

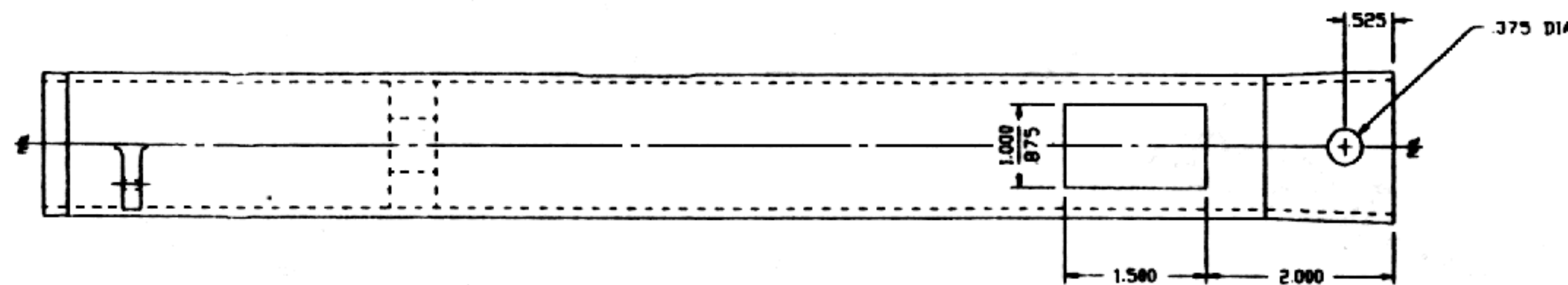
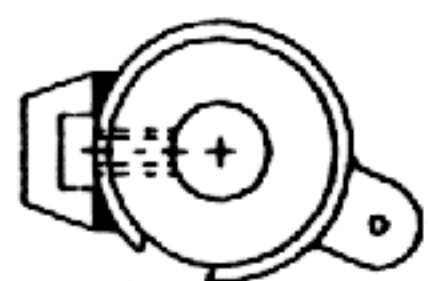
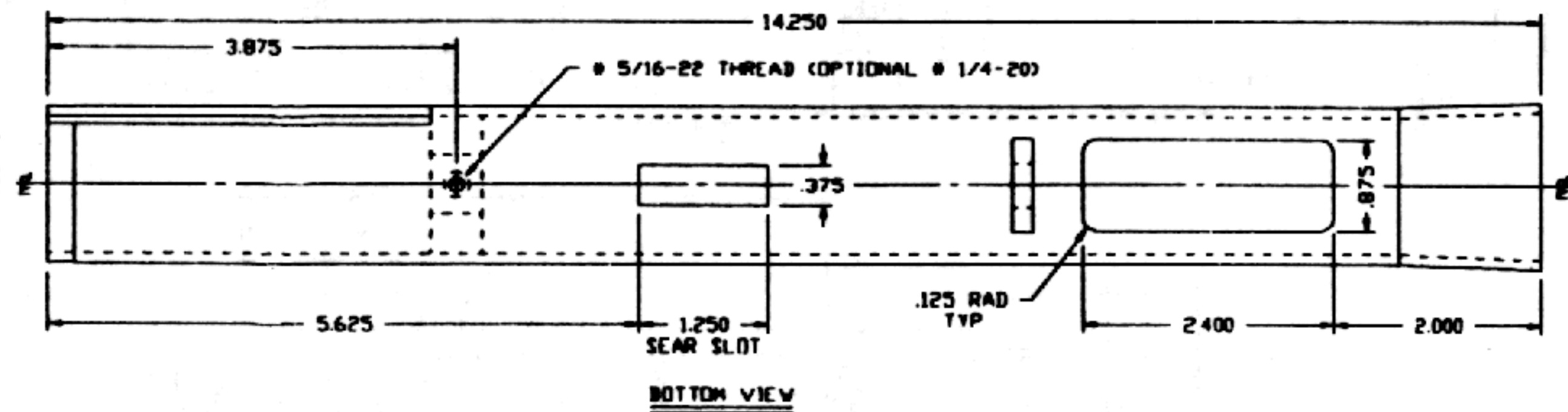
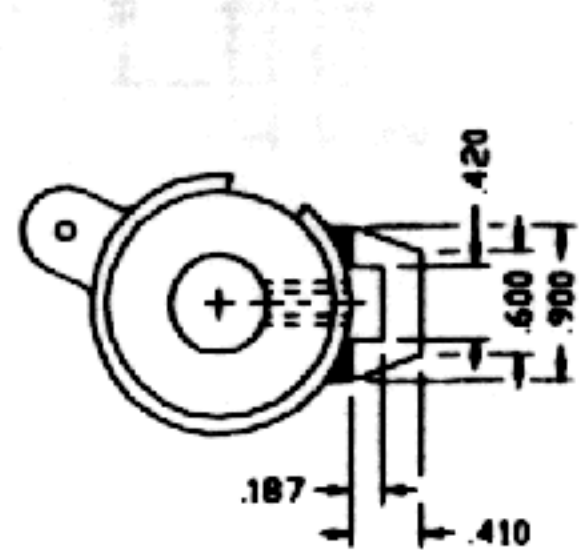
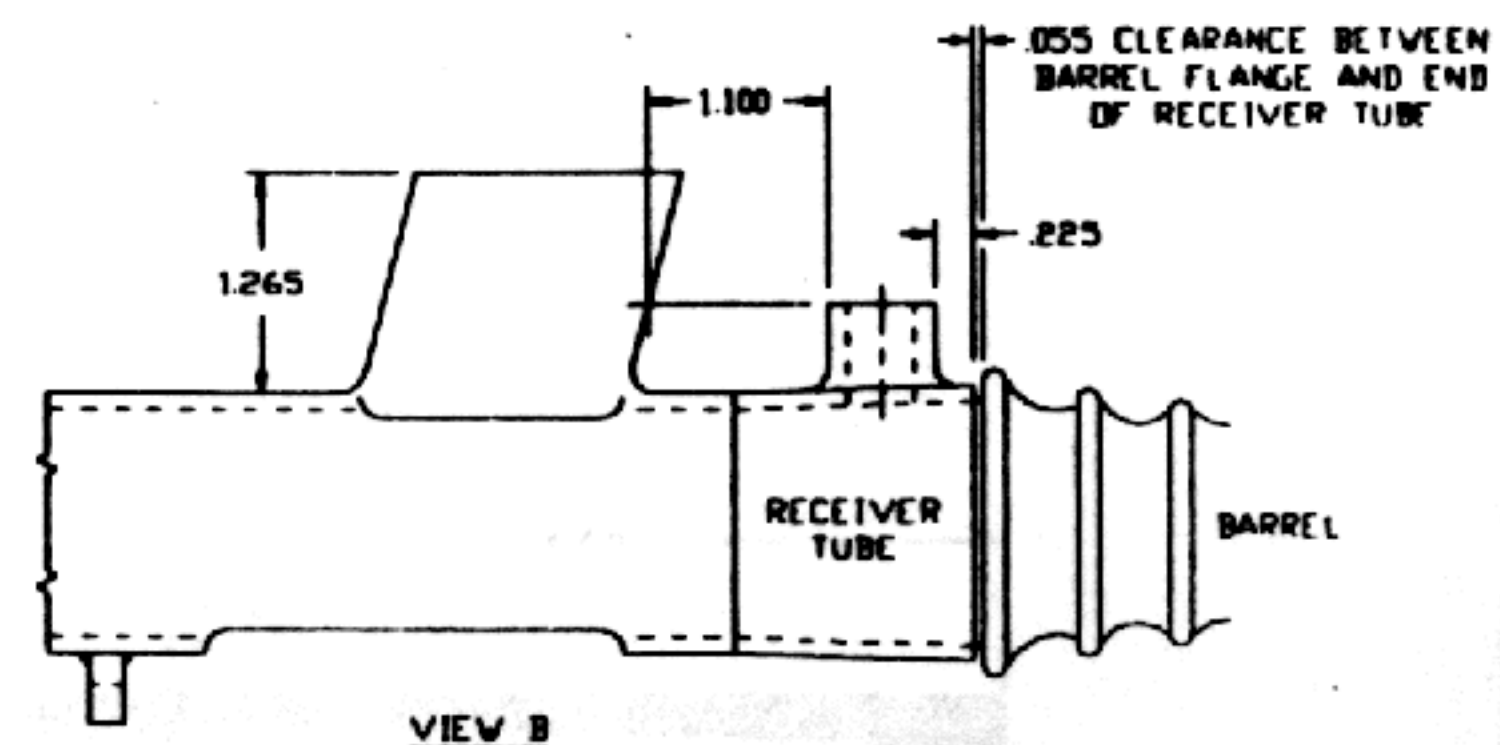
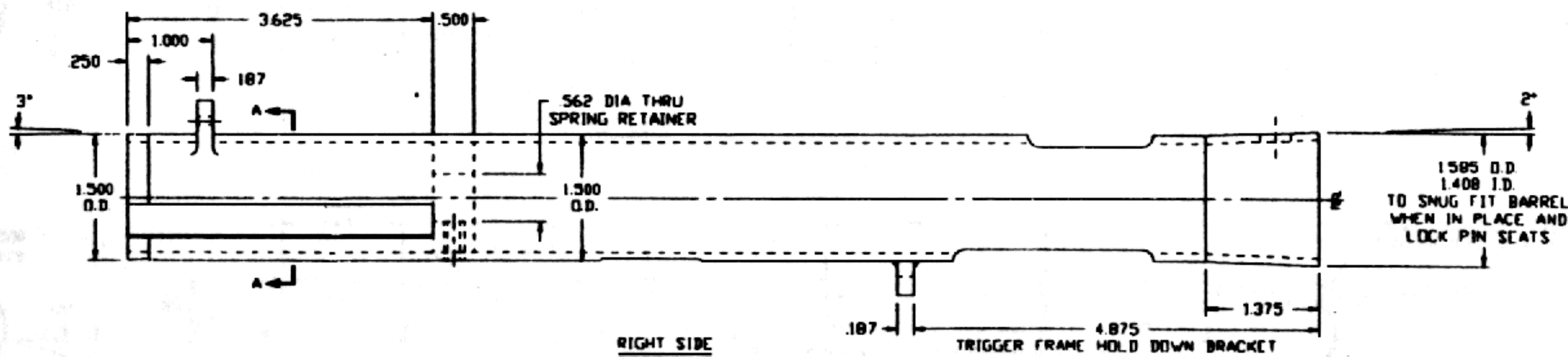
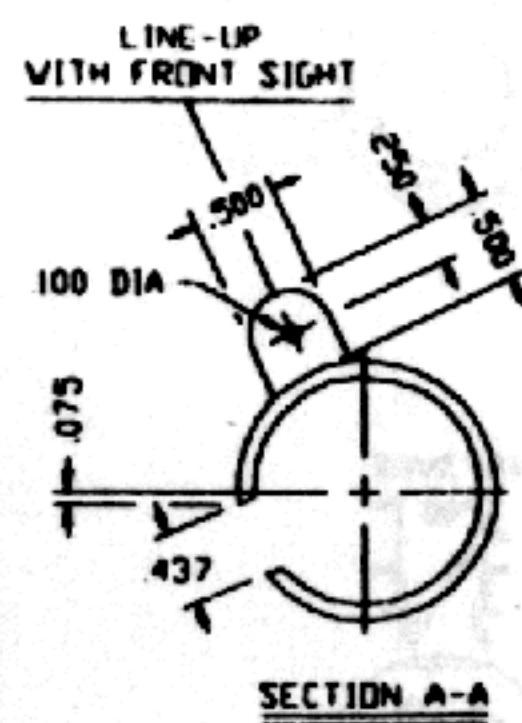
TABLE OF CONTENTS

