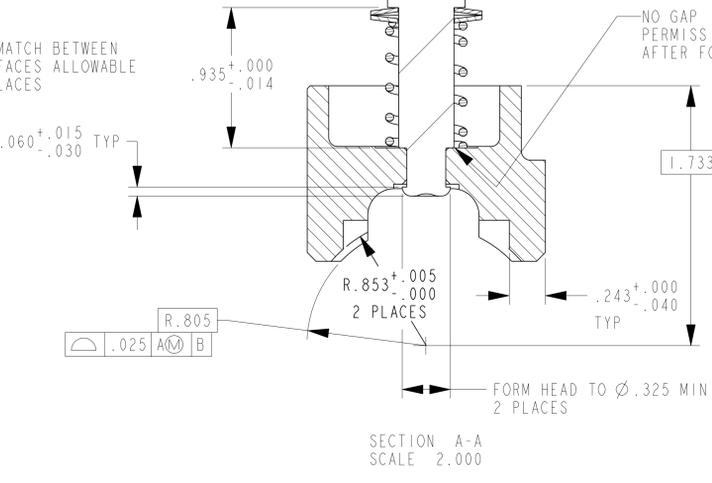
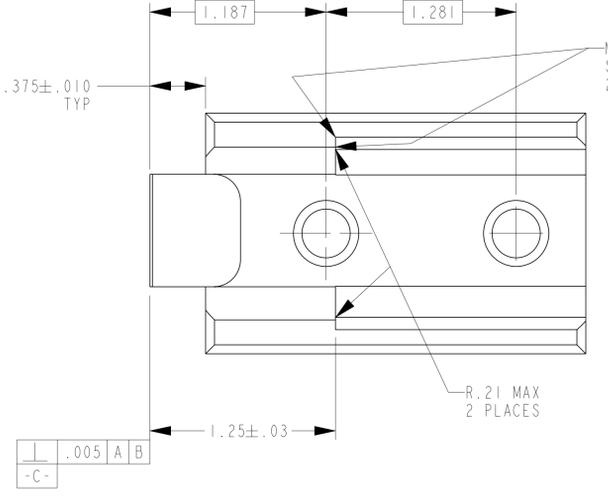
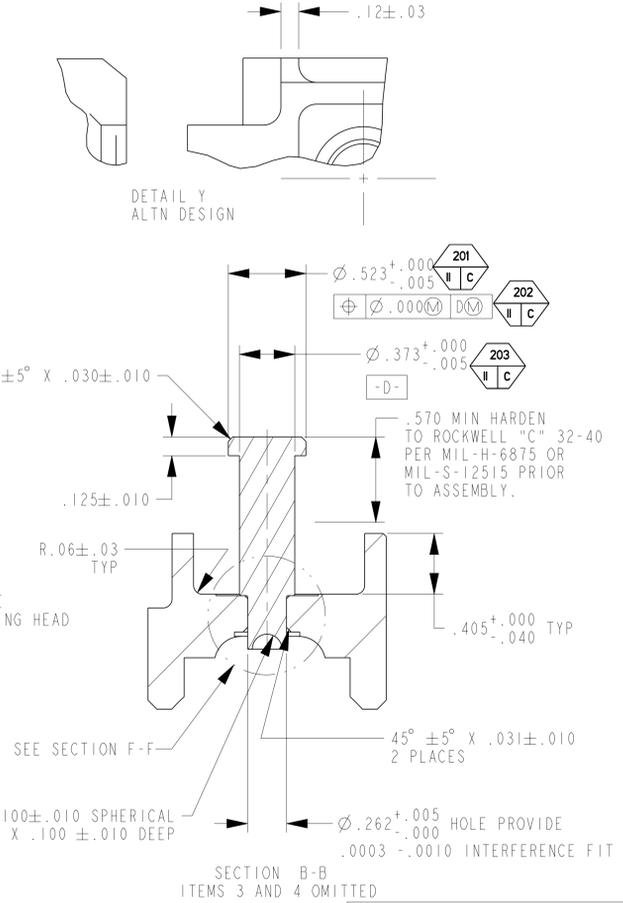
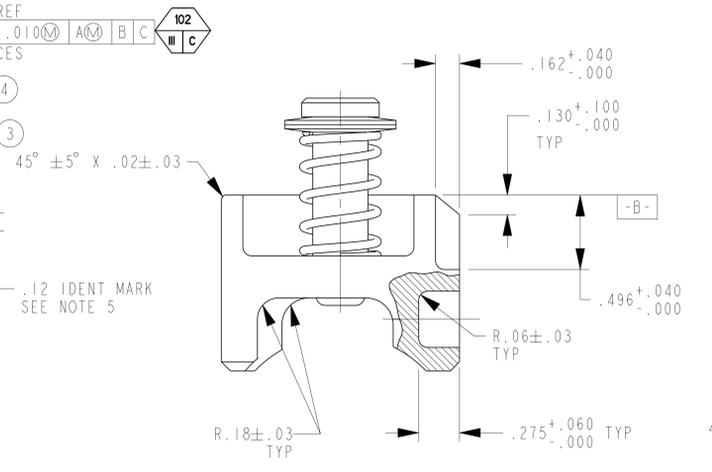
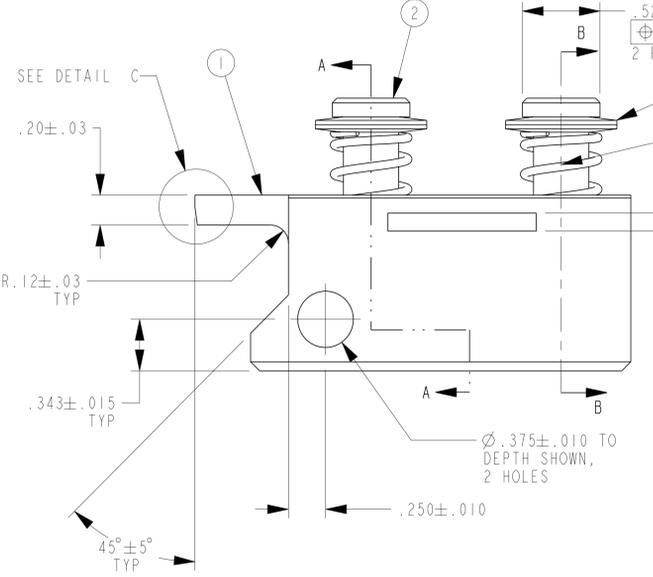
