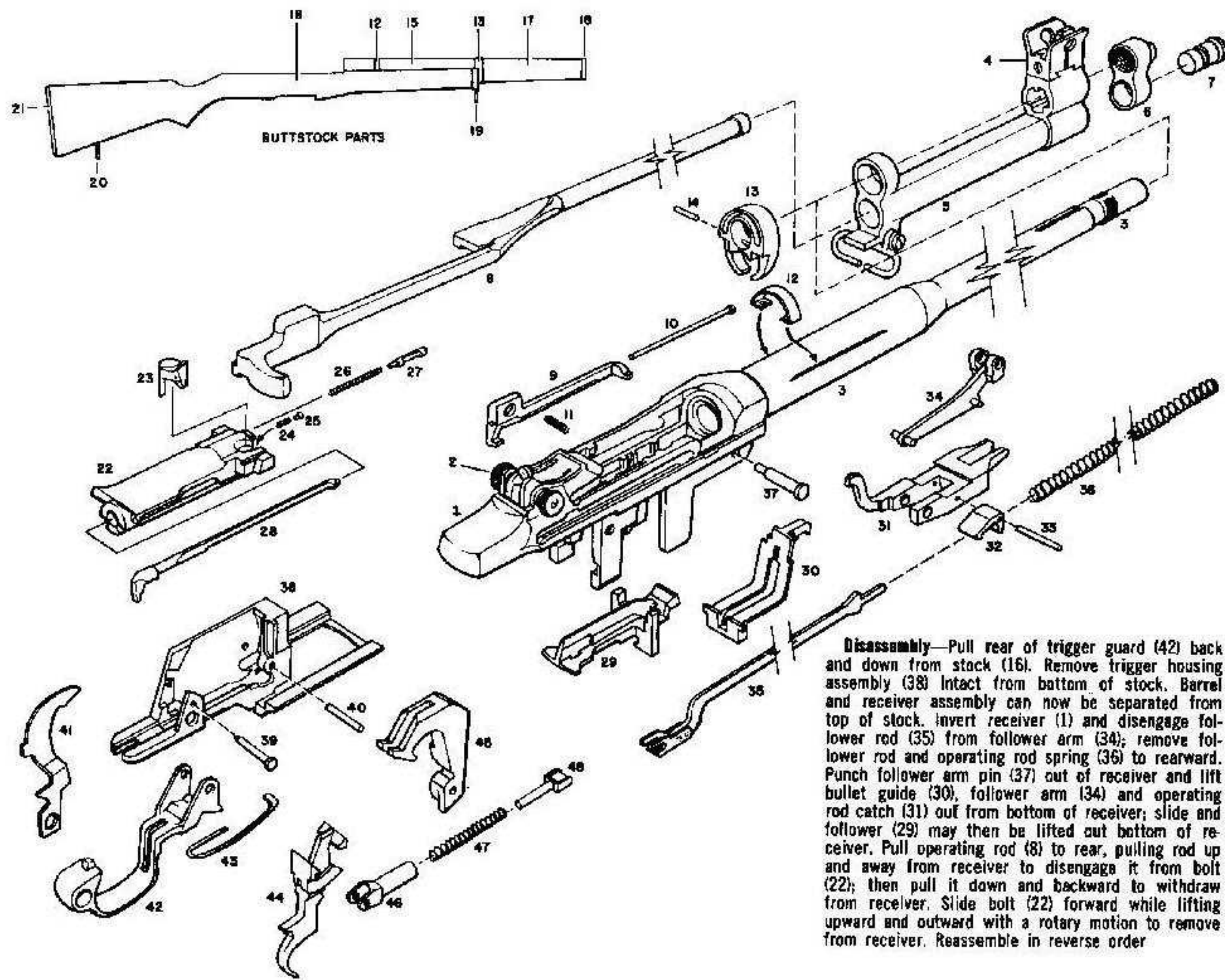
