCATED 5/32 FROM TOP OF THUMB PIECE. CONTOUR OF THUMB PIECE IS IDENTICAL REGARDLESS OF METHOD USED.  
 MIL-W-13855 APPLIES.  
 FINISH 5.3.12 OF MIL-STD-171.



ALTERNATIVE METHOD TO KNURLING  
 SCALE 10/1  
 (SEE NOTE 4)

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
 DOVER, NEW JERSEY 07801

D5503840

CODE IDENT NO. 19200

CODE IDENT NO. ~~19200~~  
 PART NO. 5503840

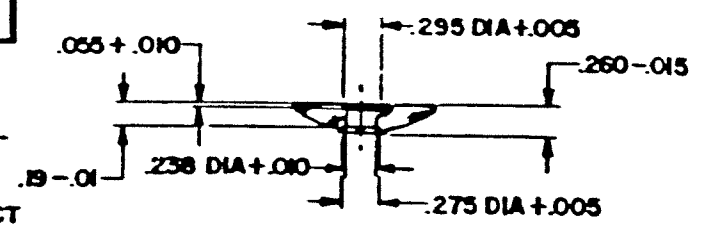
CONTROL NO.	DESCRIPTION	DATE	BY
612006320PSTOL M15			
17791205	PSTOL M15A1		
F 7268381	NATL MATCH		
F 7265695	PSTOL M15A1		

LOCK, SAFETY

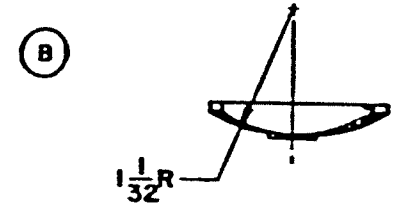
DEPT. OF ARMY  
 ROCK ISLAND ARSENAL  
 ROCK ISLAND, ILL. 61201  
 5503840

40

- NOTES:
1. RECESSES SHOWN ARE NONFUNCTIONAL AND ARE PERMITTED WITHIN REASONABLE LIMITS FOR STABILITY OF THE MOLDED PRODUCT
  2. MOLDING PLASTICS, SPEC MIL-M-14, PHENOLIC, TYPE CFI-20. COLOR: NO. 20045, 20059 OR 20062 OF TABLE II, FED. STD NO. 595; SEMI-GLOSS BROWN.
  3. APPLY PART NO. 1/8 HIGH IN RECESSED AREA PER MIL-STD-130.
  4. MIL-W-13855 APPLIES.



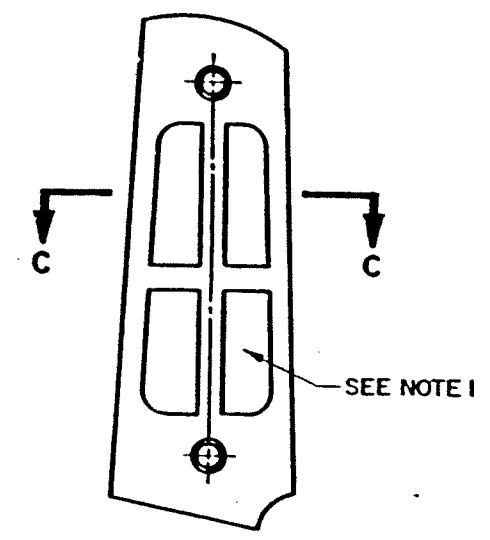
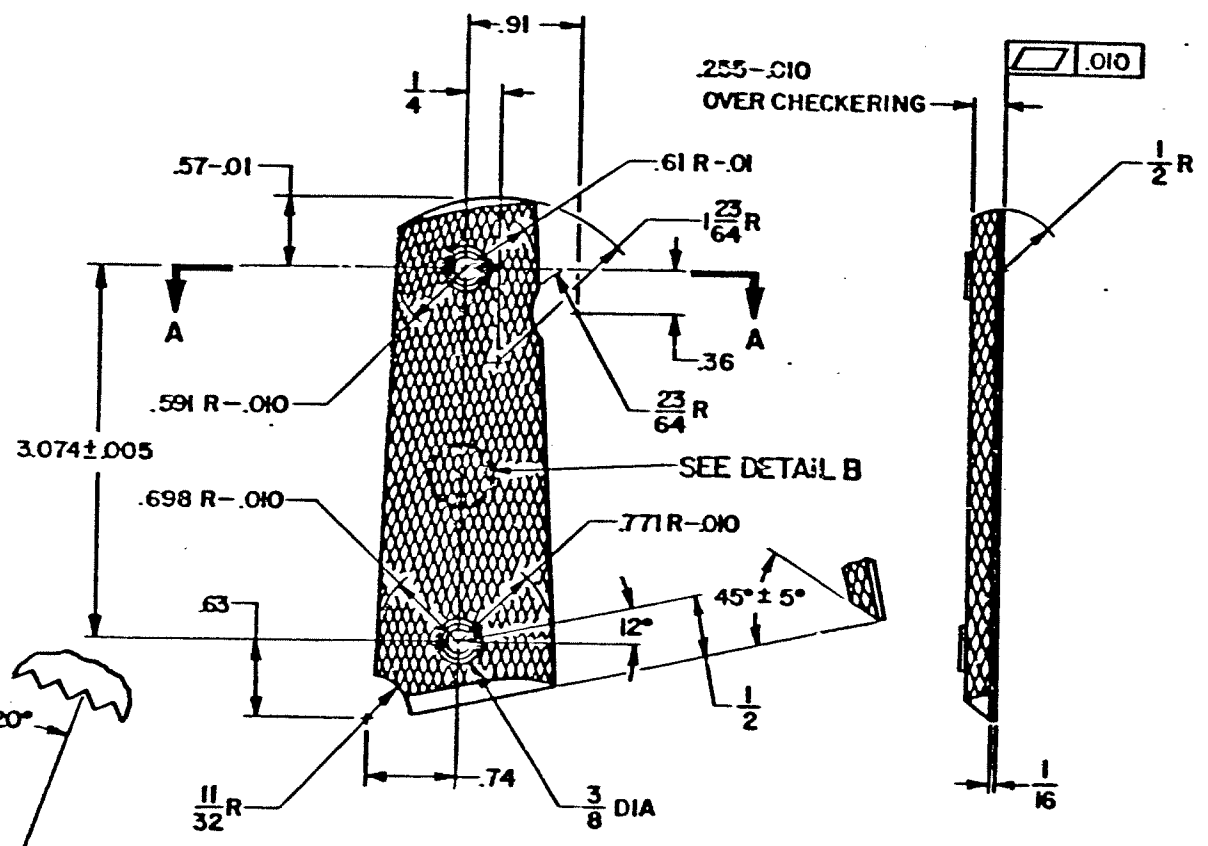
SECTION A-A



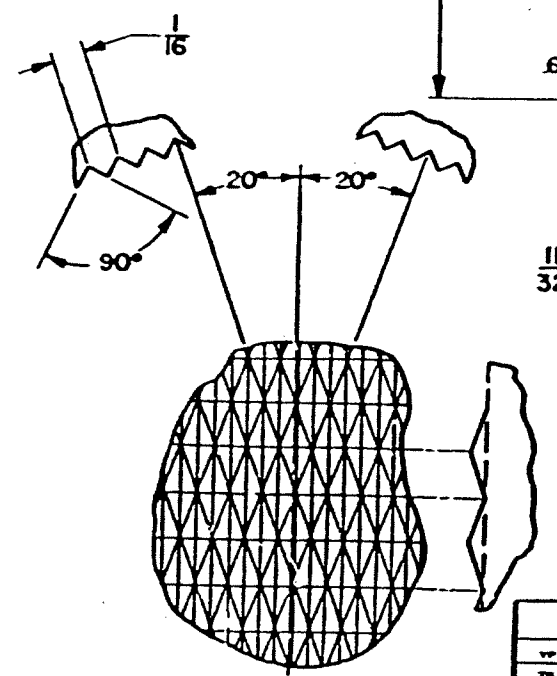
REV	DESCRIPTION	DATE	APPROVAL
16		15 JAN 59	
A	REDRAWN AND REVISED		
	SEE ED SA 24318		
B	SEE WOP 7836042-0000	1 OCT 78	