1- scale print of OWEN MK II 1943

1- scale print of REISING

1- scale print of SPRINGFIELD M-60 lt. MG

PARTS SUPPLIERS ON LAST PAGE



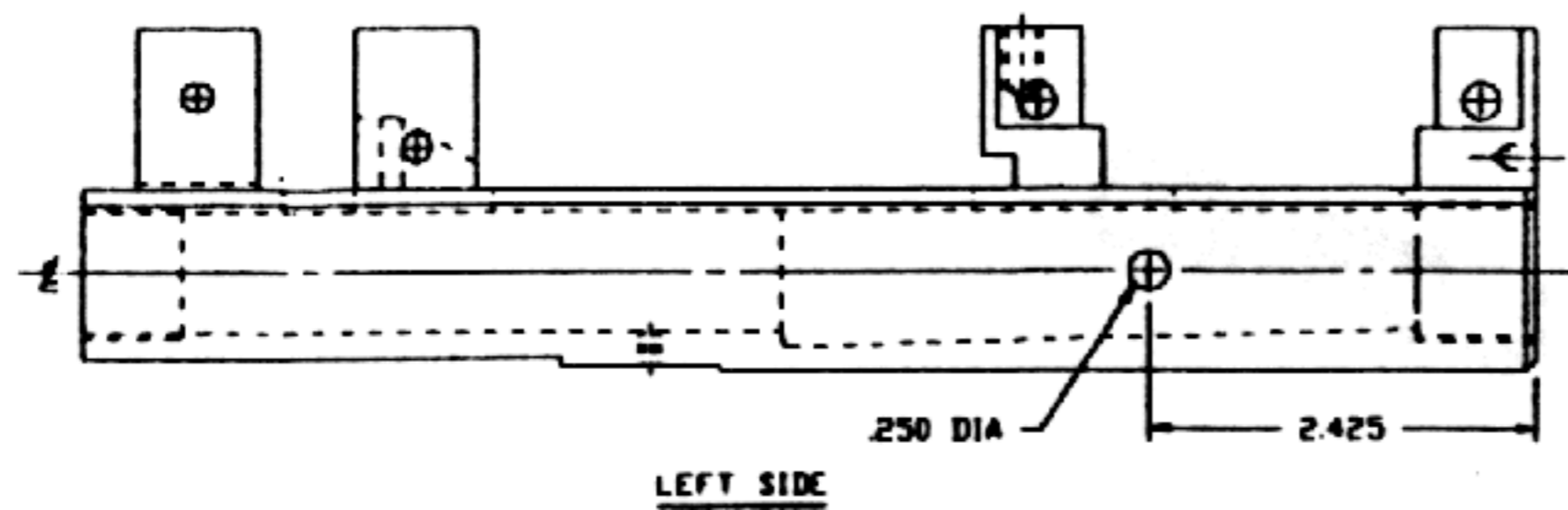
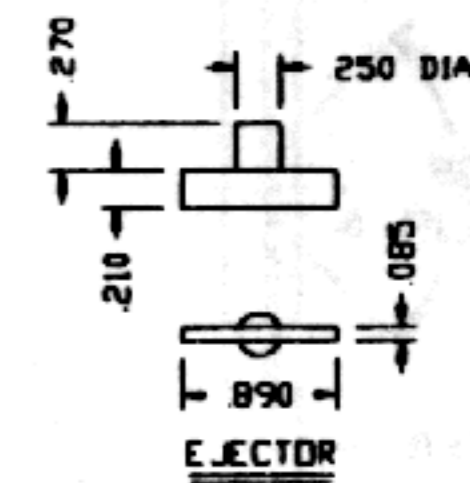
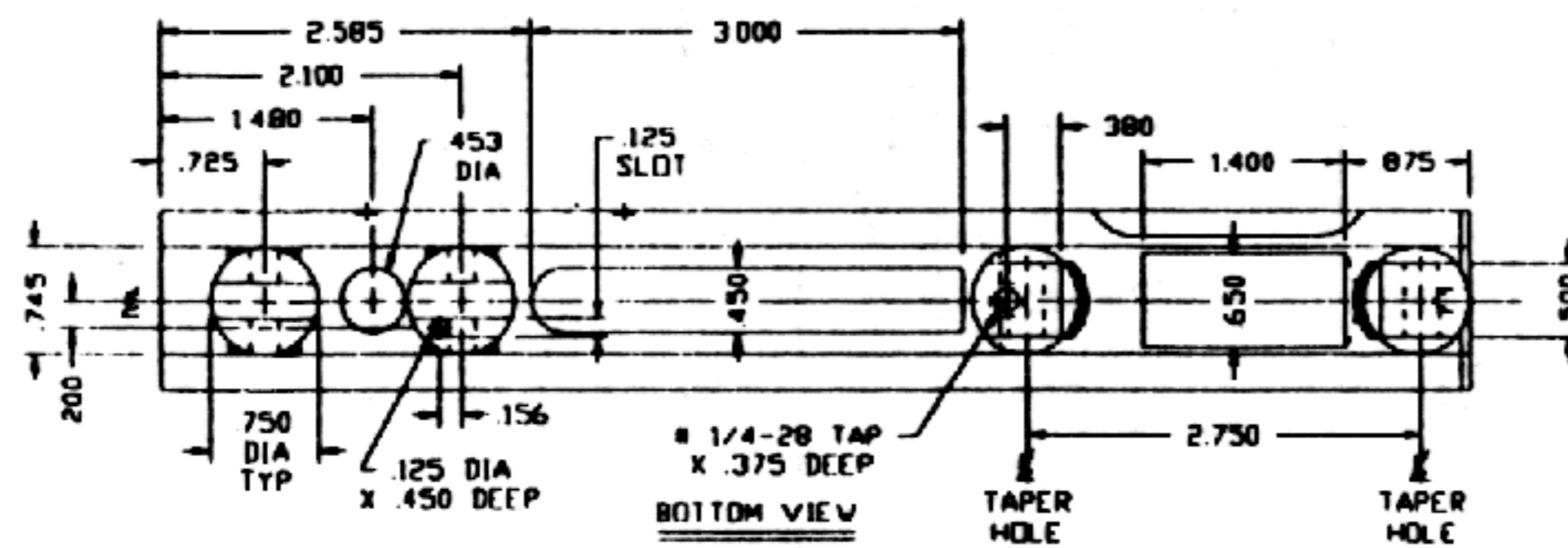
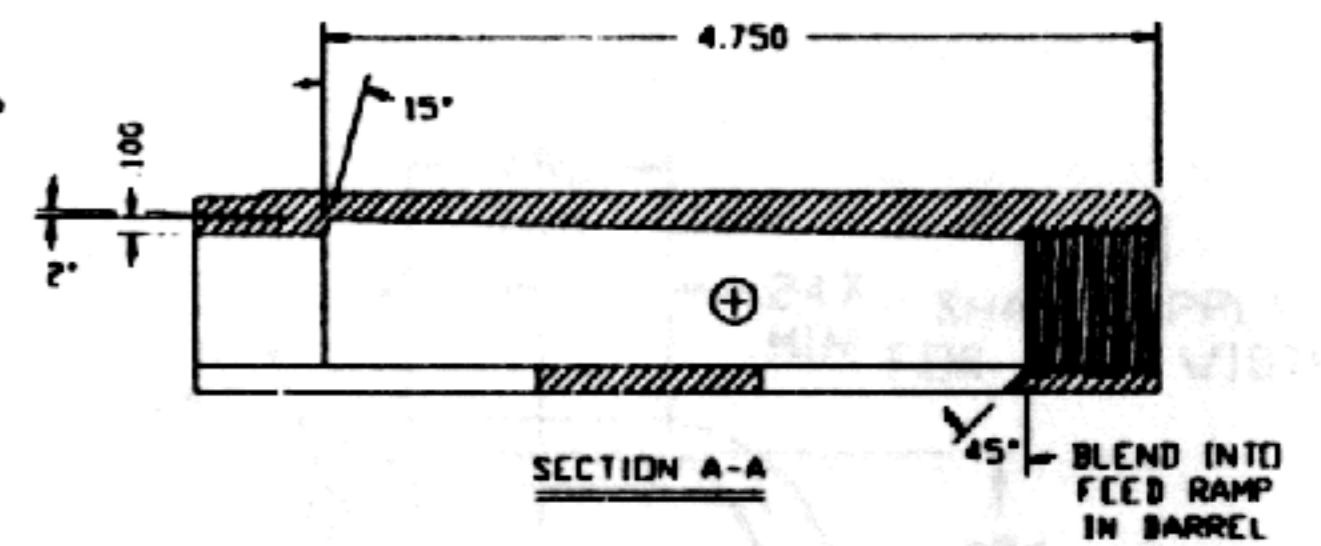
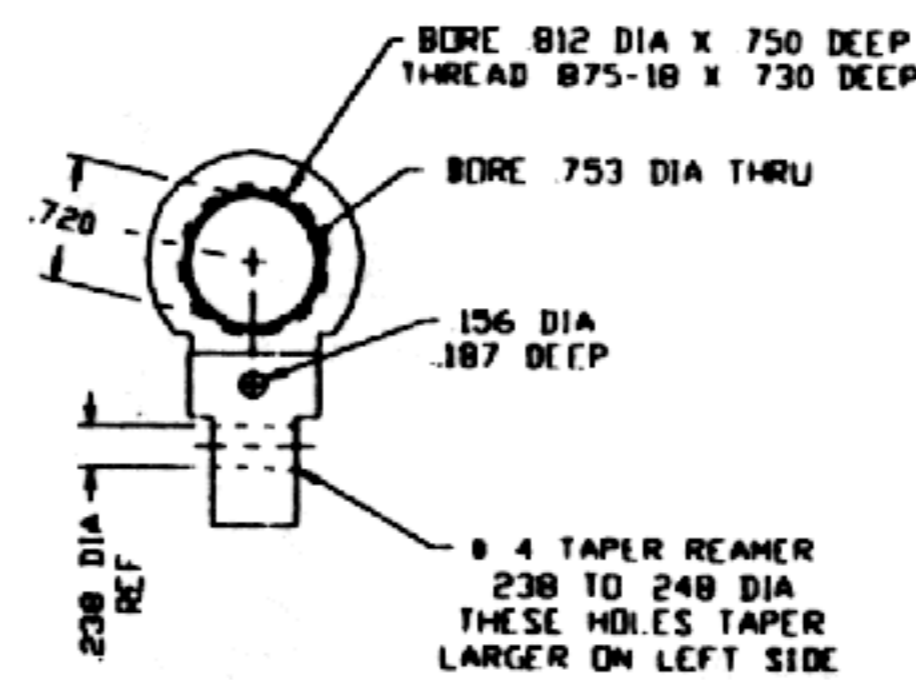
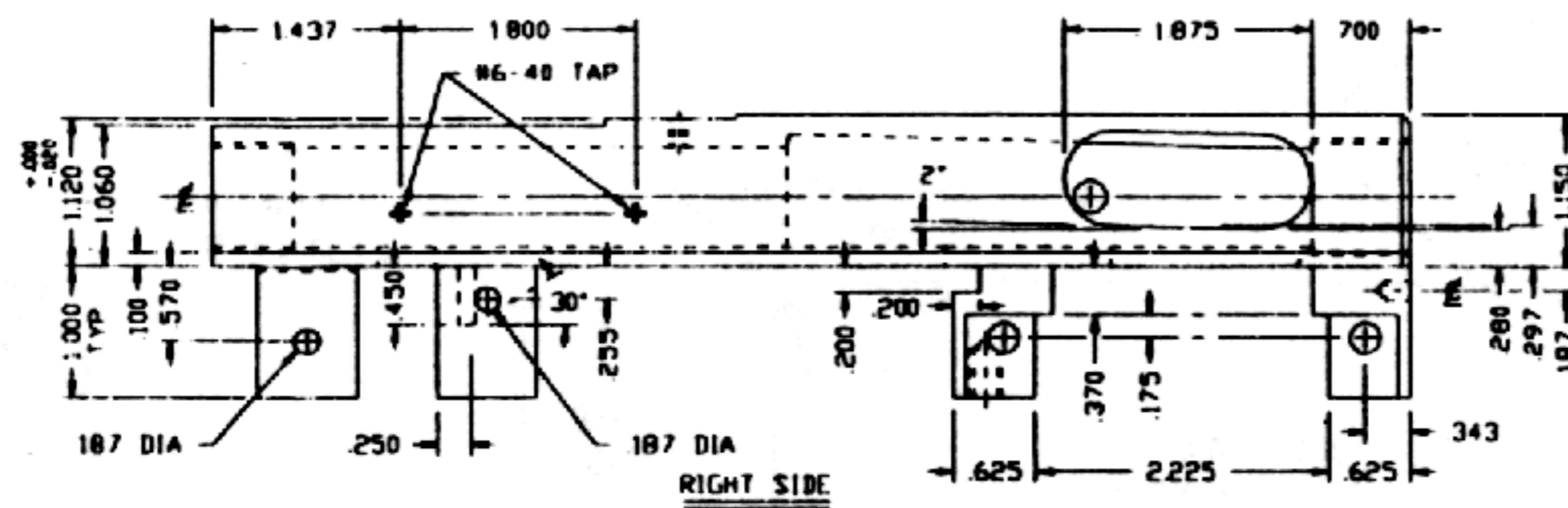
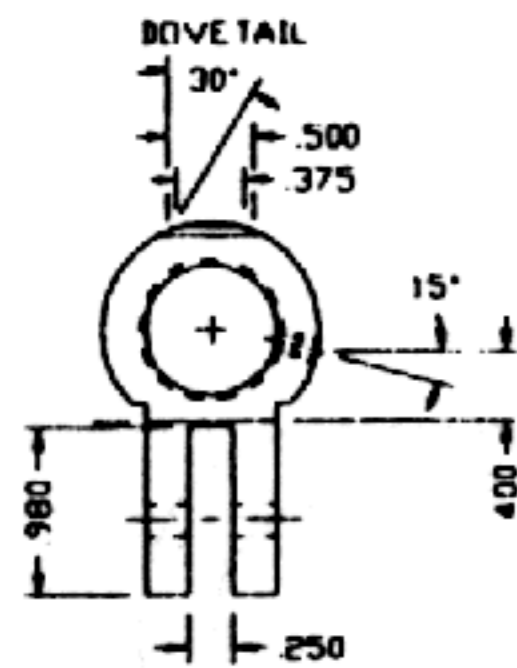
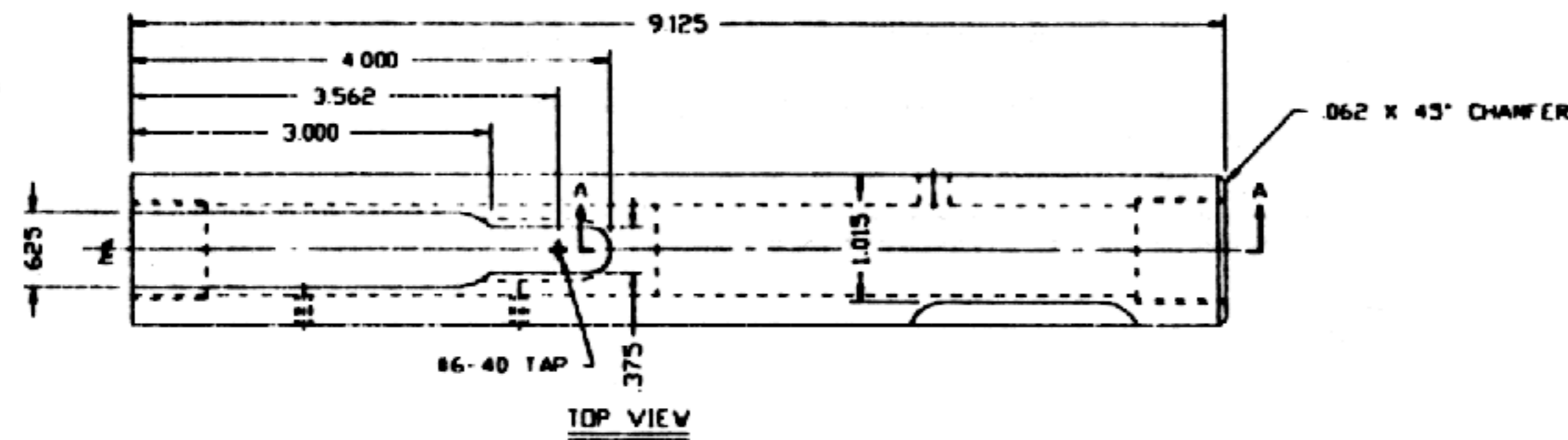
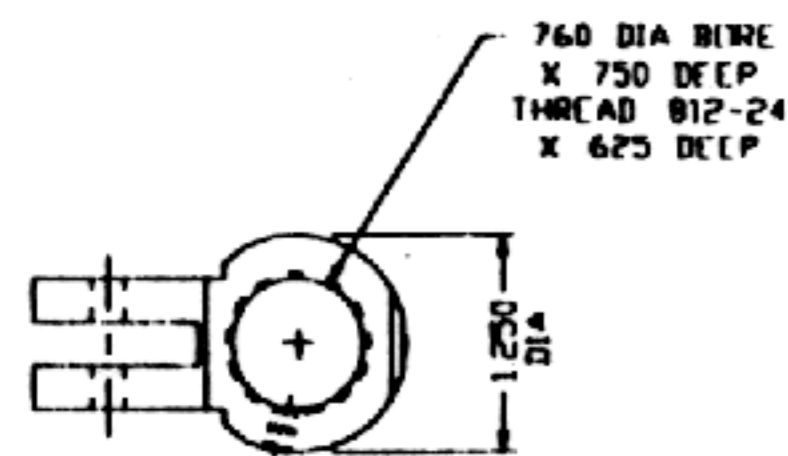
NOTES

