

**SCOPE OF WORK
INACTIVATION OF M1 RIFLES
TO RIFLE DUMMY DRILL FOR ROTC
NSN: 1005-01-113-3767**

1. Remove stock and handguards.
2. Visual inspection:

Rifles must be complete.
3. Metal components:
 - a. Cracks or breaks on the inside bridge of the receiver is acceptable. Any other cracks, breaks and deformations will not be accepted.
 - b. Dents and gouges that do not interfere with functioning of weapons or life expectancy of component will be accepted.
 - c. Surface finishes such as varnish or lacquer will be accepted.
4. Remove firing pin and close firing pin hole in face of bolt by welding.
5. Weld Barrel to the receiver utilizing high heat range carbide impregnated welding rod. The length of weld will be minimum of one inch.
6. Insert of steel rod (drill rod) .296 or .300 inches in diameter and 4 inches long into the barrel through the chamber end allowing a portion of the rod to extend into the chamber to prevent introduction of a cartridge.
7. Using either an acetylene torch or an arc welder (cutting electrode), burn through the upper portion of the barrel directly above and partially into the steel segment. This is approximately one and one half inches forward of the receiver. Apply weld in this cavity. This assures positive retention of the segment of the barrel. No further filing of the cavity is required. If necessary, grind off any excess material (splatter, runoff) to assure positive assembly of the stock and handguards.
8. Place barrel sight down in vise, center punch gas cylinder and lock on junction of these two part end drill 3/16 inch hole deep enough to weld the gas cylinder, lock and lock screw into one unit. (Use low hydrogen electrodes such as 7013 – 1/8-inch diameter).
9. The Contractor will hold weapons meeting above requirements for issue to customers.

10. Weapons and parts not meeting above requirements will be made available to the Civilian Marksmanship Program (CMP) for disposition.

11. Packaging will be Level C Commercial. Quantities being shipped will vary.