DRAWINGS
OF THE
1911-A1
MODEL
GOVERNMENT
PISTOL

Note from the publisher
The information contained in these pages is provided solely for entertainment, education and historical interest. The publisher assumes no responsibility for the accuracy of this information or how this information is used by the reader. Any other use of this information is subject to applicable laws and regulations and is the sole responsibility of the user/reader. Be advised that any attempt to build or modify a firearm using this or any other information may be subject to federal, state, and local laws, and it is solely the responsibility of the reader to understand and obey those laws.
©2004 Western Sky Publishing Inc.
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.
<table>
<thead>
<tr>
<th>PART NUMBER</th>
<th>GOVERNMENT PART NUMBER</th>
<th>DESCRIPTION</th>
<th>PAGE</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>7265655</td>
<td>EXPLODED VIEW</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>6008596</td>
<td>SECTIONAL VIEWS</td>
<td>2, 3</td>
</tr>
<tr>
<td>3</td>
<td>7790314</td>
<td>BARREL BUSHING</td>
<td>6</td>
</tr>
<tr>
<td>4</td>
<td>7791193</td>
<td>SLIDE</td>
<td>4, 5</td>
</tr>
<tr>
<td>5</td>
<td>5013198</td>
<td>BARREL LINK</td>
<td>7</td>
</tr>
<tr>
<td>6</td>
<td>5013199</td>
<td>BARREL LINK PIN</td>
<td>8</td>
</tr>
<tr>
<td>7</td>
<td>6008598</td>
<td>EXTRACTOR</td>
<td>9</td>
</tr>
<tr>
<td>8</td>
<td>5013200</td>
<td>RECOIL SPRING</td>
<td>10</td>
</tr>
<tr>
<td>9</td>
<td>6008597</td>
<td>RECOIL SPRING GUIDE</td>
<td>11</td>
</tr>
<tr>
<td>10</td>
<td>5013201</td>
<td>RECOIL SPRING PLUG</td>
<td>12</td>
</tr>
<tr>
<td>11</td>
<td>6008599</td>
<td>FIRING PIN</td>
<td>13</td>
</tr>
<tr>
<td>12</td>
<td>5013205</td>
<td>FIRING PIN STOP</td>
<td>14</td>
</tr>
<tr>
<td>13</td>
<td>5013204</td>
<td>FIRING PIN SPRING</td>
<td>15</td>
</tr>
<tr>
<td>14</td>
<td>6535359</td>
<td>FRAME</td>
<td>16</td>
</tr>
<tr>
<td>15</td>
<td>5508659</td>
<td>MAGAZINE BODY</td>
<td>17</td>
</tr>
<tr>
<td>16</td>
<td>6008608</td>
<td>MAGAZINE FOLLOWER</td>
<td>18</td>
</tr>
<tr>
<td>17</td>
<td>6008607</td>
<td>MAGAZINE SPRING</td>
<td>19</td>
</tr>
<tr>
<td>18</td>
<td>6008606</td>
<td>MAGAZINE BASE PLATE</td>
<td>20</td>
</tr>
<tr>
<td>19</td>
<td>6008609</td>
<td>MAGAZINE CATCH</td>
<td>21</td>
</tr>
<tr>
<td>20</td>
<td>5013217</td>
<td>MAGAZINE CATCH SP.</td>
<td>22</td>
</tr>
<tr>
<td>21</td>
<td>5013218</td>
<td>MAGAZINE CATCH LOCK</td>
<td>23</td>
</tr>
<tr>
<td>22</td>
<td>5503841</td>
<td>MAINSPRING HOUSING</td>
<td>24</td>