1. MATERIAL - 1.625 O.D. X 1.312 I.D. DOM STEEL TUBE
2. FINISH - PAKERIZE THEN PAINT BLACK OR CAMOFLAGE
3. SOME PART KITS COME WITH FRONT RECEIVER PARTS IN FACT. IF THIS IS YOUR CASE, THEN REAR PART OF RECEIVER TUBE CAN BE ALIGNED AND BUTT WELDED.
4. IF PARTS ARE LOOSE, REFER TO 'VIEW B' FOR THEIR LOCATION
5. Ø 5/16-22 THREAD IS BRITISH AND CAN BE SUBSTITUTED WITH Ø 7 DRILL (.201 DIA) AND TAP Ø 1/4-20 THREAD. REPLACE ORIGINAL Ø 5/16 SCREW WITH Ø 1/4 ROUND HEAD SCREW
6. SPRING RETAINER IS 1.312 O.D. WITH .562 DIA HOLE IN CENTER AND .500 WIDE. WELD IN PLACE USING 3 OR 4 DRILLED HOLES EQUALLY SPACED IN RECEIVER TUBE AT 3.875 DIMENSION AFTER ARC WELDING SPRING RETAINER AND RECEIVER TUBE TOGETHER DRILL AND TAP Ø 1/4-20 HOLE IN BOTTOM FOR TRIGGER FRAME HOLD DOWN SCREW.
7. WHEN 3° TAPER IS CUT ON REAR OF RECEIVER TUBE IT SHOULD MEASURE 1.400 AT SMALL END. DUST COVER FITS IN PLACE OVER THIS TAPER.
8. EARLY MODEL BARRELS WERE FINISHED. LATE MODEL BARRELS WERE PLAIN.

RESTRICTED MATERIAL

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SCALE: FULL	MATERIAL: SEE NOTE 1	CRS	TOLERANCES: SEE 2 PL. 3 PL. 4 PL.
DATE:	FINISH: SEE NOTE 2	DATE:	SEE 3 PL. 4 PL.
TITLE: OWEN MK II MODEL 1943 RECEIVER		REV.	ANGLES: 8°
		NO.	

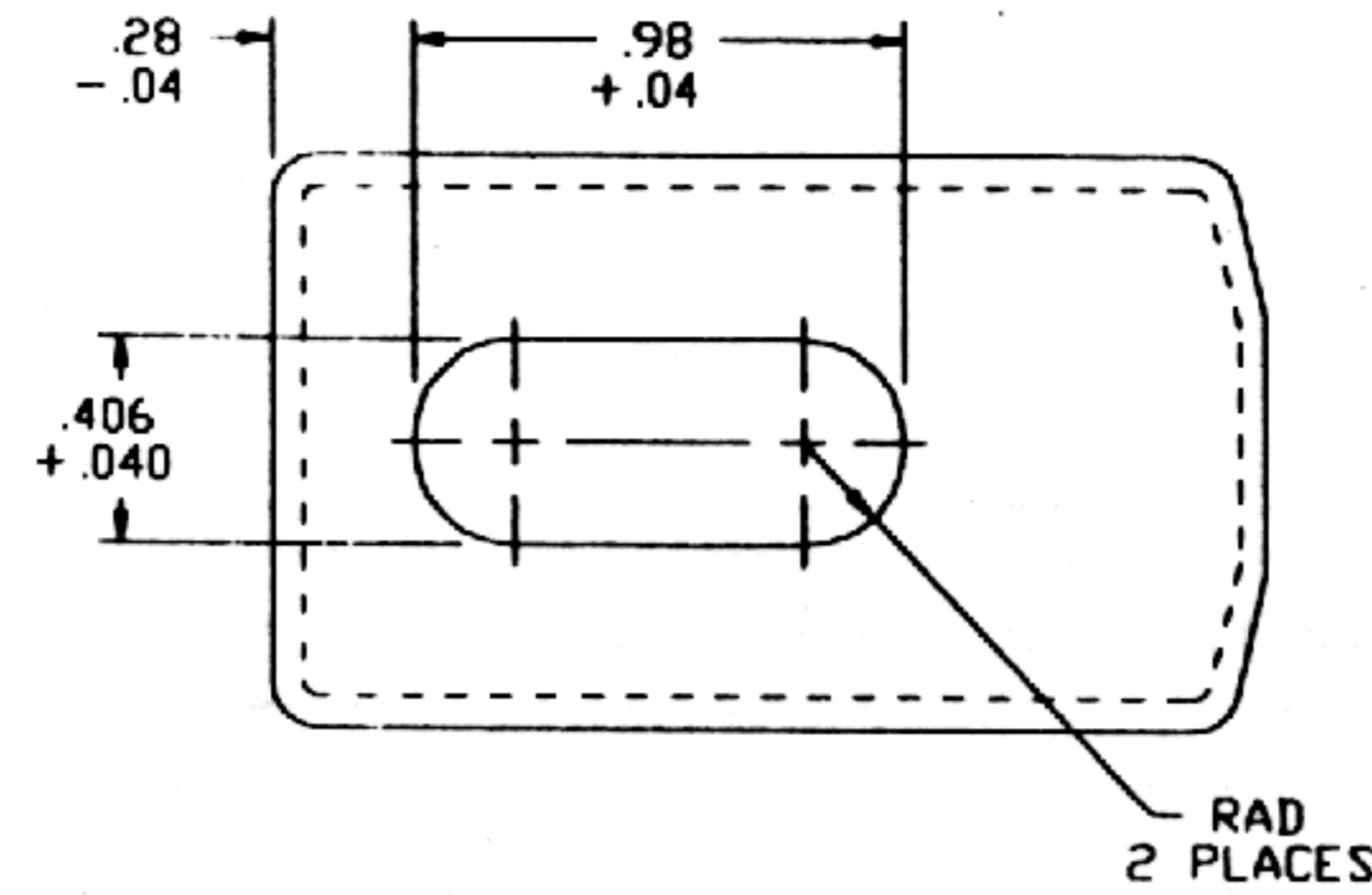


- NOTES:
1. MATERIAL - 1020 STEEL DOM TUBING
 2. FINISH - MILITARY 30 PARKERIZE, CIVILIAN 30 OR 60 BLUE
 3. DARKENED AREAS AROUND 7.50 DIA POST REPRESENT ELECTRIC WELDS AFTER POSTS HAVE BEEN BRAZED OR SILVER BRAZED IN PLACE JUST LIKE ORIGINAL RECEIVER
 4. .375 AREA OF SIGHT SLOT IS UNDERCUT WITH A 60° DOVETAIL CUTTER
 5. EJECTION PORT IS ANGLED TO RESULT IN .280 DIMENSION IN FRONT AND .297 IN REAR
 6. BORE OR REAM .753 DIA THRU HOLE BEFORE CUTTING OFF SET
 7. SEMI AUTOMATIC RECEIVER CAN BE ACCOMPLISHED BY NOT CUTTING .125 SLOT WITH 30° RAMP AND .125 HOLE X .450 DEEP THIS WILL NOT ALLOW DISCONNECTOR TO BE ASSEMBLED

CONFIDENTIAL

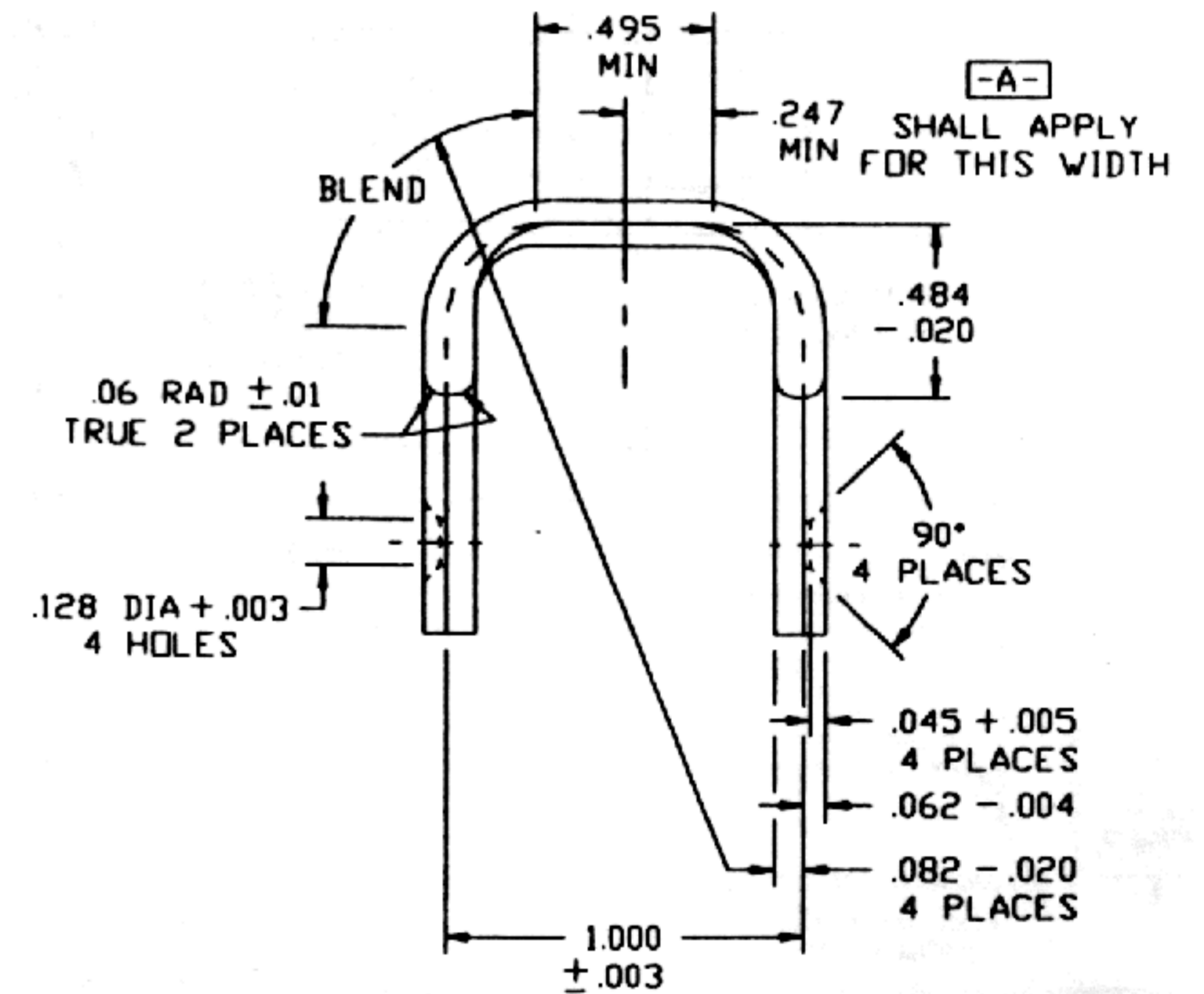
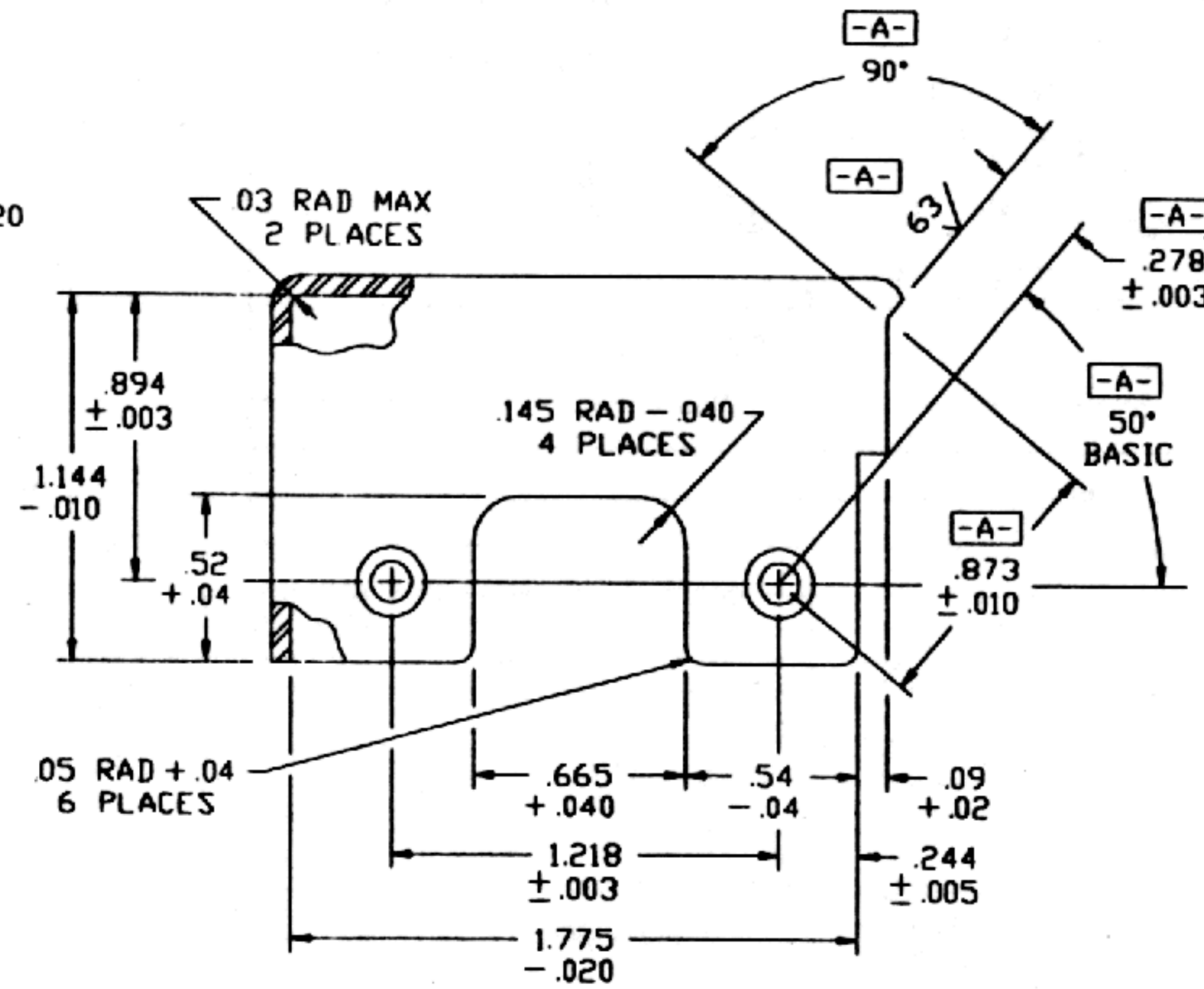
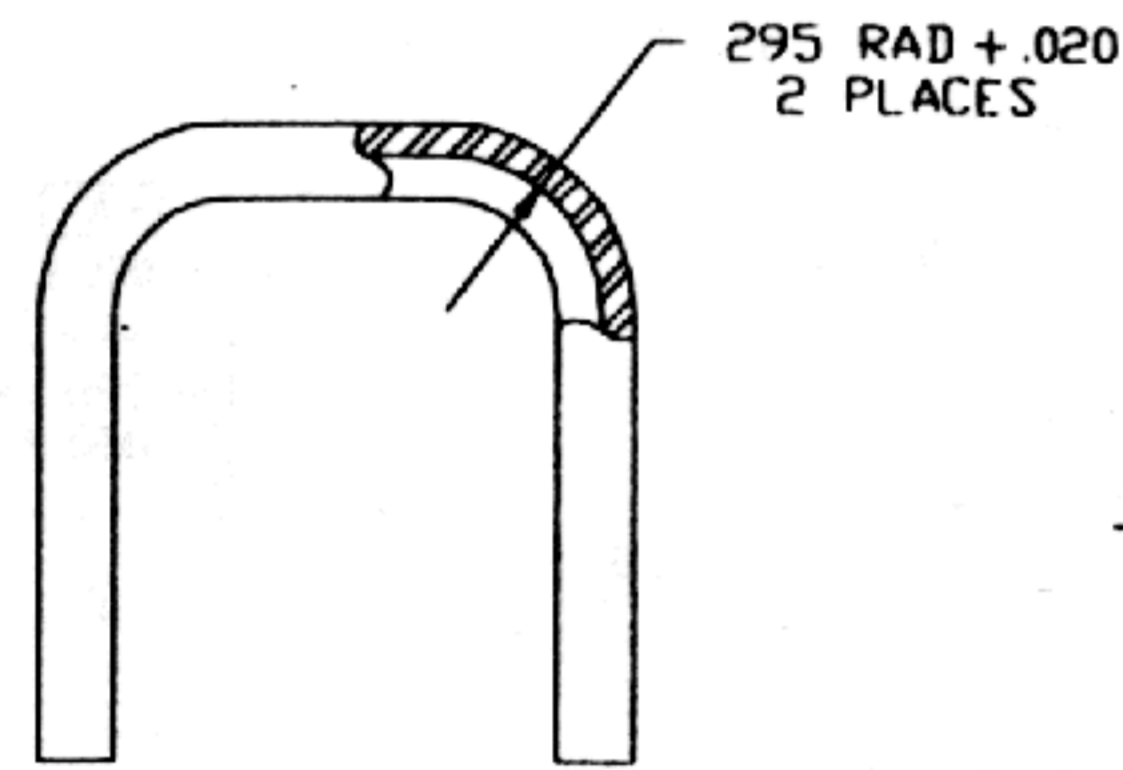
**RESTRICTED
MATERIAL**

