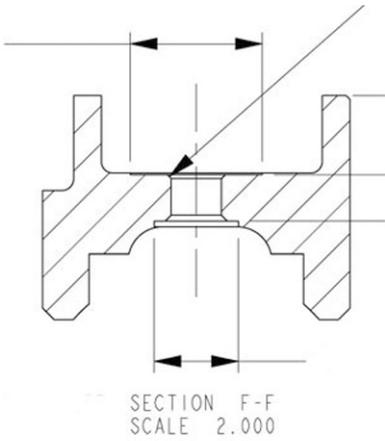
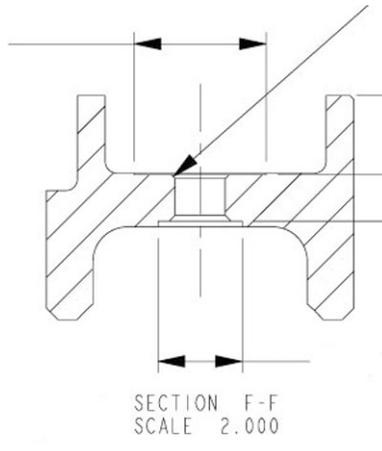
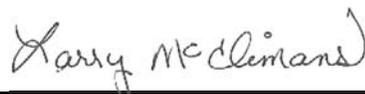


NOTICE OF REVISION (NOR) THIS REVISION DESCRIBED BELOW HAS BEEN AUTHORIZED FOR THE DOCUMENT LISTED		1. DATE (YYYYMMDD) 20040730	Form Approved OMB No. 0704-0188
<small>The public reporting burden for this collection of information is estimated to average 2 hours per response, including the time for reviewing instructions, searching existing data sources, gathering and maintaining the data needed, and completing and reviewing the collection of information. Send comments regarding this burden estimate or any other aspect of this collection of information, including suggestions for reducing the burden, to Department of Defense, Washington Headquarters Services, Directorate for Information Operations and Reports (0704-0188), 1215 Jefferson Davis Highway, Suite 1204, Arlington, VA 22202-4302. Respondents should be aware that notwithstanding any other provision of law, no person shall be subject to any penalty for failing to comply with a collection of information if it does not display a currently valid OMB control number. PLEASE DO NOT RETURN YOUR COMPLETED FORM TO THIS ADDRESS. RETURN COMPLETED FORM TO THE GOVERNMENT ISSUING CONTRACTING OFFICER FOR THE CONTRACT/PROCURING ACTIVITY NUMBER LISTED IN ITEM 2 OF THIS FORM.</small>		2. PROCURING ACTIVITY NO. L04S3051	3. DODAAC
		6. NOR NO. 001	8. DOCUMENT NO. F3269439
4. ORIGINATOR a. TYPED NAME (First, Middle Initial, Last) Bennie J. Boswell	b. ADDRESS (Street, City, State, Zip Code) ARDEC, AMSRD-AAR-AIC-F Rock Island, IL 61299-7300	5. CAGE CODE 19200	7. CAGE CODE 10001
9. TITLE OF DOCUMENT Round Positioning Block	10. REVISION LETTER a. CURRENT H	b. NEW J	11. ECP NO. L04S3051
12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIES Round Positioning Block for MK 19 Grenade Machine Gun	NOR SHT 1 of 4	ECP SHT 2 of 5	
13. DESCRIPTION OF REVISION <p>See NOR sheet 3 and 4 for attached drawing incorporating below changes. Drawing has been released into Inralink as a Work In Progress (WIP) drawing.</p> <p>In Zone 1E2: Change Section F-F pictorial view:</p> <div style="display: flex; justify-content: space-around; align-items: flex-end;"> <div style="text-align: center;"> <p>From:</p>  <p>SECTION F-F SCALE 2.000</p> </div> <div style="text-align: center;"> <p>To:</p>  <p>SECTION F-F SCALE 2.000</p> </div> </div>			
14. THIS SECTION FOR GOVERNMENT USE ONLY			
a. (X one)	<input checked="" type="checkbox"/>	(1) Existing document supplemented by this NOR may be used in manufacture. (2) Revised document must be received before manufacturer may incorporate this change. (3) Custodian of master document shall make above revision and furnish revised document.	
b. ACTIVITY AUTHORIZED TO APPROVE CHANGE FOR GOVERNMENT ARDEC, AMSRD-AAR-AIC-F		c. TYPED NAME (First, Middle Initial, Last)	
d. TITLE TIMOTHY D. KARCHER Comp Mgr (Actg), CM & Lifecycle Int Spt to Fielded Systems Div	e. SIGNATURE 		f. DATE SIGNED (YYYYMMDD) 5 August 2004
15.a. ACTIVITY ACCOMPLISHING REVISION	b. REVISION COMPLETED (SIGNATURE)		c. DATE SIGNED (YYYYMMDD)