</tr>
<tr>
<td>23</td>
<td>5506458</td>
<td>MAINSPRING HOUSING</td>
<td>25</td>
</tr>
<tr>
<td>24</td>
<td>5013208</td>
<td>MAINSPRING</td>
<td>26</td>
</tr>
<tr>
<td>25</td>
<td>5013209</td>
<td>MAINSPRING CAP</td>
<td>27</td>
</tr>
<tr>
<td>26</td>
<td>5013213</td>
<td>HOUSING PIN RETAINER</td>
<td>28</td>
</tr>
<tr>
<td>27</td>
<td>5013210</td>
<td>MAINSPRING CAP PIN</td>
<td>29</td>
</tr>
<tr>
<td>28</td>
<td>5013212</td>
<td>HOUSING PIN</td>
<td>30</td>
</tr>
<tr>
<td>29</td>
<td>5508600</td>
<td>HAMMER STRUT</td>
<td>31</td>
</tr>
<tr>
<td>30</td>
<td>5013207</td>
<td>HAMMER STRUT PIN</td>
<td>32</td>
</tr>
<tr>
<td>31</td>
<td>5013206</td>
<td>HAMMER PIN</td>
<td>33</td>
</tr>
<tr>
<td>32</td>
<td>6501828</td>
<td>GRIP SAFETY</td>
<td>34</td>
</tr>
<tr>
<td>33</td>
<td>6008595</td>
<td>SLIDE STOP</td>
<td>35</td>
</tr>
<tr>
<td>34</td>
<td>5503840</td>
<td>SAFETY LOCK</td>
<td>36</td>
</tr>
<tr>
<td>35</td>
<td>5554052</td>
<td>RIGHT GRIP</td>
<td>37</td>
</tr>
<tr>
<td>36</td>
<td>6019023</td>
<td>GRIP SCREW</td>
<td>38</td>
</tr>
<tr>
<td>37</td>
<td>6008602</td>
<td>SEAR SPRING</td>
<td>39</td>
</tr>
<tr>
<td>38</td>
<td>6008603</td>
<td>DISCONNECTOR</td>
<td>40</td>
</tr>
<tr>
<td>39</td>
<td>7268068</td>
<td>SEAR</td>
<td>41</td>
</tr>
<tr>
<td>40</td>
<td>6008594</td>
<td>PLUNGER TUBE</td>
<td>42</td>
</tr>
<tr>
<td>41</td>
<td>5013194</td>
<td>PLUNGER SPRING</td>
<td>43</td>
</tr>
<tr>
<td>42</td>
<td>5013193</td>
<td>SLIDE STOP PLUNGER</td>
<td>44</td>
</tr>
<tr>
<td>43</td>
<td>5013195</td>
<td>SAFETY LOCK PLUNGER</td>
<td>45</td>
</tr>
<tr>
<td>44</td>
<td>5013196</td>
<td>REAR SIGHT</td>
<td>46</td>
</tr>
<tr>
<td>45</td>
<td>6019024</td>
<td>EJECTOR</td>
<td>47</td>
</tr>
<tr>
<td>46</td>
<td>5013203</td>
<td>EJECTOR PIN</td>
<td>48</td>
</tr>
<tr>
<td>47</td>
<td>6019022</td>
<td>GRIP SCREW BUSHING</td>
<td>48</td>
</tr>
<tr>
<td>48</td>
<td>5013197</td>
<td>FRONT SIGHT</td>
<td>49</td>
</tr>
<tr>
<td>49</td>
<td>7266316</td>
<td>N.M. FRONT SIGHT</td>
<td>50</td>
</tr>
<tr>
<td>50</td>
<td>7791435</td>
<td>N. M. STANDARD CHAMBER</td>
<td>51</td>
</tr>
<tr>
<td>51</td>
<td>726671</td>
<td>N. M. SLIDE</td>
<td>52</td>
</tr>
<tr>
<td>52</td>
<td>7265718</td>
<td>N. M. BARREL BUSHING</td>
<td>53</td>
</tr>
<tr>
<td>53</td>
<td>7791469</td>
<td>N.BB/BUSH ASSY.</td>
<td>54</td>
</tr>
<tr>
<td>54</td>
<td>7255555</td>
<td>CUT-AWAY DRAWING</td>
<td>55</td>
</tr>
<tr>
<td>55</td>
<td>7266555</td>
<td>EXTERIOR VIEW</td>
<td>56</td>
</tr>
<tr>
<td>56</td>
<td>5013198</td>
<td>1NM</td>
<td>57</td>
</tr>
</tbody>
</table>

