Drawings of the Government Model 1911-A1 Pistol

These drawings are primarily from the 1928 update of the Government Model 1911 pistol to the Government Model 1911-A1 version. However, a few of the drawings, primarily of the National Match parts, are from later dates. As with any successful product with a long lifetime, this pistol underwent a variety of changes over the years. Many of the parts have had minor revisions and/or alterations to the dimensions to improve performance of the firearm or to make manufacturing more efficient. Most of the changes can be found as drawings from a facility other than the one that made the original drawings. However, these minor changes do not alter the interaction of the parts.

The reader will no doubt notice that the drawings are not uniform in size or scale. The original drawings coming from a variety of sources naturally were made in different sizes. Some extensive enlarging and shrinking was required in trying to make them fit into a single-size format that could be easily reproduced. For example, the drawings were put two to a page when the originals were close to the 8-1/2 x 11 inch (A size) format. In some cases some of the top, bottom, or one side of a drawing may be missing. The missing areas do not contain any critical information concerning the dimensions or metal treatment.

Part numbers used in the exploded view at right should make it easy to locate a specific part. This numbering system was in use by the National Rifle Association in their disassembly manuals many years ago. The numbering system has also been adopted by some suppliers for their parts catalogs.
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SECTION C-C
MAGAZINE FOLLOWER IN CONTACT WITH SLIDE STOP
1. MATERIAL:
   A. WHEN FABRICATED FROM WROUGHT MATERIAL: STEEL,
      CMPSH06D THRU 1040, SPEC QQ-S-635,
      OR STEEL, CMPSN 4140, SPEC QQ-S-624,
      AUSTENITIC GRAIN SIZE 6
      OR FINER
   B. WHEN FABRICATED FROM CASTING:
      PRECISION CASTING, CMPSN IC-4140,
      SPEC ML-S-2241.

2. ALL EDGES SHALL BE BROKEN
   .005 + .00.

3. FINISH \* EXCEPT AS OTHERWISE
   SPECIFIED.

4. HEAT TREATMENT: HEAT
   AT 1520°F TO 1575°F, OIL
   QUENCH, TEMPER TO
   HARDNESS SPECIFIED.
   HEAT TREATMENT METHOD
   IS FOR GUIDANCE.

5. LUBRICATING OIL,
   SPEC VV-L-800.

6. CASTING SHALL BE
   CLASSIFIED AND INSPECTED
   IN ACCORDANCE WITH CLASS IB
   GRADE B, SPEC ML-C-6021.

7. MIL-W-13855 APPLIES.

---

THIS NATIONAL MATCH BUSHING
DRAWING HAS BEEN MODIFIED TO
STANDARD BUSHING DIMENSIONS,
NUMBERING AND MARKINGS

---

PHYSICAL

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TOLERANCES ON: _ 2.000 _ 1000.000 |

SEE NOTE 4

HEAT TREATMENT

SEE NOTE 4

FINAL PROTECTIVE FINISH

SEE NOTE 5

---

BUSHING,
BARREL

---

DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, ILL. 62010

E 6008596
**Part No. 5013199**

**B5013199**

**NOTES:**

1. **Finish**: M-12355 applies.
2. **M-12355** applies.
3. **Finish Type**: M-12355 applies.
4. **Material**: M-12355 applies.

---

**SIDE VIEW**

- **Piece**: B-5153127
- **Bowl**: B-5153126
- **Chop**: B-515304
- **Bowl**: B-515305
- **Chop**: B-515306

---

**ASSEMBLY**

- **Trig**: B-6147780
- **Pin**: B-6147781
- **Barrel**: B-6147782
- **Link**: B-6147783

---

**REFERENCE:**

- **File**: B-6147784
- **Note**: B-6147785
- ** bson**: B-6147786

---

**DRAWING INFORMATION**

- **Part No.**: B-6147787
- **File**: B-6147788
- **Note**: B-6147789
- ** bson**: B-6147790

---

**DIAGRAM**

- **Assembly**: B-6147791
- **Part**: B-6147792
- **Sheet**: B-6147793
- **Note**: B-6147794

---

**REFERENCES**

- **File**: B-6147795
- **Note**: B-6147796
- ** bson**: B-6147797

---

**SPECIFICATIONS**

- **Finish**: M-12355 applies.
- **M-12355** applies.
- **Finish Type**: M-12355 applies.
- **Material**: M-12355 applies.