NOTICE OF REVISION (NOR)

Continuation Sheet

NOR CONTINUATION SHEET 2 OF 4

ORIGINATOR NAME AND ADDRESS

ARDEC, AMSRD-AAR-AIC-F
Rock Island, IL 61299-7300

CAGE CODE

19200

DATE

20040730

NOR NO. 001

PAN

DOCUMENT NO.

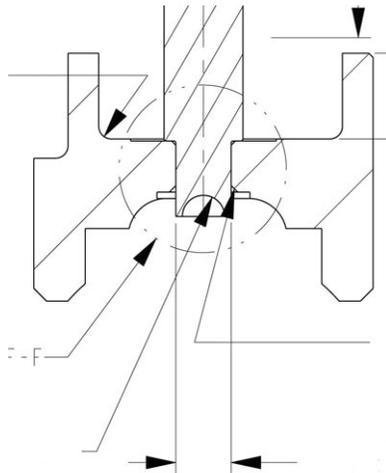
L04S3051 - F3269439

ECP NO.
L04S3051

Drawing 3269439, sheet 1, Cont:

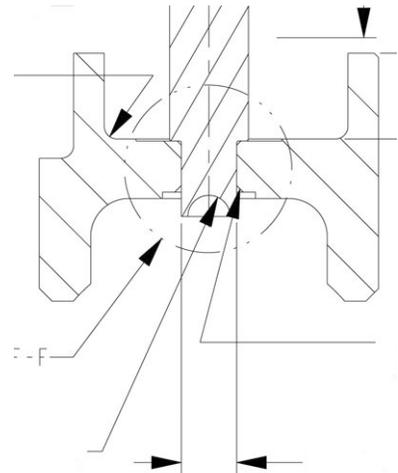
In Zone 1B2, Change Section B-B pictorial view:

From:



SECTION B-B
ITEMS 3 AND 4 OMITTED

To:



SECTION B-B
ITEMS 3 AND 4 OMITTED

Note to Bldg 12. The following changes have not been incorporated into the WIP drawing in Interlink and must be incorporated before product release:

In Zone B2: change call out:

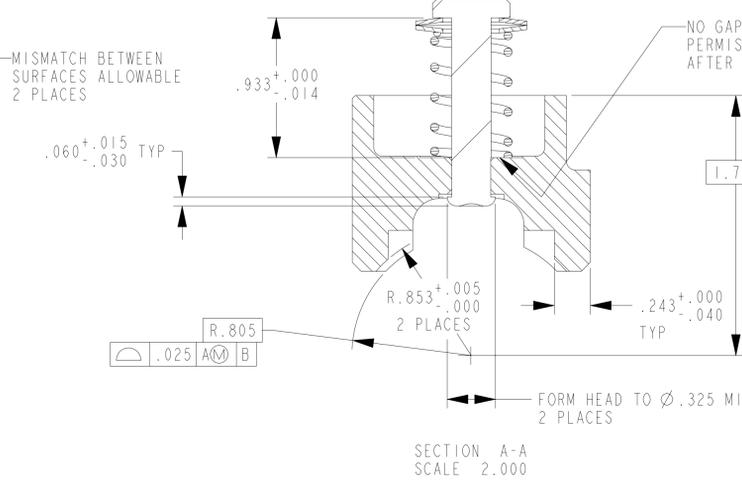
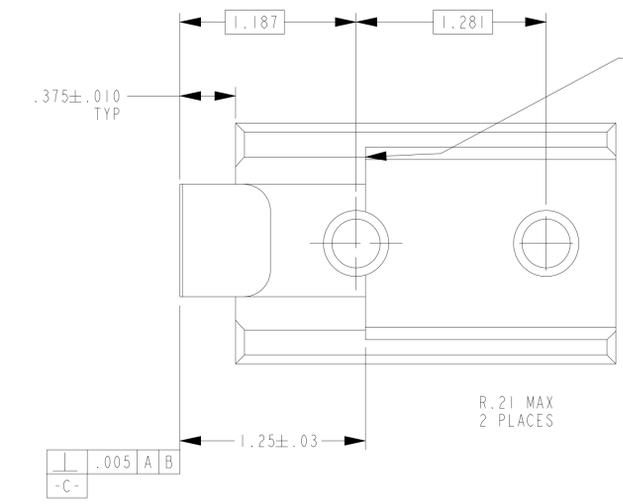
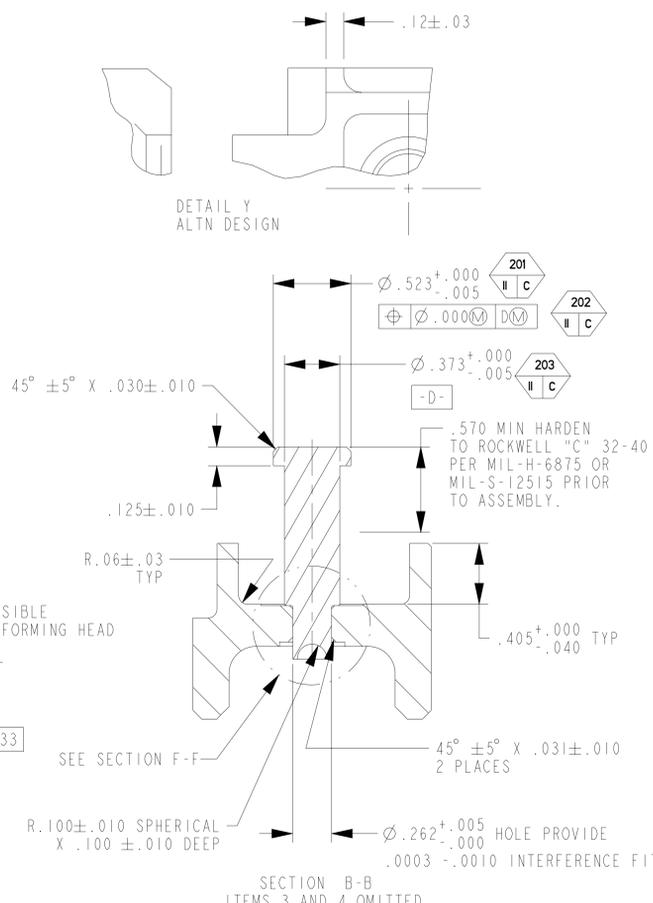
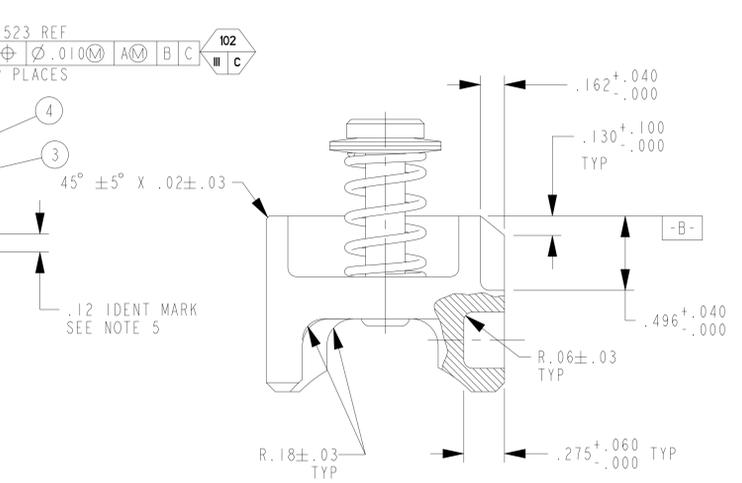
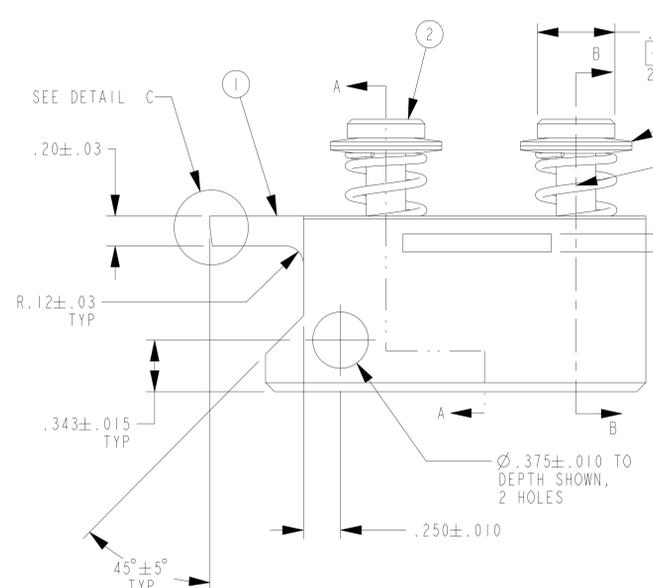