SCALE	MATERIAL	DES	TOLERANCES
FULL	SEE NOTE 1		DECIMALS
	FINISH	DATE	REC'D BY
	SEE NOTE 2		DATE
TITLE		REV.	NO
REISING RECEIVER			



NOTES:

1. FINISH $125\sqrt{\text{ }}$ EXCEPT AS NOTED. SHEARED SURFACES $250\sqrt{\text{ }}$
2. ALL EDGES SHALL BE BROKEN .005 +.010 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL - STEEL QQ-S-698 CARBON .17 TO .24, MANGANESE .30 TO .60 DRAWING QUALITY KILLED.
4. HEAT TREATMENT - CARBURIZE AT 1600°F FOR .005 TO .010 CASE DEPTH. OIL QUENCH. TEMPER 30 MINUTES AT 350°F. HEAT TREATMENT METHOD IS FOR GUIDANCE, EXCEPT THAT CASE DEPTH AND HARDNESS REQUIREMENT ARE MANDATORY AND TIME AT TEMPERATURE SHALL NOT BE REDUCED BELOW THAT SPECIFIED. THE USE OF STRAIGHT CYANIDE BATH OR CARBONITRIDING PROCESS SHALL NOT BE PERMITTED WITHOUT PRIOR APPROVAL OF THE CONTRACTING OFFICER.
5. FILEHARD TEST IN ACCORDANCE WITH SA-STD-104. (H1)
6. FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171