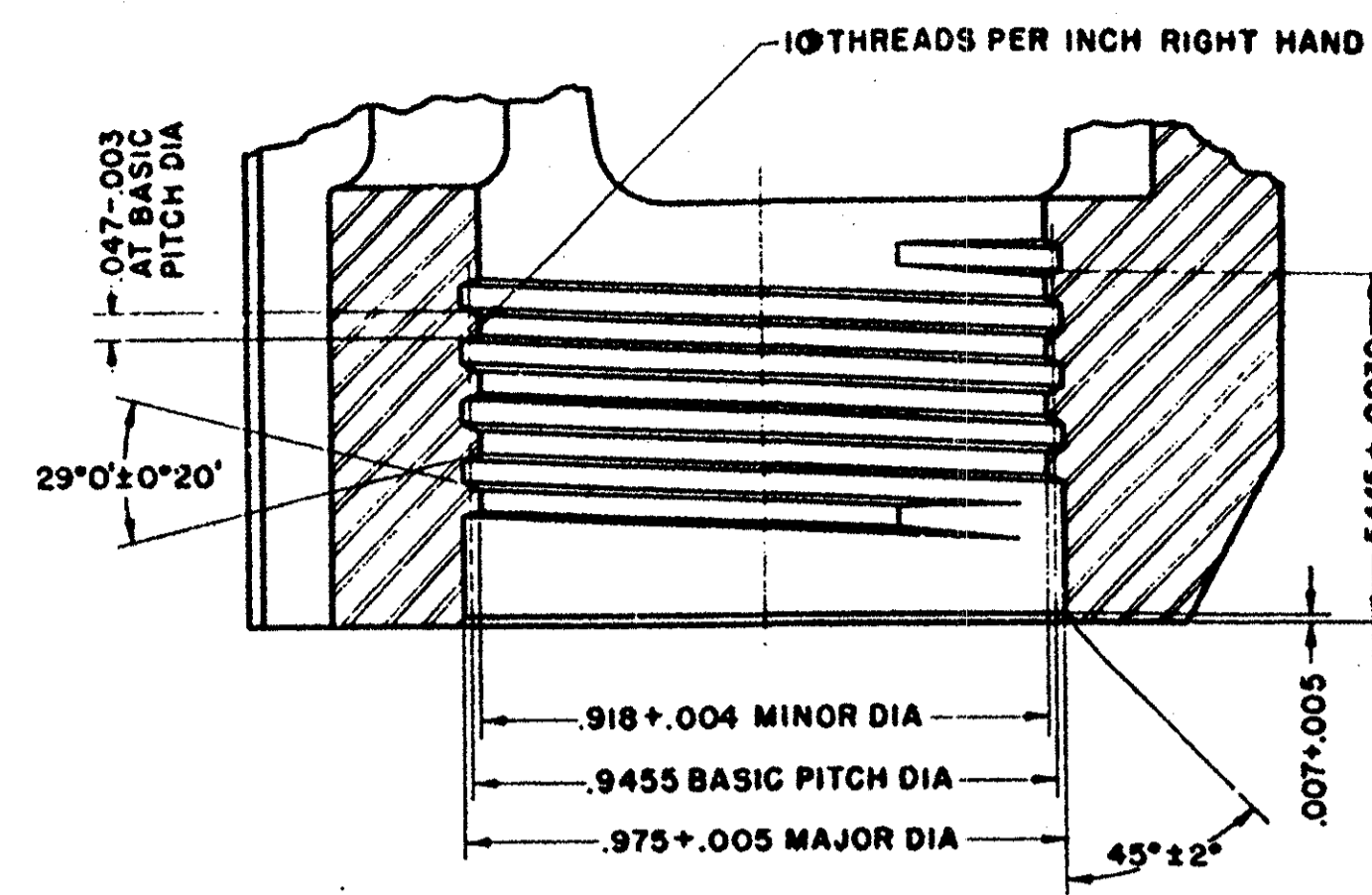