INDEX OF 1911-A1 PARTS DRAWINGS
1. MATERIAL:
A. WHEN FABRICATED FROM WROUGHT MATERIAL: STEEL, CMPSHDG THRU 1080, SPEC QQ-S-563, OR STEEL, CMPSN 4140, SPEC QQ-S-5624, AUSTENITIC GRAIN SIZE 6 OR FINER.
B. WHEN FABRICATED FROM CASTING: PRECISION CASTING, CMPSN IC-4140, SPEC ML-S-22141.
2. ALL EDGES SHALL BE BROKEN .005" ± .0025.
3. FINISH AS 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 VV-L-800.
6. CASTING SHALL BE CLASSIFIED AND INSPECTED IN ACCORDANCE WITH CLASS 18 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.

<table>
<thead>
<tr>
<th>PHYSICAL PROPERTIES</th>
<th>TOLERANCES ON</th>
<th>MODIFIED</th>
<th>1.000</th>
</tr>
</thead>
<tbody>
<tr>
<td>12</td>
<td></td>
<td>67794166</td>
<td></td>
</tr>
<tr>
<td>13</td>
<td></td>
<td>67794166</td>
<td></td>
</tr>
<tr>
<td>14</td>
<td></td>
<td>67794166</td>
<td></td>
</tr>
<tr>
<td>15</td>
<td></td>
<td>67794166</td>
<td></td>
</tr>
</tbody>
</table>

ORIGINAL DATE OF DRAWING 4 FEB 55

BUSHING, BARREL

DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, ILL. 61201

C 6003596
NOTES:
1. FINISH .75
2. ALL EDGES SHALL BE BROKEN .005 + .010.
3. MIL-W-13855 APPLIES.

PART NO. 5153127
THIS PART WAS RE-DRAWN FROM A DAMAGED MASTER.
SOME DIMENSIONS MAY BE APPROXIMATE.

TRIGGER PAD
NOTES:
1. FINISH 125 ALL OVER.
2. ALL EDGES SHALL BE BROKEN 0.005+0.010 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 1 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

DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, ILL., 61201

GUIDE, RECOIL SPRING

<table>
<thead>
<tr>
<th>CODE</th>
<th>DESCRIPTION</th>
<th>REVISIONS</th>
</tr>
</thead>
<tbody>
<tr>
<td>B</td>
<td>6008597</td>
<td>10FEB75</td>
</tr>
<tr>
<td>A</td>
<td>(1) SEE ERR HOR 50065</td>
<td>10FEB75</td>
</tr>
<tr>
<td>C</td>
<td>SEE ERR HOR 30687-1</td>
<td>23MAY75</td>
</tr>
<tr>
<td>D</td>
<td>(6) SEE ERR HOR 20704</td>
<td>26JAN75</td>
</tr>
<tr>
<td>A</td>
<td>REDRAWN AND REVISED SEE ED5A 26316</td>
<td>27NOV75</td>
</tr>
</tbody>
</table>

TABLE:

<table>
<thead>
<tr>
<th>PHYSICAL PROPERTIES</th>
<th>UNLESS OTHERWISE SPECIFIED</th>
</tr>
</thead>
<tbody>
<tr>
<td>APPLICATION</td>
<td>G35</td>
</tr>
<tr>
<td>MATERIAL</td>
<td>PISTOL M15</td>
</tr>
<tr>
<td>FINISH</td>
<td>0.086-0.005</td>
</tr>
<tr>
<td>DRAWING</td>
<td>0.095-0.010</td>
</tr>
<tr>
<td>TOLERANCES</td>
<td>0.655-0.006</td>
</tr>
<tr>
<td>3/16 R 2 PLACES</td>
<td>0.09 R+0.02</td>
</tr>
<tr>
<td>SCALE</td>
<td>2/1</td>
</tr>
<tr>
<td>UNIT WGT</td>
<td>0.02 LB</td>
</tr>
</tbody>
</table>

Date: 1 MAY 28
**DIAMETER OF WIRE**  
**DIAMETER OF COIL (OD)**  
**FREE LENGTH**  
**ACTIVE COILS**  
**TOTAL COILS**  
**DIRECTION OF HELIX**  
**LOAD AT COMPRESSED LENGTH OF**  
**LOAD AT COMPRESSED LENGTH OF**  
**SPRING RATE**  
**SOLID LENGTH**  
**TYPE OF ENDS**  
CRIMP ONE END COIL TO .326 -.010 ID

**SPECIAL DATA**
- HOLE DIA INTO WHICH SPRING FITS FREELY: .448 MIN
- ROD DIA OVER WHICH SPRING SLIDES FREELY: .336 MAX
- MANUFACTURE IN ACCORDANCE WITH MIL-S-13572,
  TYPE I, GRADE A.