---

**NOTES**

1. **Finish**: M-12355 applies.
2. **M-12355** applies.
3. **Finish Type**: M-12355 applies.
4. **Material**: M-12355 applies.
NOTES:
1. FINISH .125
2. ALL EDGES SHALL BE BROKEN .005 + .010.
3. MIL-W-13855 APPLIES.

A
B
C

PART NO. 5153127
THIS PART WAS REDRAWN FROM A DAMAGED MASTER. SOME DIMENSIONS MAY BE APPROXIMATE.

TRIGGER PAD
NOTES:

1. FINISH 125 ALL OVER.

2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.

3. HEAT TREATMENT: HEAT AT 1500°F TO 1550°F, OIL QUENCH. TEMPER 30 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

4. STEEL, CMPSN 1045, 1050, PER ASTM A108 OR CMPSN 1137, PER QQ-S-637.

5. FINISH 5.3.1.2 OF MIL-STD-171.

MIL-W-13855 APPLIES.

SECTION A-A

CODE IDENT NO. 19204
PART NO. 6008597

GUIDE,
RECOIL SPRING

DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, ILL., 61201
**DIAMETER OF WIRE** 0.043
**DIAMETER OF COIL (OD)** 0.450 ± 0.005
**FREE LENGTH** 6.55 REF
**ACTIVE COILS** 29 REF
**TOTAL COILS** 30 REF
**DIRECTION OF HELIX** L/H
**LOAD AT COMPRESSED LENGTH OF** 3.72 = 8.00 LB ± 0.50 LB
**LOAD AT COMPRESSED LENGTH OF** 1.81 = 13.55 LB ± 0.60 LB
**SPRING RATE** 2.88 LB/IN REF
**SOLID LENGTH** 1.375 MAX
**TYPE OF ENDS** NOT SQUARED OR CLOSED
**CRIMP ONE END COIL TO** 0.326 = 0.01 ID

**SPECIAL DATA**
- **HOLE DIA INTO WHICH SPRING FITS FREELY** 0.448 MIN
- **ROD DIA OVER WHICH SPRING SLIDES FREELY** 0.336 MAX
- **MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE 1, GRADE A.**

*EXCEPT FOR CRIMPED END.*

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**US ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND**
DOVER, NEW JERSEY 07851

| ROCK ISLAND ARSENAL |
| DEPT OF THE ARMY |
| ROCK ISLAND ILL 61201 |

**SCALE**
- **UNIT WT** 0.02 LB
- **SHEET** 1 OF 1
NOTES:
1. FINISH ALL OVER.
2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. STEEL, CMPSN IO60, IO70, PER ASTM A108 OR STEEL, 4140 OR 4150, SPEC QQ-S-624 AUSTENITIC GRAIN SIZE 6 OR FINER.
   ALTERNATIVE MATERIAL:
   STEEL, CMPSN IC8640, MIL-S-22141
   CLASSIFICATION AND INSPECTION OF INVESTMENT CASTINGS TO BE IN ACCORDANCE WITH CLASS IA, GRADE B, MIL-C-6021.
   HEAT AT 1520°F TO 1560°F. OIL QUENCH. TEMPER AT APPROXIMATELY 750°F FOR ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. FINISH 5.3.1.2 OF MIL-STD-171.
   MIL-W-I3855 APPLIES.

