

J	ERR Z9Z1241D (ECP W6S2003 86-04-10)	90-02-20	DAY
K	ERR Z9Z1285AL (ECP G9S2092,89-10-27)	90-09-28	

NOTES:

- HEAT TREATMENT: STRESS RELIEVE AT 435° ± 10°F FOR 30 MINUTES AFTER FORMING.
- FINAL PROTECTIVE FINISH: FINISH 3.3.1 OF MIL-STD-171 WITH MIL-L-3150 SUPPLEMENTARY OIL TREATMENT.
- HOLE DIA INTO WHICH SPRING FITS FREELY. .352 MIN.
- ROD DIA OVER WHICH SPRING SLIDES FREELY. .161 MAX.
- DO NOT COMPRESS SPRING SOLID. NOTE 6 APPLIES.

6. MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE B, EXCEPT THAT:
- PARAGRAPH 4.4.4.1 (PROCEDURE FOR REMOVING SET) SHALL NOT APPLY. PARAGRAPH 4.4.4 (LOAD TEST) SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED TO A HEIGHT OF .340 FIVE (5) TIMES.
 - PARAGRAPH 3.5.5 (SQUARENESS OF ENDS) SHALL NOT APPLY. SQUARED AND GROUND ENDS SHALL BE SQUARE WITH THE SPRING AXIS WITHIN 3°

7. ALL SPRINGS SHALL BE COMPRESSED TO A HEIGHT OF .340 FIVE (5) TIMES.

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
A	REDRAWN WITH CHANGE SEE EO SA 29355	17 FEB 67	<i>P. Hillman</i>
B	(1-4) SEE EO-82044	21 FEB 68	<i>P. Hillman</i>
C	SEE EO HQRD 00175	4 AUG 70	<i>W. Hillman</i>
D	(1) SEE ERR HQR 20008-1	14 JAN 72	<i>J. Hillman</i>
E	SEE ERR HQR 40639	18 FEB 75	<i>W. Hillman</i>
F	(3) SEE ERR HQR 50655	1 OCT 75	<i>W. Hillman</i>
G	NOR W8S3014 79-05-01	79-11-07	<i>W. Hillman</i>
H	NOR W5S2115/860214	860711	<i>W. Hillman</i>

WIRE DIAMETER..... .038

COIL DIAMETER (O.D.)..... .345 ± .005

FREE LENGTH.....1.050 REF

TOTAL COILS.....8.5 REF

DIRECTION OF HELIX.....RH (F)

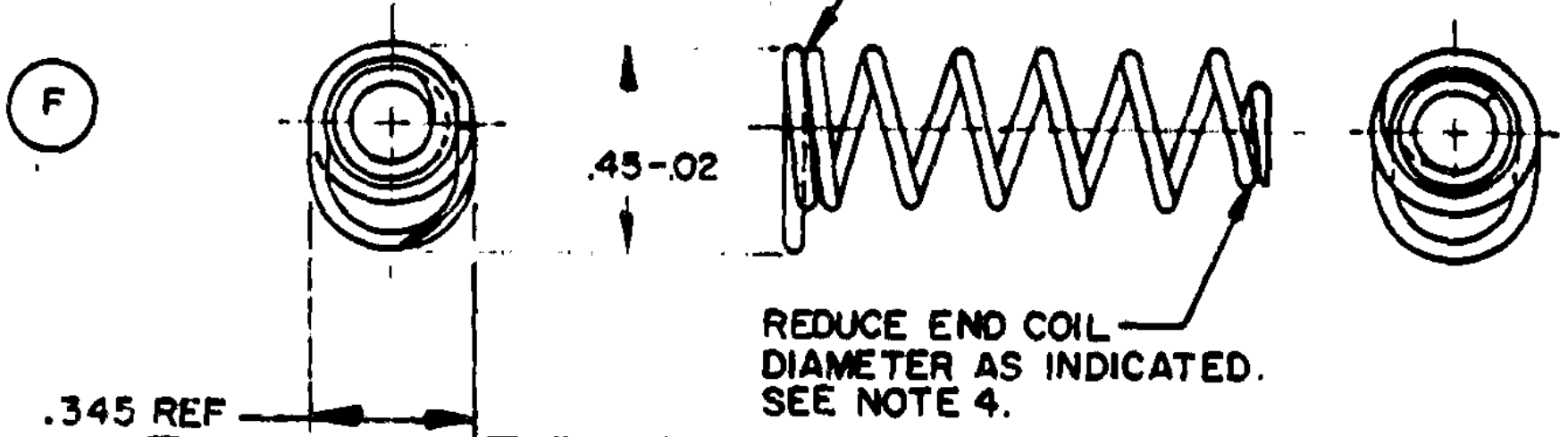
LOAD AT COMPRESSED LENGTH OF .43812.1 LB ± 1.2 LB

LOAD AT COMPRESSED LENGTH OF .32314.39 LB ± 1.4 LB

SPRING RATE19.8 LB/IN REF

SOLID LENGTH..... MAX

TYPE OF ENDS..... CLOSED ENDS GROUND



		B4		GUN, ACFT,	
				CAL .50,	
				GAU-10/A	
				MG CAL .50	
MECHANICAL PROPERTIES				XM213	
				MG CAL .50:	
				M2 HB FXD	
				FLEX. TT, MG	
		D6528309		CAL 50, XM21B	
YP					
TS					
EL 2					
RA		NEXT ASSY		USED ON	
BH		APPLICATION			
RH		APPLY PART NO:			

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON	DECIMALS ±
FRACTIONS ±	ANGLES ±
MATERIAL: WIRE, MUSIC, STEEL	
ASTM A228	
HEAT TREATMENT	
SEE NOTE 1	
FINAL PROTECTIVE FINISH	
SEE NOTE 2	

ORIGINAL DATE OF DRAWING 1 DEC 26	
DRAFTSMAN <i>Ree</i>	CHECKER <i>CK</i>
TRACER <i>Ree</i>	CHECKER <i>CK</i>
ENGINEER	ENGINEER <i>Ch. B. Schindler</i>
SUBMITTED <i>Ree</i>	
APPROVED <i>W. Hillman</i>	

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

PART NO. 5009351

SPRINGFIELD ARMORY, SPRINGFIELD, MASS

SPRING, HELICAL
COMPRESSION

DWG SIZE	CODE IDENT NO.	
B	19205	5009351
SCALE 2:1	UNIT WT	SHEET 1 OF 1