Parts List

1. Receiver
2. Rear Sight Assembly
3. Barrel
4. Front Sight
5. Gas Cylinder with Stacking Swivel
6. Gas Cylinder Lock
7. Gas Cylinder Lock Screw
8. Operating Rod
9. Clip Latch
10. Clip Latch Pin
11. Clip Latch Spring
12. Rear Handguard Band
13. Lower Band
14. Lower Band Pin
15. Rear Handguard (wood)
16. Stock (wood)
17. Front Handguard (wood)
18. Front Handguard Ferrule
19. Stock Ferrule & Swivel
20. Butt Swivel
21. Buttplate & Screws
22. Bolt
23. Extractor
24. Extractor Spring
25. Extractor Plunger
26. Ejector Spring
27. Ejector
28. Firing Pin
29. Slide & Follower
30. Bullet Guide
31. Operating Rod Catch
32. Accelerator
33. Accelerator Pin
34. Follower Arm
35. Follower Rod
36. Operating Rod Spring
37. Follower Arm Pin
38. Trigger Housing
39. Trigger Pin
40. Hammer Pin
41. Safety
42. Trigger Guard
43. Clip Ejector
44. Trigger
45. Hammer
46. Hammer Spring Housing
47. Hammer Spring
48. Hammer Spring Plunger

