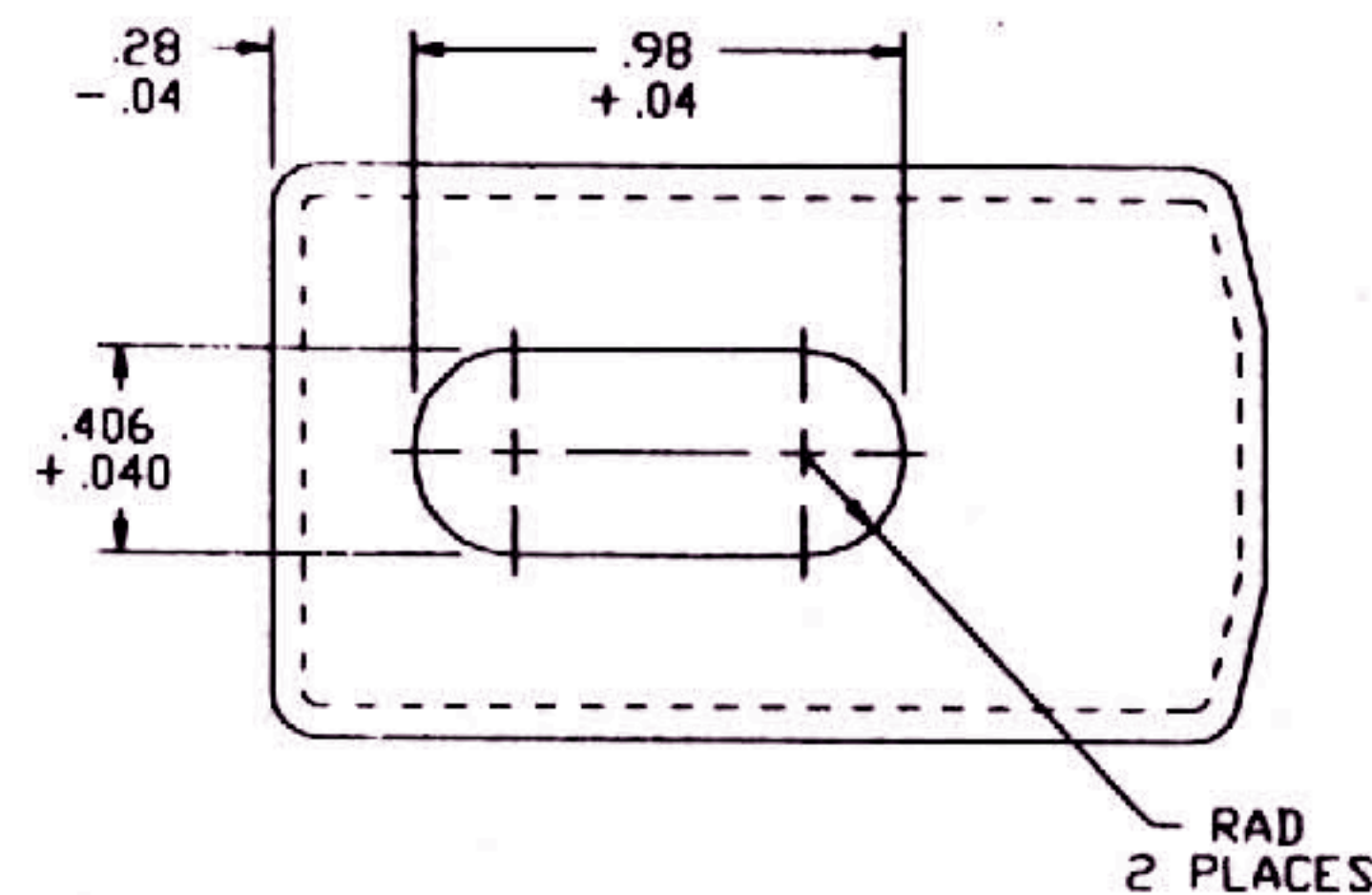
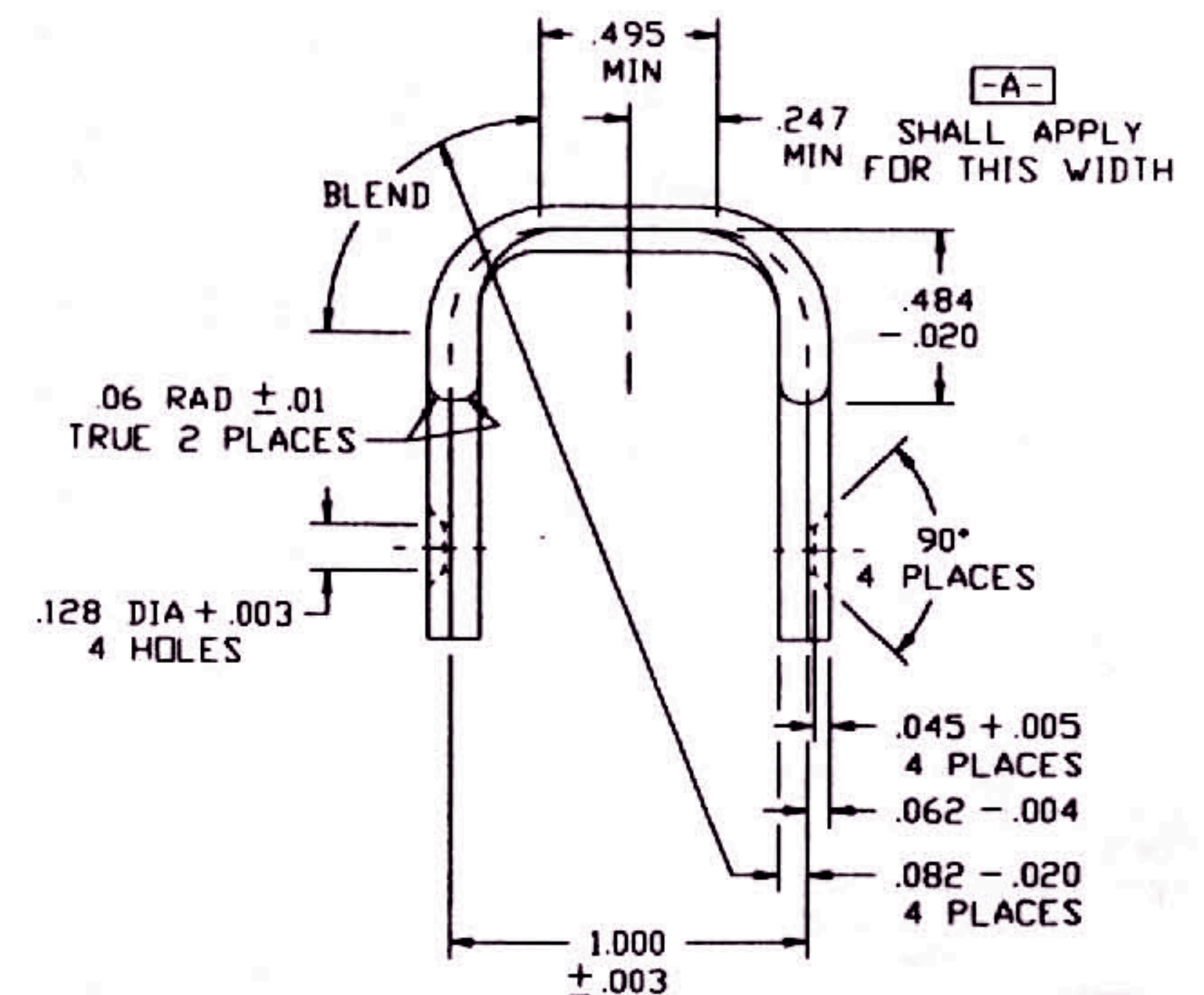