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SEE NOTE 3

DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, ILLINOIS, 61201

DATE 1 MAY 28
STOP, FIRING PIN

PREPARED
CHECKED
INSPECTED
APPROVED

C 19204 5013205
1. Finish 1/8" EXCEPT AS NOTED.
2. All edges shall be broken 0.05 + 0.010 unless otherwise specified.
3. Material: Steel, Spec 06.5-631 or ASTM A108 1010, 1020, 1025, austenitic grain size 7 or finer.
4. Heat treatment: Heat at 1425°C to 1500°C, oil quench, temper 30 minutes at heat to hardness specified. Heat treatment method is for guidance except that tempering time shall not be reduced below that specified.
5. Take hardness reading on 0.20 dia. - 0.01.
6. MIL-W-13855 applies.
7. Finish 5.3.1.2 of MIL-STD-171.
NOTES:
1. STRESS RELIEVE AT 435°F ± 10°F FOR 20 MINUTES AFTER FORMING.
2. MANUFACTURE IN ACCORDANCE WITH MIL-S-33572 TYPE I, GRADE A, EXCEPT DO NOT COMPRESS TO SOLID HEIGHT.
3. MATERIAL: MUSIC WIRE, STEEL, SPEC QQ-W-470.

INSIDE DIA., FREE, NOT LESS THAN ___________ .091
OUTSIDE DIA., SOLID, NOT MORE THAN ___________ .149
FREE LENGTH(APPROX.) ___________ .708
ACTIVE COILS ___________ 11 REF
TOTAL COILS ___________ 13 REF
DIRECTION OF HELIX ___________ RH
LOAD AT COMPRESSED LENGTH OF .550 (BASIC) = 5.7 LB ± 0.5 LB
LOAD AT COMPRESSED LENGTH OF .456 (BASIC) = 8.5 LB ± 0.7 LB

SOLID LENGTH ___________ .364 MAX
TYPE OF ENDS ___________ PLAIN (OPEN ENDS NOT GROUND)
REDUCE ID OF LAST COIL ON BOTH ENDS TO .085 DIA.-.010

PART NO. 5013217

SPECIAL DATA
HOLE DIA INTO WHICH SPRING FITS FREELY ___________ .152 MIN

PMIC

MECHANICAL PROPERTIES

NOTES:
1. MANUFACTURE IN ACCORDANCE WITH TYPE I, GRADE A, MIL-S-33572.

DIAMETER OF WIRE ___________ .0260
DIAMETER OF COIL (OD) ___________ .207 ± .005
FREE LENGTH ___________ 1.70 REF
ACTIVE COILS ___________ 38 REF
TOTAL COILS ___________ 40 REF
DIRECTION OF HELIX ___________ OPTIONAL
LOAD AT COMPRESSED LENGTH OF ___________ 1.36 ± 1.030 LB ± .0135 LB
LOAD AT COMPRESSED LENGTH OF ___________ LB ± LB
SPRING RATE ___________ 30 LB/IN REF
SOLID LENGTH ___________ 1.066 MAX
TYPE OF ENDS ___________ SQUARED AND GROUND

USED WITH PIN-6008599
NOTES:
2. FINISH ALL OVER. 0.0125.
3. FINISH 33.1 OF MIL-STD-171 WITH VV-L-805 SUPPLEMENTARY OIL TREATMENT.
4. MIL-W-13855 APPLIES.

SECTION A-A

SECTION B-B

SCALE 1/16"
ASSEMBLED HEIGHT .......................... 4.3
LOAD AT COMPRESSED LENGTH ................ 1.2
APPROXIMATE NUMBER OF COILS ............... 12.5
LOAD AT COMPRESSED LENGTH ................. 0.025
MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A.
NOTES:
1. FOR WROUGHT MATERIAL: STEEL, CARBON SAE 1015 TO 1025; ASTM-A108.
2. FOR PRECISION CASTING: STEEL, CMPSN IC-1020, IC-1030, MIL-S-22041.
4. FINISH IT ALL OVER.
5. MIL-W-13255 SHALL APPLY.
6. THIS INFORMATION MAY BE INSCRIBED ON PART NO. 614714 AT ASSEMBLY.

INSCRIBE THE FOLLOWING INFORMATION:
.09 HIGH X .010 + .005 DEEP PER MIL-STD-130.
12100-ASSY 5506694
MFR: CODE IDENT NO. (SEE NOTE 6)

CURRENT DESIGN ACTIVITY CASE CODE 19200.
U.S. ARMY ARTILLERY RESEARCH, DEVELOPMENT AND ENGINEERING CENTER.
FORT BELVOIR, VIRGINIA, NEW JERSEY 07006-5000.