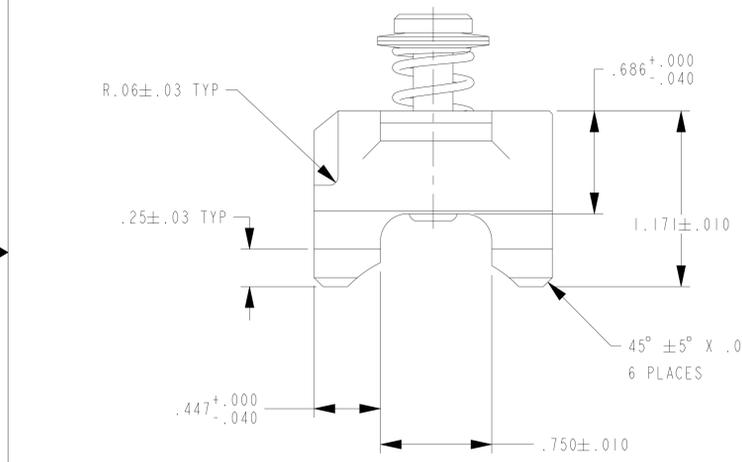
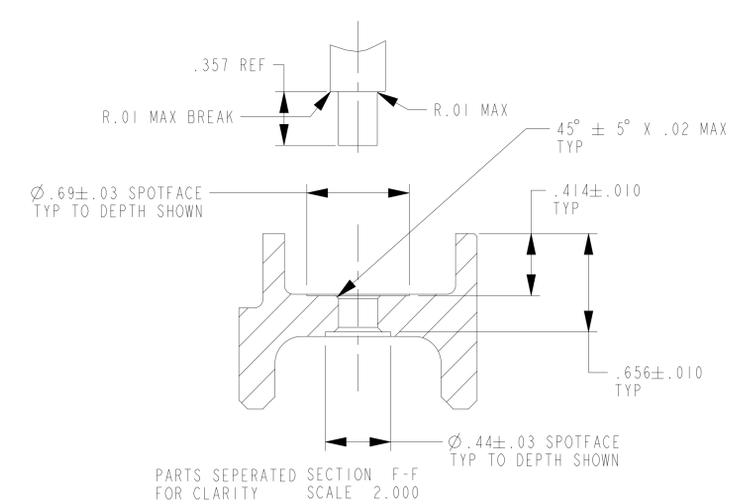
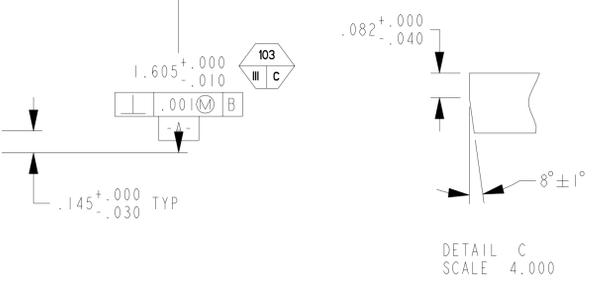
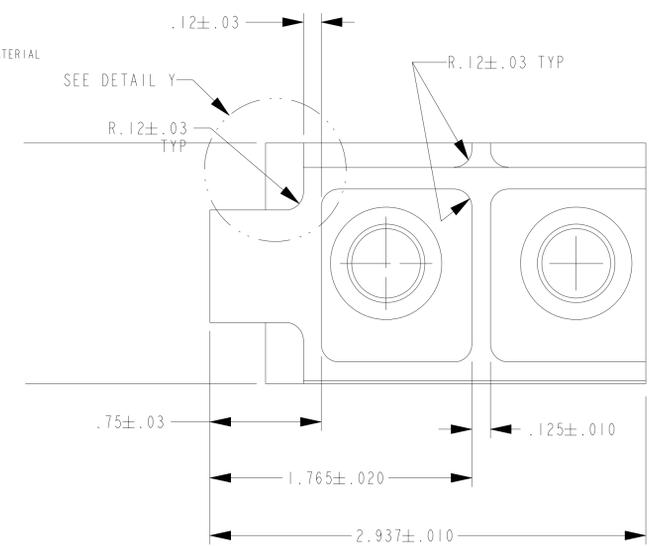
From: SEE SECTION F-F To: SEE DETAIL F

