CASTING NOTES:

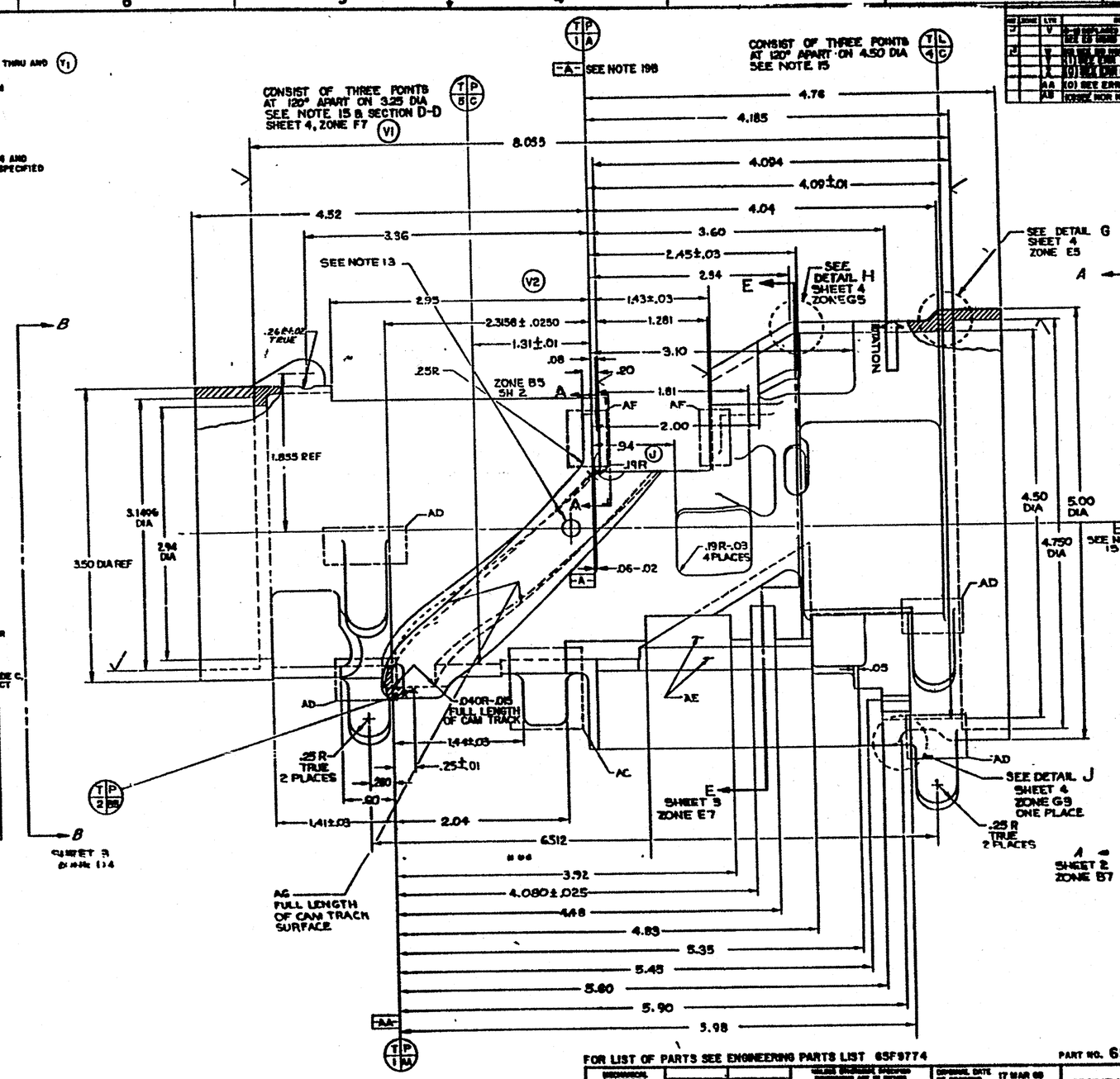
1. 290/ EXCEPT AS NOTED CASTING SHALL NOT BE SHOT BLASTED. (V3)
2. MATERIAL: STEEL, CRE, MIL-S-8858, EXCEPT OMIT PARA, 3.5.2 AND 4.2.2 THRU AND INCLUDING 4.2.2.4.3.COMP 1C-322A (TYPE 17-4PH). STAINLESS STEEL (T1)
3. HEAT TREATMENT: SOLUTION HEAT TREAT AND AGE TO THE FOLLOWING MINIMUM MECHANICAL PROPERTIES. QUALITY ASSURANCE PROVISIONS OF MIL-H-6875 SHALL APPLY:
   TENSILE STRENGTH ___ 150,000 PSI
   YIELD STRENGTH ___ 140,000 PSI
   ELONGATION _____ 12 % AT 4 X D
   HARDNESS ROCKWELL C36 TO 40
4. HEAT TREATMENT: SOLUTION HEAT TREAT LOCAL AREAS SPECIFIED ON SHEET 4 AND AGE ENTIRE CASTING TO ATTAIN ROCKWELL C42 MINIMUM FOR LOCAL AREAS SPECIFIED ONLY. SPECIFICATION MIL-S-12519 AND QUALITY ASSURANCE PROVISIONS OF MIL-H-6875 SHALL APPLY.
5. TWO PLACE DECIMAL DIMENSIONS HAVE A TOLERANCE OF ±.005 IN./IN. OR ± .015 WHICHEVER IS GREATER UNLESS OTHERWISE SPECIFIED.
6. CAST WALLS SHALL BE .125 ± .015 UNLESS OTHERWISE SPECIFIED.
7. CAST FILLETS SHALL BE .125 R ± .015 UNLESS OTHERWISE SPECIFIED.
8. CAST EDGES SHALL BE .03R MAXIMUM UNLESS OTHERWISE SPECIFIED.
9. ANGULAR DIMENSIONS HAVE A TOLERANCE OF ±0° 30' UNLESS OTHERWISE SPECIFIED.
10. ALL CAM DATA IS BASIC. A TOLERANCE VARIATION BETWEEN ANGLES PER CAM DATA SHALL NOT EXCEED ± .001.
11. TOOLING POINTS AND TOOLING LOCATIONS IDENTIFIED BY T/P 1/A, T/P 1/B, T/P 1/C, ETC., ARE THE PLANNED POINTS ON SURFACES FROM WHICH ALL OTHER POINTS OR SURFACES ARE TO BE CHECKED AND MACHINING OPERATIONS STARTED.
12. NEVER GATE WITHIN .38 DIAMETER OF TOOLING POINTS OR TOOLING LOCATIONS.
13. TWO HOLES, .190 MAXIMUM DIAMETER, OPTIONAL FOR TOOLING.
14. ON SURFACES INDICATED, PERMISSIBLE TO USE DRAFT ANGLE OF 1° MAXIMUM IN ADDITION TO GIVEN DIMENSIONS EXCEPT DO NOT DECREASE SECTION BELOW GIVEN TOLERANCE.
15. DATUM -C- IS DEFINED BY T/P 5/C AND T/L 4/C
16. THREE PLACE DECIMAL DIMENSIONS DEFINE THE MACHINED SURFACES ON THE FINISHED PART UNLESS OTHERWISE SPECIFIED. MACHINED SURFACES ARE DESIGNATED BY A FINISH SYMBOL (√) AND ALLOWANCE IS TO BE MADE FOR MACHINING.
17. ACTUAL CENTER OF REAR DWELL (SEE CAM DATA) MAY NOT COINCIDE WITH THE 0° CENTER LINE
18. CASTING CLASSIFICATION AND INSPECTION PER MIL-C-6021, CLASS 2A, GRADE C. AREAS DESIGNATED AB, AC, AD, ETC. ARE GRADED AS FOLLOWS BY DEFECT AS PER ASTM-E186 PLATES.