RESTRICTED MATERIAL

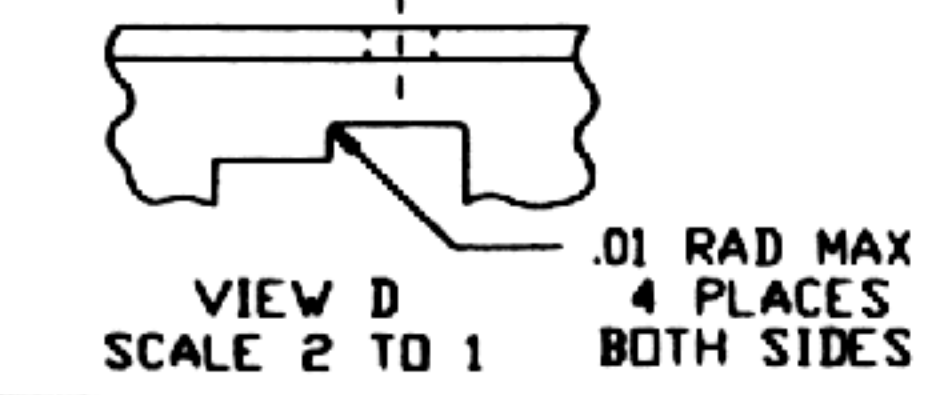
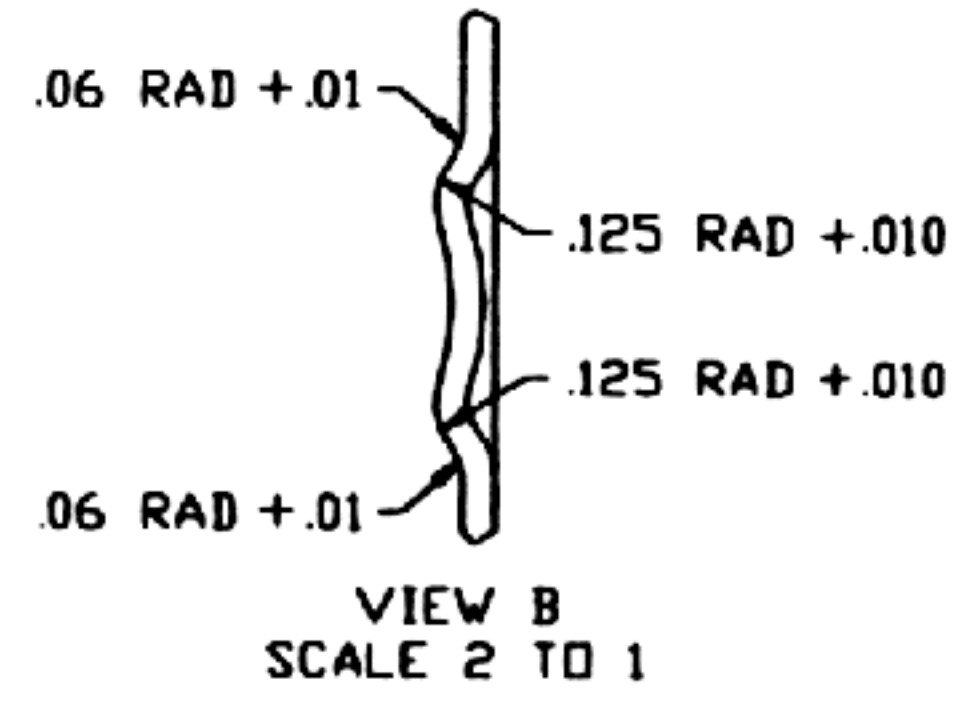
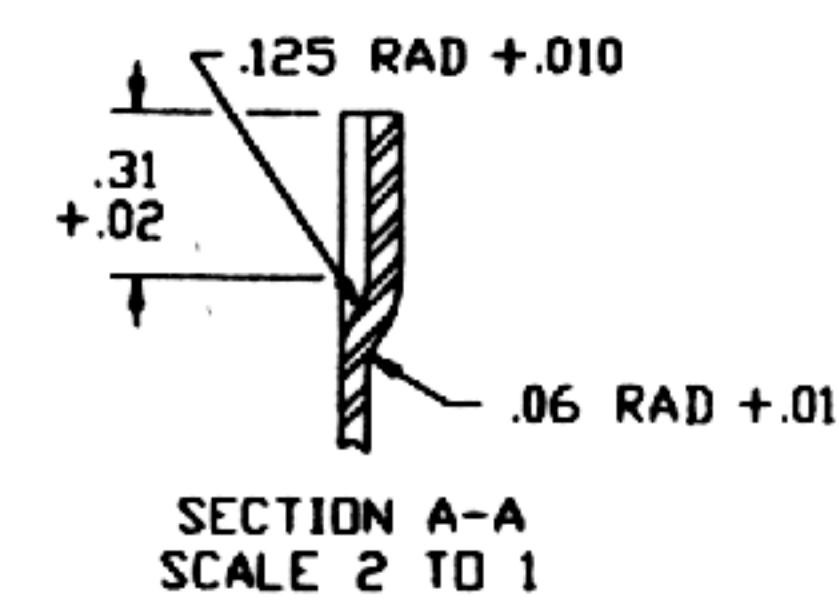
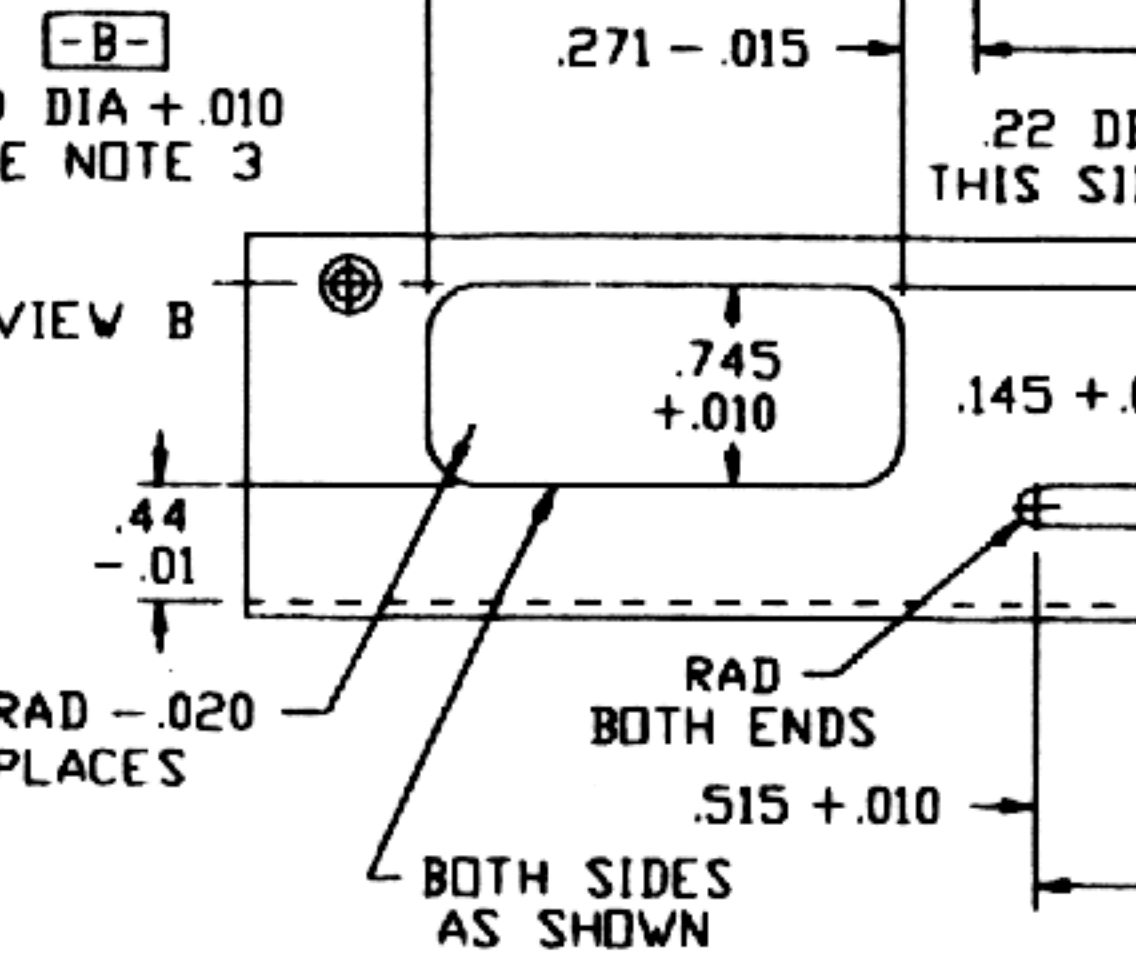
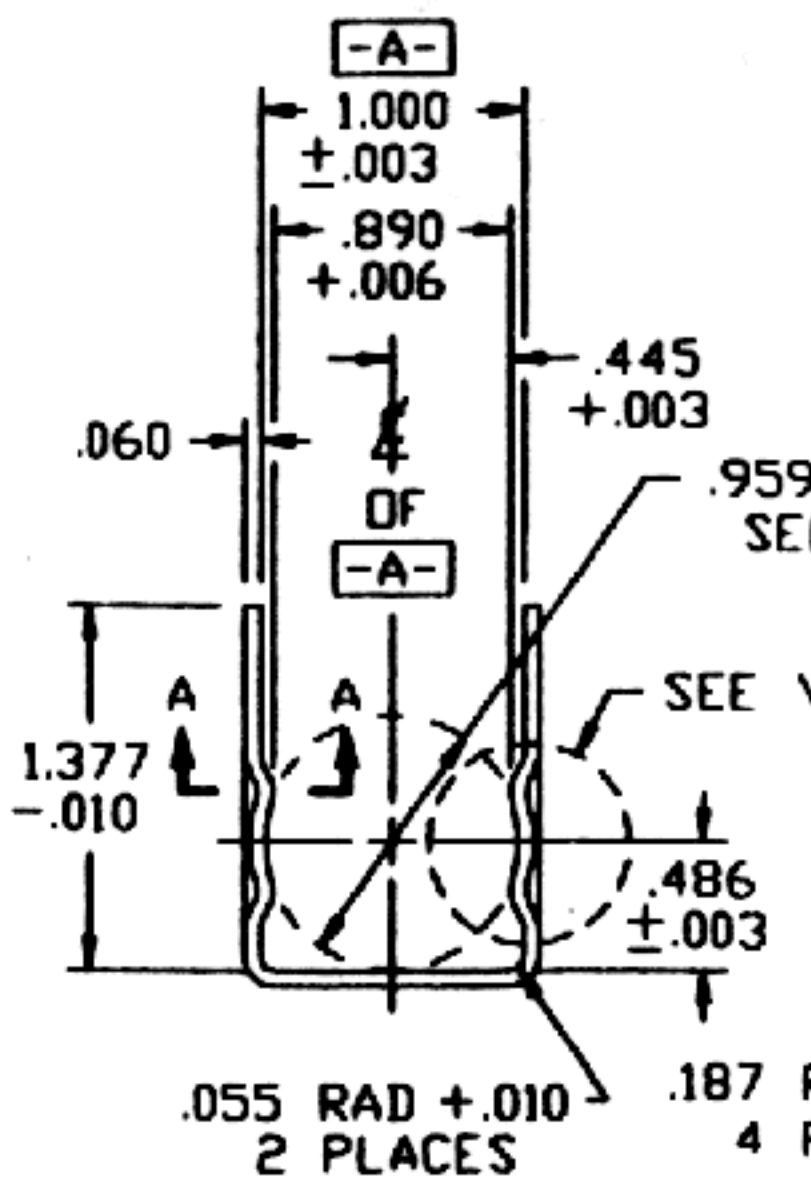
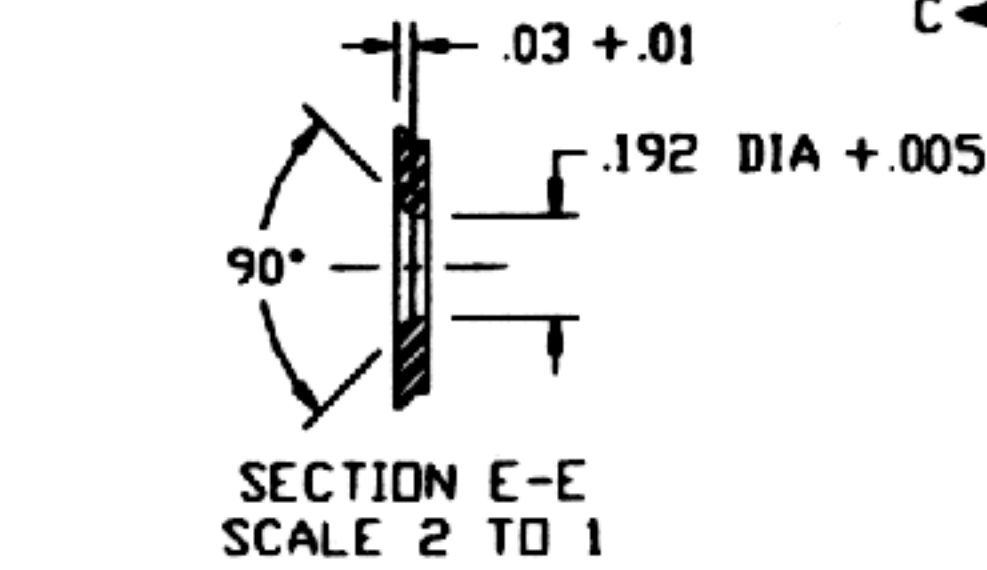
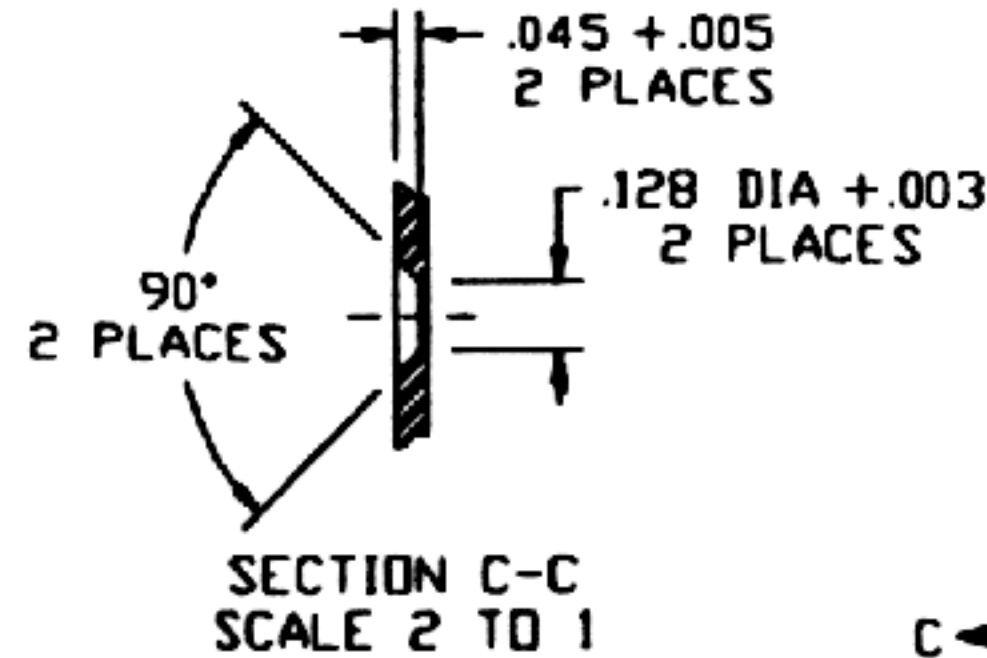
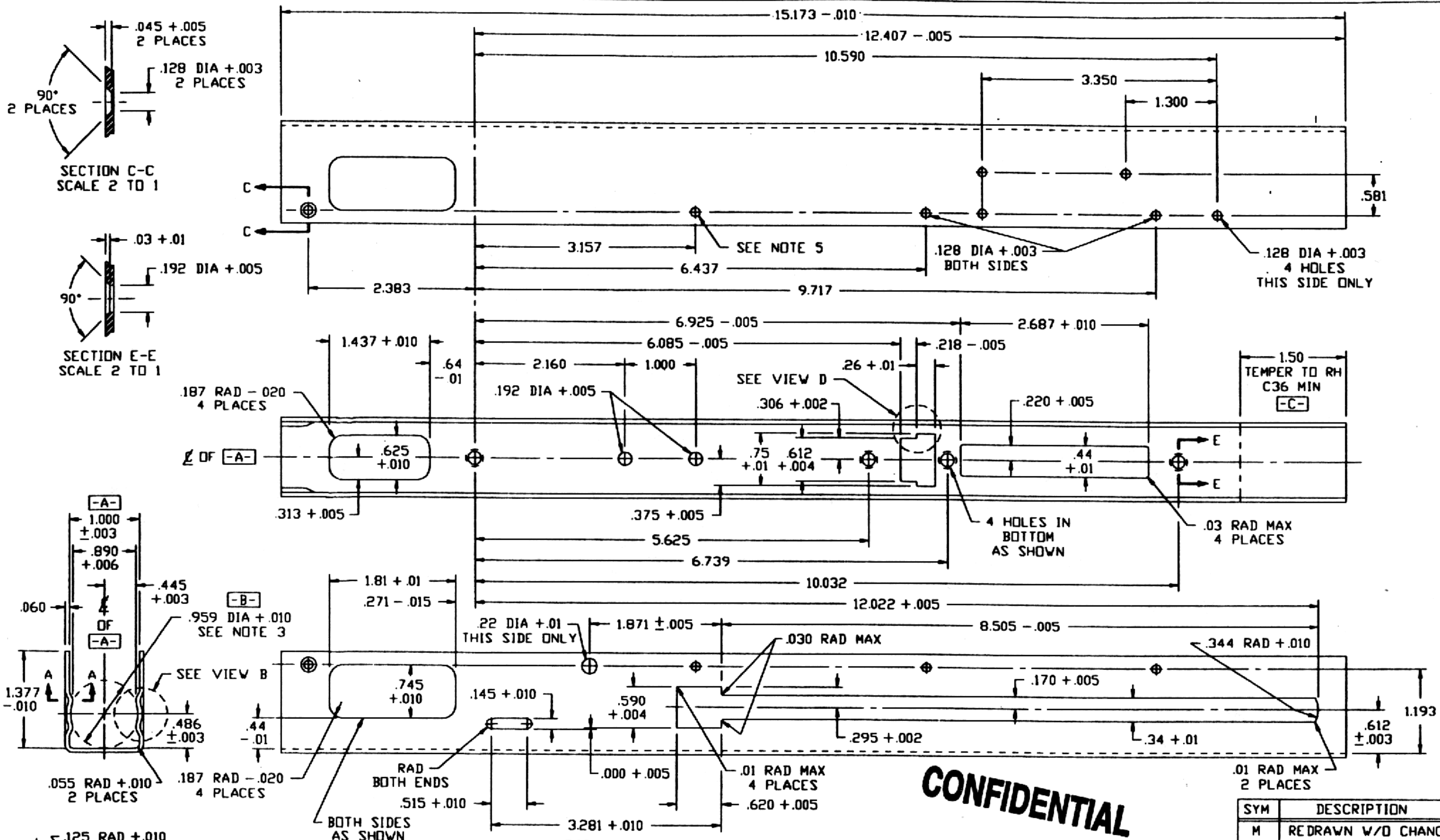
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NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60D

CODE IDENT NO. 19205
 DRAWN FROM ORD PART NO. 7269252
 SPRINGFIELD ARMORY ORDNANCE CORPS
 DEPT OF THE ARMY
 SPRINGFIELD 1, MASS

SCALE: 2 TO 1	MATERIAL: SEE NOTE 3	CKD.	TOLERANCES
DWN.	FINISH: SEE NOTE 1	DATE	DEC 2 PL ±.02 H H 2 PL ±.51
TITLE: M60 BRIDGE, RECEIVER	REV.		DEC 3 PL ±.005 H H 3 PL ±.127 ANGLES ±.5°
			NO

SYM	DESCRIPTION
G	REDRAWN WITH CHANGE SEE EO NO. SA30116
H	(1) SEE EO HRD 82232



- NOTES:
1. FINISH $125\sqrt{\text{}}$ EXCEPT SHEARED EDGES $250\sqrt{\text{}}$.
 2. ALL EDGES SHALL BE BROKEN $.005 +.010$ UNLESS OTHERWISE SPECIFIED.
 3. **-B-** APPLIES WHEN **-A-** IS MAINTAINED AT 1.00 DATUM.
 4. HEAT TREATMENT- HEAT AT 1500° TO 1535° F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. TOTAL AND PARTIAL DECARBURIZATION PERMISSIBLE TO $.002$ MAX.
 5. SEE RECEIVER ASSEMBLY DWG F11686308 AND F11699805 FOR DIA OF HOLE. EACH SIDE.
 6. FINISH- 5.3.1.2 OF MIL-STD-171. EXCEPT PARA 3.3 OF MIL-P-16232 SHALL NOT APPLY. (P1)
 7. MATERIAL- STEEL QQ-S-777 1060, 1065, 1075.