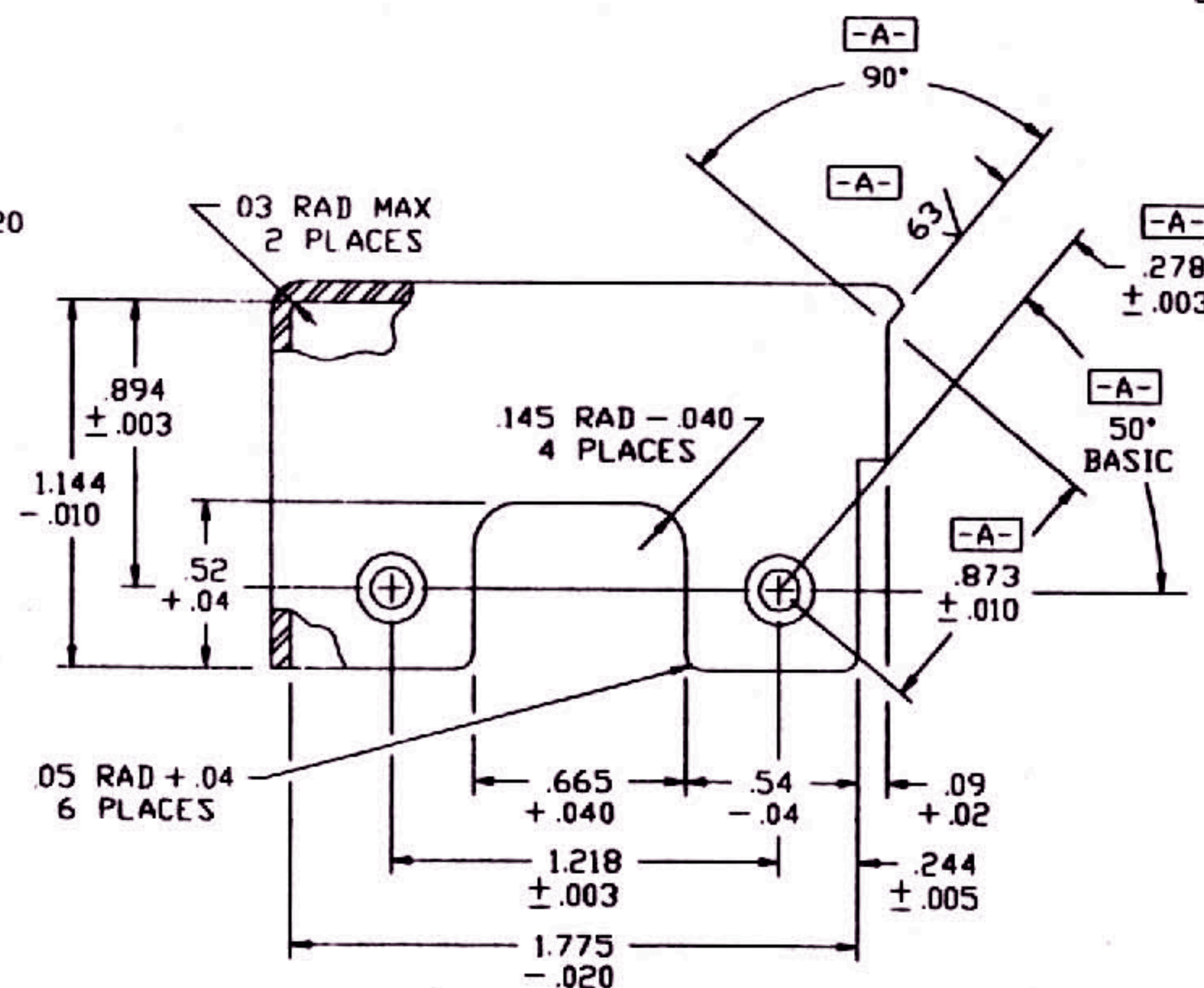
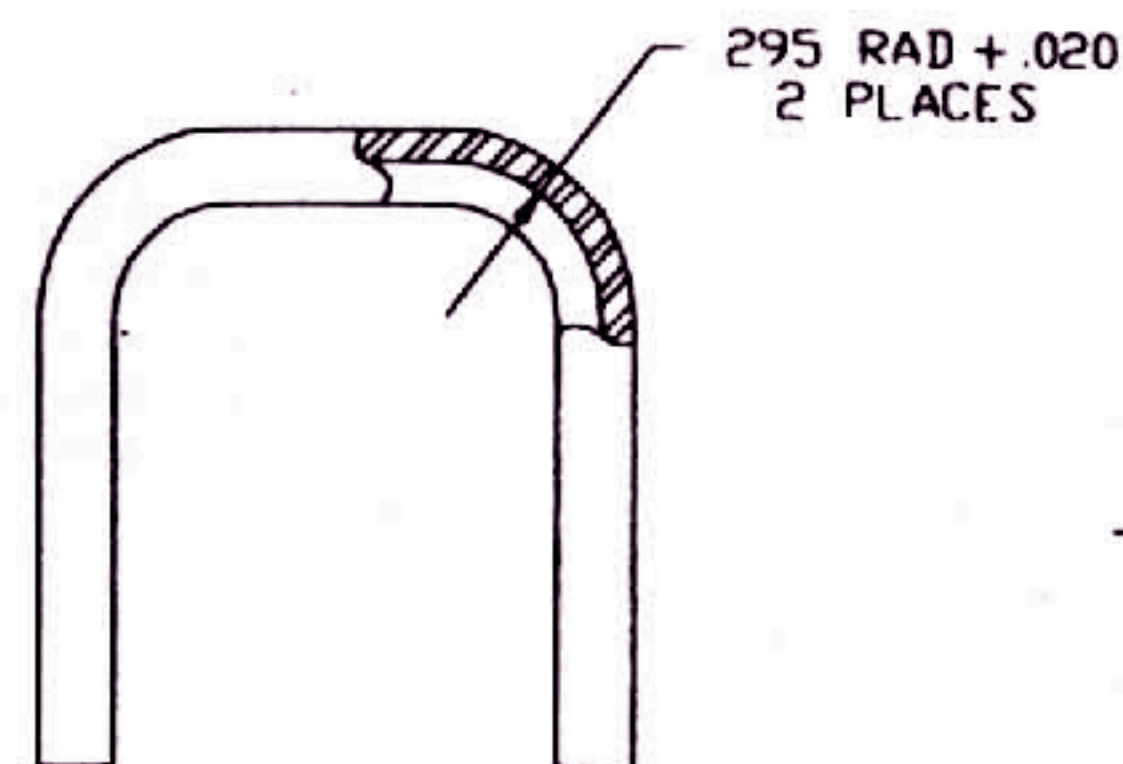