SECTION C-C



C8584062



DETAIL B  
SCALE 4/1

CODE IDENT NO. 19204  
PART NO. 5564062

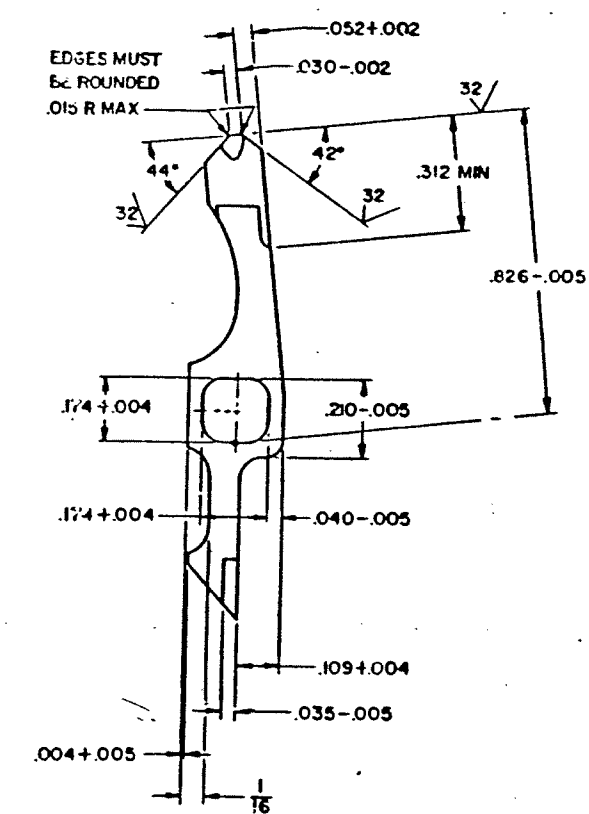
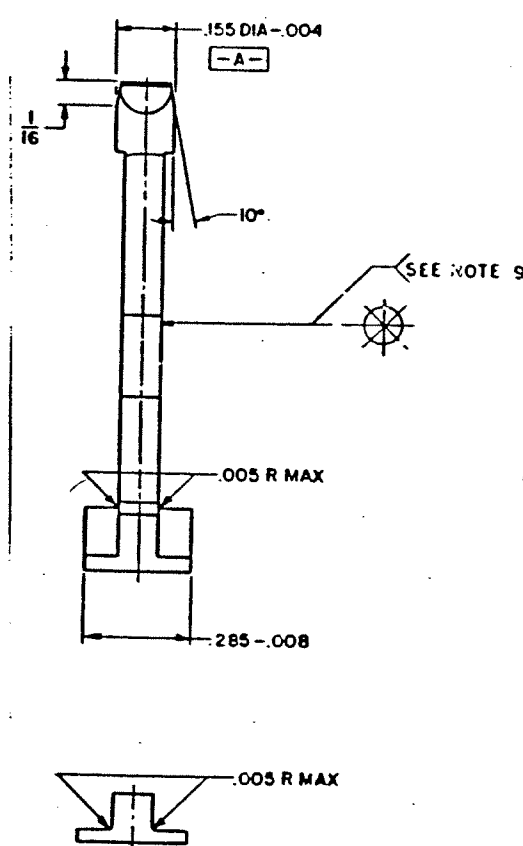
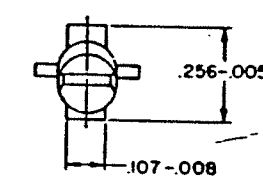
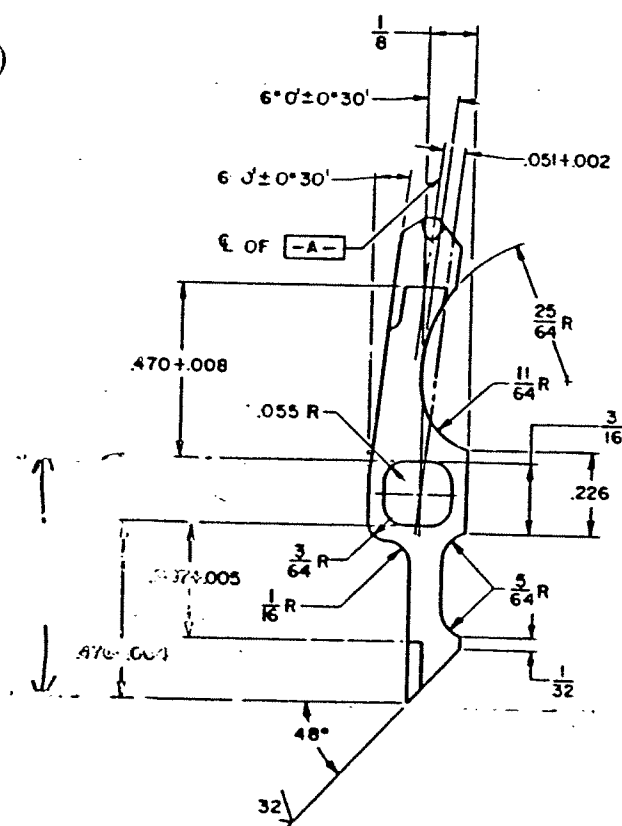
PHYSICAL PROPERTIES VP TB Q. 2 RA BR BR		TOLERANCES ON DIMENSIONS ARE AS SHOWN DECIMALS ±.01 FRACTIONS ±1/64 ANGLES ±1° MATERIAL: SEE NOTE 2 HEAT TREATMENT FINAL PROTECTIVE FINISH	ORIGINAL DATE 15 JAN 36 OF DRAWING DRAFTER S.J.B. CHECKER J.F.O.B. TRACER J.R.P. CHECKER J.R.P. DRAWN J.S.L. CHECKER J.S.L. SUBMITTED APPROVED J.C. Miller	STOCK, RIGHT HAND, PLASTIC	DEPT OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILL. 61201
APPLICATION SEE NOTE 3		SCALE 1/1 UNIT WT. 0.31 LB	DWG NO. C 5564062 SHEET OF		

C 5564062

13			
A	REDRAWN AND REVISED: WAS "E" SIZE, SEE EC -A 28316	22AP53	
B	(1) SEE ERR HOR 30697-2	27NOV64	W. J. J.
C	(2) SEE ERR HOR 50605	10FEB75	
D	NOR WBS 8003 78-12-49	790517	R. J. J.

41

- NOTES:
1. FINISH  $125 \sqrt{32}$  EXCEPT AS NOTED.
  2. ALL EDGES SHALL BE BROKEN  $.005 \pm .010$  UNLESS OTHERWISE SPECIFIED.
  3. MATERIAL:
    - A. STEEL CMPSM 1060 THRU 1074 ASTM A575 A576, ASTM A108, AUSTENIC GRAIN SIZE 6 OR FINER.
    - B. INVESTMENT CASTING IC4150 OR IC6150, SPEC MIL-S-2214L.
  4. UNLESS OTHERWISE SPECIFIED, SURFACES REQUIRING  $32 \sqrt{32}$  ROUGHNESS HEIGHT RATING MAY BE PROCESSED AFTER APPLICATION OF FINAL PROTECTIVE FINISH. BRIGHT AREAS RESULTING FROM SUCH PROCESSING ARE PERMISSIBLE.
  5. NO TRANSVERSE TOOL MARKS PERMITTED ON SURFACES MARKED  $32 \sqrt{32}$ .
  6. UNLESS OTHERWISE SPECIFIED ALL INTERIOR CORNERS SHALL BE ROUNDED WITH FILLET RADII OF FROM  $.005$  TO  $.015$  INCH.
  7. MIL-W-13855 APPLIES.
  8. FINISH 5.3.12 OF MIL-STD-171.
  9. INSPECT CASTING PER MIL-C-6021, CLASS 1, GRADE A.



.476  
.170  
.150

D6008603

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND  
DOVER, NEW JERSEY 07801

CODE IDENT NO. ~~157034~~ PART NO. 6008603 CODE IDENT NO. 19200

F7791205	PISTOL M9HAR	YP							
F7268381	NATL MATCH	TS							
F7265655	PISTOL M9HAR	EL 2							
F12006306	PISTOL M15	BH							
	NEXT ASSY USED ON	RH							
			C435						
			TD 50						

DISCONNECTOR

6008603

4/1 .0043 LB



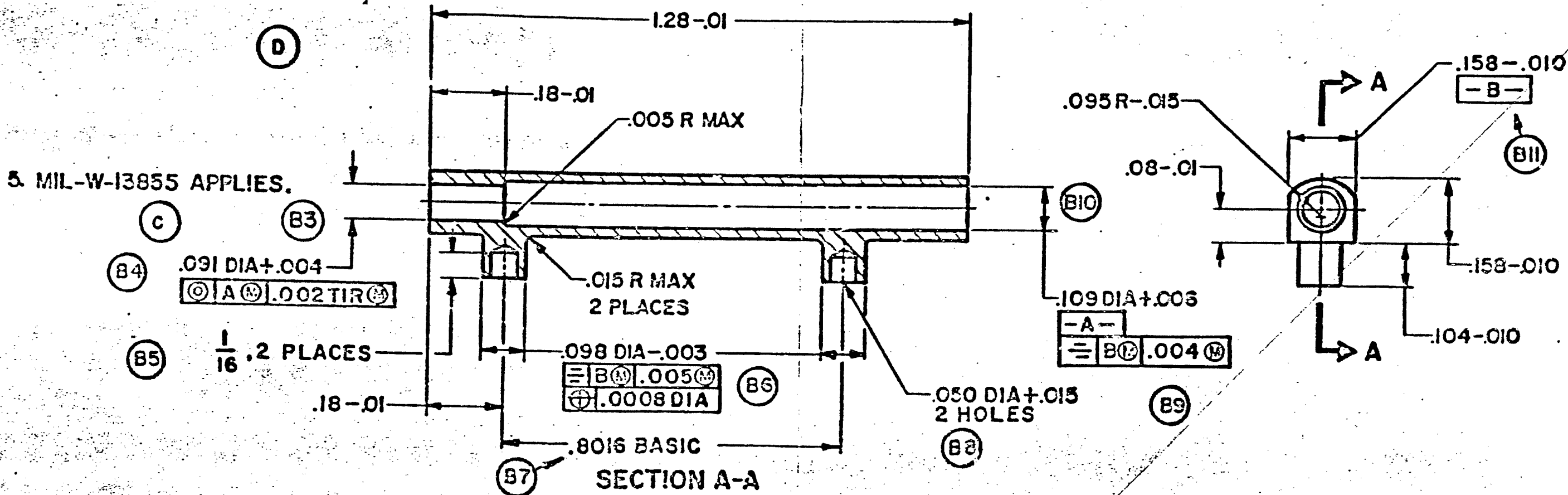
66008594

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
7		7 APR 52	
A	REDRAWN AND REVISED SEE EO SA 26316	27 NOV 53	
B	(1-11) SEE EO NO. RIA-13876	12-30-63	
C	(3) SEE ERR HGR 30687-1	23 MAY 73	
D	(2) SEE ERR HGR 50605	10 FEB 75	

43

NOTES:

- FINISH ALL OVER <sup>125</sup> ✓
- ALL EDGES SHALL BE BROKEN .005+.010
- STEEL, CMPSN 1017 THRU 1025, SPEC QQ-S-631 OR STEEL, CMPSN 1117 OR 1118, SPEC QQ-S-637.
- FINISH 5.3.1.2 OF MIL-STD-171.