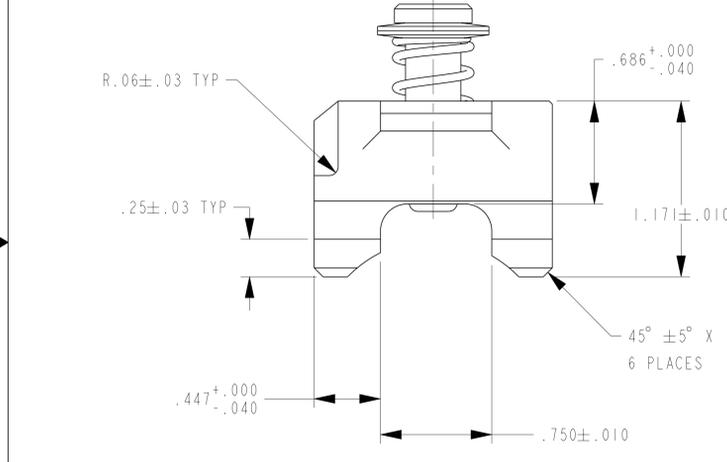
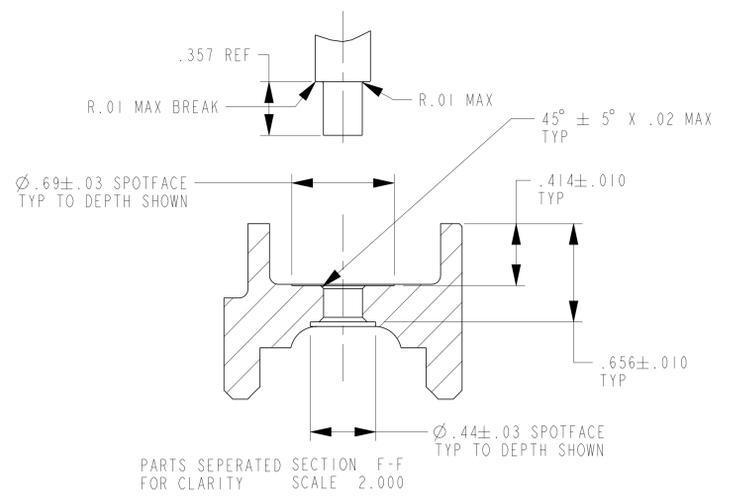
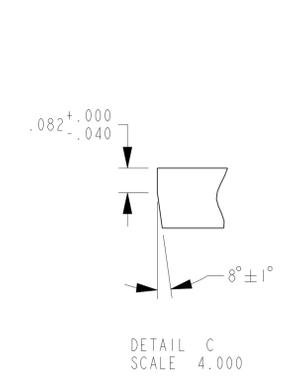
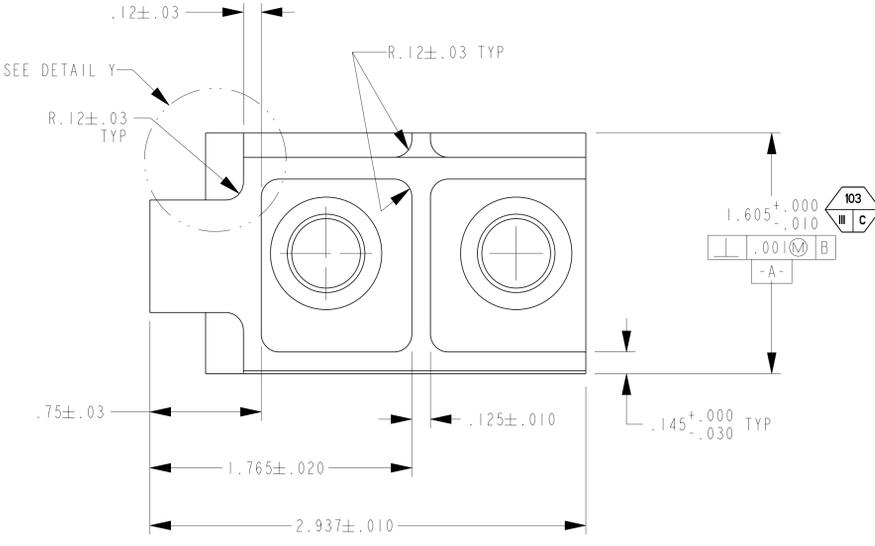