NOTES:

1. FINISH $\sqrt{125}$ EXCEPT AS NOTED. SHEARED SURFACES $\sqrt{250}$.
2. ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL - STEEL QQ-S-698 CARBON .17 TO .24, MANGANESE .30 TO .60 DRAWING QUALITY KILLED.
4. 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.
5. FILEHARD TEST IN ACCORDANCE WITH SA-STD-104. (H1)
6. FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171

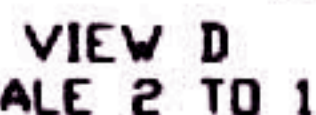
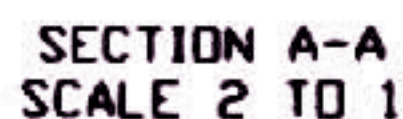
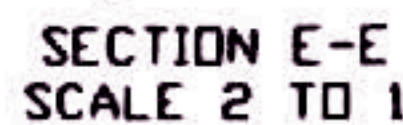


NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60D

CODE IDENT NO. 19205
 DRAWN FROM ORD PART NO. 7269252
 SPRINGFIELD ARMORY ORDNANCE CORPS
 DEPT OF THE ARMY
 SPRINGFIELD 1, MASS

SYM	DESCRIPTION
G	REDRAWN WITH CHANGE SEE EO NO. SA30116
H	(1) SEE EO HRD 82232

SCALE: 2 TO 1	MATERIAL: SEE NOTE 3	CKD.	TOLERANCES
DWN.	FINISH: SEE NOTE 1	DATE	DEC 2 PL ± .02 H H ± .51
TITLE: M60 BRIDGE, RECEIVER	REV.		DEC 3 PL ± .005 H H ± .127 ANGLES ± .5°
			NO.



NOTES:

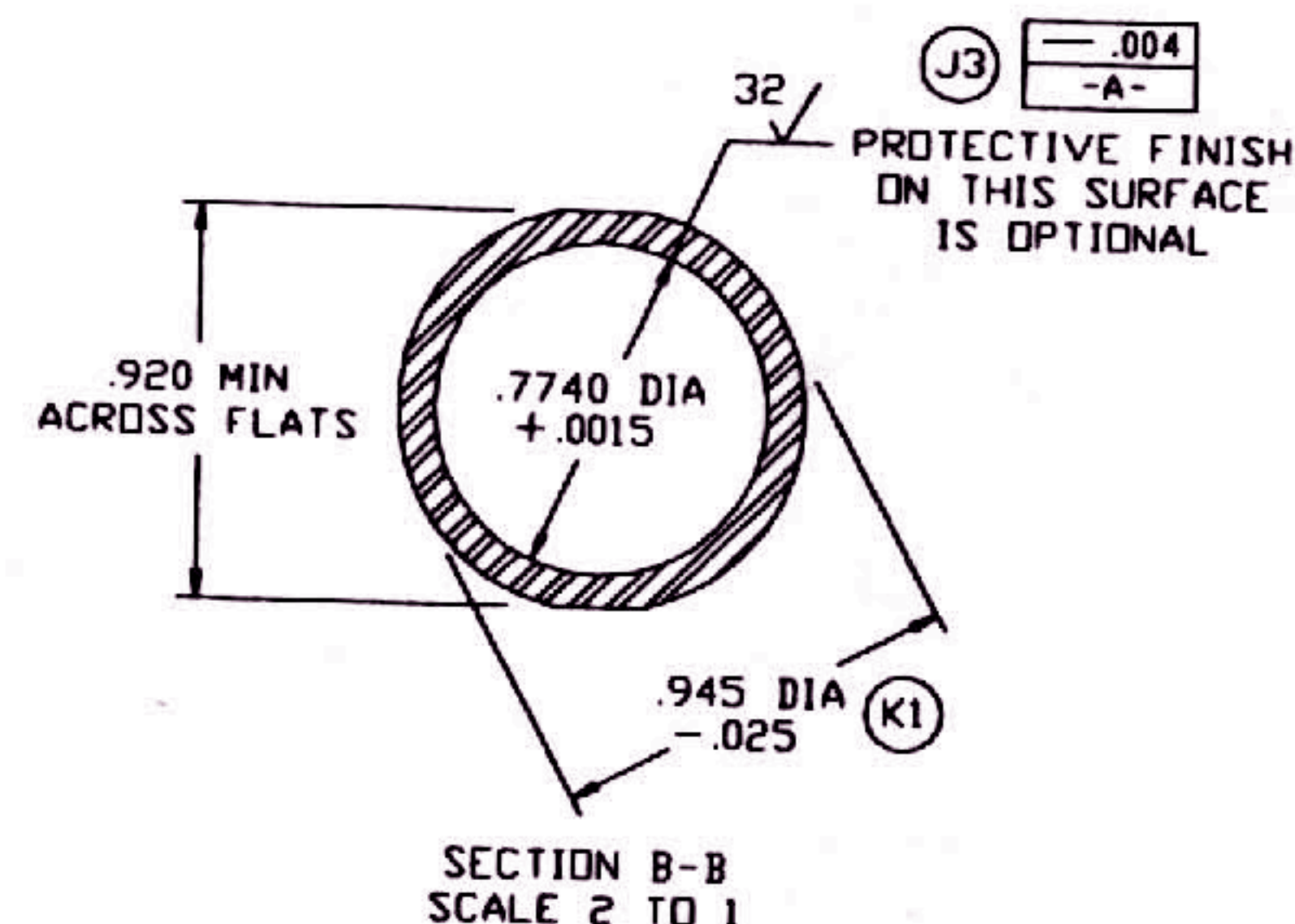
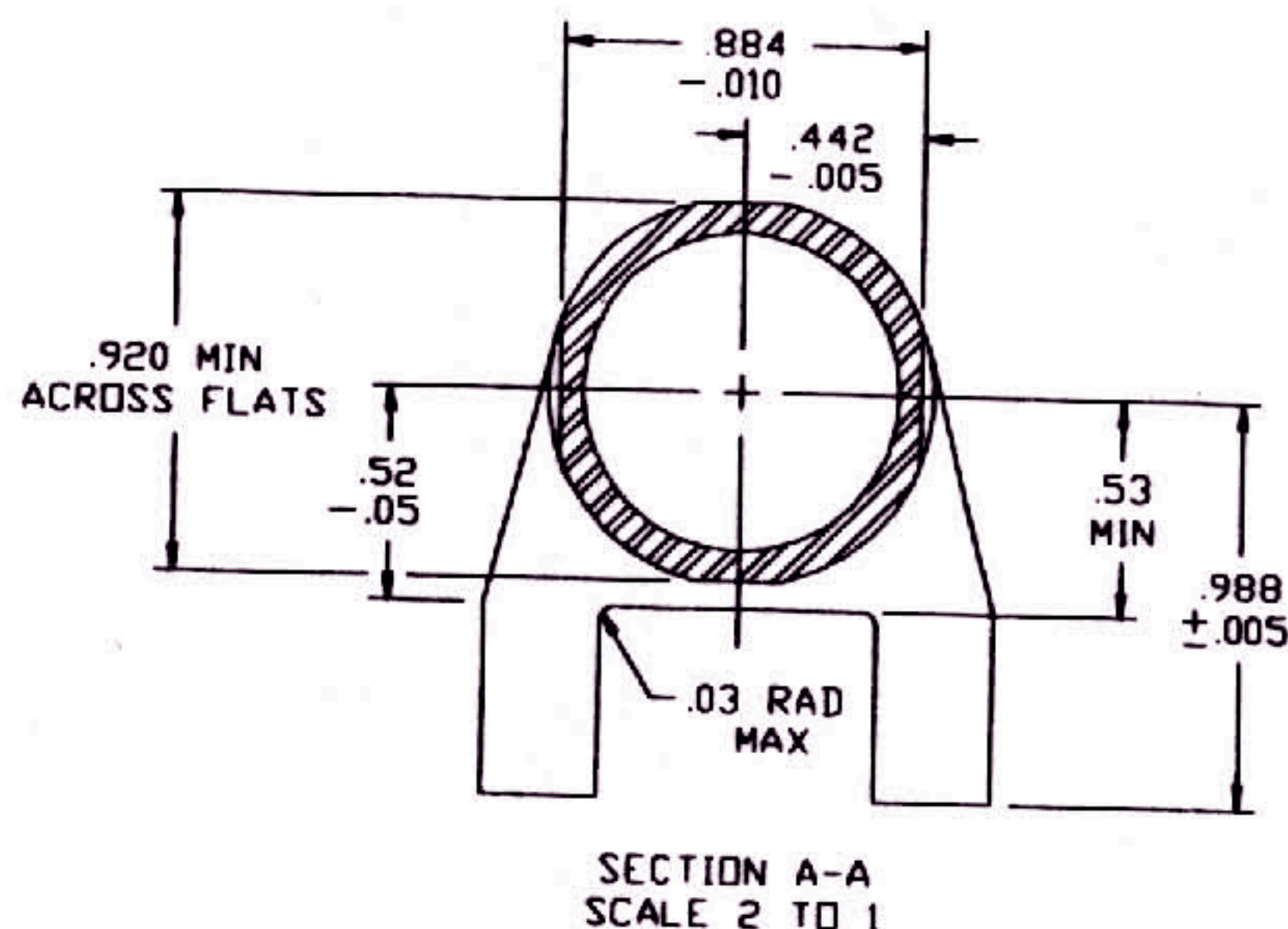
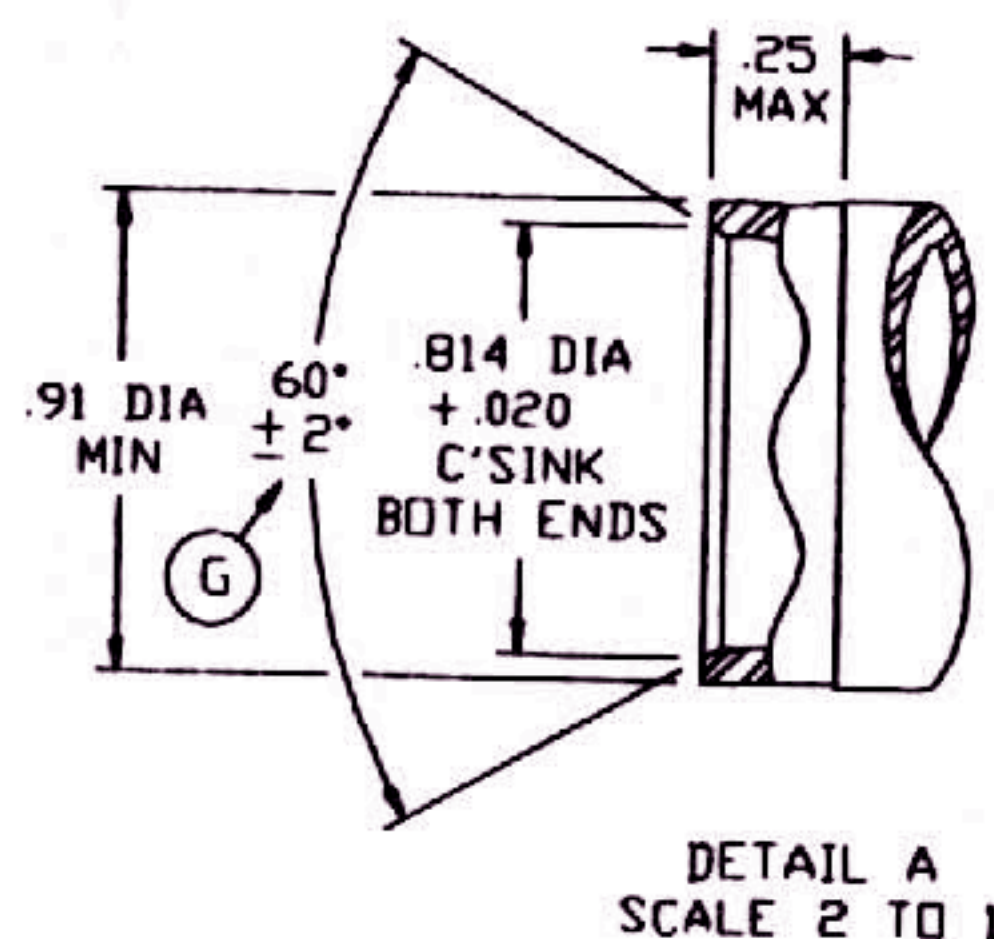
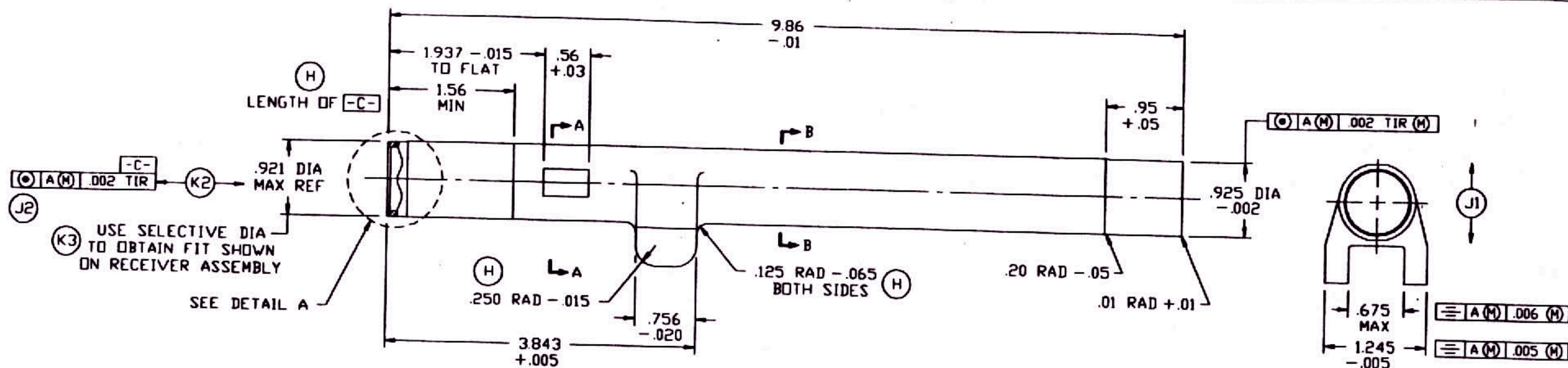
1. FINISH $\sqrt{125}$ EXCEPT SHEARED EDGES $\sqrt{250}$.
2. ALL EDGES SHALL BE BROKEN .005 +.010 UNLESS OTHERWISE SPECIFIED.
3. -B APPLIES WHEN -A IS MAINTAINED AT 1.00 DATUM.
4. HEAT TREATMENT- HEAT AT 1500° TO 1535°F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. TOTAL AND PARTIAL DECARBURIZATION, PERMISSIBLE TO .002 MAX.
5. SEE RECEIVER ASSEMBLY 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. (P1)
7. MATERIAL- STEEL QQ-S-777 1060 , 1065 , 1075.