CODE IDENT NO. 19204  
PART NO. 6008594

B12006343	PISTOL, M15	PHYSICAL PROPERTIES	UNLESS OTHERWISE SPECIFIED	ORIGINAL DATE OF DRAWING	<p>TUBE, PLUNGER</p> <p>DEPT OF THE ARMY ROCK ISLAND ARSENA ROCK ISLAND, ILL., 61901</p>
F7790428	NATL MATCH	YP	DIMENSIONS ARE IN INCHES	1 MAY 28	
D6509389	PISTOL, M51A1	TB	TOLERANCES ON FRACTIONS DECIMALS ANGLES		
		EL2	±1/64		
		RA	MATERIAL:		<p>6008594</p> <p>SHEET 1 OF 1</p>
		BH	SEE NOTE 3		
		RH	HEAT TREATMENT		
			FINAL PROTECTIVE FINISH:		
			SEE NOTE 4		

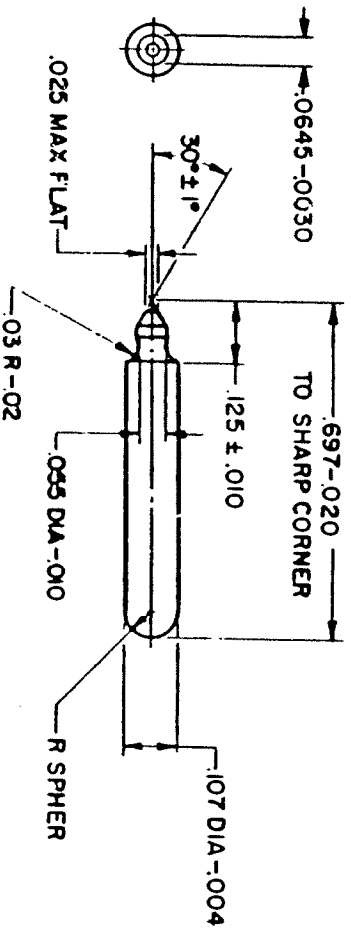
00 125 1176



561E105B

REV	DESCRIPTION	DATE	APPROVAL
B		27NOV62	
A	REDRAWN AND REVISED WAS "A" SIZE. SEE EO SA 26316	27NOV62	
B	(3) SEE ERR HOR 30687-2	19JUN73	
C	NOR W452067/83-12-21	84-06-04	
D	REDRAWN W/CHANGE NOR W452049/840719 (ECP W452067/841224)	870621	

- NOTES:
1. FINISH 125
  2. HEAT TREATMENT: CARBURIZE TO CASE DEPTH .002 TO .005. OIL OR WATER QUENCH. TEMPER 350°F FOR 20 MINUTES AT HEAT. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
  3. STEEL, CARBON; SAE 1117; ASTM A108
  4. MIL-W-13855 APPLIES.
  5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171.



CURRENT DESIGN ACTIVITY CASE CODE 19205  
 ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER,  
 PICAATTI, MASSACHUSETTS, NEW JERSEY 07004-3000

PART NO. 5013195

19205

PLUNGER,  
SAFETY LOCK

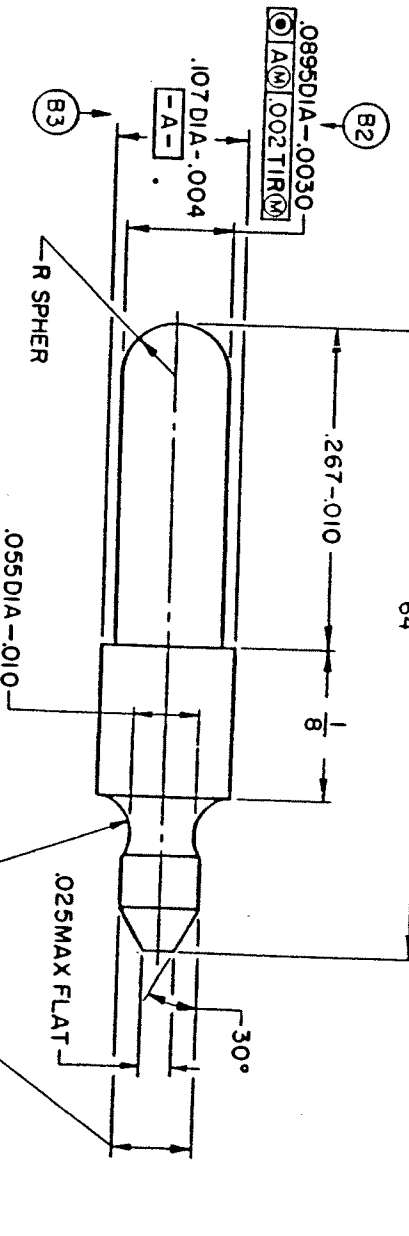
DEPT OF THE ARMY  
SPRINGFIELD ARMORY  
SPRINGFIELD, MASS

REV	DESCRIPTION	DATE	APPROVAL
B		10AUG43	
A	REDRAWN AND REVISED WAS "A" SIZE. SEE EO SA 26316	27NOV62	
B	(1-6) SEE EO RIA-13876	12-30-66	
C	(2) SEE ERR HOR 30687-2	19JUN73	
D	SEE ERR HOR 50605	10FEB75	
E	REDRAWN W/CHANGE NOR W452049/840719 (ECP W452067/841224)	870621	

DEPT OF THE ARMY  
SPRINGFIELD ARMORY  
SPRINGFIELD, MASS

61E105B

REV	DESCRIPTION	DATE	APPROVAL
5		10AUG43	
A	REDRAWN AND REVISED WAS "A" SIZE. SEE EO SA 26316	27NOV62	
B	(1-6) SEE EO RIA-13876	12-30-66	
C	(2) SEE ERR HOR 30687-2	19JUN73	
D	SEE ERR HOR 50605	10FEB75	
E	REDRAWN W/CHANGE NOR W452049/840719 (ECP W452067/841224)	870621	



- NOTES:
1. FINISH ALL OVER 125
  2. HEAT TREATMENT: CARBURIZE TO CASE DEPTH .002 TO .005. OIL OR WATER QUENCH. TEMPER AT 350°F FOR 20 MINUTES AT HEAT. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBO-NITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
  3. FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
  4. MIL-W-13855 APPLIES.

CURRENT DESIGN ACTIVITY CASE CODE 19205  
 ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER,  
 PICAATTI, MASSACHUSETTS, NEW JERSEY 07004-3000

PART NO. 5013193

19205

PLUNGER,  
SLIDE STOP

DEPT OF THE ARMY  
SPRINGFIELD ARMORY  
SPRINGFIELD, MASS.

REV	DESCRIPTION	DATE	APPROVAL
B		10AUG43	
A	REDRAWN AND REVISED WAS "A" SIZE. SEE EO SA 26316	27NOV62	
B	(3) SEE ERR HOR 30687-2	19JUN73	
C	NOR W452067/83-12-21	84-06-04	
D	REDRAWN W/CHANGE NOR W452049/840719 (ECP W452067/841224)	870621	

DEPT OF THE ARMY  
SPRINGFIELD ARMORY  
SPRINGFIELD, MASS.

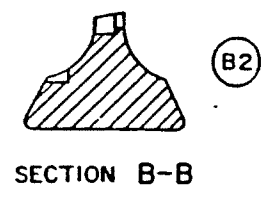
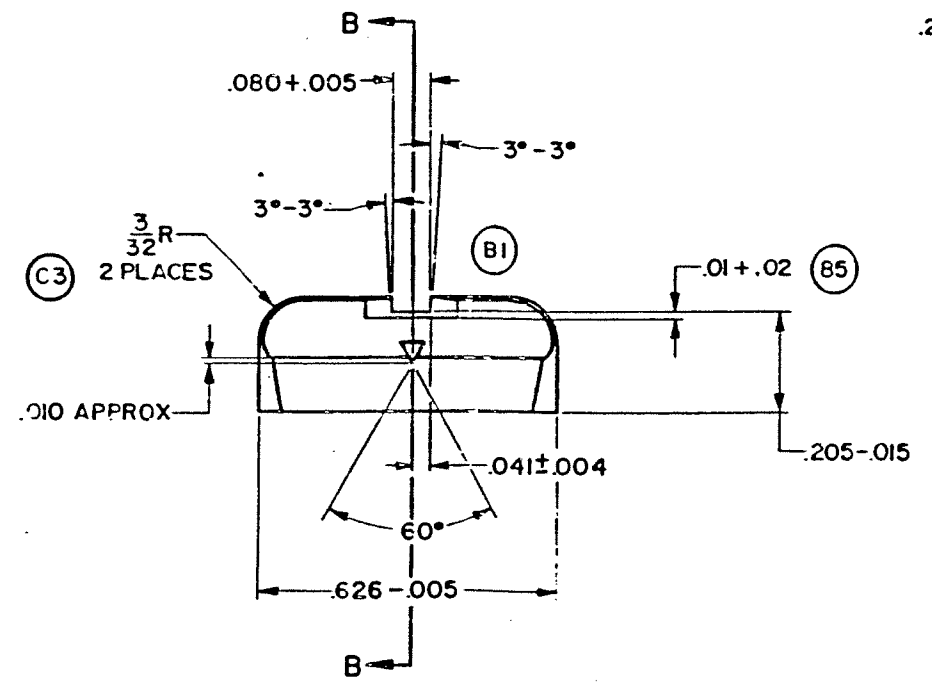
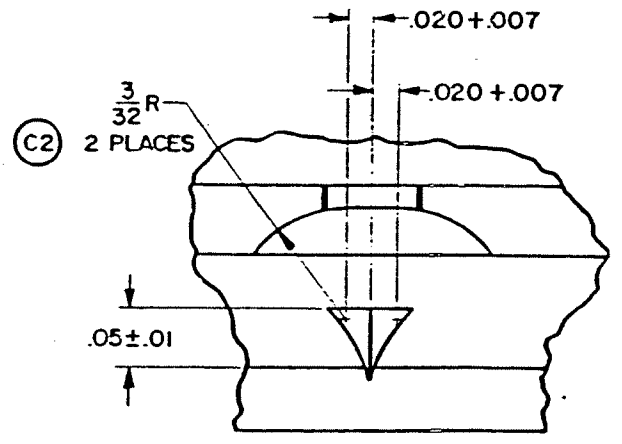
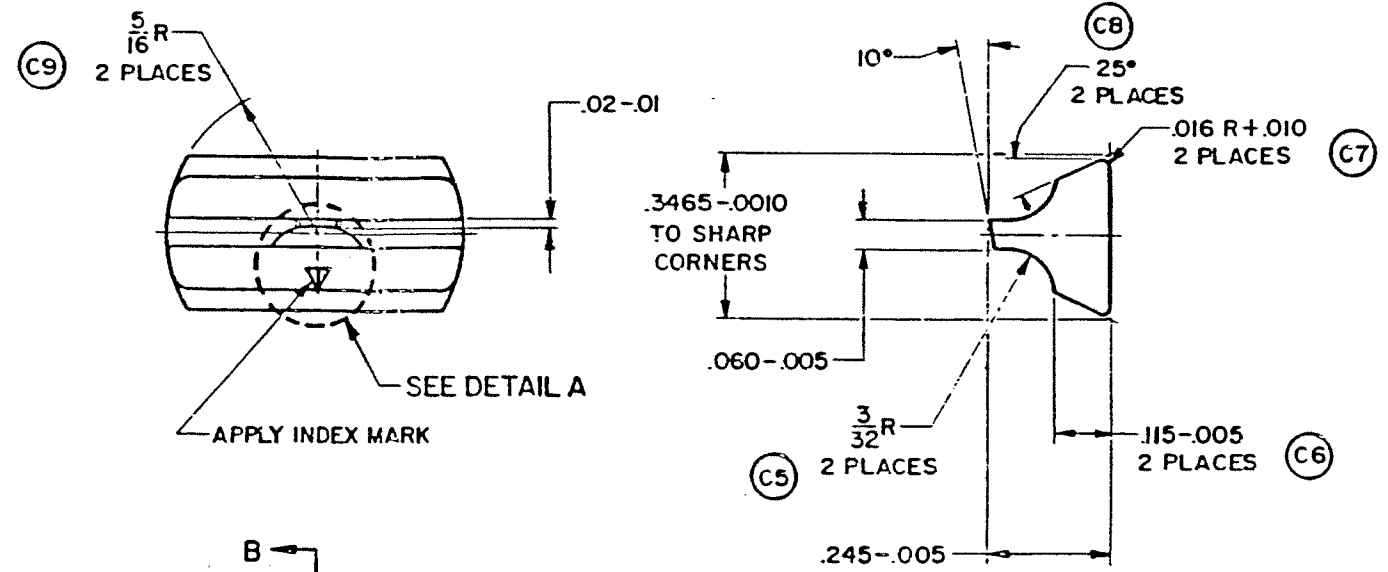
DEPT OF THE ARMY  
SPRINGFIELD ARMORY  
SPRINGFIELD, MASS.