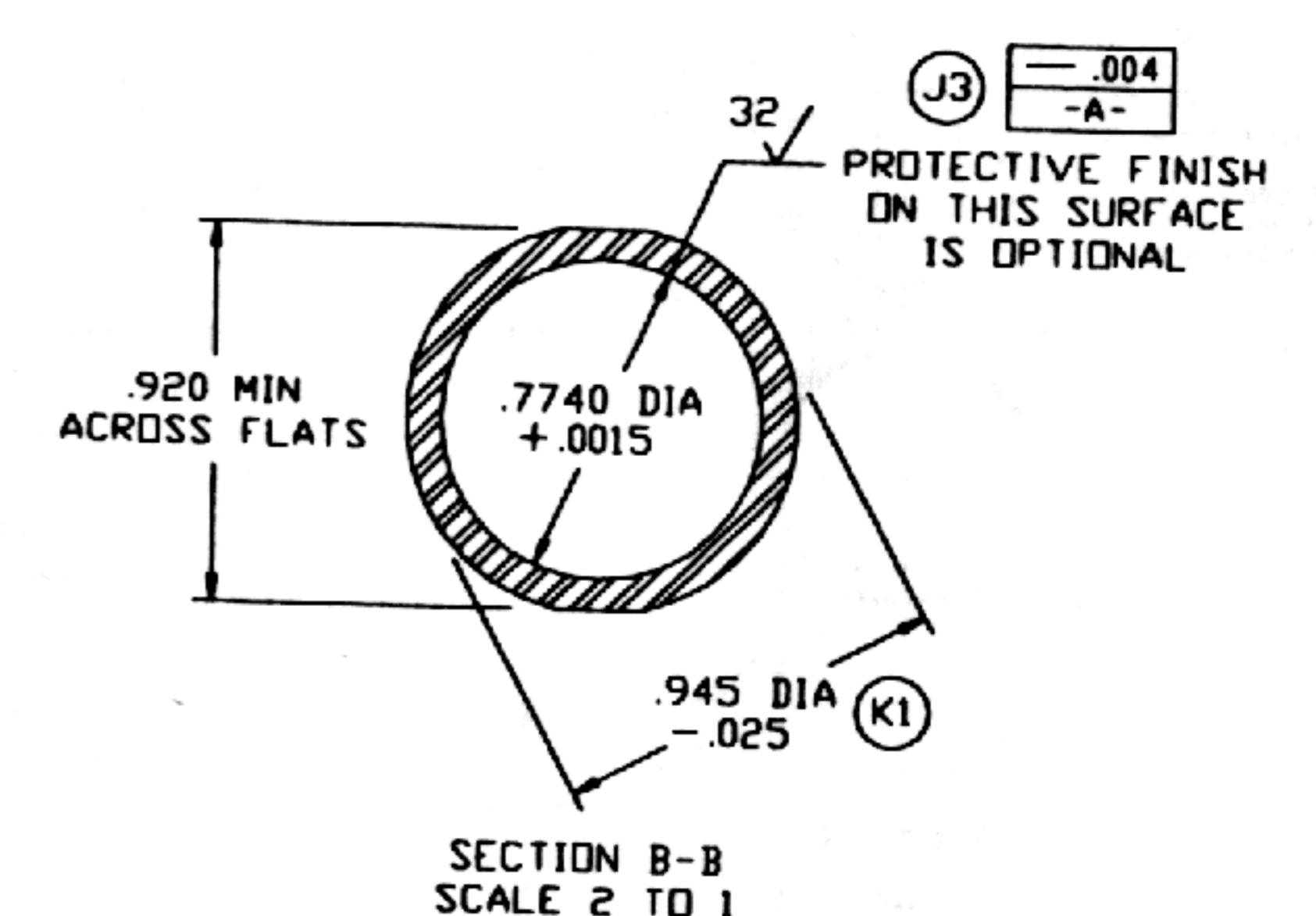
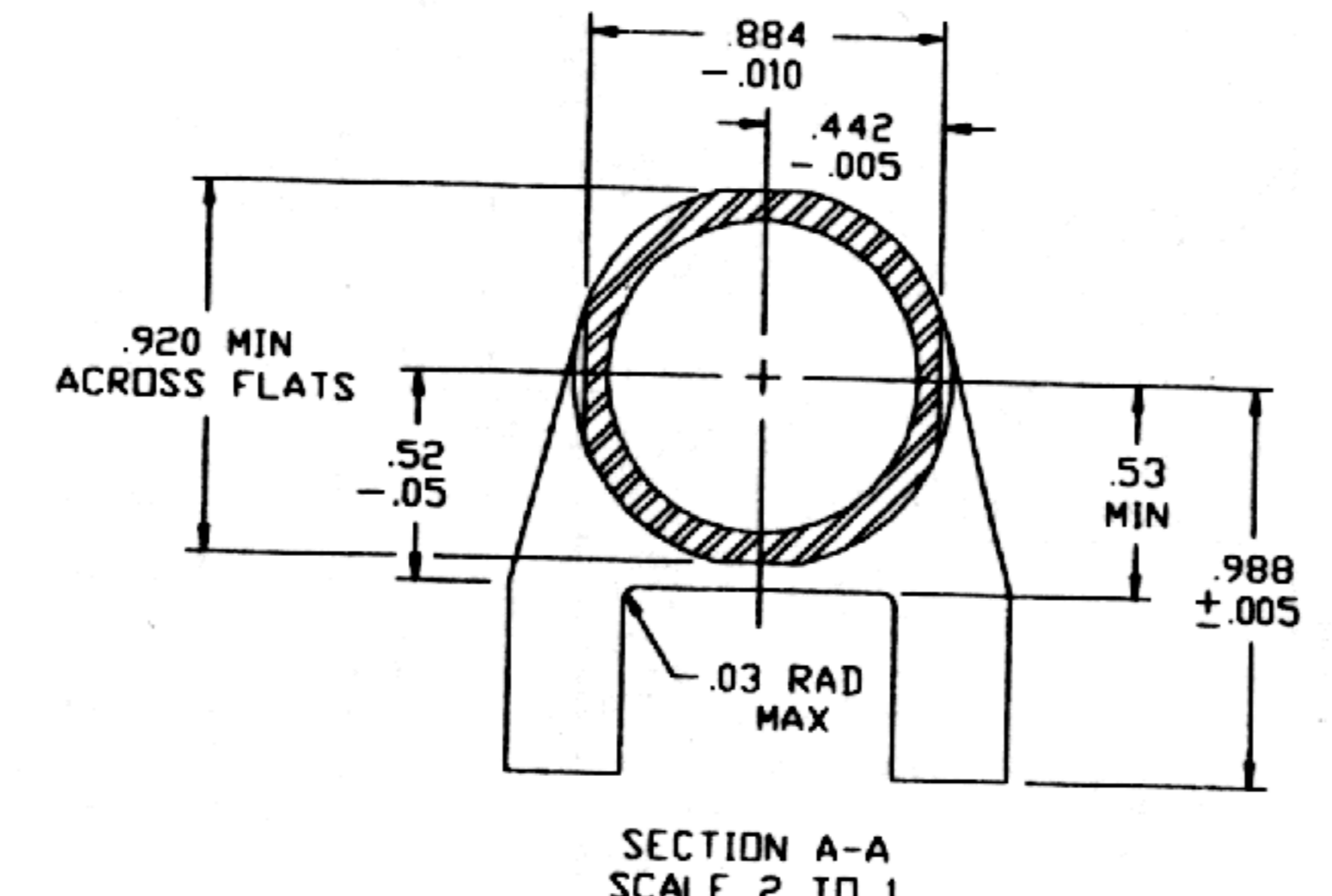
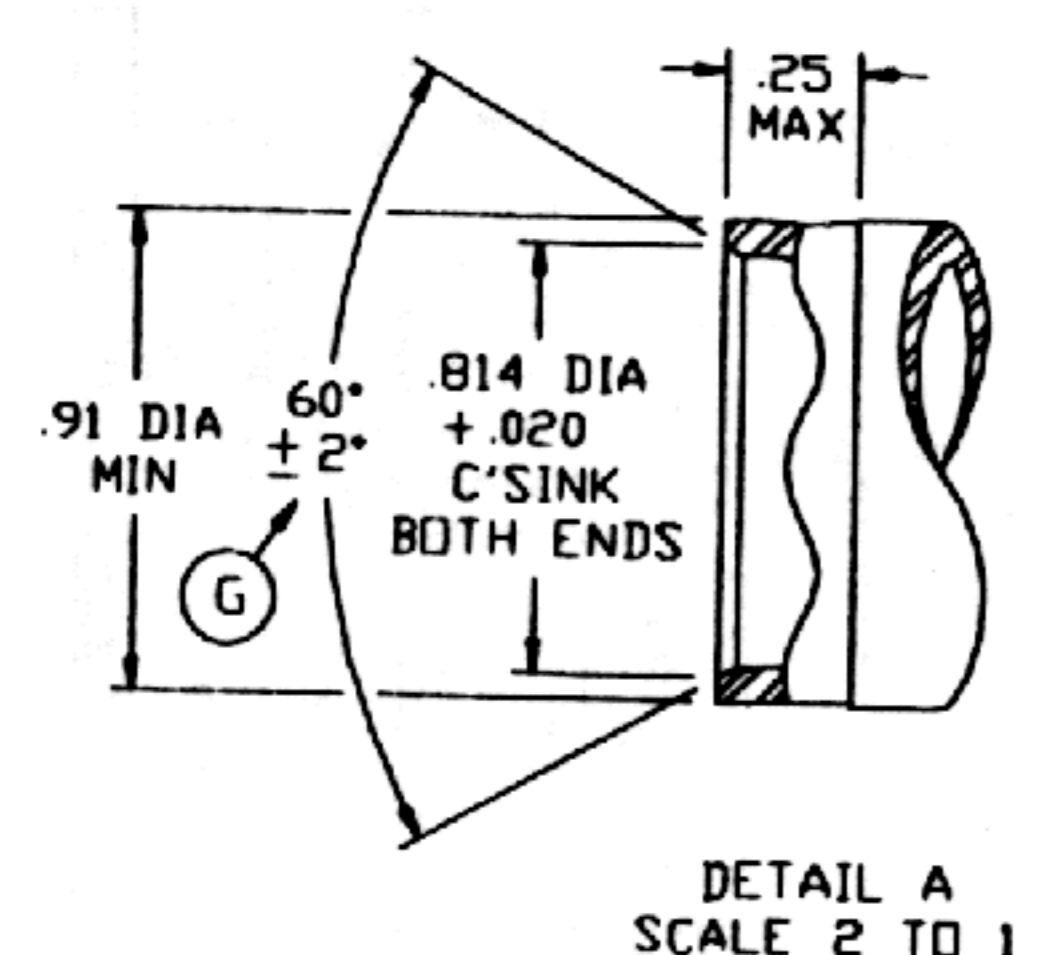
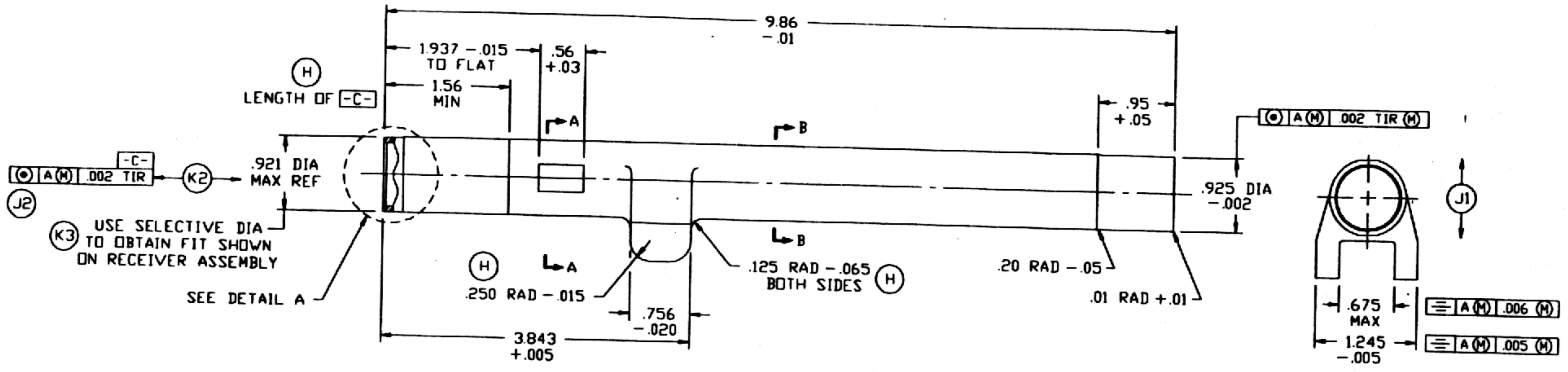
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SYM	DESCRIPTION
M	REDRAWN W/D CHANGE SEE ED NO. SA30121
N	(1-2) SEE ED HRD 82232

NEXT ASSEMBLY	F11686308	MG, 762 MM M60 M60G	RESTRICTED (P2)
	F11699805	M60D	

CODE IDENT NO. 19205
 DRAWN FROM ORD PART NO. 7269254
 SPRINGFIELD ARMORY ORDNANCE CORPS
 DEPT OF THE ARMY
 SPRINGFIELD 1, MASS

SCALE: FULL	MATERIAL: SEE NOTE 7	CKD.	TOLERANCES DEC 2 PL ± .02 M N ± .01 DEC 3 PL ± .005 M N ± .027 ANGLES ± 5°
DWN.	FINISH: SEE NOTE 1	DATE	
TITLE: M60 CHANNEL, RECEIVER	REV.	NO.	