N	(1-2) SEE EO HRD 02232
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P2

SCALE: FULL	MATERIAL: SEE NOTE 7	CKD.
DWN.	FINISH: SEE NOTE 1	DATE
TITLE: M60 CHANNEL, RECEIVER		REV.

NO



NOTES:

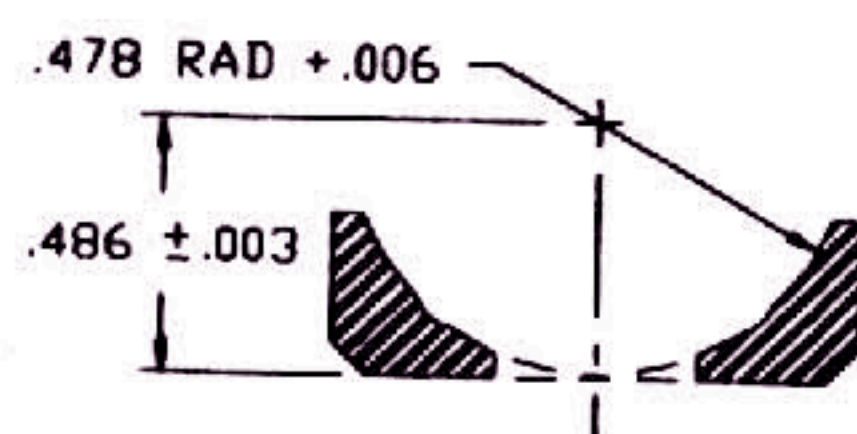
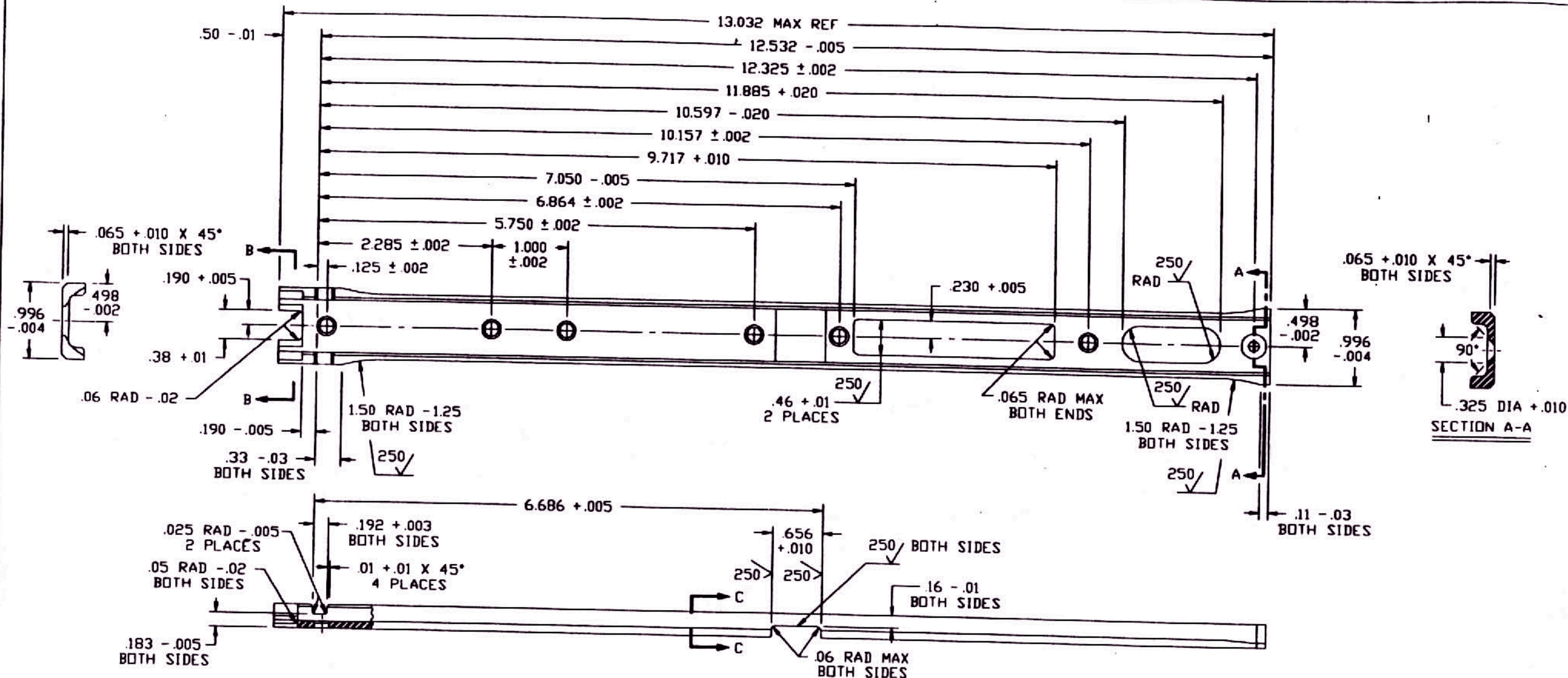
1. FINISH $125\sqrt{\text{EXCEPT AS NOTED. FORGED SURFACES } 250\sqrt{\text{ }}$
2. MATERIAL- STEEL, COMP 4140, SPEC QQ-S-624 (J5) OR COMP 1141, SPEC QQ-S-637, EXCEPT HOT FINISHED 1141 STEEL BARS FOR FORGING PURPOSES, AND ALL OTHER CONDITIONS OF SPECIFICATIONS ARE COMPLIED WITH. (L1)
3. HEAT TREATMENT- 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.
4. FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171

SYM	DESCRIPTION
E	
F	REDRAWN & REVISED SEE ED SA26085
G2	REF ED NO. SA27115
H5	REF ED NO. SA27297
J	(1-5) REF ED SA28042
K	(1-3) SEE ED SA29002
L	(1) SEE ED HRD 82370