44

UNLESS OTHERWISE SPECIFIED, DIMENSIONS, SPECIFICATIONS, OR OTHER DATA ARE TO BE IN INCHES. DIMENSIONS SHOWN IN CONNECTION WITH A DECIMAL POINT SHALL BE IN INCHES UNLESS OTHERWISE SPECIFIED. THE UNITED STATES GOVERNMENT ASSUMES NO LIABILITY FOR ANY LOSS OR DAMAGE TO PROPERTY OR PERSONS IN CONNECTION WITH THE USE OF THIS DRAWING. THE FACT THAT THE GOVERNMENT HAS FORMULATED, APPROVED, OR ADAPTED THIS DRAWING DOES NOT CONSTITUTE AN ENDORSEMENT OR A GUARANTEE OF THE QUALITY OF THE MATERIALS OR THE WORKMANSHIP OF THE MANUFACTURE THEREOF. THE GOVERNMENT WILL NOT BE RESPONSIBLE FOR ANY LOSS OR DAMAGE TO PROPERTY OR PERSONS IN CONNECTION WITH THE USE OF THIS DRAWING. THE GOVERNMENT WILL NOT BE RESPONSIBLE FOR ANY LOSS OR DAMAGE TO PROPERTY OR PERSONS IN CONNECTION WITH THE USE OF THIS DRAWING.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
B	←	18 MAY 49	
A	REDRAWN AND REVISED WAS		
	A" SIZE, SEE EO SA 26316	27 NOV 62	<i>[Signature]</i>
B	(1-5) SEE EO SA 29396	13 JUN 66	<i>[Signature]</i>
C	(1-10) SEE EO NO. RIA - 13899	1-9-67	<i>[Signature]</i>
D	NOR W85800 79-1-2-1	79-12-13	
E	NOR WIS 2035/82-02-22	83-07-10	<i>[Signature]</i>
F	NOR W653012/860321	871021	<i>[Signature]</i>
G	NOR G952013/890414	891206	<i>[Signature]</i>

- NOTES:
- FINISH  $125 \sqrt{\text{C1}}$  ALL OVER.
  - ALL EDGES SHALL BE BROKEN  $.005 + .010$  UNLESS OTHERWISE SPECIFIED.
  - FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.  $\text{C10}$
  - ALTERNATIVE MATERIAL INVESTMENT CASTING 1.320, SPEC MIL-S-22141.
  - INSPECT CASTINGS PER MIL-STD-2175 CLASS 3, GRADE 1.



45

C5013196

U S ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER  
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19205  
PART NO. 5013196  
CURRENT  
CODE IDENT NO. 19200

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON DECIMALS ANGLES $\pm 1^\circ$ FRACTIONS $\pm 1/64$	ORIGINAL DATE OF DRAWING 1 MAY 28	SPRINGFIELD ARMYORY ORDNANCE CORPS DEPT OF THE ARMY
	VP			
TE		MATERIAL: STEEL, SPEC ASTM-A108:COMP 1015 THRU 1025	CHECKER M.E.K.	SIGHT, REAR
EL 2	C7790353 45AP, MIAI	HEAT TREATMENT	TRACER R.P.P.	
PA	SEE ENGRG RECORDS	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE	ENGINEER E.S. [Signature]	5013196
SH	NEXT ASSY USED ON	APPROVED BY [Signature]	SUBMITTED [Signature]	
SH	DO NOT APPLY PART NO.	FINAL PROTECTIVE FINISH: SEE NOTE 3	LT COL [Signature]	SCALE 4/1 LINT WT .0073LB

C  
B  
A

D  
D  
B  
A





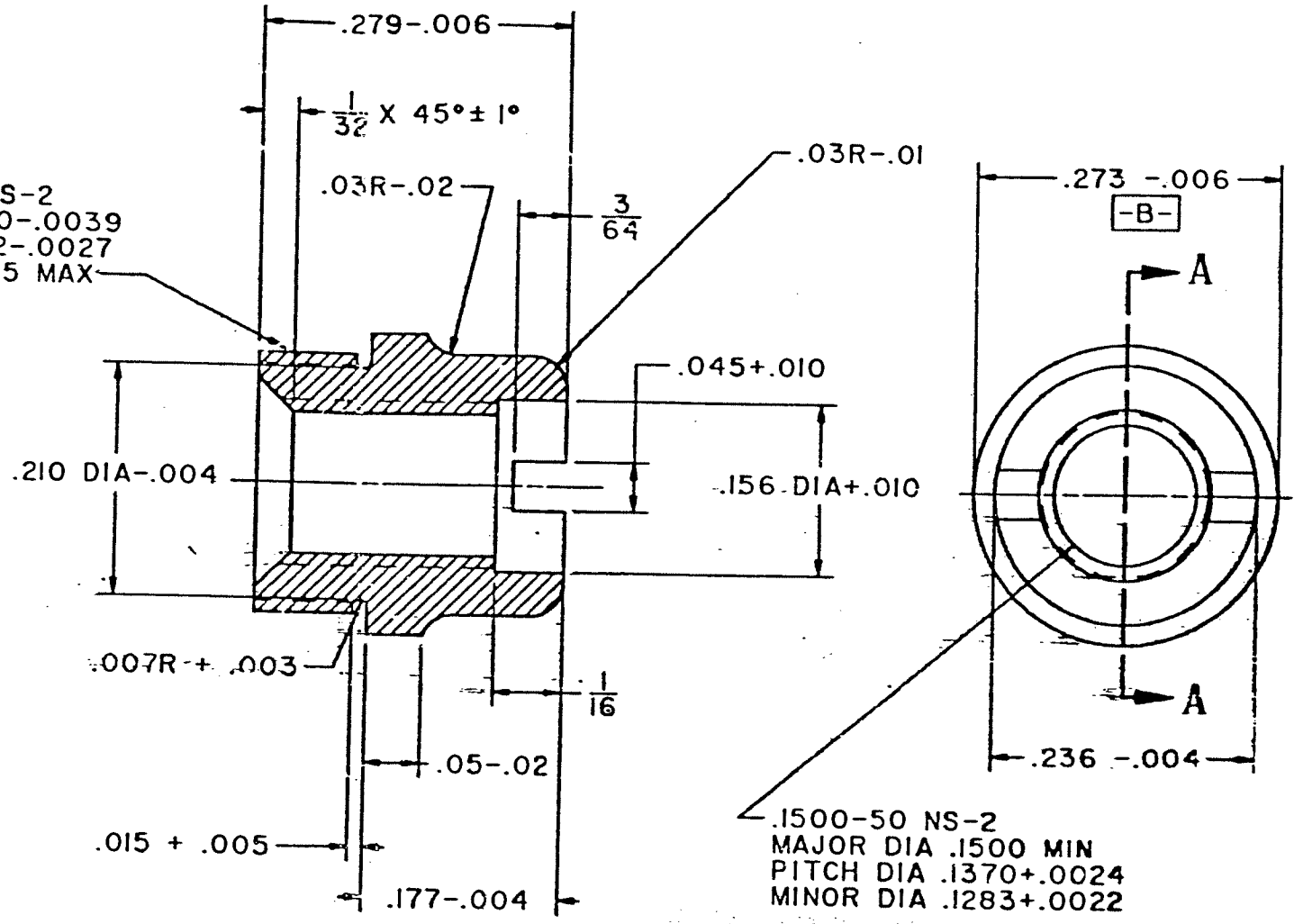




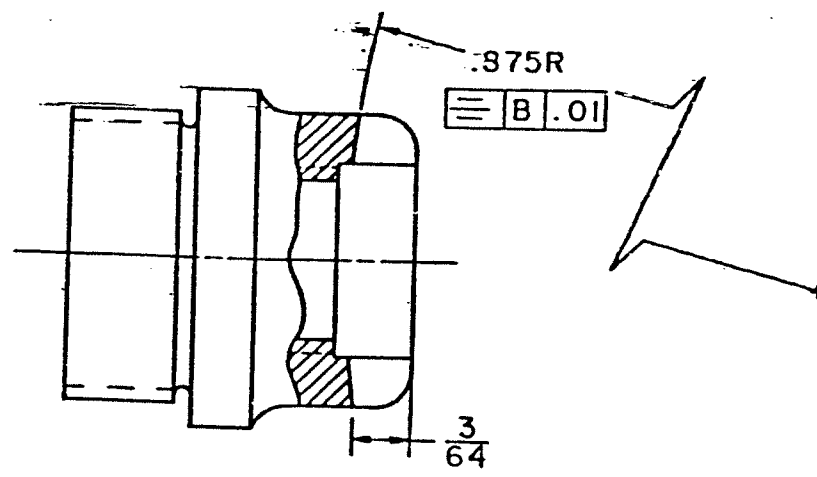
- NOTES:
1. FINISH  $\sqrt[125]{}$  ALL OVER.
  2. UNLESS OTHERWISE SPECIFIED, ALL INTERIOR CORNERS SHALL BE ROUNDED WITH FILLET RADII OF FROM .005 TO .015 INCH.
  3. STEEL, CARBON: SAE 1020, 1016, 1017 ASTM A576 OR ASTM A108.
  4. MIL-W-13855 APPLIES.
  5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171.