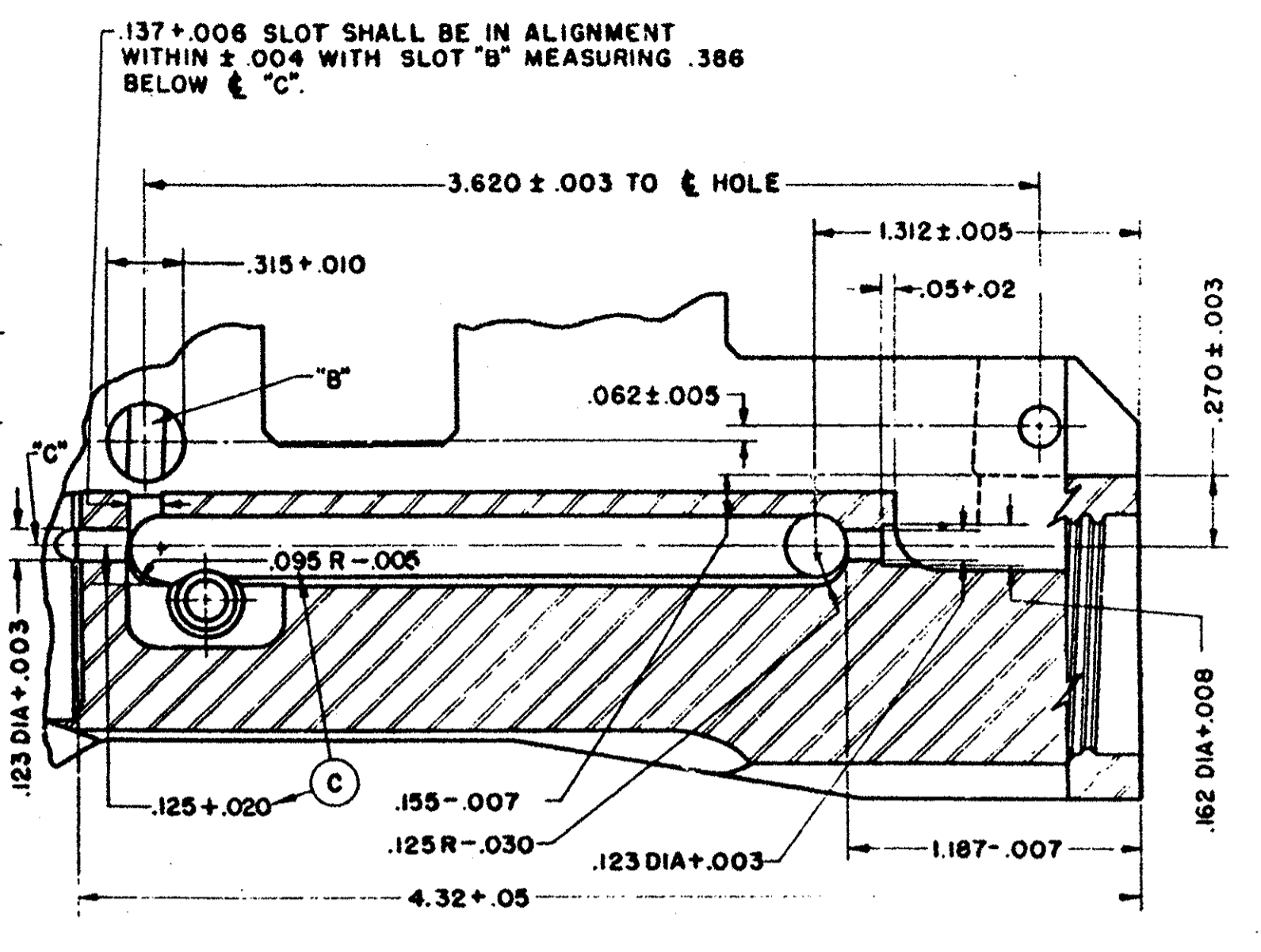
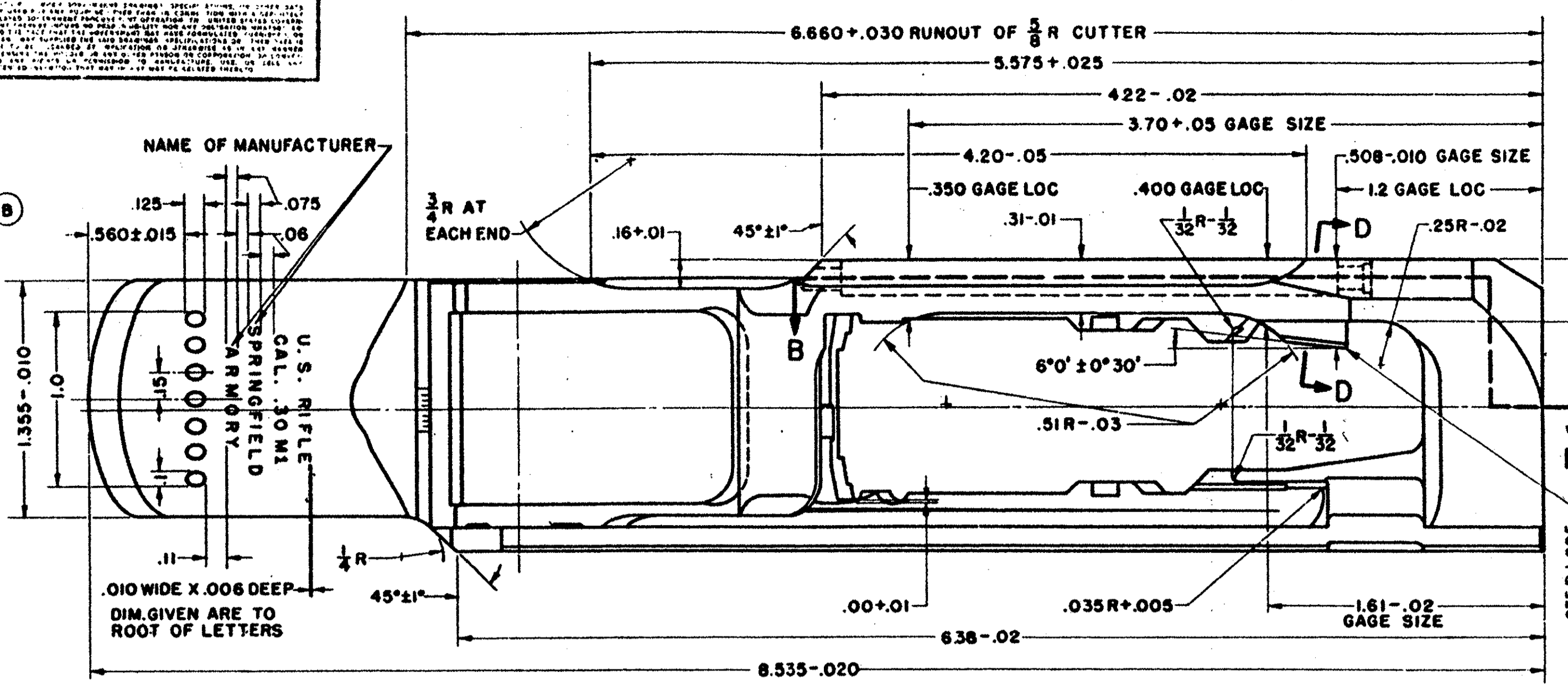