SMCAR FORM 67.1 DEC 87 (REPLACES SMCAR FORM 67.1 MAR 87 TEMPS). WHICH MAY BE USED UNTIL EXHAUSTED.
NOTES:
1. STEEL, CMPSN 1018 THRU 1020, ASTM A108
   OR
   STEEL, CMPSN 1117
   SPEC QQ-S-637.
2. FINISH 125% ALL OVER.
3. CARBURIZE AT 1575° TO 1600° F TO CASE DEPTH
   OF .003 TO .005. OIL QUENCH. TEMPER 450°
   FOR 20 MINUTES. HEAT TREATMENT METHOD
   IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH
   AND HARDNESS REQUIREMENTS ARE MANDATORY
   AND TIME AT TEMPERATURE SHALL NOT BE
   REDUCED BELOW THAT SPECIFIED.
4. REMOVE ALL BURRS AND SHARP EDGES,
   .005 R MAX.
5. MIL-W-13855 APPLIES.
6. FINISH 5.3.1.2 OF MIL-STD-171.

CODE IDENT NO. 19204
PART NO. 5013218
LOCK,
MAGAZINE CATCH
DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, ILL.
51801
26

HOSUING-5503841

LOOP-5013214

PIN-MS 16562-25 OR
MS 16562-110

SECTION A-A

1. MIL-W-13855 APPLIES.
NOTES:
1. FINISH ALL OVER.
2. ALL EDGES SHALL BE BROKEN .005+.010 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT: CARBURIZE TO CASE DEPTH .003 TO .005. OIL QUENCH. TEMPER AT 350°F MINIMUM FOR 30 MINUTES. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. MIL-W-13855 APPLIES.
NOTES:

1. FINISH \( \frac{1}{16} \) ALL OVER.

2. ALL EDGES SHALL BE BROKEN 0.005 + 0.010 UNLESS OTHERWISE SPECIFIED.

3. HEAT TREATMENT: CARBURIZE TO CASE DEPTH 0.003 TO 0.005. OIL QUENCH. TEMPER AT 350°F MINIMUM FOR 30 MINUTES. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENTS ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED.


5. MIL-W-13855 APPLIES.
NOTES:
1. FINISH 128 V ALL OVER.
2. HEAT TREATMENT: HEAT AT 1450°F TO 1500°F; OIL QUENCH, TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
3. MIL-W-13855 APPLIES.
4. FINISH 5.3.1.2 OF MIL-STD-171.

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<th>DESCRIPTION</th>
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DIMENSIONS ARE IN INCHES
TOLERANCES PER ASME Y14.5-84
Finishes 3.3.2.5 
OFFICIAL DRAWING

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1 MAY 28

CAGE CODE 19205
DEPT OF THE ARMY
SPRINGFIELD ARMORY
SPRINGFIELD, MASS

PART NO. 5013212
HOUSING

SCALE 4/1 UNIT WT .004 LB

RMH SHEET 1 OF 1
NOTES:
1. FINISH 125 EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN .003+.010
3. MATERIAL: STEEL, ASTM A684, CMPSN 1045, 1095, AUSTENITIC GRAIN SIZE 7 OR FINEER
4. HEAT TREATMENT: HEAT AT 1450°F TO 1500°F;
   OIL, QUENCH, TEMPER 20 MINUTES AT HEAT TO
   HARDNESS SPECIFIED, HEAT TREATMENT
   METHOD IS FOR GUIDANCE EXCEPT THAT
   TEMPERING TIME SHALL NOT BE REDUCED
   BELOW THAT SPECIFIED.
5. MIL-W-13055 APPLIES.
6. FINISH 5.3.1.2 OF MIL-STD-171.