*EXCEPT FOR CRIMPED END.*

---

<table>
<thead>
<tr>
<th>UNLESS OTHERWISE SPECIFIED</th>
<th>PHYSICAL PROPERTIES</th>
<th>MATERIALS AND MIN INCHES</th>
<th>GEOMETRIC TOLERANCES ON</th>
<th>DEPARTMENTS</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>TOLERANCES IN INCHES</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>DECIMALS ANGLES</td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**F7791205** PISTOL M9A1 VP  
**F7269381** NATL MATCH TS  
**F7265655** PISTOL M9A1 BA  
**SEE ENGGR RECORDS**

---

**US ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND**  
**DOVER, NEW JERSEY 07780**

- **CODE IDENT NO:** 19200  
- **PART NO:** 5013200  
- **SPRING, RECOIL**

---

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

- **BO MRT**  
- **APPLY PART NO. 00-00-G00000**

---

**SCALE:** LT COL  
[Unit Wt: .02 LB]
NOTES:

1. FINISH ALL OVER.

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

3. STEEL, CMPSN 1060, 1070, 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-13855 APPLIES.

---

**MECHANICAL PROPERTIES**

<table>
<thead>
<tr>
<th>YS MIN</th>
<th>YS MAX</th>
<th>EL2</th>
<th>RA</th>
<th>RH</th>
<th>RH</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td>B12066315</td>
<td>F7791205</td>
<td>F7268385</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>PISTOL, M15</td>
<td>PISTOL, M191A</td>
<td>NATL MATCH</td>
</tr>
</tbody>
</table>

**UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES**

- TOLERANCES:
  - ANGLES ± 5°
  - 3 PLACE DECIMALS
- 2 PLACE DECIMALS: \( \frac{1}{64} \)

**CONTRACT NO.:**

---

**DATE:** 1 MAY 28

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

**MATERIAL:** SEE NOTE 3

**STOP FIリング PIN**

---

**APPROVED:**
NOTES:
1. FINISH \( \frac{3}{8} \) EXCEPT AS NOTED.
2. ALL EDGES SHALL BE BROKEN 0.005 X 0.010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, SPEC QQ-S-563 OR ASTM A108 1060, 1070, 1095, AUSTENITIC GRAIN SIZE 7 OR FINER.

4. HEAT TREATMENT: HEAT AT 1450° TO 1500° 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.

5. TAKE HARDNESS READING ON .20 DIA +.01.

6. MIL-W-13855 APPLIES.

7. FINISH 5.3.1.2 OF MIL-STD-171.

---

**Physical Properties**

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>F279105</td>
<td>PISTOL M1911</td>
</tr>
<tr>
<td>F2796381</td>
<td>NATL MATCH</td>
</tr>
<tr>
<td>F726555</td>
<td>PISTOL M1911</td>
</tr>
<tr>
<td>F2200306</td>
<td>PISTOL M191</td>
</tr>
</tbody>
</table>

**Tolerances**: ±0.001 (0.010) DEGREES F ACTUAL .001 (.010) DEGREES F SEE NOTE 3

**Material**: SEE NOTE 3

---

**Heat Treatment**: SEE NOTE 4

---

**Revisions**

**Part No. 6008599**

---

**Code Ident No. 19204**

---

**Description**: PIN, FIRING

---

**Approvals**

- APPROVED BY: [Signature]
- DATE: [Date]
- ORGANIZATION: DEPT OF THE ARMY
- LOCATION: ROCK ISLAND ARSENAL
- SERIAL NO: 6008599
NOTES:
2. FINISH 125% ALL OVER.
3. FINISH 3.31 OF MIL-STD-171 WITH VV-L-800 SUPPLEMENTARY OIL TREATMENT.
4. MIL-W-13855 APPLIES.
NOTES:
1. FINISH ALL OVER.
2. DRILL #8 1/2" HOLE IF USED IN WELDED ASSEMBLY 7325599.
3. USE STEEL SAE 1045 OR 1050, SSW 1519.
4. MIL-W-13855 APPLIES.
ASSEMBLED HEIGHT: 4.3
LOAD AT COMPR. LENGTH: 12.5
APPROX. NUMBER OF COILS: 12.5
LOAD AT COMPR. LENGTH:

MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE I, GRADE A.
NOTES:
1. FOR WROUGHT MATERIAL: STEEL, CARBON SAE 1010 TO 1025; ASTM-A108.
2. FOR PRECISION CASTING: STEEL, CMSN IC-1020, IC-1030, MIL-S-22041.
4. FINISH #2 ALL OVER.
5. MIL-W-13255 SHALL APPLY.
6. THIS INFORMATION MAY BE INSCRIBED ON PART NO. 614714 AT ASSEMBLY.