Disassembly—Pull rear of trigger guard (42) back and down from stock (16). Remove trigger housing assembly (38) intact from bottom of stock. Barrel and receiver assembly can now be separated from top of stock. Invert receiver (1) and disengage follower rod (35) from follower arm (34); remove follower rod and operating rod spring (36) to rearward. Punch follower arm pin (37) out of receiver and lift bullet guide (30), follower arm (34) and operating rod catch (31) out from bottom of receiver; slide and follower (29) may then be lifted out bottom of receiver. Pull operating rod (8) to rear, pulling rod up and away from receiver to disengage it from bolt (22); then pull it down and backward to withdraw from receiver. Slide bolt (22) forward while lifting upward and outward with a rotary motion to remove from receiver. Reassemble in reverse order.

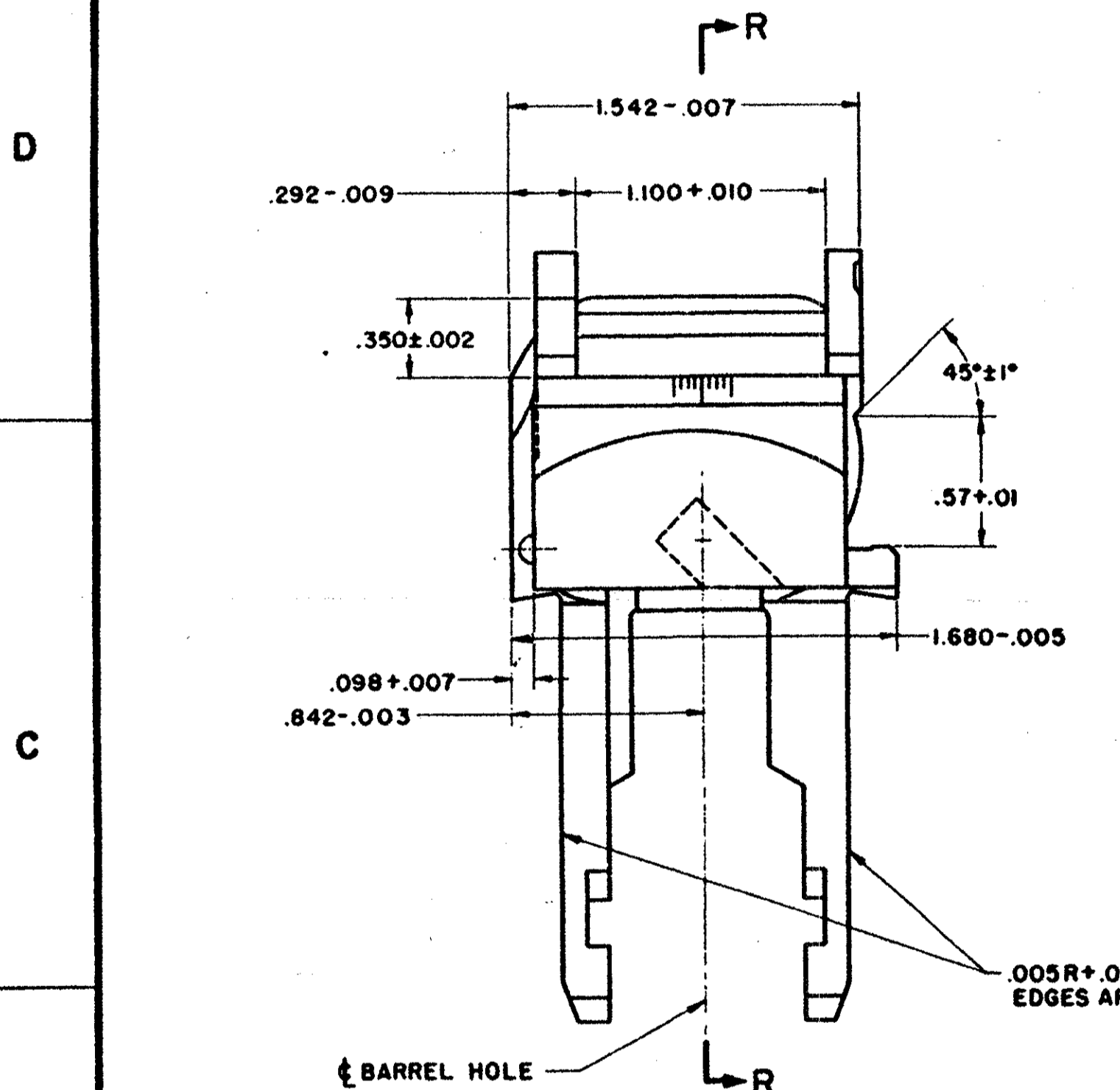


THREAD GAGE LOC ON .9455 BASIC PITCH DIA MEASURED ON HOR. C, LEFT HAND SIDE. C OF THREAD CUTTER AT RUNOUT SHALL BE 30°±10° AS SHOWN, BEYOND 5.445±.0030 DIMENSION THERE SHALL BE FOUR FULL THREADS