---

C6008600

CODE IDENT NO. 19204
PART NO. 6008600

ORIGINAL DATE: 1 MAY 20

STRUT, HAMMER
DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, ILL. 61201
NOTES:

1. FINISH ALL OVER.

2. HEAT TREATMENT: HEAT AT 1450°F TO 1500°F; OIL QUENCH. TEMPER 20 MINUTES TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

3. MIL-W-13855 APPLIES.

4. FINISH 5.3.1.2 OF MIL-STD-171.

---

PIN, EJECTOR

---

PIN, HAMMER STRUT
NOTES:

1. FINISH 125% ALL OVER.

2. HEAT TREATMENT: HEAT AT 1450° TO 1500°F; OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.

3. MIL-W-13855 APPLIES.

4. FINISH 5.3.1.2 OF MIL-STD-171.

PART NO. 5013206
PIN, HAMMER

CAGE CODE 19205
DEPT OF THE ARMY
SPRINGFIELD ARMORY
SPRINGFIELD, MASS.

B
5013206

SHEET 1 OF 1
PARTIAL SECTION A-A
SECTION APPLIES TO SERRATIONS IN BOTH DIRECTIONS 30° APART
SCALE 4/1

ALTERNATIVE METHOD
SERRATIONS APPLY IN ONE DIRECTION ONLY
SCALE 4/1

DETAIL B
SCALE 4/1

SEE DETAIL B

CODE IDENT NO. 19204
PART NO. 6008595

STOP, SLIDE
ROCK ISLAND ARSENAL
DEPT OF THE ARMY
ROCK ISLAND, ILLINOIS

6008595
NOTES:
1. RECESSES SHOWN ARE NONFUNCTIONAL AND ARE PERMITTED WITHIN REASONABLE LIMITS FOR STABILITY OF THE MOLDED PRODUCT.
2. WELDING PLASTICS, SPEC MIL-P-14, PHENOLIC, TYPE CFI-20.
   COLOR: NO. 200445, 20059 OR 20062 OF TABLE II, FED. STD. NO. 595;
   SEMI-GLOSS BROWN.
3. APPLY PART NO. 1/8 HIGH IN RECESSED AREA PER MIL-STD-130.
4. MIL-W-15655 APPLIES.
NOTES:
1. *FINISH √ EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN 0.050.000
   UNLESS OTHERWISE SPECIFIED.
3. MATERIALS
   A. STEEL CAPROL 1000 THROUGH 1074 ASTM A553, A554, A555.
   B. INVESTMENT CASTING 1045 OR 10450
   SPEC. MIL-G-22246.
4. UNLESS OTHERWISE SPECIFIED, SURFACES
   REQUIRING ◢ ROUGHNESS HEIGHT
   RATINGS MAY BE PROFILACED AFTER APPLICATION
   OF FINAL PROTECTIVE FINISH (BRIGHT AREAS
   RESULTING FROM SUCH PROCESSING ARE
   PERMISSIBLE).
5. NO TRANSVERSE TOOL MARKS PERMITTED ON
   SURFACES MARKED ◢.
6. UNLESS OTHERWISE SPECIFIED, ALL INTERIOR
   CORNERS SHALL BE ROUNDED WITH FELT
   RADIUS OF 0.060 TO 0.080 INCH.
7. MIL-W-13035 APPLIES.
8. *FINISH 0.312 OF MIL-STD-750.
9. INSPECT CASTING PER MIL-C-4024.
   CLASS 1, GRADE A.
NOTES:
1. FINISH ALL OVER
2. ALL EDGES SHALL BE BROKEN .005+.010
3. STEEL, CMPSN 1017 THRU 1025, SPEC QQ-S-631 OR STEEL, CMPSN 117 OR 118, SPEC QQ-S-637.
4. FINISH 5.3.1.2. OF MIL-STD-171.
5. MIL-W-13855 APPLIES.

CODE IDENT NO. 19204
PART NO. 6008594

TUBE, PLUNGER
DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, ILL, 61201
NOTES:
1. FINISH 125 V/ALL OVER.
2. ALL EDGES SHALL BE BROKEN 0.005+0.000
   UNLESS OTHERWISE SPECIFIED.
3. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2
   OF MIL-STD-17L.
4. ALTERNATIVE MATERIAL: INVESTMENT CASTING 1.320, SPEC. MIL-S-22141.
5. INSPECT CASTINGS PER MIL-STD-247A
   CLASS 3, GRADE B.