- NOTES:
1. FINISH $125\sqrt{\text{ }}$ EXCEPT AS NOTED. FORGED SURFACES $250\sqrt{\text{ }}$
 2. MATERIAL - STEEL, COMP 4140, SPEC QQ-S-624 (J5) OR COMP 1141, SPEC QQ-S-637, EXCEPT HOT FINISHED 1141 STEEL BARS FOR FORGING PURPOSES, AND ALL OTHER CONDITIONS OF SPECIFICATIONS ARE COMPLIED WITH. (L1)
 3. HEAT TREATMENT - HEAT AT 1525° TO 1575°F. OIL QUENCH. TEMPER 1 HOUR AT HEAT TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
 4. FINAL PROTECTIVE FINISH 5.3.1.2 OF MIL-STD-171

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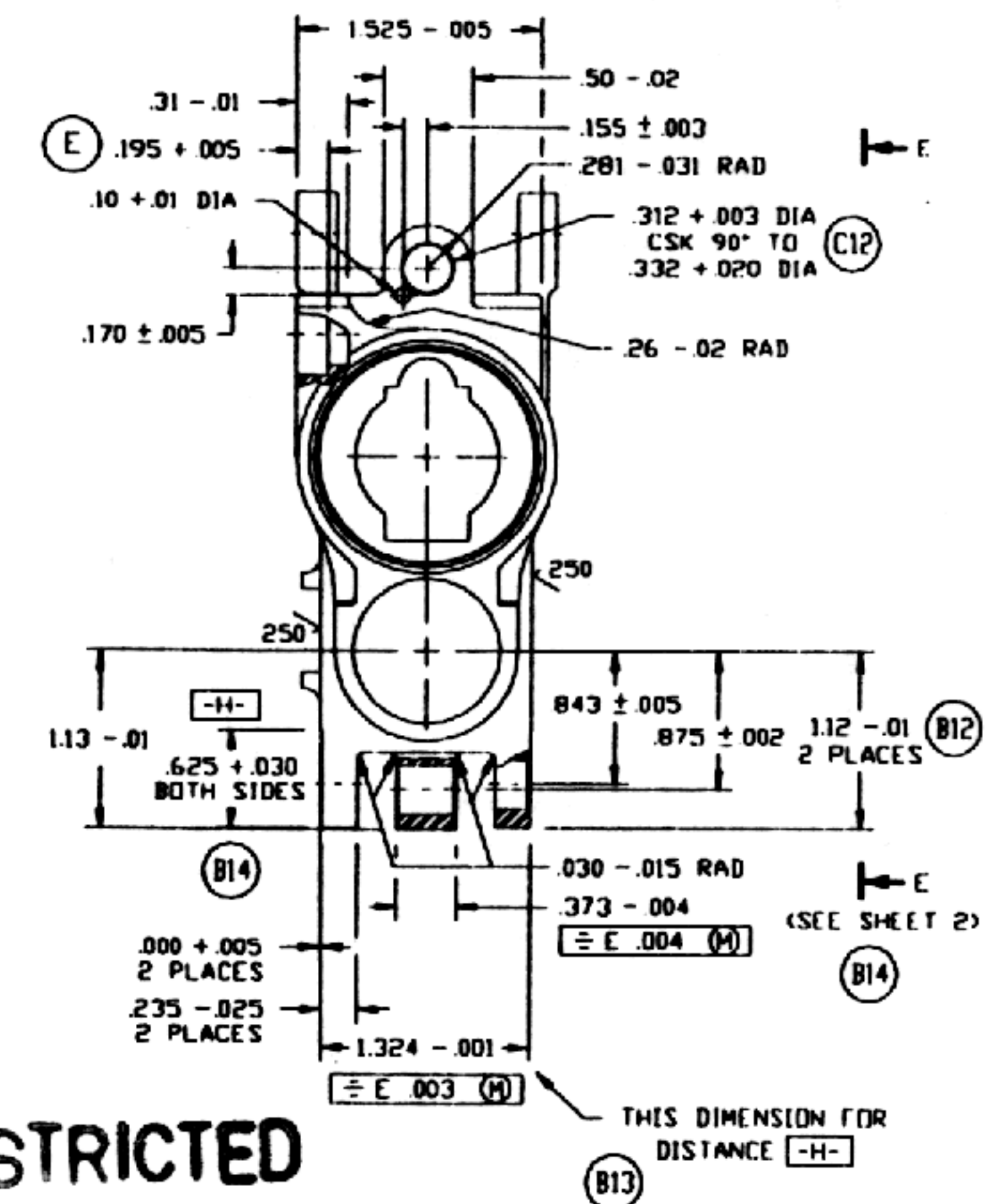
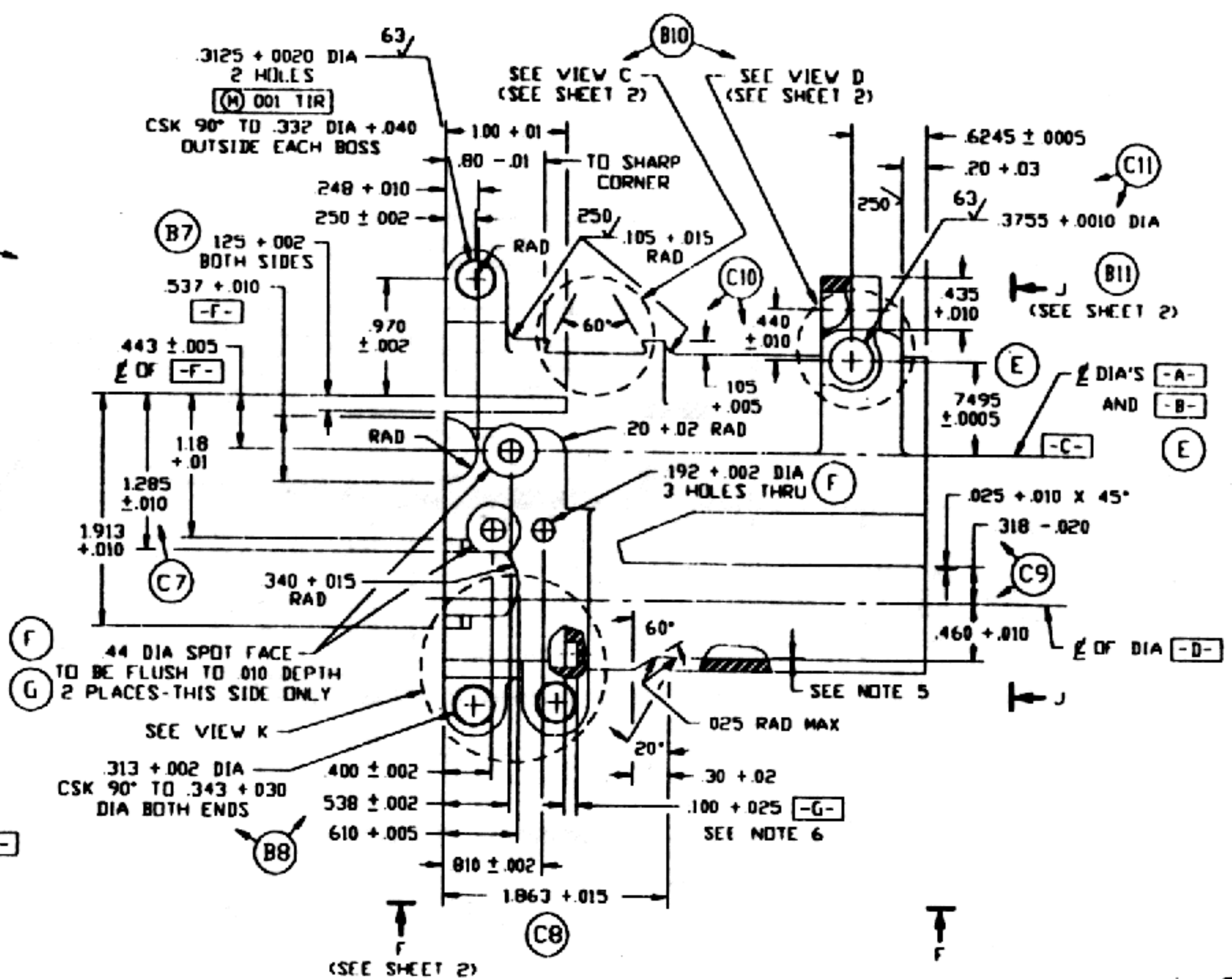
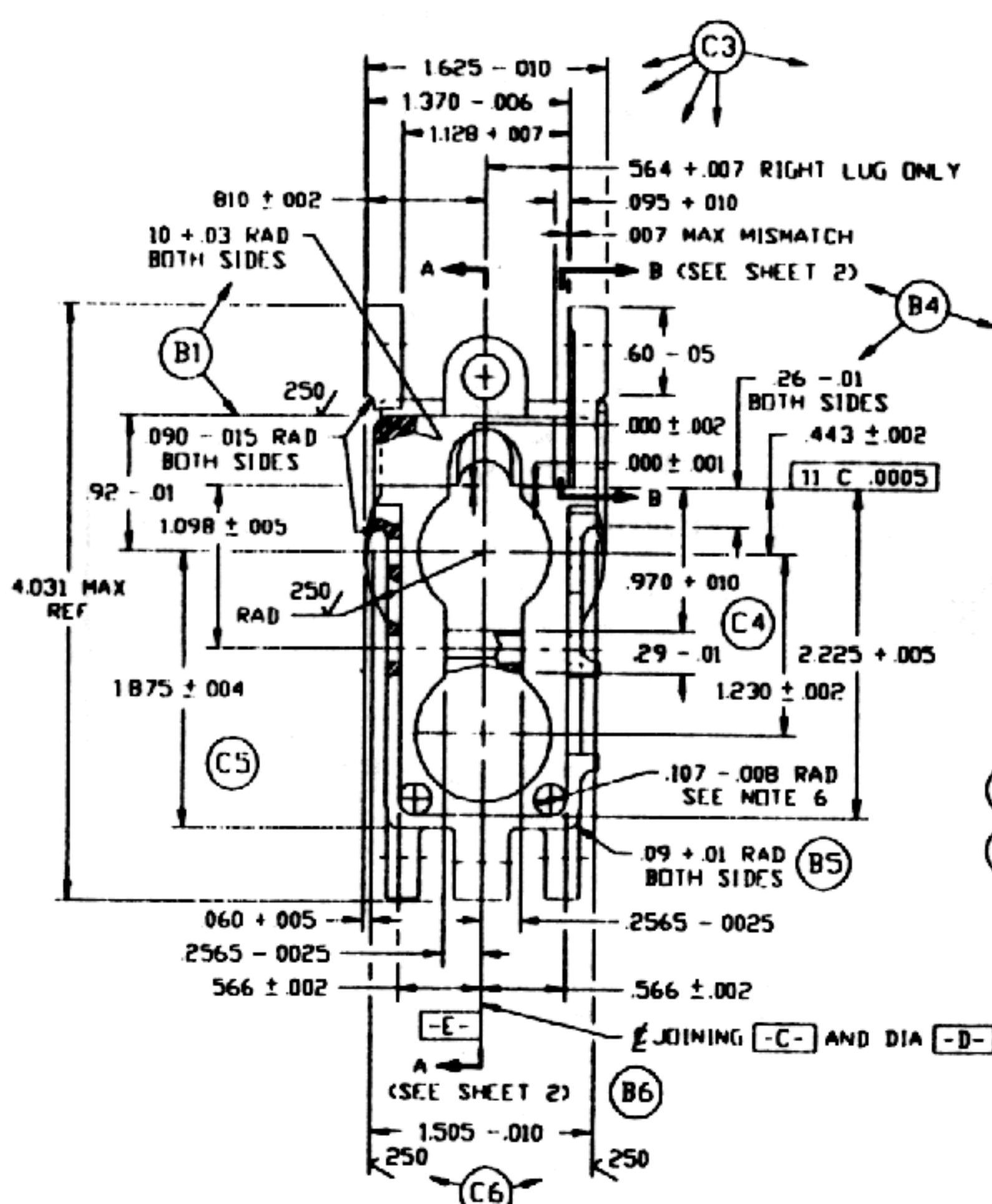
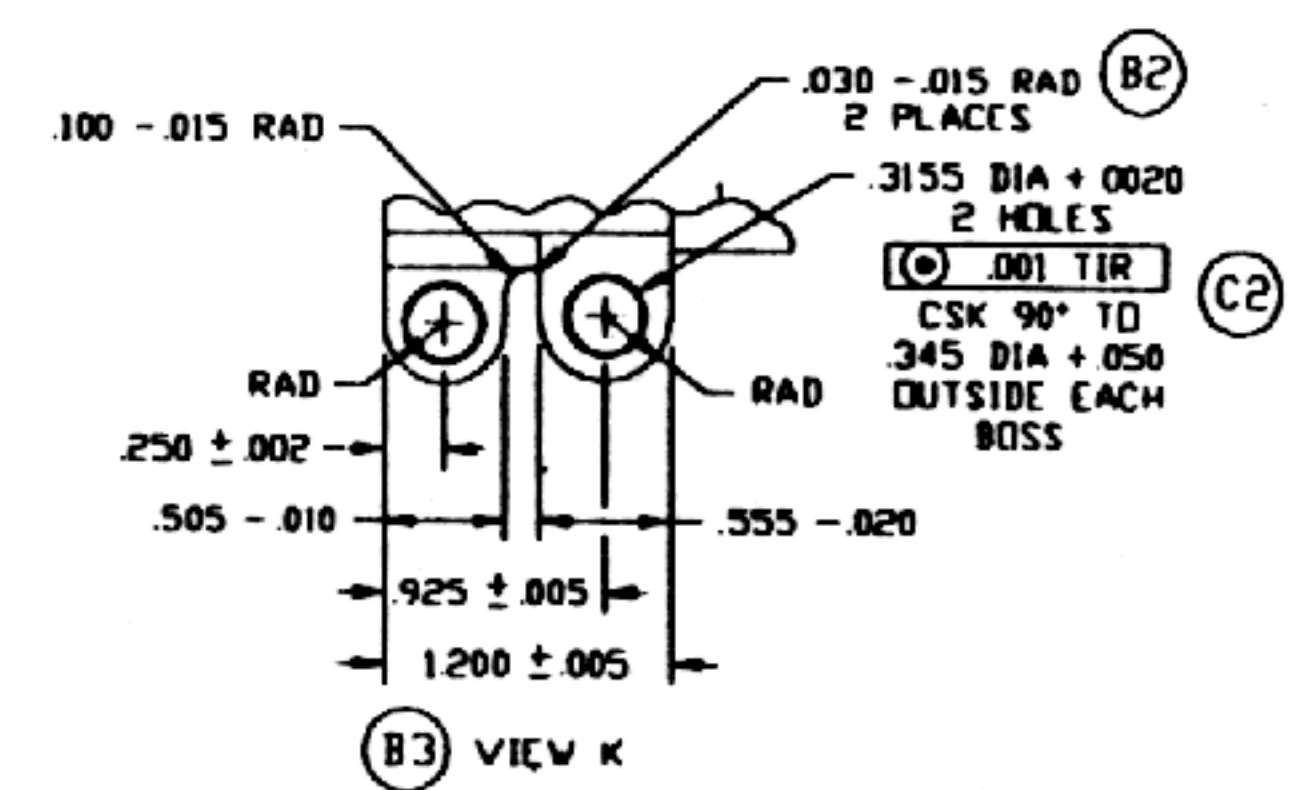
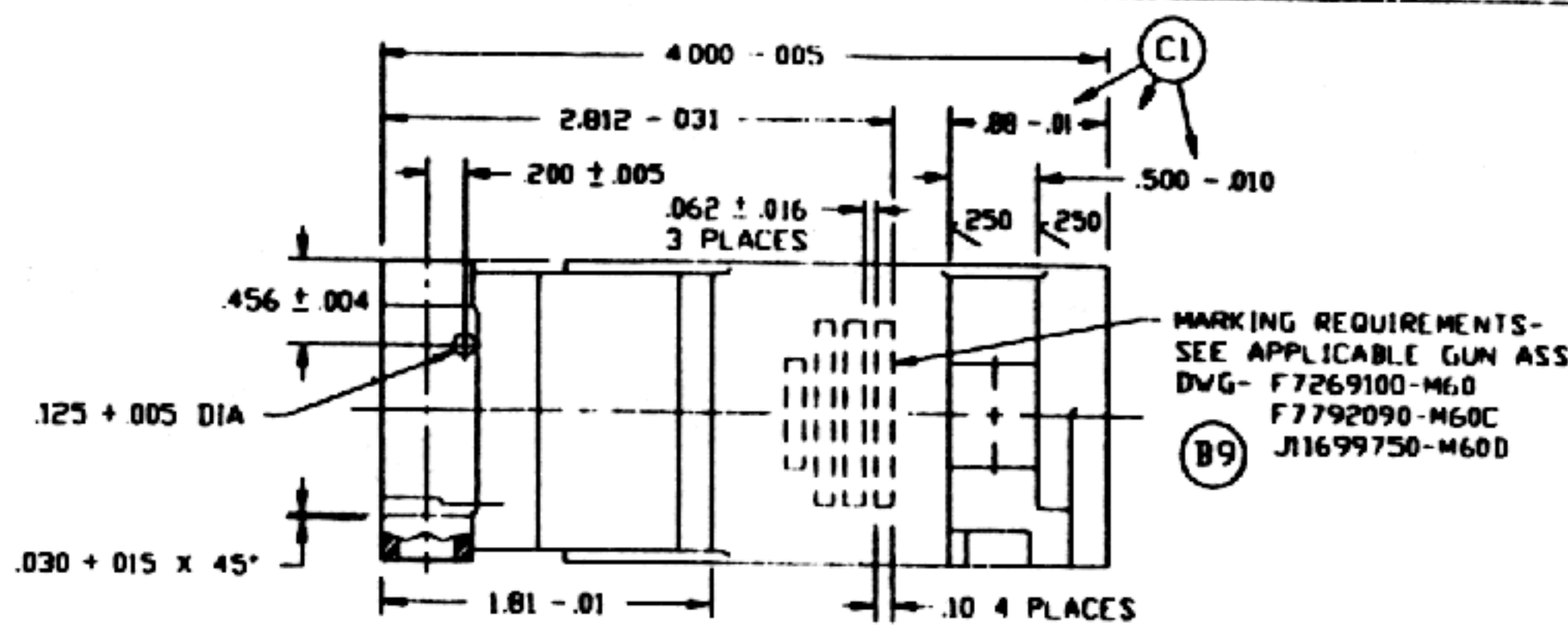
RESTRICTED MATERIAL