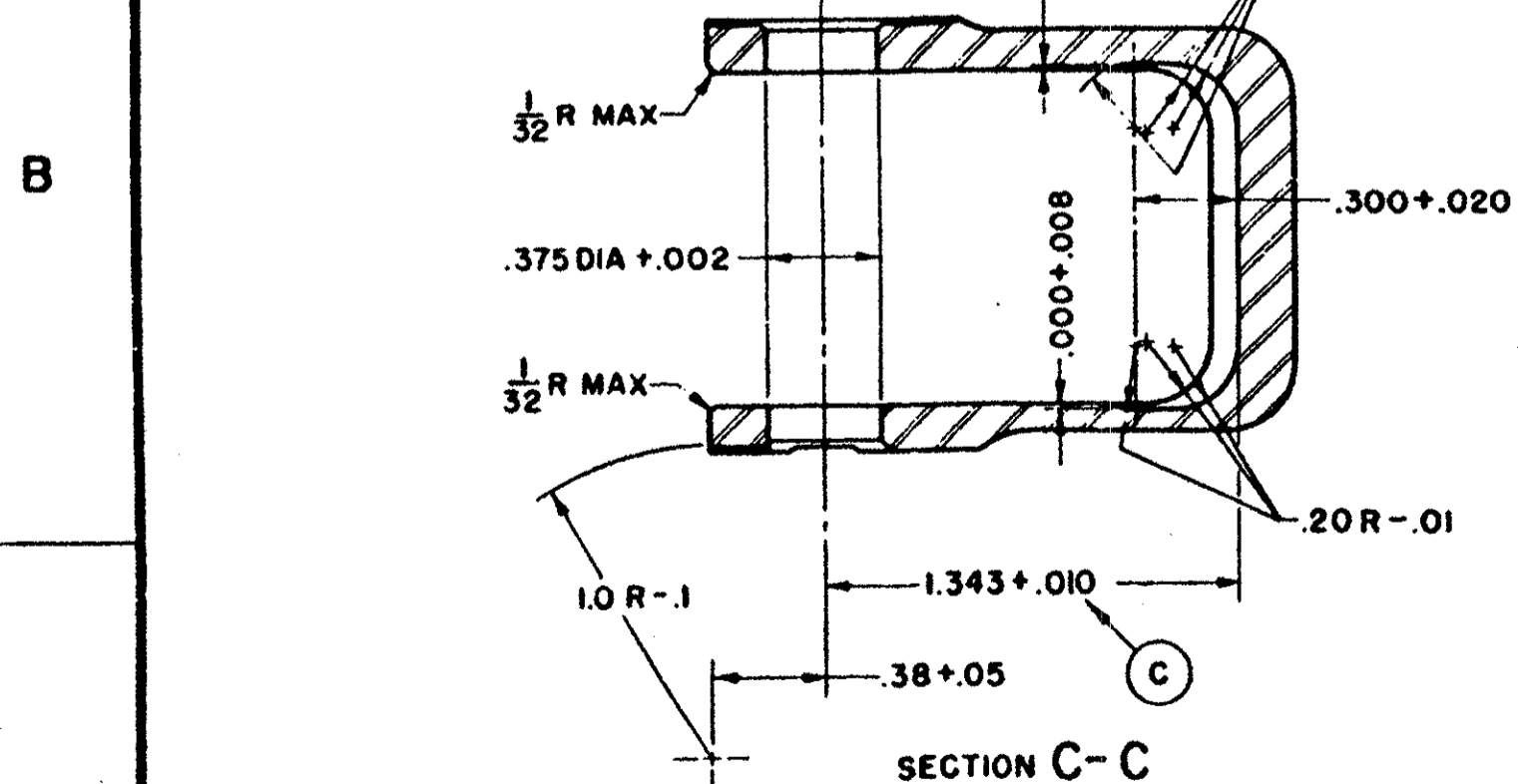
PARTIAL SECTION AA
SCALE 4/1



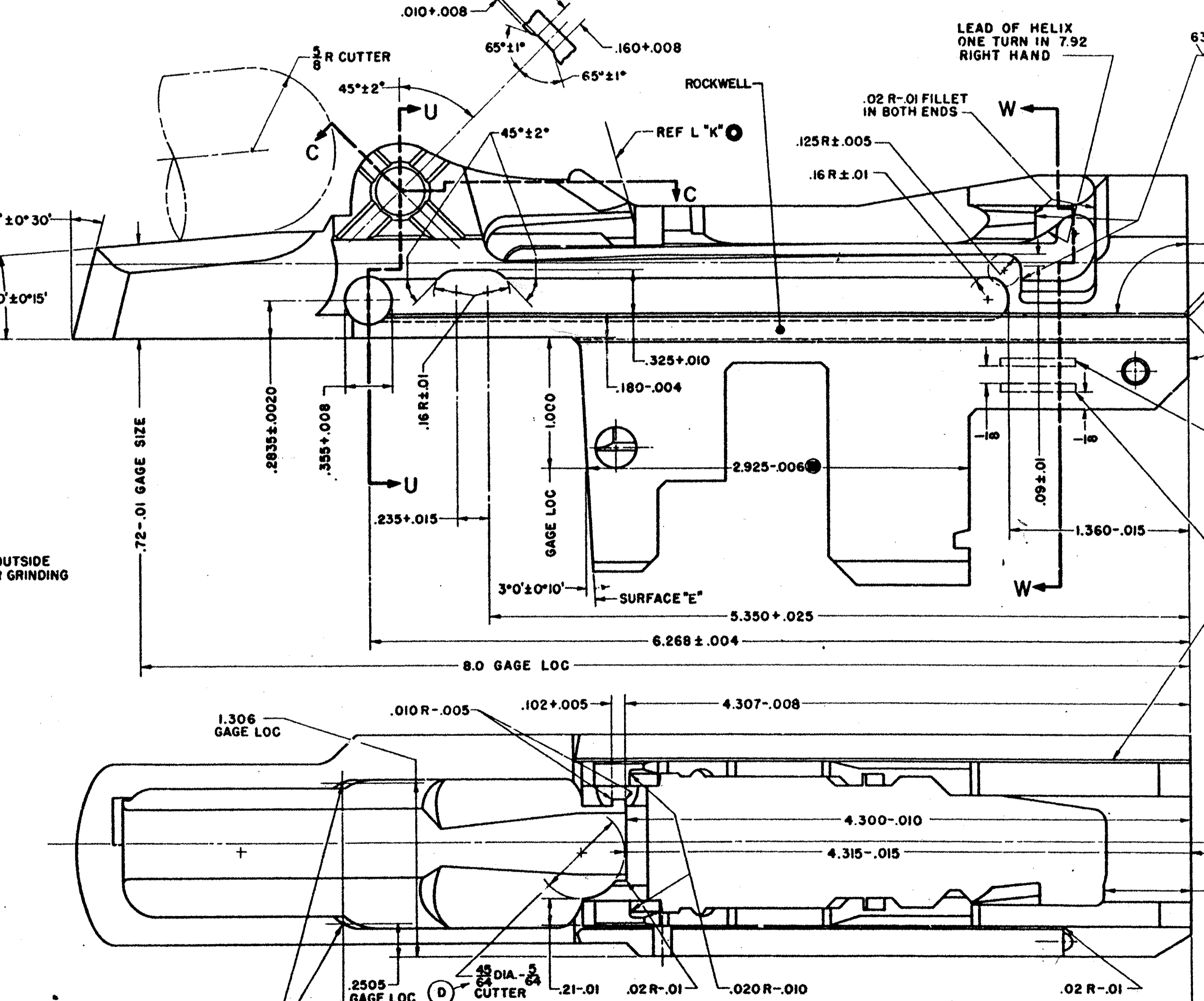
SECTION B-B



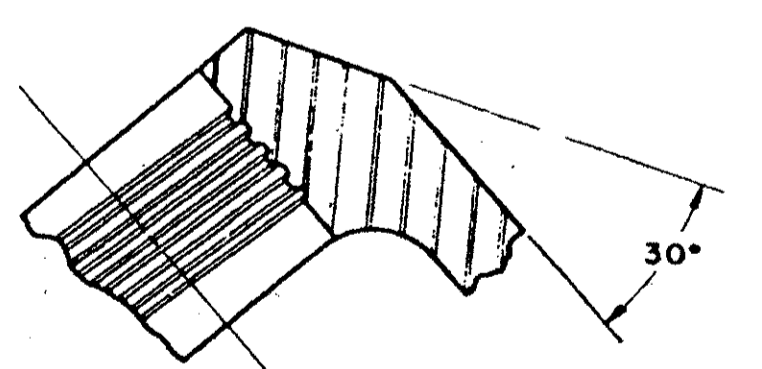
SECTION C-C



PARTIAL SECTION D-D



PARTIAL SECTION E-E



125/ALL OVER EXCEPT AS NOTED.

FACE OF LOCKING LUGS SHALL BE AT 90°0'±0'5' FROM THE CENTER LINE OF THE BOLT HOLE. GAGING OF THIS 90°0'±0'5' SHALL BE DONE RADIALLY

REFER TO SHEET 2.

HEAT TREATMENT: NORMALIZE BEFORE MACHINING. CARBURIZE .012-.018 DEEP. HEAT TO 1550°-1600° F, OIL QUENCH. TEMPER 1 HOUR AT 400° F.

MATERIAL: STEEL, FED SPEC QQ-S-624; FS 8620H. EXCEPT: SULPHUR .035-.050, (RESULPHURIZED) (GUN QUALITY) AUSTENITIC GRAIN SIZE 5 OR FINER - FED SPEC QQ-M-151, METHOD A

TAKEN ON FINISHED BOTTOM PLANE OF BOLT POCKET

GRIND SURFACE 'E' AFTER HEAT TREATMENT TO 2.918-.004 GAGE SIZE.

REFER TO SHEET 4, SEE SHEET 2 SECTION F-F FOR LOCATION

BARREL HOLE

HEAT LOT NO. 1/16 HIGH PERMISSIBLE

PART NO. 1/16 HIGH

DWG D7266081 APPLIES
DWG C7266184 APPLIES
DWG B7266102 APPLIES

PART NO. 6528291

REV	DESCRIPTION	DATE	APPROVAL
E1	ECO 23375		ESFERS
D	ECO 22075		SMARSA
C	ECO 20891		SMARSA
B1	ECO 20413		SMARSA
A	SUPERSEDES 6528291 WORKSHEET 1-53		

ORIGINAL DATE OF DRAWING: AUG 2, 1937

TRACER: G. O. [Signature]

ENGINEER: H. A. [Signature]

QUANTITY: [Blank]

HEAT TREATMENT: [Blank]

APPROVED BY: [Signature]