AREA	AB	AC	AD	AE	AF	AG	OTHER
GAS HOLES	5	5	5	6	6	5	6
SHRINKAGE CAVITY	1	3	2	2	1	1	3
SPONGE	4	5	4	4	4	4	4
DENDRITIC	4	4	4	4	4	4	4
FILAMENTARY	*NA	2	1	*NA	*NA	*NA	2
FOREIGN MATL (LESS DENSE)	4	4	4	5	4	4	6
FOREIGN MATL (MORE DENSE)	ACCORDING TO SPEC MIL-C-6021					NONE	ACC TO SPEC MIL-C-6021

*NONE ALLOWED.
ALL OTHER INDICATIONS LISTED ON TABLE OF MIL SPEC MIL-C-6021 NOT PERMITTED.

19. A. TOOL POINTS 1A AND 2A ARE ESTABLISHED BY DATUMS -C- AND -BB-. (SEE SHEET 4)
    B. -A- AND -B- ARE PLANES PERPENDICULAR TO -C- AND PASS THROUGH TOOL POINTS 1A AND 2A RESPECTIVELY
20. SEE SHEET 5 FOR MACHINING NOTES. (21 THRU 35)

36. REWORK PERMITTED ON HOUSING IN ACCORD W/DWG NO. A844801 AVAILABLE UPON REQUEST.
37. APPLY PART NO PER MIL-STD-130.



FOR LIST OF PARTS SEE ENGINEERING PARTS LIST 65F9774

PART NO. 65F9774

ORIGINAL DATE OF DRAWING	17 MAR 68
MATERIAL	SEE NOTE 2
HEAT TREATMENT	SEE NOTES 3 & 4
FINAL PROTECTIVE FINISH	
APPLICATION	GUN 7.62 MM M60-1 & M/A

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

HOUSING, GUN 7.62 MM (CASTING)

SIZE F | 19204 | 65F9774