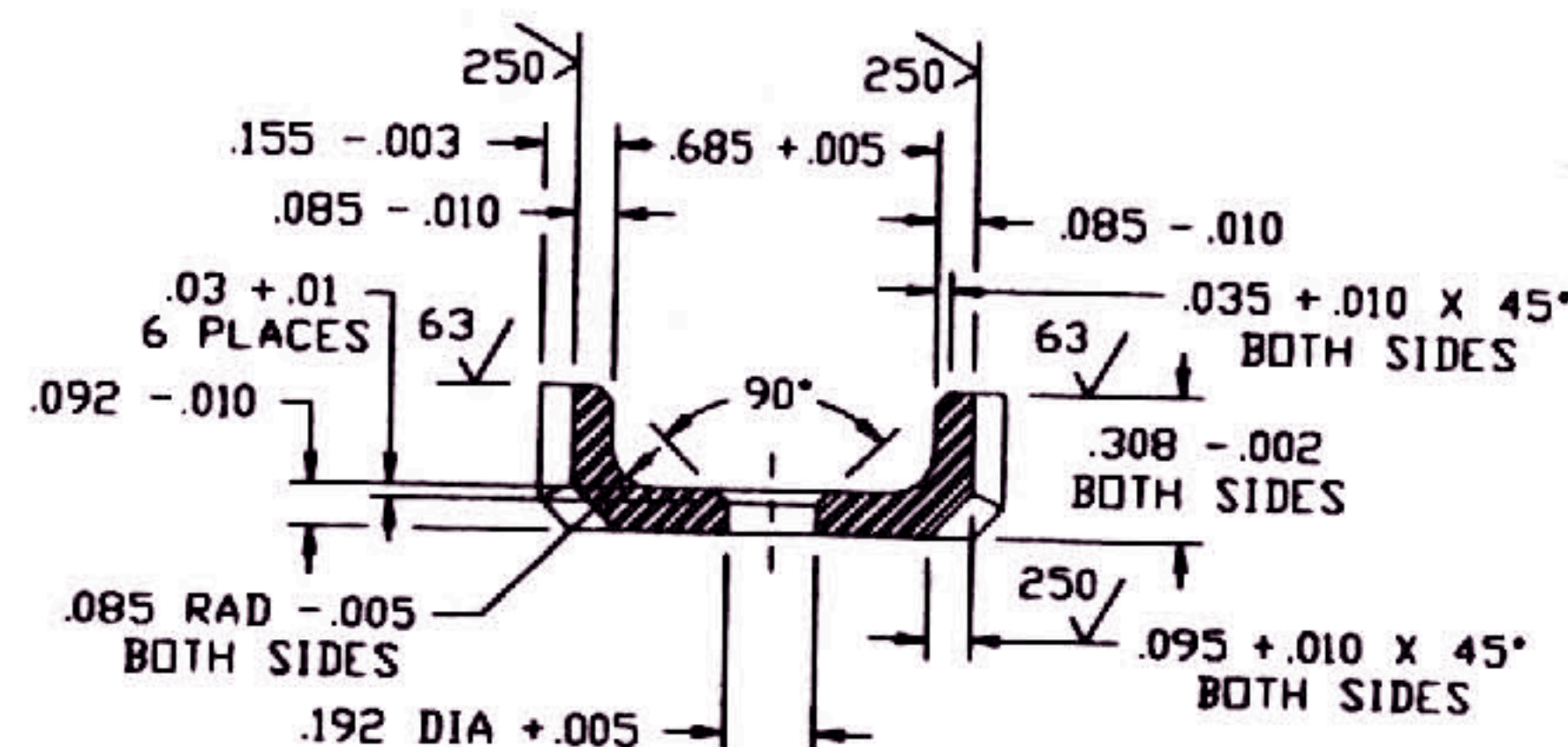
NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60C

CODE IDENT NO. 19205
DRAWN FROM ORD PART NO. 7269256 (H)
SPRINGFIELD ARMORY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1, MASS

SCALE: FULL	MATERIAL: SEE NOTE 2	CKD.	TOLERANCES
DWN.	FINISH: SEE NOTE 1	DATE	DEC 2 PL ± .02
TITLE: M60 GUIDE, OPERATING ROD	REV.		DEC 3 PL ± .005
			ANGLES ± 5°
			NO.



SECTION B-B
ROTATED 90° CW
SCALE 2 TO 1



SECTION C-C
SCALE 2 TO 1

NOTES:

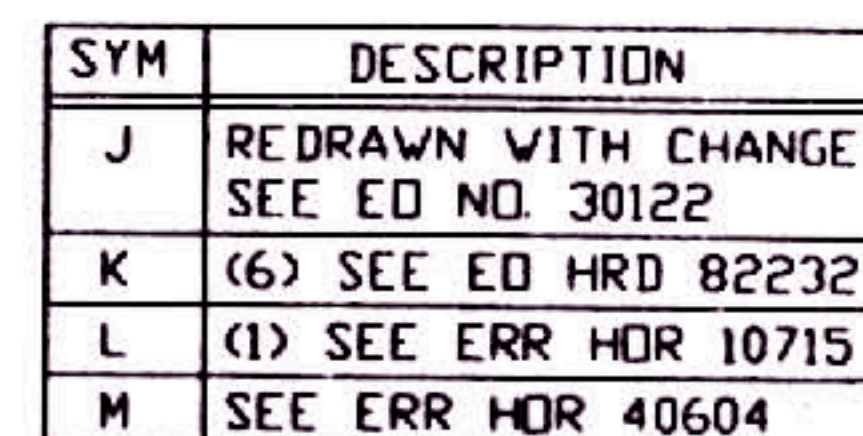
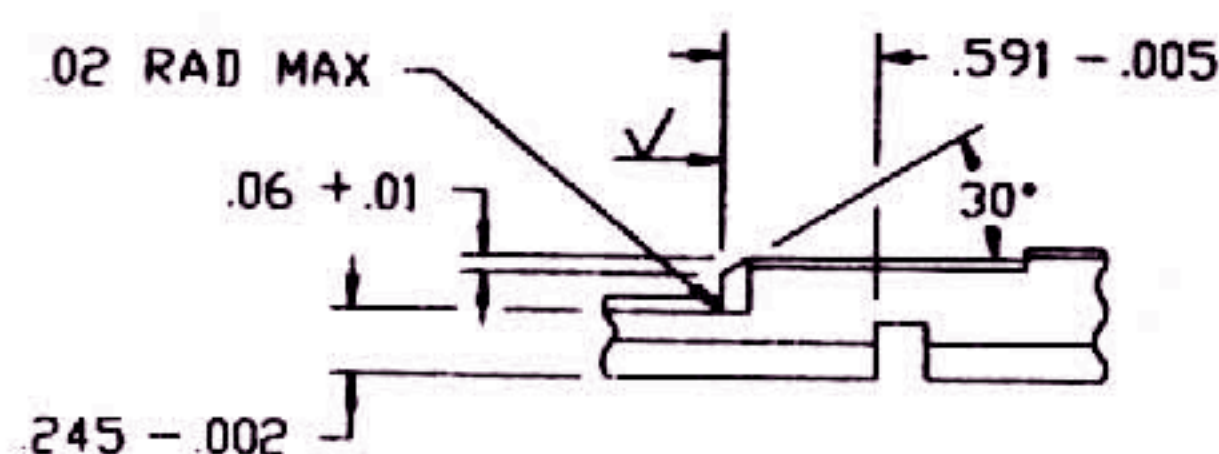
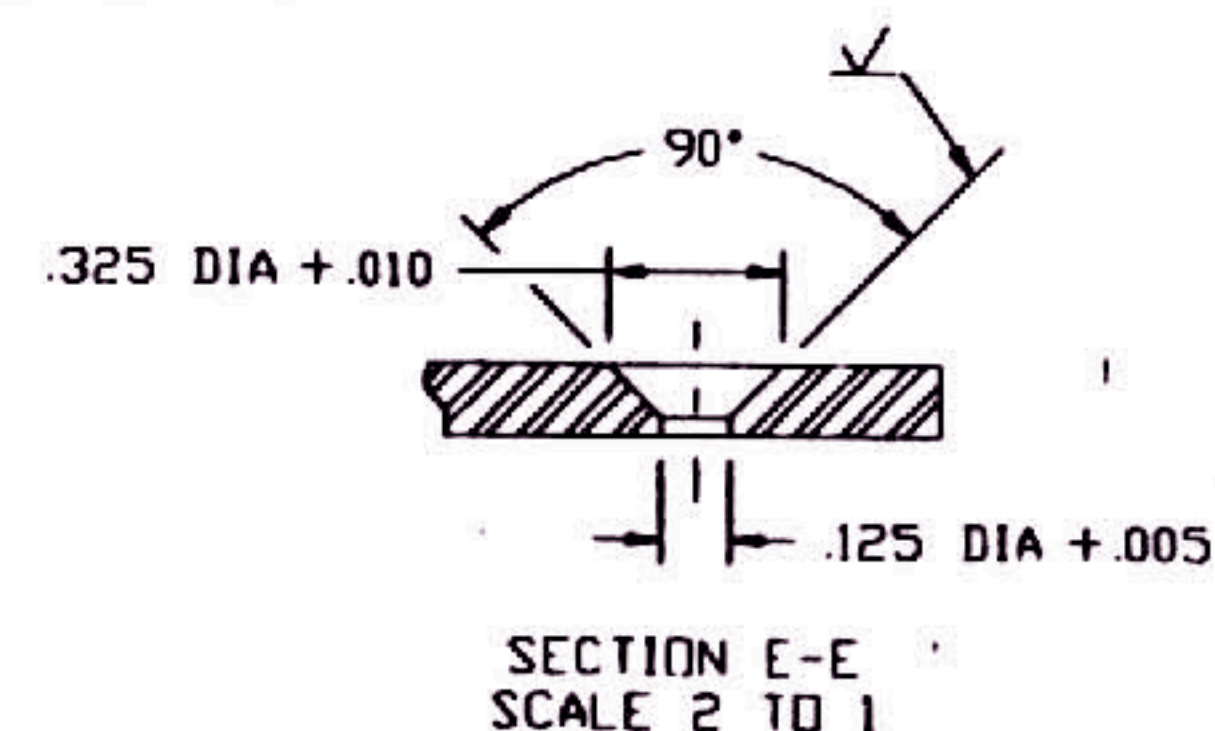
1. FINISH 125/ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .005 ± .010 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT- HEAT AT 1535° TO 1565° F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
4. HEAT TREAT BEFORE MACHINING.
5. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS AT THE COMPONENT LEVEL. (L1)
6. MATERIAL- STEEL QQ-S-624 4140, 8640, 8740.

NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60D

CODE IDENT NO. 19205
DRAWN FROM ORD PART NO. 7269259
SPRINGFIELD ARMORY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1, MASS

SYM	DESCRIPTION
K	REDRAWN WITH CHANGE SEE EO NO. SA30121
L	(1) SEE EO HRD 82232

SCALE: FULL	MATERIAL: SEE NOTE 6	CKD.	TOLERANCES DEC 2 PL $\pm .02$ M H $\pm .51$ DEC 3 PL $\pm .005$ M H $\pm .127$ ANGLES $\pm .5^{\circ}$
DWN.	FINISH: SEE NOTE 1	DATE	
TITLE: M60 RAIL , RECEIVER , LOWER		REV.	NO.



CODE IDENT NO. 19204
DRAWN FROM ORD PART NO. 7269258
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND, ILL

SCALE: FULL	MATERIAL: SEE SHEET 1	CKD.	TOLERANCES
DWN.	FINISH: SEE SHEET 1	DATE	DEC 2 PL $\pm .02$ M M $\pm .51$
TITLE: M60 RAIL, RECEIVER, LEFT HAND		REV.	DEC 3 PL $\pm .005$ M M $\pm .127$
			ANGLES $\pm 5^\circ$
			NO.

LIST OF PARTS SUPPLIERS

**wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722**

www.gunsnammo.com

**international military antiques , inc.
p.o.box 256 millington ,NJ 07946**

www.ima-usa.com

**inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110**

www.inter-ordnance.com

**sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980**

**jeffs shooters supply
p.o.box 1054 trussville , AL 35173**

**rpb industries
p.o.box 367 avondale est. GA 30002**