REVISIONS				
ZONE	LTR	DESCRIPTION	DATE (YR MO DA)	APPROVED
	G	REDRAWN W/CHANGE NOR W4S2049/840719 (ECP W4S2067/841224)	870621	EM DRFT

.2360-60 NS-2  
MAJOR DIA .2360-.0039  
PITCH DIA .2252-.0027  
MINOR DIA .2155 MAX



SECTION A-A



ALTERNATIVE DESIGN

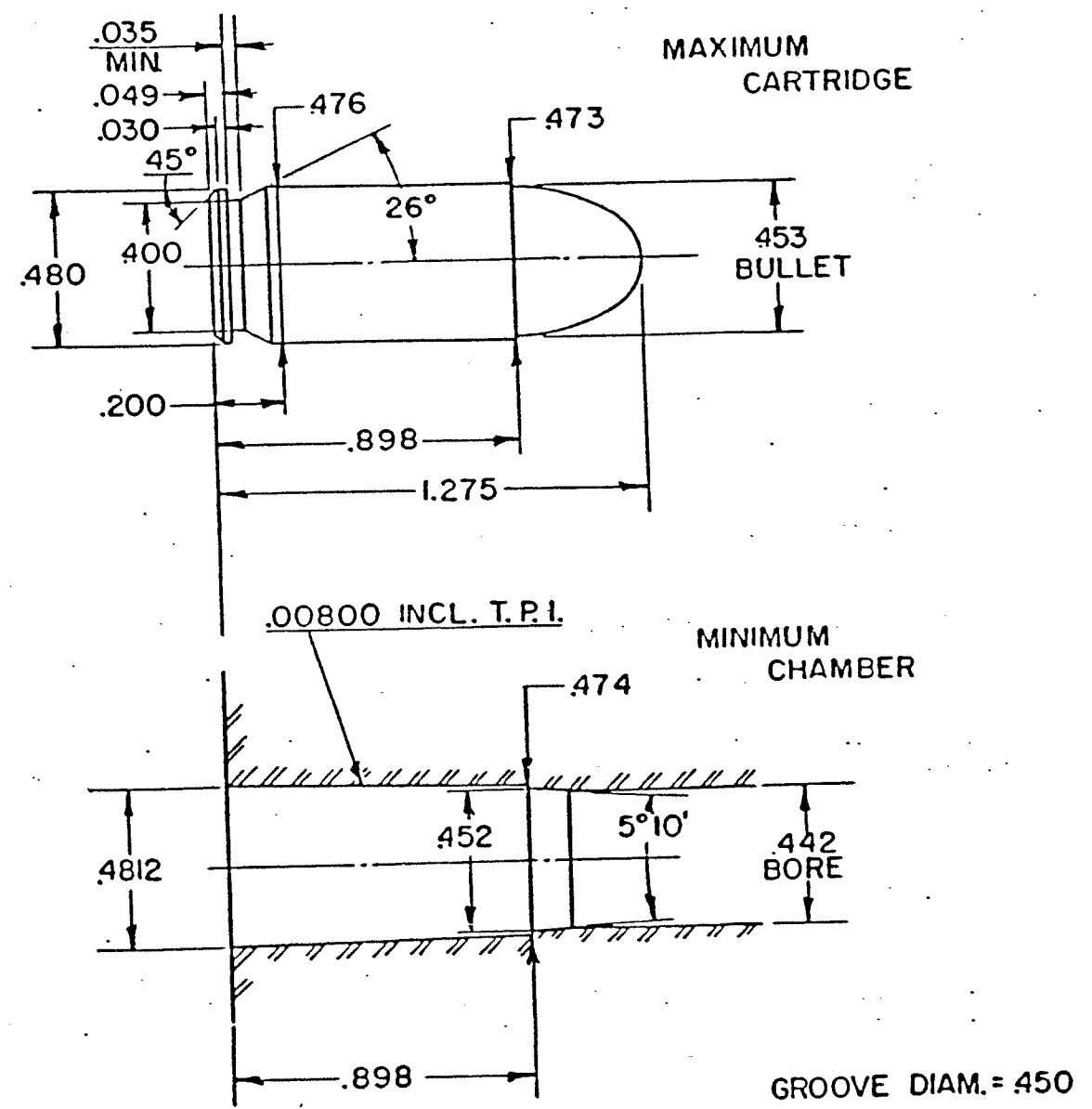
CONTRACT NUMBER 28-06-01  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PITCHER AVENUE, BELT FORT, MISSOURI

THIS DRAWING HAS BEEN GENERATED ON A CAD SYSTEM LOCATED AT ARDEC, PITCHER AVENUE, BELT FORT, MISSOURI. ANY CHANGES MUST BE APPROVED BY THE USER.

PART NO. 6019022

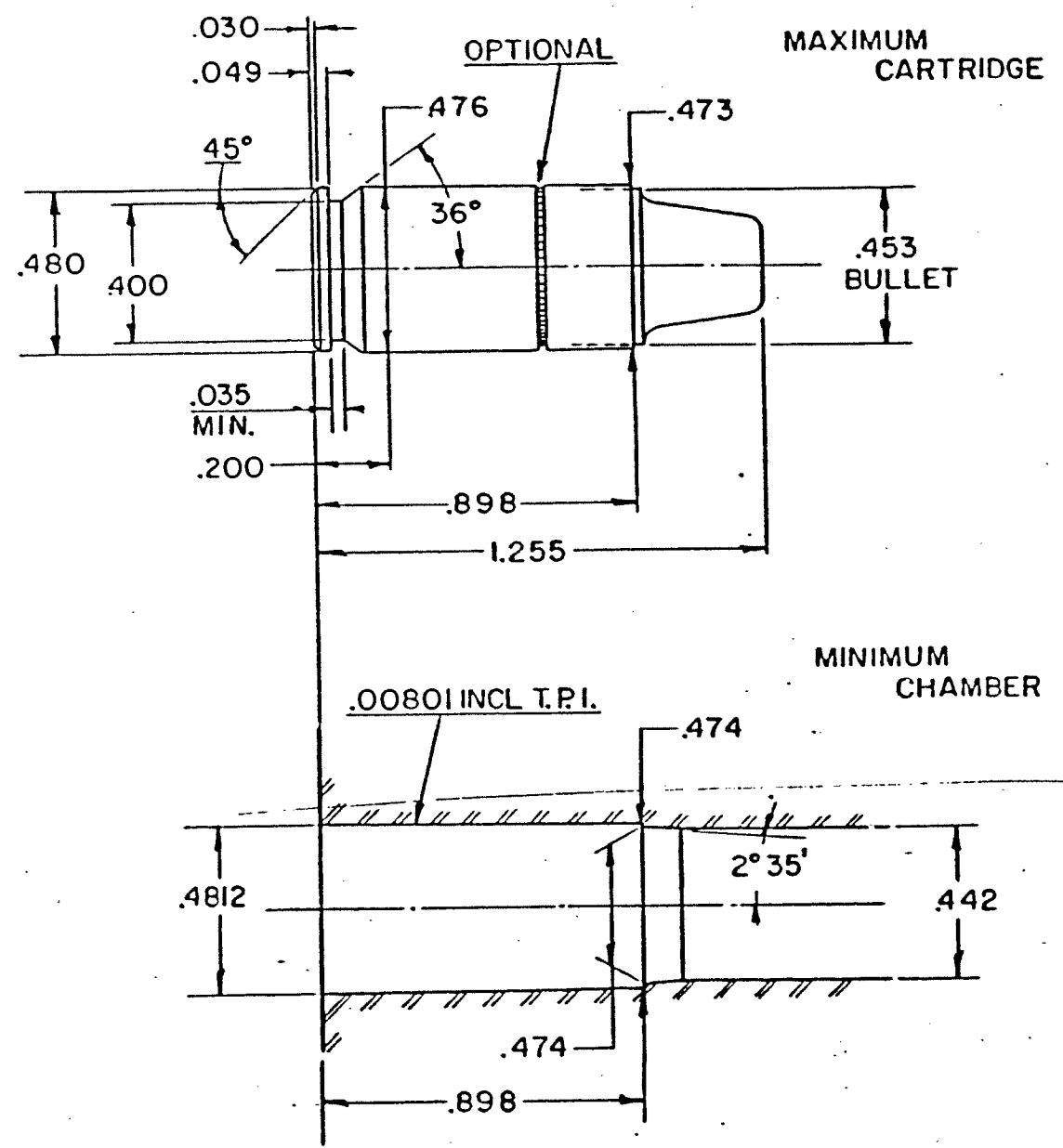
PMIC		DO NOT SCALE DRAWING		CONTRACT NUMBER		DEPT OF THE ARMY SPRINGFIELD ARMOY SPRINGFIELD, MASS	
MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		CONTRACTOR		BUSHING, STOCK SCREW	
YP	D12006342	PISTOL, M15	TOLERANCES ON DECIMAL FRACTION	DRAWN BY F.C.L.	DATE(YR-MO-DA) 28-06-01	SIZE C	CAGE CODE 19205
TS		PISTOL, M911A1	2 PL ± 1/64	CHECKER L.S.C.	ENGINEER H.E.S.		6019022
EL2	F7790428	NATL MATCH	3 PL ± .010	DRAWING APPROVAL V. A. LUUKKONEN		SCALE 10/1	UNIT WT. .002 LB
RA	D6508389	PISTOL, M911A1	THIRD ANGLE PROJECTION	DESIGN APPROVAL S. C. SHULTZ		SHEET 1 OF 1	
BH		NEXT ASSY USED ON	MATL ENGR				
RH		APPLICATION	CADS REV - 263				

CARTRIDGE & CHAMBER  
 45 AUTO  
 APPROVED S.A.A.M.I. 12-3-64  
 CHAIRMAN TECHNICAL COMMITTEE  
 ISSUED S.A.A.M.I. 3-1-65



CARTRIDGE & CHAMBER  
 45 AUTO, MATCH, WAD CUTTER  
 APPROVED S.A.A.M.I. 7-1-65  
 CHAIRMAN TECHNICAL COMMITTEE  
 ISSUED S.A.A.M.I. 8-30-65

49



NOTE:  
 BREECH ON MOUTH

GROOVE DIAM. = .450  
 TWIST = 16" L.H.