NOTES

- MIL-W-13855 AND ANSI Y14.5-1973 APPLY.
- MATERIAL: ITEMS 1 AND 2: STEEL 4130 THRU 4142 PER ASTM A322 OR A331. ALTN ITEM 1: INVESTMENT CASTING PER MIL-S-22141 COMP IC4130, IC4140. TENSILE TEST SHALL NOT APPLY. INSPECT CASTING PER MIL-STD-2175, CLASS 3, GRADE B.
- FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171. ITEMS 1 AND 2
- FINISH AS ROLLED OR CAST, CUT SURFACE FINISH SHALL BE 125/
- MARK "10001ASSY3269439" AND "MFR" FOLLOWED BY MANUFACTURER'S CAGE CODE PER MIL-STD-130 IN APPROXIMATE POSITION SHOWN.
- HEAT TREATMENT: ITEM 1: AUSTENITIZE, QUENCH, AND TEMPER PER MIL-H-6875 TO A HARDNESS OF 32-38 ROCKWELL "C".
- ALL FILLETS R.005 - .020 EXCEPT AS NOTED.
- AFTER FORMING OF HEAD THERE SHALL BE NO CLEARANCE WHICH WOULD ALLOW MOVEMENT BETWEEN MATING ITEMS 1 AND 2.
- QUALITY ASSURANCE PROVISION REQUIREMENTS PER DRAWING 12993884 APPLIES.
- REMOVE BURRS, BREAK SHARP EDGES .005-.020.