SECTION B-B

DETAIL A
SCALE 10X1

SIGHT, REAR
SPRINGFIELD ARMORY
ORDNANCE CORPS
DEPT. OF THE ARMY

U.S. ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07866

CURRENT
CODE IDENT NO. 19205
PART NO. 5013196

CODE IDENT NO. C5013196
PART NO. 5013196

PHYSICAL
DESCRIPTION

SIGHT, REAR

C7710353 KMF101

MATERIAL
STAINLESS STEEL SPEC.

APPL. ING
1995-01-12

APPROVED BY:
C5013196

SCALE 471
11/09/87
0.007"
NOTES:
1. FINISH 125/
2. ALL EDGES SHALL BE BROKEN .005 + .010 UNLESS OTHERWISE SPECIFIED.
4. HEAT TREATMENT: AUSTEMPER; OR HEAT FRONT END 1450° TO 1500°F; OIL QUENCH TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. LEAVE LONG PIN SOFT. ALTERNATE: HEAT AT 1450° TO 1500°F; OIL QUENCH TEMPER 20 MINUTES AT HEAT TO HARDNESS SPECIFIED. SOFTEN LONG PIN ONLY, SUFFICIENT FOR DRILLING. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171 FOR SPARE PARTS ONLY.

CODE IDENT NO. 00000
ORD PART NO. 6019024

SPRINGFIELD ARMORY
ORDNANCE CORPS
DEPT OF THE ARMY
NOTE:
1. MATERIAL:
   A. WHEN FABRICATED FROM WROUGHT MATERIAL: STEEL,
      CMNSHD THRU I000, SPEC 00-S-634,
      OR STEEL, CMNS440, SPEC 00-S-624.
      AUSTENITIC GRAIN SIZE 8
      OR FINER
   B. WHEN FABRICATED FROM CASTING:
      PRECISION CASTING, CMNSN IC-4140,
      SPEC MIL-S-22411.
2. ALL EDGES SHALL BE BROKEN 0.05 + 0.0
3. FINISH V. EXCEPT AS OTHERWISE SPECIFIED.
4. HEAT TREATMENT: HEAT AT 1525° TO 1575°F. OIL
   QUENCH, TEMPER TO HARDNESS SPECIFIED.
   HEAT TREATMENT METHOD IS FOR GUIDANCE.
5. LUBRICATING OIL.
   SPEC MIL-L-800.
6. CASTING SHALL BE CLASSIFIED AND INSPECTED
   IN ACCORDANCE WITH CLASS IB.
   GRADE B, SPEC MIL-C-6021.
7. MIL-W-13805 APPLIES.

APPLY MARKING AS INDICATED PER MIL-STD-130

CODE IDENT
NO. 19204

PART NO. 7267718

DESCRIPTION
BUSHING, BARREL

DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, IL 61201

52
2. REMOVE MATERIAL FROM INTERIOR OF BUSHING AS NECESSARY TO ACHIEVE SLIDING FIT (0.0002 TO 0.0005 CLEARANCE) WITH THE MUZZLE END OF THE BARREL. SURFACE FINISH ON THIS INTERNAL BEARING SURFACE SHALL NOT EXCEED 32/100 BORE CREATED BY THIS OPERATION SHALL MEET THE FOLLOWING REQUIREMENTS:

\[ \phi 0.0005 \]

\[ \phi 0.001 \mathrm{~A} (1) \]

3. MIL-W-13955 APPLIES

BUSHING — 7767718
SEE NOTE 2

BARREL — 7791414

SEE PL-7791469

PART NO. 7791469
BARREL AND BUSHING ASSEMBLY
DEPT. OF THE ARMY
SPRINGFIELD ARMORY
SPRINGFIELD, MA

MECHANICAL PROPERTIES:

<table>
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<th>MATERIAL</th>
<th>PROPERTY</th>
<th>VALUE</th>
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PISTOL: 7791209

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.

TOLERANCES ON DECIMALS:

- MATERIAL:
- APPLICATION:
- HEAT TREATMENT:
- FINAL PROTECTIVE FINISH:

ORIGINAL DATE OF DRAWING: 23 OCT 62

CHECKER:

APPROVED BY ORDER OF THE CHIEF OF MANUFACTURING:

SCALE 2/1
UNIT HT: 22LB
SHEET 1 OF 1