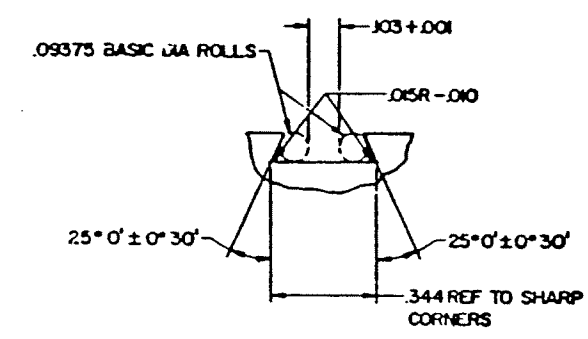
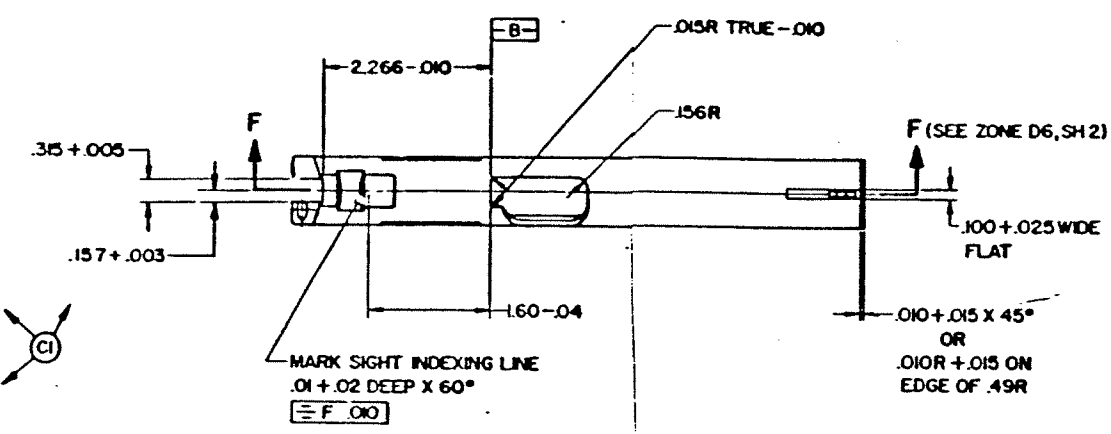
REV.	DATE	REV. BY	APPROVED BY	DESCRIPTION	CHECKED BY	CAL. 45 AUTO
11	27-64	J.W.		26° WAS 36° - REDRAWN	J.W.	<b>S.A.A.M.I.</b> TECHNICAL COMMITTEE MANUAL SECTION I - CHARACTERISTICS DRAWN _____ TRACED _____ CHECKED _____

REV.	DATE	REV. BY	APPROVED BY	DESCRIPTION	CHECKED BY	CAL. 45 AUTO, MATCH, WAD CUT
						<b>S.A.A.M.I.</b> TECHNICAL COMMITTEE MANU SECTION I - CHARACTERISTIC DRAWN _____ TRACED _____ CHECKED _____

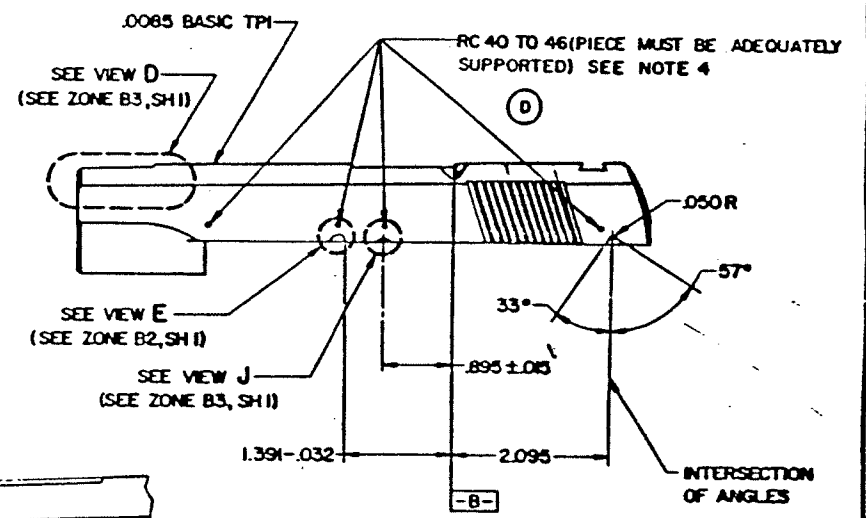
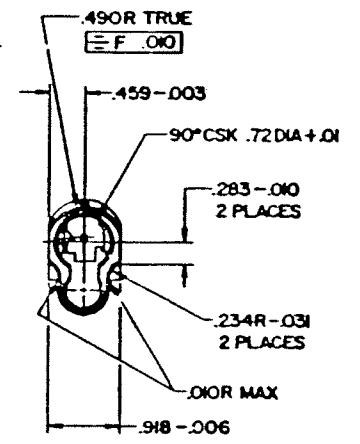
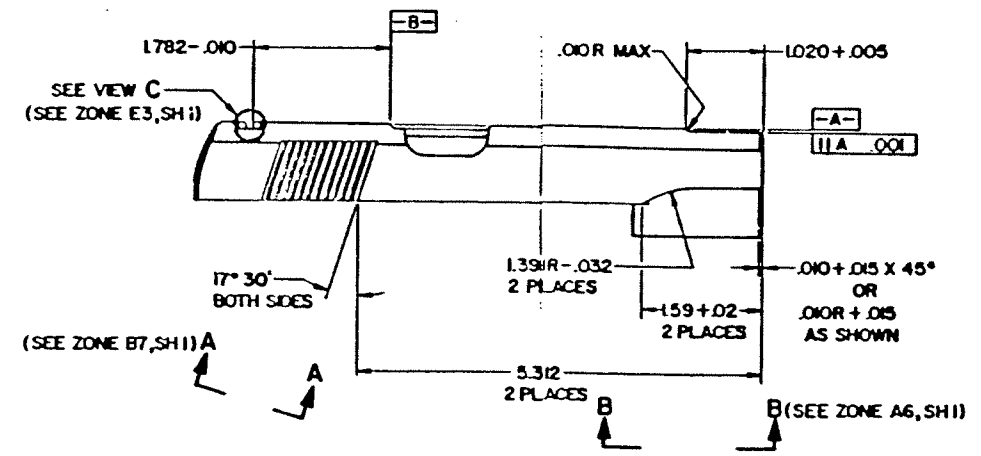


SYM	DESCRIPTION	DATE	APPROVAL
D	(SEE REPLACEMENT SHEET 7791436)	30 AUG 62	[Signature]
C	SEE 80 MIL. SPEC. FOR		
E	SEE 80 MIL. SPEC. FOR		
F	SEE 80 MIL. SPEC. FOR		

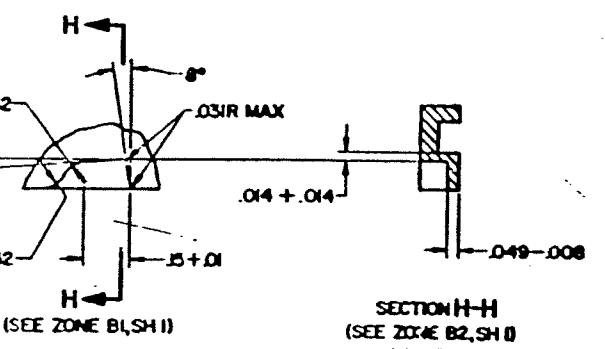
- NOTES
1. FINISH EXCEPT AS NOTED.
  2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
  3. MATERIAL: STEEL, CMPSN 4140 OR 8650, ASTM A322 OR A331.  
AUSTENITIC GRAIN SIZE 5-8
  4. HEAT TREATMENT: AUSTEMPER AT 700°F FOR 30 MINUTES FROM 1550°F TO ROCKWELL SPECIFIED. THE USE OF EQUIVALENT ROCKWELL D-SCALE READINGS IS AUTHORIZED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
  5. FOR IDENTIFICATION MARKINGS SEE DWG C7791436.
  6. THE DIRECTION OF LAY ON THE BREACH FACE MUST BE PARALLEL TO THE BOUNDARY LINE REPRESENTING THE SURFACE TO WHICH THE FINISH SYMBOL APPLIES.
  7. APPLY OIL PER VV-L-800.
  8. MIL-W-13855 APPLIES.