.. Figure showing dimensions and notes...

INSCRIBE THE FOLLOWING INFORMATION:
09 HIGH X 0.010 + 0.005 DEEP PER MIL-STD-130.
19200-ASSY 5508694

CP R: CODE IDENT NO. (SEE NOTE 6)

PMIC: DO NOT SCALE DRAWING
MECHANICAL PROPERTIES
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
DECLIMAL TOLERANCES ON
5 PL. = .01
3 PL. = .005
ANGLE = .000

THIRD ANGLE PROJECTION

NATL MATCH

V. A. LUUKKONEN
DESIGN APPROVAL
S. C. SHULTZ

BASE, MAGAZINE

PART NO. 6008606

SMC R FORM 67, 1 DEC 87(TEMP), REPLACES SMCR FORM 67, 1 MAR 87(TEMP), WHICH MAY BE USED UNTIL EXHAUSTED.
1. STEEL, CMPSN 1018 THRU 1020, ASTM A108
   OR STEEL, CMPSN 117 SPEC QQ-S-637.

2. FINISH 0.25 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.
NOTES:
1. MIL-W-13855 APPLIES.
NOTES:
1. FINISH ALL OVER.
2. STEEL EXHOR: 25% HS THRU 0.005"; PNS THRU 0.017;
   AS WE; 0.005 OR STEEL SAE 4140 THRU H2; AS WE.
   A 574.

3. MIL-H-1385 APPLIES.

PARTIAL SECTION B-B

SECTION A-A

PARTIAL SECTION C-C
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.
4. STEEL, CMPSN 1018 THRU 1020,
   SPEC ASTM A576 OR ASTM A108
   OR CMPSN 1117, SPEC QQ-S-637.
5. MIL-W-13855 APPLIES.
NOTES:

1. FINISH **25 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-13655 APPLIES.

[Diagram of a component with dimensions and notes]

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT COMMAND
DOVER, NEW JERSEY 07801

CODE IDENT NO. 19200
PART NO. 5013213

MAINSPrING HOUSING PIN RETAINER

DEPT-OF-THE-ARMY
ROCK ISLAND ARSENAL
ROCK-IsLAND, ILL. 61201

CODE IDENT NO. 19200
NOTES:

1. FINISH TO ALL OVER.

2. HEAT TREATMENT: CARBURIZE TO CASE DEPTH .005 TO .008, OIL QUENCH, TEMPER TO 250°F.

3. MFL-W-13655 APPLIES.

4. FINISH 5.3.1.2 OF MIL-STD-171.

5. J4 DIA-004 TO SHARP CORNER

6. DIA-005 MAX

PART NO. 5013211
PIN, SEAR

NOTE: THIS DRAWING HAS BEEN GENERATED VIA A CAD SYSTEM LOCATED AT ANGLO FABRICATION SERVICES, LTD. CHANGES MUST BE INCORPORATED VIA THIS SYSTEM.

DRAWING NUMBER YIELD
REV.
19205
PAGE
5013211

PART NO. 5013210
PIN MAINSPRING CAP

NOTES:

1. FINISH TO ALL OVER.

2. HEAT TREATMENT: CARBURIZE TO CASE DEPTH .005 TO .008, OIL QUENCH, TEMPER AT 250°F.

3. MINIMUM TO HARDSHIP SPECIFIED, HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY, EXCEPT THAT CAST DEPTH AND HARDSHIP REQUIREMENTS ARE MANDATORY AT TEMPERATURES PERMITTED.

