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1. MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A, EXCEPT THAT:
- A. 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 SOLID FIVE (5) TIMES.
 - B. PARAGRAPH 3.5.5 (SQUARENESS OF ENDS) SHALL NOT APPLY. SQUARED AND GROUND ENDS SHALL BE SQUARE WITH SPRING AXIS WITHIN 5°.
2. HOLE DIA INTO WHICH SPRING FITS FREELY .418 MIN.
3. ROD DIA OVER WHICH SPRING SLIDES FREELY .292 MAX.
4. HEAT TREATMENT: STRESS RELIEVE AT 435° ± 10° F. FOR 30 MIN, AFTER COILING.
5. FINAL PROTECTIVE FINISH: FINISH 3.31 OF MIL-STD-171 WITH VV-L-800 SUPPLEMENTARY OIL TREATMENT.

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
A	REDRAWN WITH CHANGE SEE EO SA 29355	17 FEB 67	<i>[Signature]</i>
B	SEE EO HORD 00175	4 AUG 70	<i>[Signature]</i>
C	(1) SEE ERR HQR 20008-1	14 JAN 72	<i>[Signature]</i>
D	(4) SEE ERR HQR 40639	18 FEB 75	<i>[Signature]</i>
E	NOR W853014 79-05-01	79-11-07	<i>[Signature]</i>
F	ERZ9Z1237AT (ECPW6S2003/8604101)	900319	<i>[Signature]</i>
G	NOR G9S2103, 89-12-18	90-06-11	<i>[Signature]</i>

WIRE DIAMETER .053

COIL DIAMETER (O.D.) .407 - .008

FREE LENGTH 22.2 REF

TOTAL COILS 144 REF

DIRECTION OF HELIX L.H.

LOAD AT COMPRESSED LENGTH OF 15.06 13.1 LB ± 1.3 LB

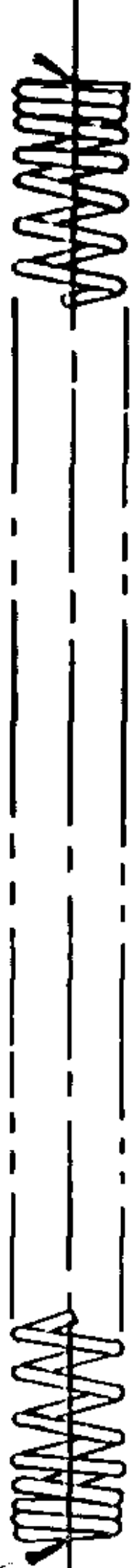
LOAD AT COMPRESSED LENGTH OF 7.90 26.3 LB ± 2.6 LB

SPRING RATE 1.84 LB/IN REF

SOLID LENGTH 7.81 MAX

TYPE OF ENDS CLOSED ENDS GROUND

THREE END COILS CLOSE WOUND



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

PART NO. 6147509

SPRINGFIELD ARMORY,
SPRINGFIELD, MA

SPRING, HELICAL
COMPRESSION

MECHANICAL PROPERTIES		GUN, ACFT,	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE 15 JUL 40
		CAL .50,		
		GAU-10/A		
		MG CAL .50		
		M2 HB FLEX,		
YP		FXD, TT	TOLERANCES ON DECIMALS ±	
TS			FRACTIONS ± ANGLES ±	
EL2			MATERIAL: WIRE, MUSIC, STEEL:	
RA	B7312243	XM218, XM213	ASTM A228	
	NEXT ASSY	USED ON		
BH		APPLICATION	HEAT TREATMENT	
			SEE NOTE 4	
RH			FINAL PROTECTIVE FINISH	
			SEE NOTE 5	

DWG SIZE	CODE IDENT NO.	
B	19205	6147509
SCALE NONE	UNIT WT	SHEET 1 OF 1