VIEW C  
(SEE ZONE C6, SH 1)  
SCALE 4/1

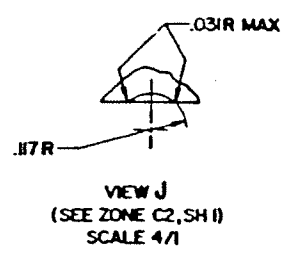


VIEW D  
(SEE ZONE C3, SH 1)  
SCALE 2/1

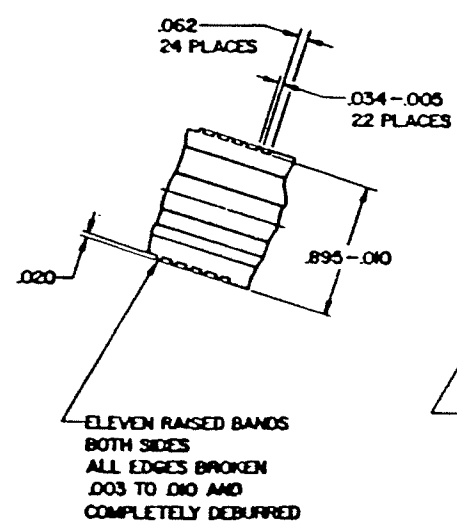


VIEW E  
(SEE ZONE C2, SH 1)  
SCALE 4/1

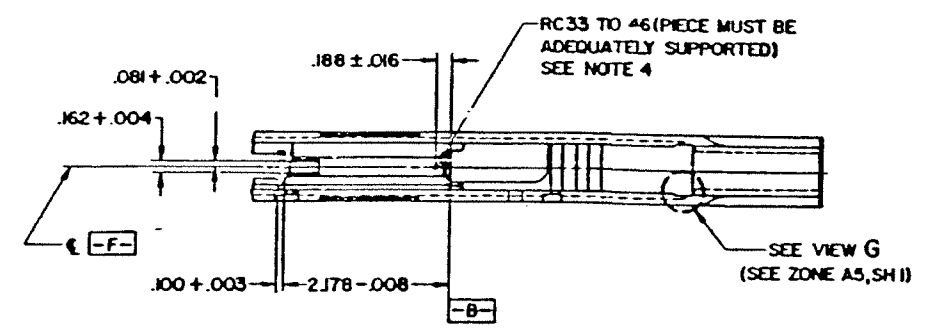
SECTION H-H  
(SEE ZONE B2, SH 1)  
SCALE 4/1



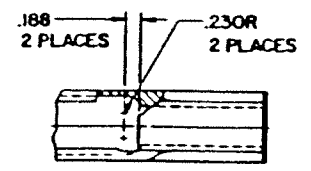
VIEW J  
(SEE ZONE C2, SH 1)  
SCALE 4/1



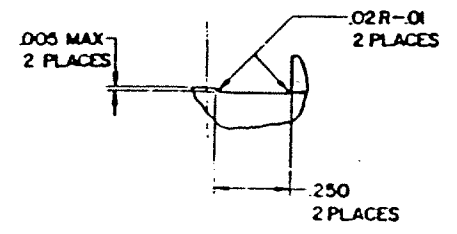
VIEW A-A  
(SEE ZONE C6, SH 1)  
SCALE 2/1



VIEW G  
(SEE ZONE A5, SH 1)



VIEW B-B  
(SEE ZONE C5, SH 1)



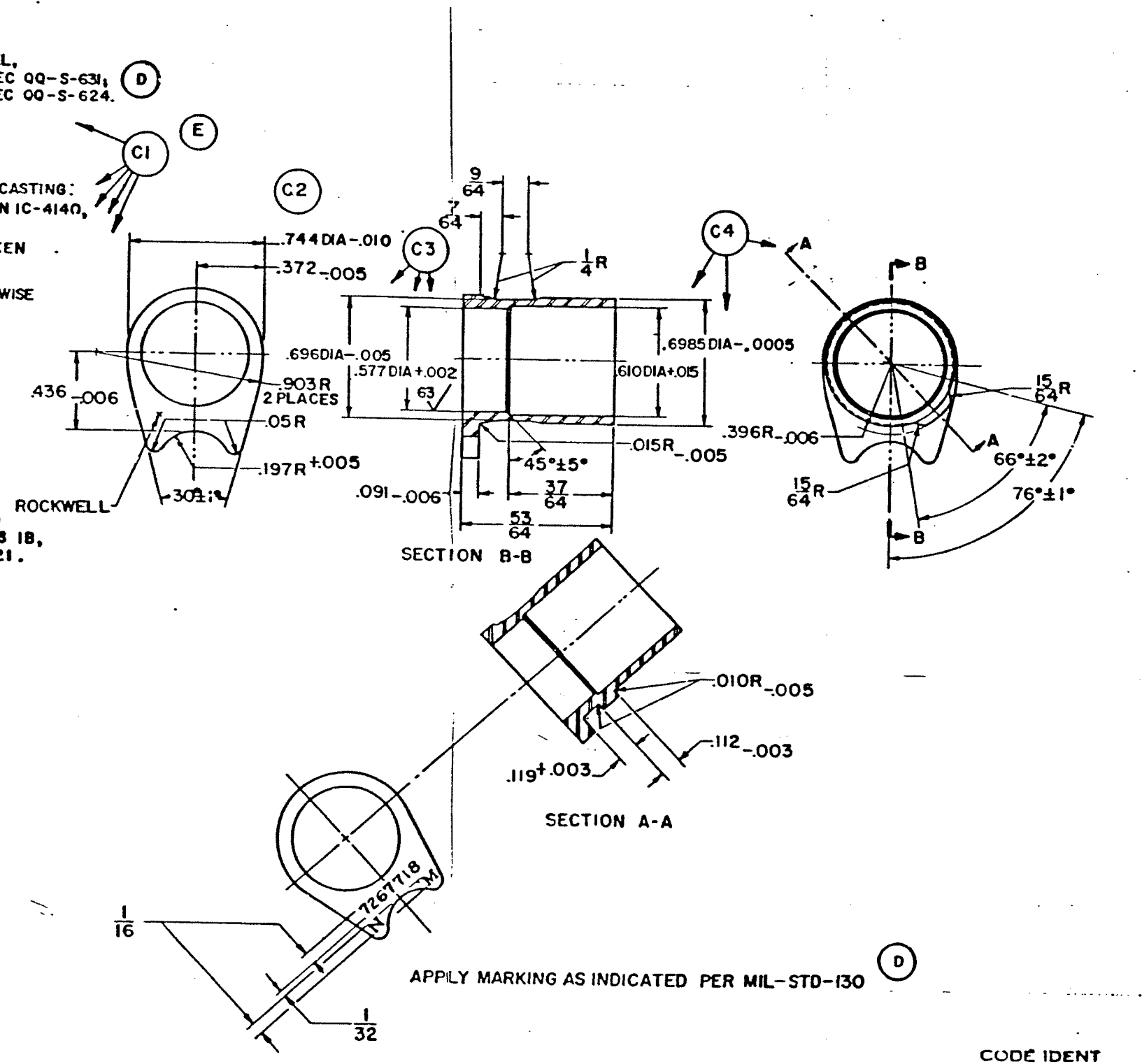
VIEW G  
(SEE ZONE B5, SH 1)  
SCALE 4/1

MECHANICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		ORIGINAL DATE OF DRAWING		PART NO. 7791435	
TP	D7791435	45AP, MP, NAL	TOLERANCES ON DIMENSIONS	30 AUG 62	DEPT OF THE ARMY	ROCK ISLAND ARSENAL, ROCK ISLAND, ILL. 61201	
TR		MATL MATCH	FRACTIONS ±	DESIGNED BY [Signature]	ENGINEER [Signature]	SLIDE	
EL 2			ANGLES ± P	TRACED BY [Signature]	CHECKER [Signature]	CODE IDENT NO. 19204 F 7791435	
RA				APPROVED BY [Signature]	ENGINEER [Signature]	SCALE 1/1	
SH		HEAT TREATMENT	SEE NOTE 3	APPROVED BY [Signature]			
RA		APPLICATION	SEE NOTE 4	APPROVED BY [Signature]			
SH		FINAL PROTECTIVE FINISH	SEE NOTE 7	APPROVED BY [Signature]			
RA		APPLY PART NO. AS SPECIFIED		APPROVED BY [Signature]			



NOTE:

1. MATERIAL:
  - A. WHEN FABRICATED FROM WROUGHT MATERIAL: STEEL, CMPSN 1060 THRU 1080, SPEC QQ-S-631, OR STEEL, CMPSN 4140, SPEC QQ-S-624. AUSTENITIC GRAIN SIZE 6 OR FINER
  - B. WHEN FABRICATED FROM CASTING: PRECISION CASTING, CMPSN IC-4140, SPEC ML-S-22141.
2. ALL EDGES SHALL BE BROKEN .005 + .010.
3. FINISH  $\sqrt{125}$  EXCEPT AS OTHERWISE SPECIFIED.
4. HEAT TREATMENT: HEAT AT 1525° TO 1575° F. OIL QUENCH. TEMPER TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE.
5. LUBRICATING OIL, SPEC VV-L-800.
6. CASTING SHALL BE CLASSIFIED AND INSPECTED IN ACCORDANCE WITH CLASS 1B, GRADE B, SPEC MIL-C-6021.
7. MIL-W-13855 APPLIES.



C7267718

C726771A

APPLY MARKING AS INDICATED PER MIL-STD-130

CODE IDENT NO. 19204

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

PART NO. 7267718

SYM	DESCRIPTION	DATE	APPROVAL
E	(2) SEE ERR HOR 50605	10 FEB 75	[Signature]
D	SEE ERR HRD 20623	26 MAY 72	[Signature]
C	(1-4) SEE EO RIA-14180	5-27-67	[Signature]
B	SEE EO NO. 24745	11 MAR 60	[Signature]
A'	SEE ECO NO. 23385	12 JAN 56	[Signature]

PHYSICAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TP		TOLERANCES ON DECIMALS ± .010	ORIGINAL DATE OF DRAWING 4 FEB 55
TS	C7791469	ANGLES FRACTIONS ± .010	DRAFTSMAN HES
ELS			CHECKER [Signature]
RA		SEE NOTE	ENGINEER [Signature]
WH		HEAT TREATMENT SEE NOTE 4	SUBMITTED [Signature]
WH	055-60	FINAL PROTECTIVE FINISH SEE NOTE 5	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE [Signature]

REVISIONS	DEPT OF THE ARMY
	ROCK ISLAND ARSENAL
	ROCK ISLAND, ILL. 61201
	DWG SIZE 7267718

**BUSHING, BARREL**

DEPT OF THE ARMY  
ROCK ISLAND ARSENAL  
ROCK ISLAND, ILL. 61201  
DWG SIZE 7267718

THIS DRAWING IS THE PROPERTY OF THE GOVERNMENT AND IS LOANED TO YOUR ORGANIZATION. IT IS TO BE USED ONLY FOR THE PURPOSES AUTHORIZED BY THE GOVERNMENT. IT IS TO BE RETURNED TO THE GOVERNMENT AT THE END OF THE LOAN PERIOD. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM THE GOVERNMENT. THE GOVERNMENT ASSUMES NO LIABILITY FOR THE USE OR MISUSE OF THIS DRAWING.