4. MATERIAL: STEEL, CARBON: SEE 1018 THRU 1020, 1127: ASTM A20 OR ASTM A456

5. FINISH 5.3.1.2 OF MIL-STD-171.

REVISIONS

ZONE
1

DESCRIPTION
REDRAWN W/CHANGE

NOR W452049/840719
(ECP W452067/841224)

DATE
2 MAY 1981

APPROVED
870621

DRAWN BY
DATE/REV/ADD
870621-01

CHECKED BY
S.L.
DATE/REV/ADD
870621-01

DESIGN APPROVAL
V.A. LUUKONEN
DATE/REV/ADD
870621-01

CONTRACTOR
S.C. SHULTZ
DATE/REV/ADD
870621-01

31
NOTES:
1. FINISH \(^{128/8} V^{C}\) 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.
3. MATERIAL: STEEL, ASTM A684, C45M
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.

MIL-W-13855 APPLIES.

6. FINISH 5.3.12 OF MIL-STD-171.
1. Finish 125% 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.
NOTES:

1. FINISH 1.25 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.
PARTIAL SECTION A-A
SECTION APPLIES TO SERRATIONS IN BOTH DIRECTIONS 10° APART.
SCALE 4/1

DETAIL B
SCALE 4/1

SEE DETAIL B

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

FINISH 5.3.1.2 OF MIL-STD-171.

MIL-W-13855 APPLIES.
TI:

THROUGH

ALL EDGES SHALL BE DRESSED 0.005 TOL

LESS OTHERWISE SPECIFIED

MATERIAL:

A. STEEL, CROMP-400, 1018, 4340—A 575, 4340.

B. STEEL, CROMP-400, 4140—A 4340.

C. INVESTMENT CASTING (CA), SPEC MIL-S-22441.

INSPECT CASTING PER MIL-C-42331, CLASS 1, GRADE A AND B. THIS METHOD PROVIDES FOUR HORIZONTAL 

ERASURES, EACH SIDE; THE LOWEST 

ERASURE TO BE LOCATED 0.068 FROM 

TOP OF THUMB PIECE. CONTOUR OF THUMB 

PIECE IS IDENTICAL REGARDLESS OF 

METHOD USED.

W-12055 APPLIES.

8555312 OF MIL—570—711.

SECTION A-A

SECTION C-C

SECTION B-B

ALTERNATIVE METHOD TO KNURLING

SCALE R0.1

(SEE NOTE 49)
NOTES:

1. RECESSES SHOWN ARE NONFUNCTIONAL AND ARE PERMITTED WITHIN REASONABLE LIMITS FOR STABILITY OF THE MOLDED PRODUCT.

2. WELDING PLASTICS SPEC MIL-M-14, PHENOLIC TYPE CFI-20.

3. APPLY PART NO. 1/8 HIGH IN RECESSED AREA PER MIL-STD-150.

4. MIL-W-15855 APPLIES.

SECTION A-A

SECTION C-C

DETAIL B

SCALE 4/1

CODE IDENT NO. 19204

PART NO. 5564062

DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, ILL. 61098

STOCK, RIGHT HAND, PLASTIC

NOTE 1

SEE NOTE 2

NOTE 3

SEE DETAIL B

SEE NOTE 1

SEE DETAIL B

SEE DETAIL B

SEE DETAIL B
1. Finish 125% except as noted.
2. All edges shall be broken .005 max unless otherwise specified.
3. Unless otherwise specified, all interior corners shall be rounded with fillet radii of from .003 to .015 inch.

4. Material:
   A - Steel, CMFSN 1060 thru 1080 per ASTM A576, A572 or ASTM A108.
   B - Steel, CMFSN 4150 per ASTM A304.
   C - Investment casting 1C4150, SPEC MIL-S-22144.

5. Unless otherwise specified, surface roughness Rz may be processed after application of final protective finish. Bright areas resulting from such processing are permissible. Apply oil per VV-L-1000 to bright areas.

6. Heat Treatment:
   A - Steel, 1060 thru 1080 and 4150 heat at 1540° to 1562°F in a neutral atmosphere or quench in well agitated austempering salt to specified hardness. Heat treatment method is for guidance only.
   B - Investment casting 4150 steel austemper to required hardness.

7. Finish 5.3.1.2 or 5.3.2.2 of MIL-STD-171.

8. MIL-W-13655 applies.

9. Inspect castings per MIL-C-6021, Class 1, Grade A.

U.S. Army Armament Research and Development Command
Dover, New Jersey 07801

Code Identify No. 19200

PART NO. 7268068

SECTION A-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-471.

