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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 THE SPRING AXIS WITHIN 5°.
2. HOLE DIA INTO WHICH SPRING FITS FREELY 292 MIN.
3. ROD DIA OVER WHICH SPRING SLIDES FREELY 206 MAX.
4. HEAT TREATMENT: STRESS RELIEVE AT 435° ± 10° F FOR 30 MIN, AFTER COILING.
5. FINAL PROTECTIVE FINISH: FINISH 3.3.1 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 HQRD 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	ERR 2921237AT (E F W6S2003/860410)	900319	<i>[Signature]</i>
G	NOR G9S2103, 89-12-18	90-06-11	<i>[Signature]</i>

**DUPLICATE**  
PSC-U  
COPY ON FILE IN TECHNICAL  
DATA DIVISION

DOCUMENT	19204	19205
61147510		
CAGE	19200	B G U-1
SOURCE	PA	DATE 9-3-91
CONTRACT		
PHOTOGRAPHER		DATE 2 SEP 1991

WIRE DIAMETER-----.039

COIL DIAMETER ( O.D. )-----.290--005

FREE LENGTH-----21.8 REF

TOTAL COILS-----197 REF

DIRECTION OF HELIX-----R.H. (D)

LOAD AT COMPRESSED LENGTH OF 15.02-----7.7 LB ± 1.0 LB

LOAD AT COMPRESSED LENGTH OF 8-----15.6 LB ± 1.6 LB

SPRING RATE-----1.13 LB/IN REF

SOLID LENGTH-----7.80 MAX

TYPE OF ENDS-----CLOSED ENDS GROUND

DISTRIBUTION STATEMENT A:  
"APPROVED FOR PUBLIC RELEASE:  
DISTRIBUTION IS UNLIMITED."

CURRENT DESIGN ACTIVITY CAGE CODE 19200  
U.S. ARMY  
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER  
PICAATINY ARSENAL, NEW JERSEY 07805-5000

PART NO. 6147510

SPRINGFIELD ARMORY,  
SPRINGFIELD, MA

SPRING, HELICAL  
COMPRESSION

MECHANICAL PROPERTIES	GUN, ACFT,	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	ORIGINAL DATE OF DRAWING 15 JUL 40
YP	CAL. 50,		DRAFTSMAN RZE
TS	GAU-10/A	TOLERANCES ON DECIMALS ±	CHECKER CK
EL2	M2 HB FLEX,	FRACTIONS ± ANGLES ±	TRACER RZE
RA	FXD, TT	MATERIAL: WIRE, MUSIC, STEEL: ASTM A228	CHECKER CK
BH	B7312243 XM218, XM213	HEAT TREATMENT SEE NOTE 4	ENGINEER N. Buehler
	NEXT ASSY USED ON	FINAL PROTECTIVE FINISH SEE NOTE 5	ENGINEER
RH	APPLICATION		SUBMITTED
	APPLY PART NO.		APPROVED

DWG SIZE	CODE IDENT NO.	
B	19205	6147510
SCALE NONE	UNIT WT	SHEET 1 OF 1