REVISIONS			
SYM	DESCRIPTION	DATE	APPROVA
A	(1-3) SEE TO RJA-14180	5-27-67	<i>[Signature]</i>
B	(2) SEE EPR HGR 50605	10 FEB 75	<i>[Signature]</i>
C	NOR W352097 83-08-13	25-10-21	<i>[Signature]</i>
D	NOR W452049/840719 (ECP W452067/841224)	870621	<i>[Signature]</i>
E	ERR Z9Z1290AW ECPG853076/880802	901030	<i>[Signature]</i>
F	NOR G2S3065/92-08-07	92-10-05	<i>[Signature]</i>

NOTES:  
1. THE COMPONENTS OF THIS ASSEMBLY ARE A MATCHED SET AND SHALL NOT BE SEPARATED FOR USE INDIVIDUALLY IN WEAPONS.

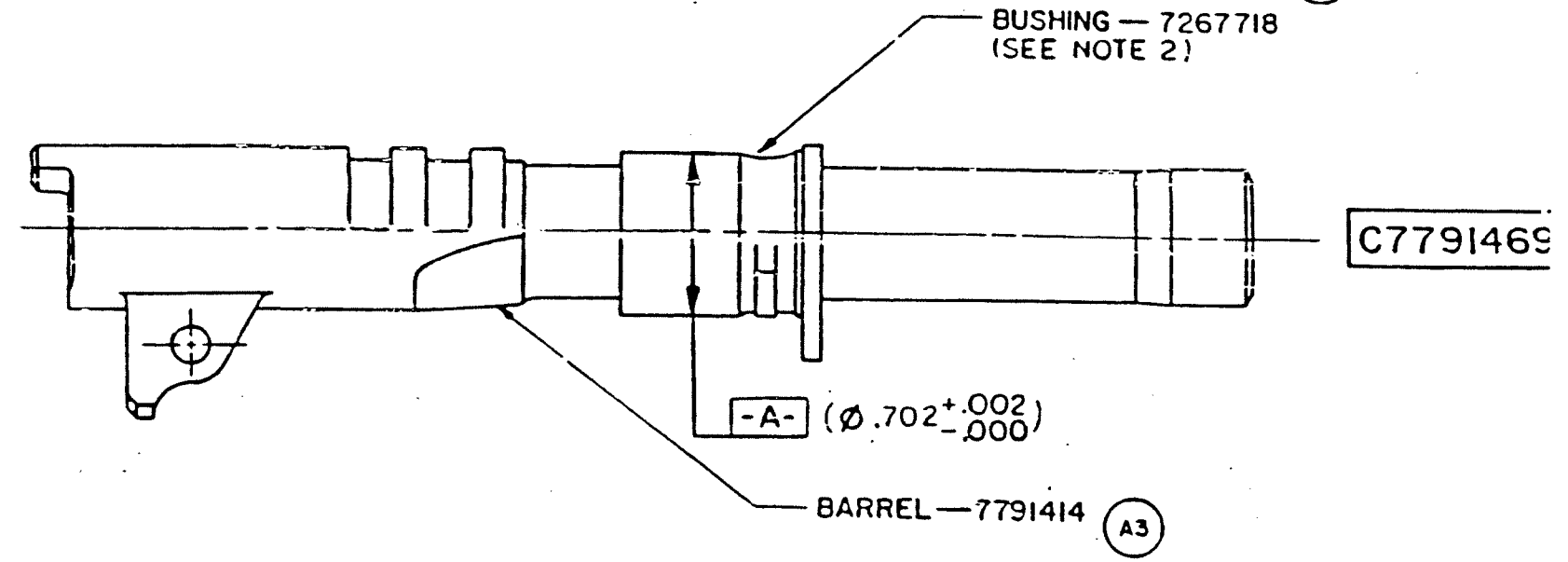
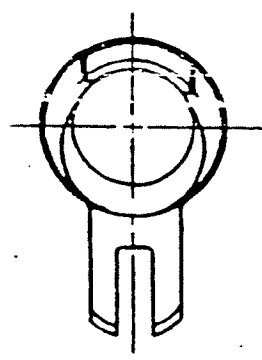
(A1)

53

2 REMOVE MATERIAL FROM INTERIOR OF BUSHING AS NECESSARY TO ACHIEVE A SLIDING FIT (.0002 TO .0005 CLEARANCE) WITH THE MUZZLE END OF THE BARREL. SURFACE FINISH ON THIS INTERNAL BEARING SURFACE SHALL NOT EXCEED 32/. BORE CREATED BY THIS OPERATION SHALL MEET THE FOLLOWING REQUIREMENTS:

○	.0005	
⊕	⊕ .001	A ○

3 MIL-W-13955 APPLIES



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

SEE PL-7791469 (3)

PART NO. 7791469

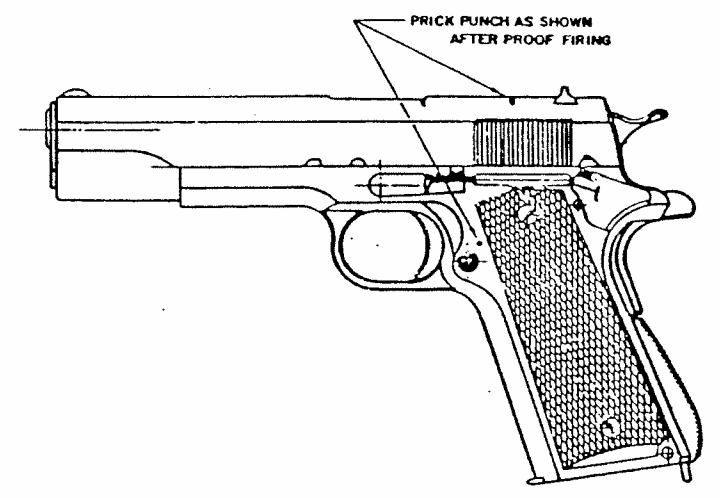
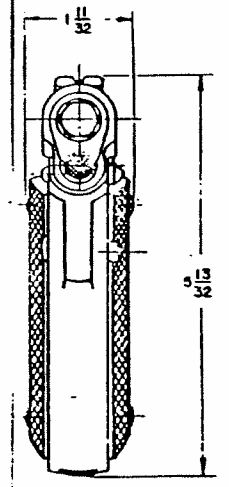
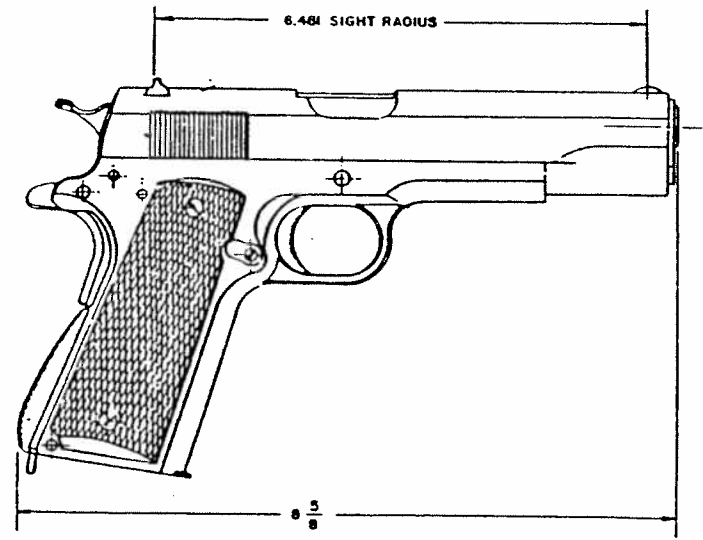
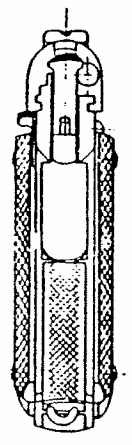
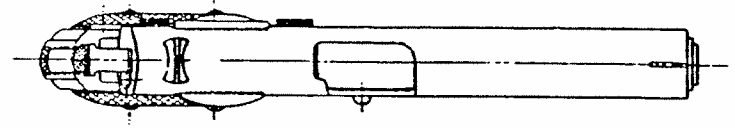
MECHANICAL PROPERTIES	F7791205	PISTOL:	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING	23 OCT 62	DEPT OF THE ARMY SPRINGFIELD ARMORY SPRINGFIELD, MASS		
YP		MISHAI NM	TOLERANCES ON DECIMALS ±	DRAFTER	<i>[Signature]</i>	BARREL AND BUSHING ASSEMBLY		
TS			FRACTIONS ±	CHECKER	<i>[Signature]</i>	CAGE CODE	DWG SIZE	7791469
EL 2			ANGLES ±	ENGINEER	<i>[Signature]</i>	19205	C	
RA			MATERIAL	ENGINEER	<i>[Signature]</i>	SCALE 2/1	UNIT WT .22 LB	SHEET 1 OF 1
BH		NEXT ASSY USED ON	HEAT TREATMENT	SUBMITTER	<i>[Signature]</i>			
RM		APPLICATION	FINAL PROTECTIVE FINISH	APPROVED BY ORDER OF THE CHIEF OF ORDNANCE	<i>[Signature]</i>			
		DO NOT APPLY PART NO						

ES:  
 PEC D-P-355 APPLIES.  
 HL-W-13855 APPLIES.  
 THE DIRECT PARTS CALLOUT ON SHEETS 2 & 3  
 DO NOT INCLUDE SUBASSEMBLY OR COMPONENT  
 NUMBERS. (B)

54

REV	DATE	BY	CHKD
A	DEC 20 1955	SA FARM	STONER
B	SEE EAR H Q R 10823	TE HIG	AW

F 7265655



F7265655

F

D

C

B

A

CODE IDENT NO. 19204  
 PART NO. 7265655

(A) SEE PL 7265655

PHYSICAL PROPERTIES		TOLERANCES UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF THIS DRAWING		PISTOL, AUTOMATIC, CAL. 45, M1911A1 (EXTERIOR VIEWS)	DEPT OF THE ARMY U.S. ARMY WEAPONS COMMAND ROCK ISLAND, ILL. 61201
PISTOL CAL 45		UNLESS OTHERWISE SPECIFIED		11 MAR 60			
A8410896 AUTO. M1911A1		MATERIAL		DRAWN BY		F 7265655	F
A8737905 W/HOLSTER		TREATMENT		CHECKED BY			
APPROVED BY		FINAL PROTECTIVE FINISH		SUBMITTED BY			
DO NOT APPLY PART NO.				APPROVED BY			