5. MIL-W-13655 APPLIES.

CODE IDENT NO. 19204
PART NO. 6008594

B1006343 PISTOL, M15
PISTOL, M15A1
F7790428 NATL. MATCH
D5506399 PISTOL, M15A1

PHYSICAL PROPERTIES
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON FRACTIONS DECIMALS ANGLES
2.04

MATERIALS:
SEE NOTE 3

QTY.

APPROVED BY:

TUBE, PLUNGER
DEPT OF THE ARMY
ROCK ISLAND ARSENAL
ROCK ISLAND, ILL., SICC
NOTES:
1. FINISH 125 ALL OVER.
2. ALL EDGES SHALL BE BROKEN 0.005 + 0.000 UNLESS OTHERWISE SPECIFIED.
3. FINAL PROTECTIVE FINISH: FINISH 53.1.2 OR 5.3.2.2 OF MIL-STD-17L.
4. ALTERNATIVE MATERIAL: INVESTMENT CASTING 3620, SPEC. MIL-S-22181.
5. INSPECT CASTINGS PER MIL-STD-2410, CLASS 3, GRAY.

SEE DETAIL A
SCALE 10/1

DETAIL A

US ARMY ARMAMENT RESEARCH AND DEVELOPMENT CENTER
DOVER, NEW JERSEY 07802

CODE IDENT NO. 19205
PART NO. 5013196
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.
NOTE:
1. MATERIAL:
   A. WHEN FABRICATED FROM WROUGHT MATERIAL: STEEL, CMSPHDTH NMN, SPEC 00-S-6311, OR STEEL, CMSPH4140, SPEC 00-S-624.
   B. WHEN FABRICATED FROM CASTING: PRECISION CASTING, CMSPH4140, SPEC MIL-S-22141L.
2. ALL EDGES SHALL BE BROKEN 0.05 + .020.
3. FINISH AS SHOWN EXCEPT AS OTHERWISE SPECIFIED.
4. HEAT TREATMENT: HEAT AT 1625° TO 1775° 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 IN GRADE B, SPEC MIL-C-6021.
7. MIL-W-13855 APPLIES.

APPLY MARKING AS INDICATED PER MIL-STD-130

CODE IDENT NO. 19204

PART NO. 7267718

BUSHING, BARREL

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

C7267718

52
1. The components of this assembly are a matched set and shall not be separated for use individually in weapons.

2. Remove material from interior of bushing as necessary to achieve a sliding fit (0.002 to 0.005 clearance) with the muzzle end of the barrel. Surface finish on this internal bearing surface shall not exceed 32. Bore created by this operation shall meet the following requirements:

- 0.0005
- ± 0.001 A (L)

3. MIL-W-13955 applies

---

BUSHING — 7267718 (SEE NOTE 2!)

BARREL — 7791414

---

MECHANICAL PROPERTIES

<table>
<thead>
<tr>
<th>PROPERTY</th>
<th>7791400</th>
<th>MATERIAL</th>
<th>MRPIAI - NM</th>
</tr>
</thead>
<tbody>
<tr>
<td>TPR</td>
<td>1500</td>
<td>TEMPER</td>
<td>1500</td>
</tr>
<tr>
<td>EL 2</td>
<td>250</td>
<td>EXTREMES</td>
<td>250</td>
</tr>
<tr>
<td>BHN</td>
<td>200</td>
<td>HARDENED</td>
<td>200</td>
</tr>
<tr>
<td>AN</td>
<td>100</td>
<td>ANNEALED</td>
<td>100</td>
</tr>
</tbody>
</table>

UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES

TOLERANCES

<table>
<thead>
<tr>
<th>DIMENSIONS</th>
<th>TOLERANCES</th>
<th>DECIMALS</th>
</tr>
</thead>
<tbody>
<tr>
<td>23 OCT 62</td>
<td>.001</td>
<td>3</td>
</tr>
</tbody>
</table>

ORIGINAL DATE OF DRAWING: 23 OCT 62

CHECKER: L. R. R. CHECKER: R. W. R.

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE

SPRINGFIELD ARMORY
SPRINGFIELD, MASS.

CASE CODE: 19205 C 7791469

PART NO. 7791469

BARREL AND BUSHING ASSEMBLY

SCALE 2/1 UNIT MT 22LB SHEET 1 OF 1