In Zone D2: change call out:

From: SECTION F-F To: DETAIL F

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

NOR CONTINUATION SHEET 3 OF 4
 NOR 001, DRAWING SHEET 1
 PROPOSED REVISION
Thom B. Smith 2004-07-30

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	

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
A	J	NOR L0453031 / 2004-06-01	2004-07-28	RLV

J	J
SHT 1	SHT 2

CURRENT DESIGN ACTIVITY CAGE CODE 19200
 U.S. ARMY
 ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
 PICATINNY ARSENAL, NEW JERSEY 07806-5000
PART NO. 3269439

PMIC		DO NOT SCALE DRAWING		CONTRACT NUMBER		DESIGN ACTIVITY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		TOLERANCES ON ANGLES ± °		DRAWN BY: KREIDER		DATE (YEAR-MO-DA): 1983-07-27	
THIRD ANGLE PROJECTION		TOLERANCES ON ANGLES ± °		CHECKER: B. BOSWELL		ENGINEER: R.E. SMITH	
FORM HEAD TO Ø.325 MIN 2 PLACES		TOLERANCES ON ANGLES ± °		DRAWING APPROVAL: W. SONGALIA		DATE: 2004-02-20	
APPLICATION		MATERIAL: MK19 GMG		DESIGN APPROVAL: R. ELBE		DATE: 2004-02-20	
MECHANICAL PROPERTIES		NEXT ASSY USED ON		SCALE: 2:1		UNIT WT.	
Y.P. EL2		MATERIAL ENGR		MODELED BY: J. KREIDER		SHEET 1 OF 2	
TS		MODELED BY		CONTRACTOR		BLOCK, ROUND POSITIONING	
RA		MATERIAL ENGR		DESIGN APPROVAL		CAGE CODE: 10001	
BH		MATERIAL ENGR		DESIGN APPROVAL		DWG NO.: 3269439	
RH		MATERIAL ENGR		DESIGN APPROVAL		CAGE CODE: 10001	

REVISIONS				
MODEL REV	DRAWING REV	DESCRIPTION	DATE/YEAR-MO-DA	APPROVED
A	J	NOR L04S3031 / 2004-06-01	2004-07-28	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.

NOR CONTINUATION SHEET 4 OF 4
 NOR 001, DRAWING SHEET 2
 PROPOSED REVISION
Baron B. Powell 2004-07-30

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
 PISCATAWAY 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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