- 101 HARDNESS (BLOCK)
- 104 MISSING OR DEFECTIVE PROTECTIVE FINISH
- 106 HARDNESS (PIN)
- 107 INCOMPLETE OR IMPROPER ASSEMBLY
- 205 MISSING OR INCORRECT ID
- 206 WORKMANSHIP (PER MIL-W-63150)
- 301 STRESS AND HYDROGEN EMBRITTLEMENT RELIEF TEST, SHT 2
- 302 PROTECTIVE COATING SALT SPRAY TEST, SHT 2
- 303 SUPPLEMENTAL OIL TREATMENT SALT SPRAY TEST, SHT 2
- 304 MATING CONDITION BETWEEN PIN AND BODY, SHT 2
- 502 SALT SPRAY TEST
- 503 COATING WEIGHT

REVISIONS				
MODEL REV	DRAWING REV	DESCRIPTION	DATE(YEAR-MO-DA)	APPROVED
N/A	D	REPLACES REV C WITHOUT CHANGE	1989-09-18	ETM
N/A	E	NOR G954320 / 1989-09-01 (ECP G054423 / 1990-09-17)	1991-08-13	ETM
N/A	F	NOR L053019 / 2000-05-24	2000-06-30	RLV
N/A	G	NOR L152068 / 2001-10-11	2002-01-04	HJS
-	H	NOR L0453004 / 2004-02-20	2004-03-18	RLV

THIS DRAWING WAS GENERATED FROM A SOLID MODEL AND IS CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

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

REVISION STATUS OF SHEETS

H	H
SHT 1	SHT 2

PART NO. 3269439

ITEM NO.	QTY. REQ.	PART NO.	NOMENCLATURE	REMARKS
4	4	2680901	WASHER, SPRING	
3	2	MS24585-1404	SPRING	
2	2	3269439-2	PIN	
1	1	3269439-1	BODY	

PMIC		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	CONTRACT NUMBER	DESIGN ACTIVITY
MECHANICAL PROPERTIES		TOLERANCES ON ANGLES ± ° 2 PLACE DECIMALS ± 3 PLACE DECIMALS ±	CONTRACTOR	DEPARTMENT OF THE NAVY NAVAL SEA SYSTEMS COMMAND, WASHINGTON DC 20362
YP		THIRD ANGLE PROJECTION	DRAWN BY	BLOCK, ROUND POSITIONING
TS			DATE (YEAR-MO-DA)	
EL2	12997551		CHECKER	SIZE F
RA	3269400	MK19 GMG	ENGINEER	CAGE CODE 10001
BH	NEXT ASSY	USED ON	QUALITY ENGINEER	DWG NO. 3269439
RH				SCALE 2:1
		APPLICATION	DRAWING APPROVAL	UNIT WT.
			DESIGN APPROVAL	SHEET 1 OF 2

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

REVISIONS				
MODEL REV	DRAWING REV	DESCRIPTION	DATE/YEAR/MO-DA	APPROVED
-	H	NOR L04S3004 / 2004-02-20	2004-03-18	RLV

301 STRESS AND HYDROGEN EMBRITTLEMENT RELIEF TEST (PHOSPHATE). ADEQUACY OF THE STRESS AND HYDROGEN EMBRITTLEMENT RELIEF TREATMENT SHALL BE DEMONSTRATED ON A 120 DAY INTERVAL BY TESTING ONE (1) SPECIMEN IN ACCORDANCE WITH STM-1. THE SPECIMEN SHALL CONFORM TO MIL-DTL-16232. IF THE SPECIMEN FAILS, THE QUANTITY REPRESENTED SHALL BE REJECTED.