SCALE: 2/1

UNIT WT: 1.46

RECEIVER

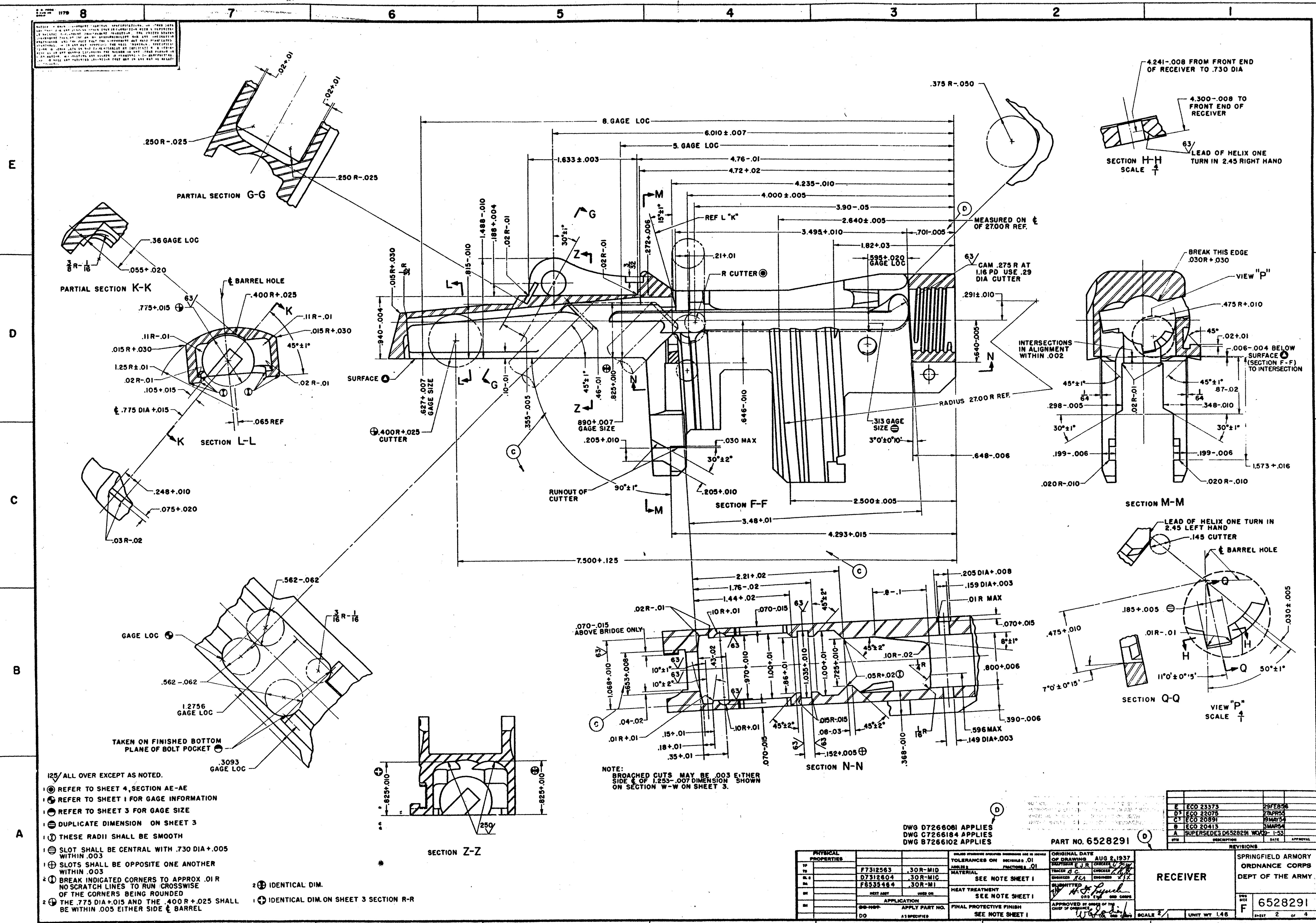
SPRINGFIELD ARMY
ORDNANCE CORPS
DEPT OF THE ARMY

DWG NO: F 6528291

SHEET: 1 OF 4

1179 8

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE TO BE TAKEN FROM THE SURFACE UNLESS OTHERWISE INDICATED. DIMENSIONS ARE TO BE TAKEN FROM THE SURFACE UNLESS OTHERWISE INDICATED. DIMENSIONS ARE TO BE TAKEN FROM THE SURFACE UNLESS OTHERWISE INDICATED.



- 125/ ALL OVER EXCEPT AS NOTED.
- 1 REFER TO SHEET 4, SECTION AE-AE
 - 2 REFER TO SHEET 1 FOR GAGE INFORMATION
 - 3 REFER TO SHEET 3 FOR GAGE SIZE
 - 4 DUPLICATE DIMENSION ON SHEET 3
 - 5 THESE RADII SHALL BE SMOOTH
 - 6 SLOT SHALL BE CENTRAL WITH .730 DIA + .005 WITHIN .003
 - 7 SLOTS SHALL BE OPPOSITE ONE ANOTHER WITHIN .003
 - 8 BREAK INDICATED CORNERS TO APPROX .01R NO SCRATCH LINES TO RUN CROSSWISE OF THE CORNERS BEING ROUNDED
 - 9 THE .775 DIA + .015 AND THE .400R + .025 SHALL BE WITHIN .005 EITHER SIDE ̄ BARREL
 - 10 IDENTICAL DIM.
 - 11 IDENTICAL DIM. ON SHEET 3 SECTION R-R

NOTE:
BROACHED CUTS MAY BE .003 EITHER SIDE ̄ OF 1.253 ± .007 DIMENSION SHOWN ON SECTION W-W ON SHEET 3.

DWG D7266081 APPLIES
DWG C7266184 APPLIES
DWG B7266102 APPLIES

PART NO. 6528291

PHYSICAL PROPERTIES		TOLERANCES ON DIMENSIONS .01 UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING AUG 2, 1937	
SP	F7312563	30R-MID	FUNCTIONS .01	DESIGNED BY	CHIEF
AL	D7312604	30R-MIC	FUNCTIONS .01	ENGINEER	CHIEF
IN	F8335484	30R-MI	FUNCTIONS .01	APPROVED BY	CHIEF
HEAT TREATMENT	SEE NOTE SHEET 1		APPROVED BY		
APPLICATION	APPLY PART NO. AS SPECIFIED		APPROVED BY		
DO	AS SPECIFIED		APPROVED BY		

REVISIONS	DATE	APPROVAL
E	ECO 23373	29FEB36
D	ECO 22076	27APR34
C	ECO 20891	29MAY34
B	ECO 20413	29MAY34
A	SUPPLEMENT 3 D6528291 W482-1-33	

RECEIVER

SPRINGFIELD ARMY ORDNANCE CORPS DEPT OF THE ARMY

6528291

SCALE 2/ UNIT WT 1.46 SHEET 2 OF 4

