

NOTES:

- APPLICABLE SPECIFICATIONS AND STANDARDS:
 - ANSI Y14.5-1973.
 - ASME B46.1.
 - MIL-G-10944.
 - MIL-STD-120 REF.
- MATERIAL:

GAGE: HIGH-SPEED TOOL STEEL, T1 TO T15 OR M1 TO M62 PER ASTM A600 OR ALLOY TOOL STEEL, O1 PER ASTM A681.

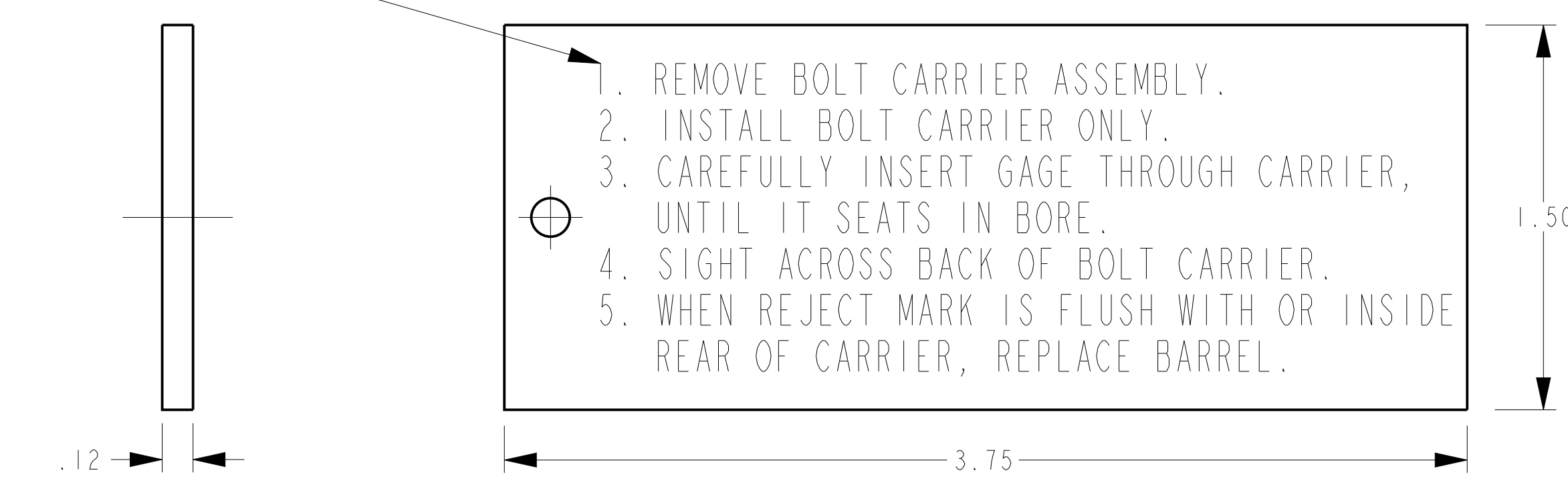
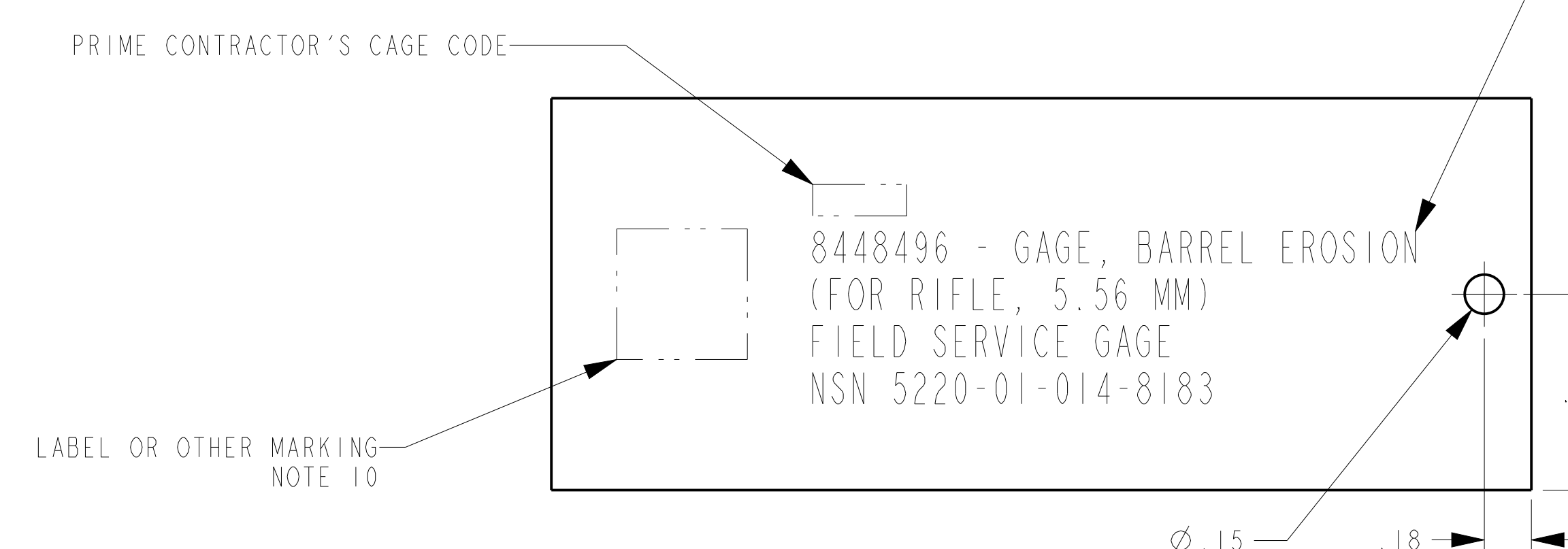
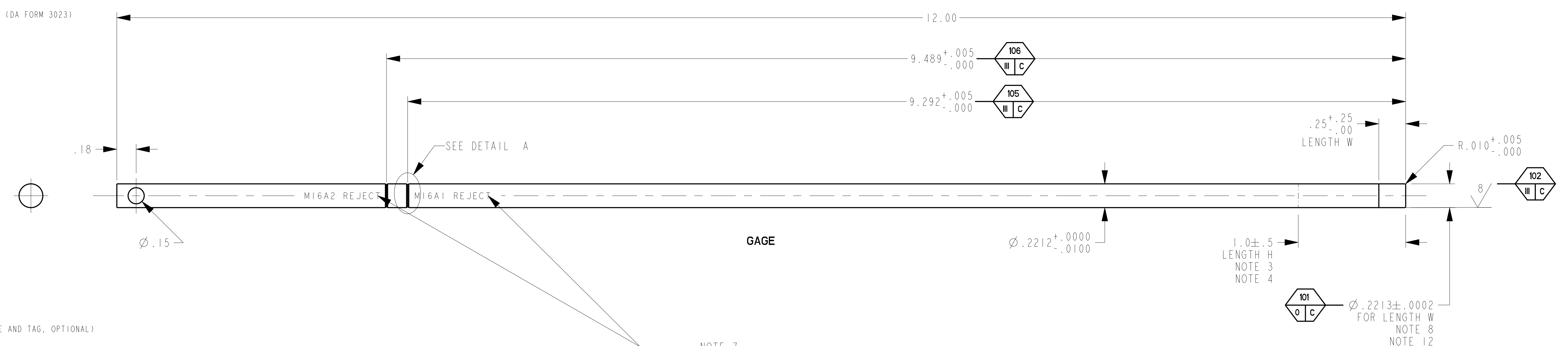
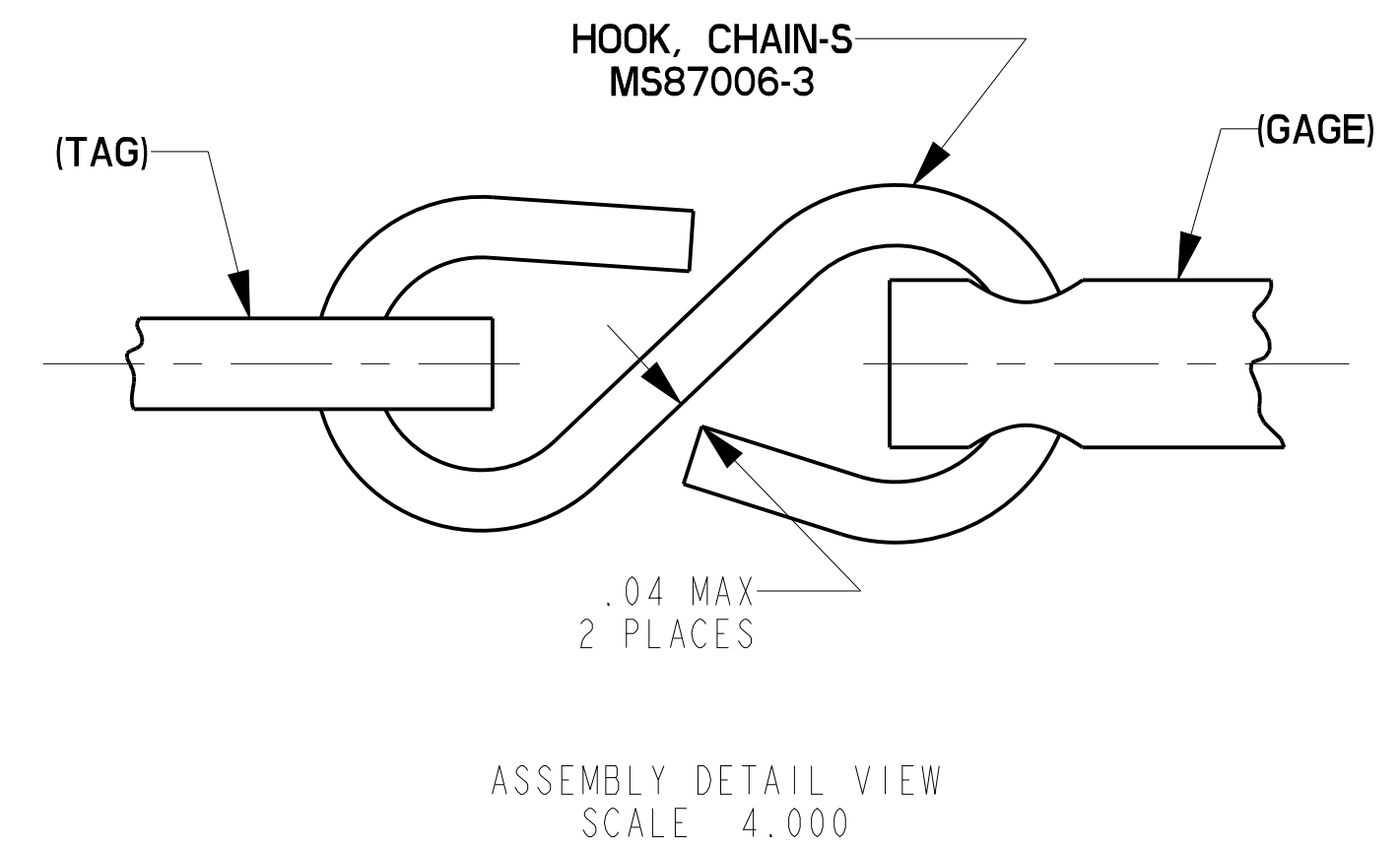
TAG: ALUMINUM ALLOY 1100 OR 3003-H1X OR H2X PER ASTM B209 OR PHOTOSENSITIVE ANODIZED ALUMINUM PLATE, TYPE II, GRADE A, CLASS 2 PER GG-P-455.
- HEAT TREATMENT: FOR LENGTH H ONLY, HEAT TREAT TO PRODUCE HARDNESS EQUIVALENT TO ROCKWELL C 60 TO 63.
- ALTERNATE METHOD:

HEAT TREAT PER NOTE 3. APPLY FINISH 1.2.2 OF MIL-STD-171. FILM THICKNESS FOR LENGTH W SHALL BE .0010±.0005. (∅.2213±.0002 APPLIES AFTER FINISH.)
- BREAK EDGES .005^{+0.010}/_{.000} EXCEPT AS NOTED.
- SURFACE FINISH: $\sqrt{63}$ EXCEPT AS NOTED.
- MARK DATA AS SHOWN. DATA SHALL BE LEGIBLE. GAGE: NUMBERS AND LETTERS SHALL BE .06 HIGH. TAG: NUMBERS AND LETTERS SHALL BE .12 HIGH, AND SPACE BETWEEN LINES SHALL BE .03 MIN.
- NEWLY-PRODUCED GAGES SHALL MEET ALL REQUIREMENTS OF THE DRAWING. ANNUAL FIELD RE-CALIBRATION REQUIREMENTS ARE NOTED. WITH REGARD TO ANNUAL FIELD RE-CALIBRATION, A REVISION LETTER MAY BE MARKED ON THE GAGE PER EARLIER DRAWING REVISIONS.
- ALL MAJOR QAP CHARACTERISTICS SHALL BE LISTED ON THE GAGE RECORD CARD IN THE BLOCK ENTITLED "REQUIRED COMPONENT DIMENSION." EACH DIMENSION SHALL BE MEASURED AND THE MEASUREMENT RECORDED IN THE BLOCK ENTITLED "ACTUAL GAGE DIMENSIONS." EACH CARD SHALL BE SIGNED AND DATED BY THE CONTRACTOR CERTIFYING THAT THE GAGE COMPLIES WITH THE REQUIRED DIMENSIONS SPECIFIED ON THE GAGE DRAWING AND SHALL BE PLACED IN THE PACKAGING WITH THE GAGE. EACH PACKAGE ASSEMBLY SHALL CONTAIN ONE GAGE AND THE GAGE RECORD CARD SPECIFIC TO THAT GAGE. THE GAGE RECORD CARD MUST BE COMPLETED AT THE TIME OF ACCEPTANCE BY THE ACCEPTANCE POINT (ORIGIN OR DESTINATION) IDENTIFIED IN THE CONTRACT.
- THE LABEL OR OTHER MARKING SHALL CONTAIN A LINEAR BAR CODE (MACHINE-READABLE INFORMATION), ALONG WITH THE HUMAN-READABLE INTERPRETATION, REPRESENTING THE GAGE IDENTIFICATION NUMBER. A DUPLICATE LABEL OR OTHER MARKING SHALL APPEAR ON THE GAGE RECORD CARD IN THE BLOCK ENTITLED "IDENTIFICATION NO." EACH GAGE IDENTIFICATION NUMBER SHALL BE CHOSEN/ASSIGNED BY THE GOVERNMENT.
- QUALITY ASSURANCE PROVISION REQUIREMENTS PER DRAWING NUMBER 12993884 APPLY.
- OPTIONAL PROTECTIVE FINISH:

GAGE (IN LIEU OF ALTERNATE METHOD PER NOTE 4): FINISH 3.3.2 OF MIL-STD-171 EXCEPT ON ∅.2213 AND .020 X 90°, 2 PLACES.

TAG: FINISH 7.2.2 OF MIL-STD 171. COLOR: APPROXIMATELY COLOR NO. 37038 (LUSTERLESS BLACK) BUT NOT LIGHTER THAN COLOR NO. 36081 OF SAE AMS-STD-595.

REVISIONS			
REVISION	DESCRIPTION	DATE (YEAR-MO-DA)	APPROVED
J	REDRAWN WITH CHANGE NOR L08S3069 / 2008-06-25	2008-08-08	AMW
K	NOR L09S3003 / 2009-02-25	2009-03-12	BMG
L	NOR L09S3130 / 2009-09-08	2009-09-10	BMG
M	NOR L14S3061 / 2014-05-20	2014-05-23	JTD
N	NOR L16S3073 / 2016-11-17	2016-11-28	RLV
P	NOR L18S3050 / 2018-09-05	2018-09-11	RLV
R	REPLACED WITH CHANGE BY DRAWING NUMBER 13076673 NOR L18S3118 / 2018-10-25	2018-10-29	BAC



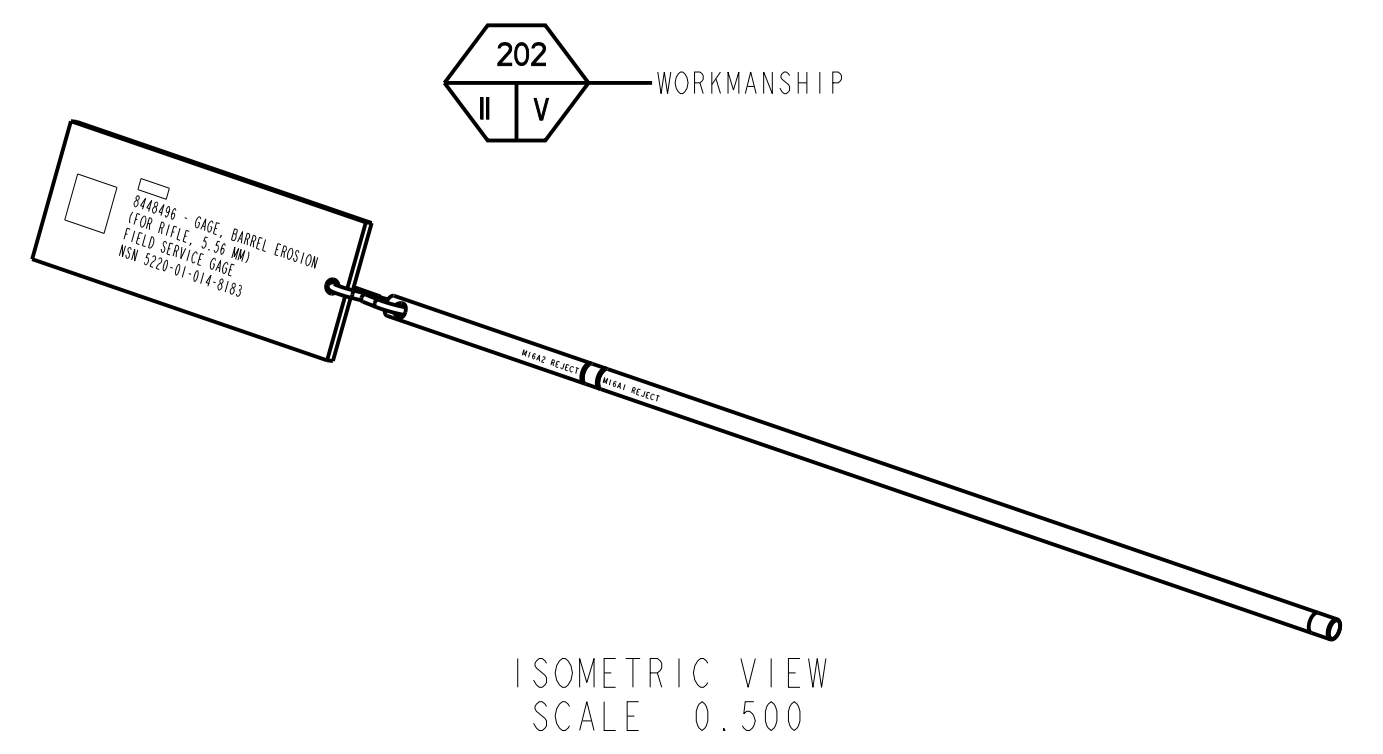
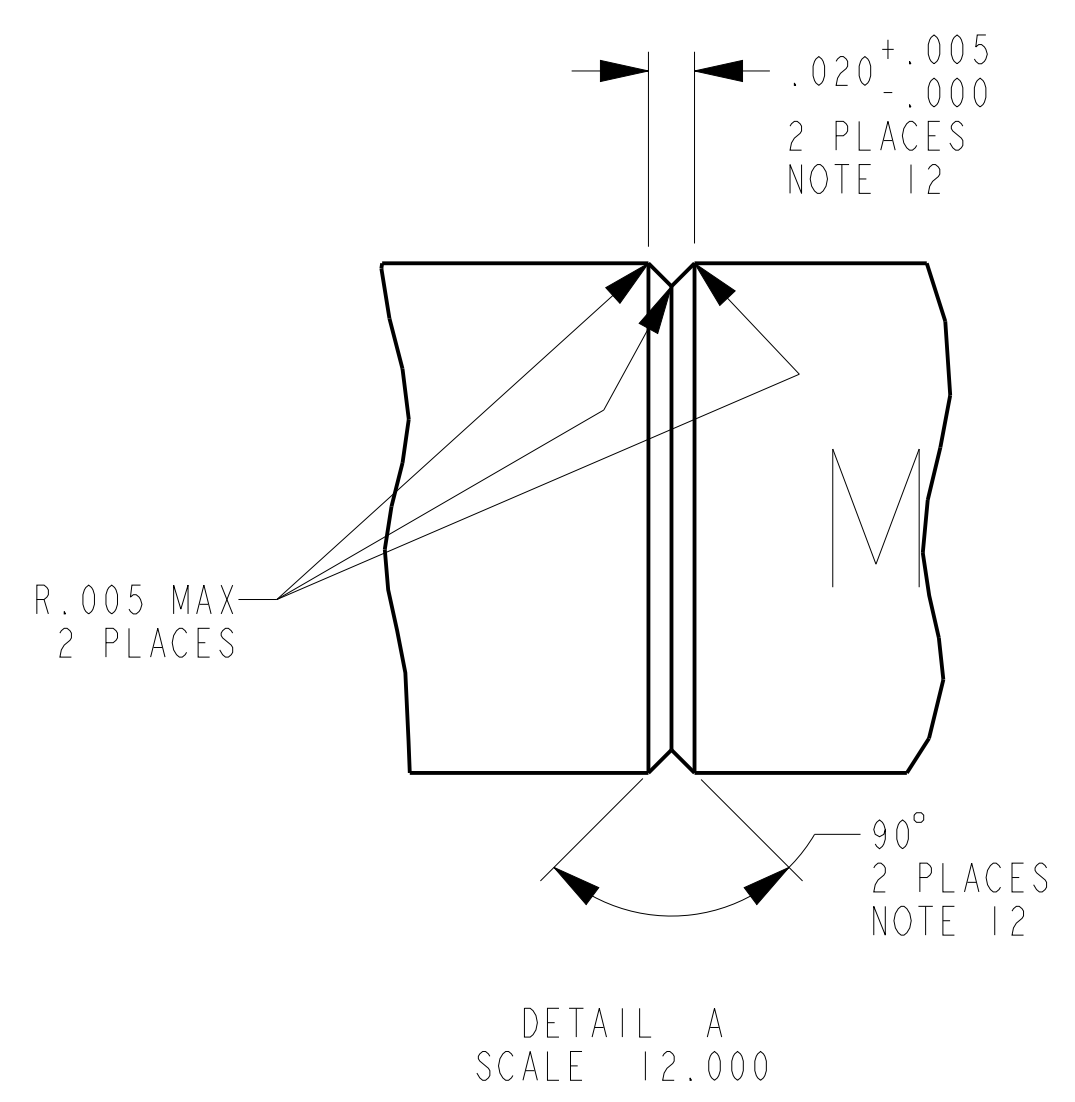
- REMOVE BOLT CARRIER ASSEMBLY.
- INSTALL BOLT CARRIER ONLY.
- CAREFULLY INSERT GAGE THROUGH CARRIER, UNTIL IT SEATS IN BORE.
- SIGHT ACROSS BACK OF BOLT CARRIER.
- WHEN REJECT MARK IS FLUSH WITH OR INSIDE REAR OF CARRIER, REPLACE BARREL.

OBSOLETE
(REPLACED BY
PART NO. 13076673)

THIS DRAWING WAS GENERATED FROM A SOLID MODEL AND IS CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY.

CURRENT DESIGN ACTIVITY GAGE CODE 19200
US ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

PART NO. 8448496



PMIC		DO NOT SCALE DRAWING UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	CONTRACT NUMBER	DESIGN ACTIVITY
MECHANICAL PROPERTIES		TOLERANCES ON ANGLES ± 1° 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005	CONTRACTOR	US ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILLINOIS
YP		THIRD ANGLE PROJECTION	DRAWN BY	GAGE, BARREL EROSION (CHROME-PLATED BORE)
TS	M16A4		CHECKER	
EL2	M16A3		ENGINEER	
RA	M16A2		ENGINEER	
BH	M16A2		ENGINEER	
RH			ENGINEER	
	NEXT ASSY	USED ON	DATE (YEAR-MO-DA)	SIZE
			J. WINDHAM 2008-06-25	F
	APPLICATION	MATL ENGR	DESIGN APPROVAL	CAGE CODE
			M. CROSSON 2008-06-25	19204
				DWG NO.
				8448496
				SCALE
				2.000
				UNIT WT.
				0.202
				SHEET
				1 OF 1