302 PHOSPHATE COATING SUPPLEMENTAL OIL TREATMENT SALT SPRAY TEST. TESTING SHALL BE ACCOMPLISHED ON A PER LOT BASIS OR PER SHIFT, I.E., AT LEAST ONCE EVERY EIGHT HOURS. FOUR (4) SPECIMENS, DISTRIBUTED RANDOMLY AND PROCESSED CONCURRENTLY WITH THE ITEMS, OR FOUR (4) ITEMS RANDOMLY SELECTED SHALL BE TESTED IN ACCORDANCE WITH STM-2. THE SPECIMENS SHALL CONFORM TO MIL-DTL-16232. IF ANY ITEM/SPECIMEN IN THE SAMPLE FAILS, THE QUANTITY REPRESENTED SHALL BE REJECTED.

303 SUPPLEMENTAL OIL TREATMENT SALT SPRAY TEST. TESTING SHALL BE ACCOMPLISHED AT THE TIME OF FIRST ARTICLE AND AT LEAST SEMI-MONTHLY DURING PRODUCTION. THREE (3) TEST PANELS FOR FIRST ARTICLE AND THREE TEST PANELS PER PROCESSING TANK OR DISPENSER USED DURING PRODUCTION SHALL BE PREPARED AND TESTED IN ACCORDANCE WITH STM-3. THE SPECIMENS SHALL CONFORM TO MIL-PRF-3150. IF ANY TEST PANEL IN THE SAMPLE FAILS, THE QUANTITY REPRESENTED SHALL BE REJECTED.

304 MATING CONDITION BETWEEN PIN AND BODY. TESTING SHALL BE ACCOMPLISHED AT THE TIME OF FIRST ARTICLE AND AFTER ANY MANUFACTURING PROCESS CHANGE, DEFINED AND UNDEFINED. FIVE (5) SPECIMENS SHALL BE TESTED IN ACCORDANCE WITH STM-4.

STM-1 STRESS AND HYDROGEN EMBRITTLEMENT RELIEF TEST (PHOSPHATE). THIS TEST SHALL BE CONDUCTED AT A FREQUENCY OF 120 DAYS MAXIMUM. THE COATED CYLINDRICAL TEST SPECIMEN SHALL BE MADE IN ACCORDANCE WITH MIL-DTL-16232 AND FIGURE 8 OF ASTM E8 USING 4340 STEEL OF RC 51-55 HARDNESS. THE SUSTAINED TENSILE LOAD (75% OF THE ULTIMATE TENSILE STRENGTH) SHALL BE DETERMINED FOR THE COATED SPECIMEN BY TESTING AND AVERAGING THE ULTIMATE TENSILE STRENGTH RESULTS FROM THREE (3) NOTCHED AND UNCOATED SPECIMENS FROM THE HEAT BATCH THAT THE COATED SPECIMEN WAS MADE. THE LENGTH OF THE TEST SHALL BE 200 HOURS. AFTER COMPLETION OF THE TEST, THE COATED SPECIMEN SHALL SHOW NO EVIDENCE OF CRACKS AS SPECIFIED IN MIL-DTL-16232.

STM-2 PROTECTIVE COATING (PHOSPHATE) SUPPLEMENTAL OIL TREATMENT SALT SPRAY TEST. THIS TEST SHALL BE CONDUCTED IN ACCORDANCE WITH MIL-DTL-16232 AND ASTM B117 AFTER APPLICATION OF SUPPLEMENTAL OIL TREATMENT.

STM-3 SUPPLEMENTAL OIL TREATMENT SALT SPRAY TEST. THIS TEST SHALL BE CONDUCTED IN ACCORDANCE WITH MIL-PRF-3150 AND ASTM B117.

STM-4 MATING CONDITION BETWEEN PIN AND BODY. THIS TEST SHALL BE CONDUCTED IN ACCORDANCE WITH FIRST ARTICLE PROVISIONS AND DRAWING NOTE 8.

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

PART NO. 3269439

DESIGN ACTIVITY DEPARTMENT OF THE NAVY
NAVAL SEA SYSTEMS COMMAND, WASHINGTON DC. 20362

BLOCK, ROUND
POSITIONING

SIZE F	CAGE CODE 10001	DWG NO. 3269439
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SCALE	UNIT WT.	SHEET 2 OF 2
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