SYM	DESCRIPTION
E	
F	REDRAWN & REVISED SEE ED SA26085
G2	REF ED NO. SA27115
H5	REF ED NO. SA27297
J	(1-5) REF ED SA28042
K	(1-3) SEE ED SA29002
L	(1) SEE ED HRD 82370

NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60C

CODE IDENT NO. 19205
 DRAWN FROM ORD PART NO. 7269256 (H)
 SPRINGFIELD ARMORY ORDNANCE CORPS
 DEPT OF THE ARMY
 SPRINGFIELD 1, MASS

SCALE: FULL	MATERIAL: SEE NOTE 2	CKD.	TOLERANCES DEC 2 PL ± .02 H H ± .01 DEC 3 PL ± .005 H H ± .127 ANGLES ± 5°
DWN.	FINISH: SEE NOTE 1	DATE	
TITLE: M60 GUIDE, OPERATING ROD		REV.	NO.



- NOTES:
- 1 FINISH $125\sqrt{\text{ }}$ EXCEPT AS NOTED.
 2. ALL EDGES SHALL BE BROKEN $.005 \pm .010$ UNLESS OTHERWISE SPECIFIED.
 3. ALL UNSPECIFIED RADII SHALL BE $.030 \pm .030$.
 4. HEAT TREATMENT- HEAT AT 1535° TO 1565° F. OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
 5. BREAK THRU SHALL BE PERMISSIBLE IN THIS AREA PROVIDED RESULTANT BURRS ARE REMOVED.
 6. $.215$ DIA $-.015$ (2) HOLES MAY BE MACHINED IN CORNERS FOR DEPTH $[-G-]$ TO PROVIDE REQUIRED RADIUS.
 7. FINISH 5.3.12 OF MIL-STD-171. (G)
 8. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED (D) OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS AT THE COMPONENT LEVEL.
 9. MIL-W-13855 APPLIES. (E)
 10. MATERIAL- STEEL QQ-S-624 4140, 8640, 8740.

CONFIDENTIAL

RESTRICTED MATERIAL

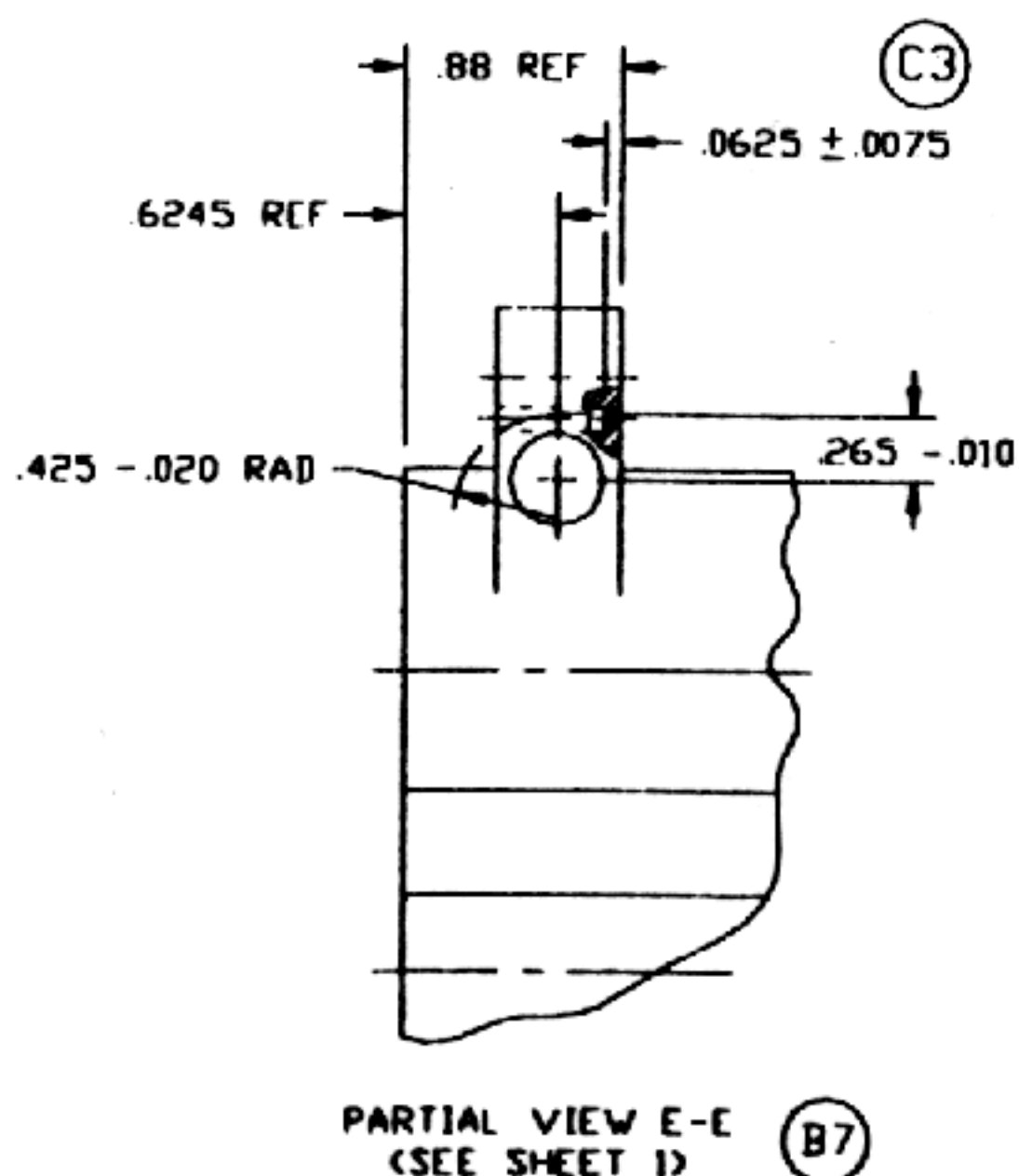
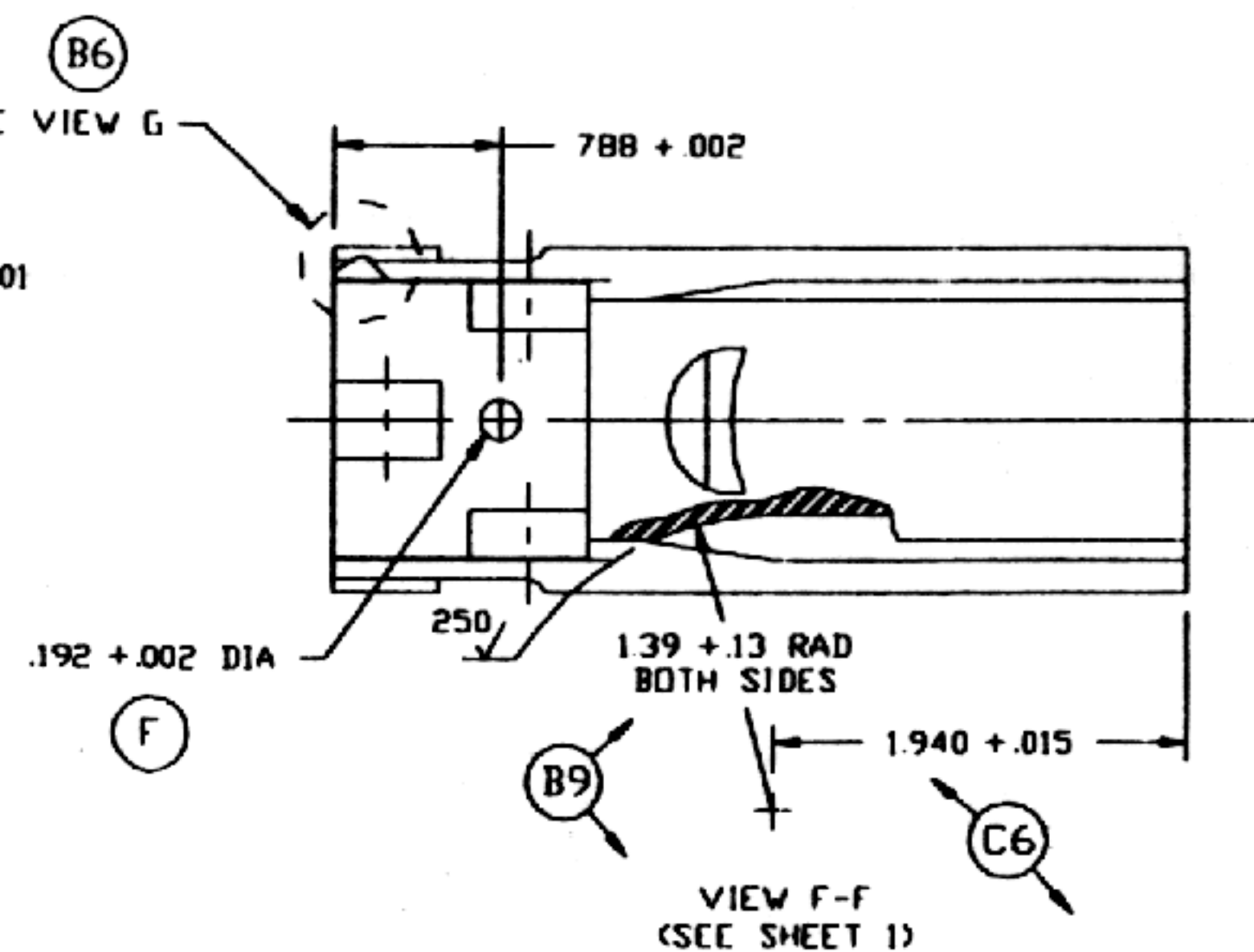
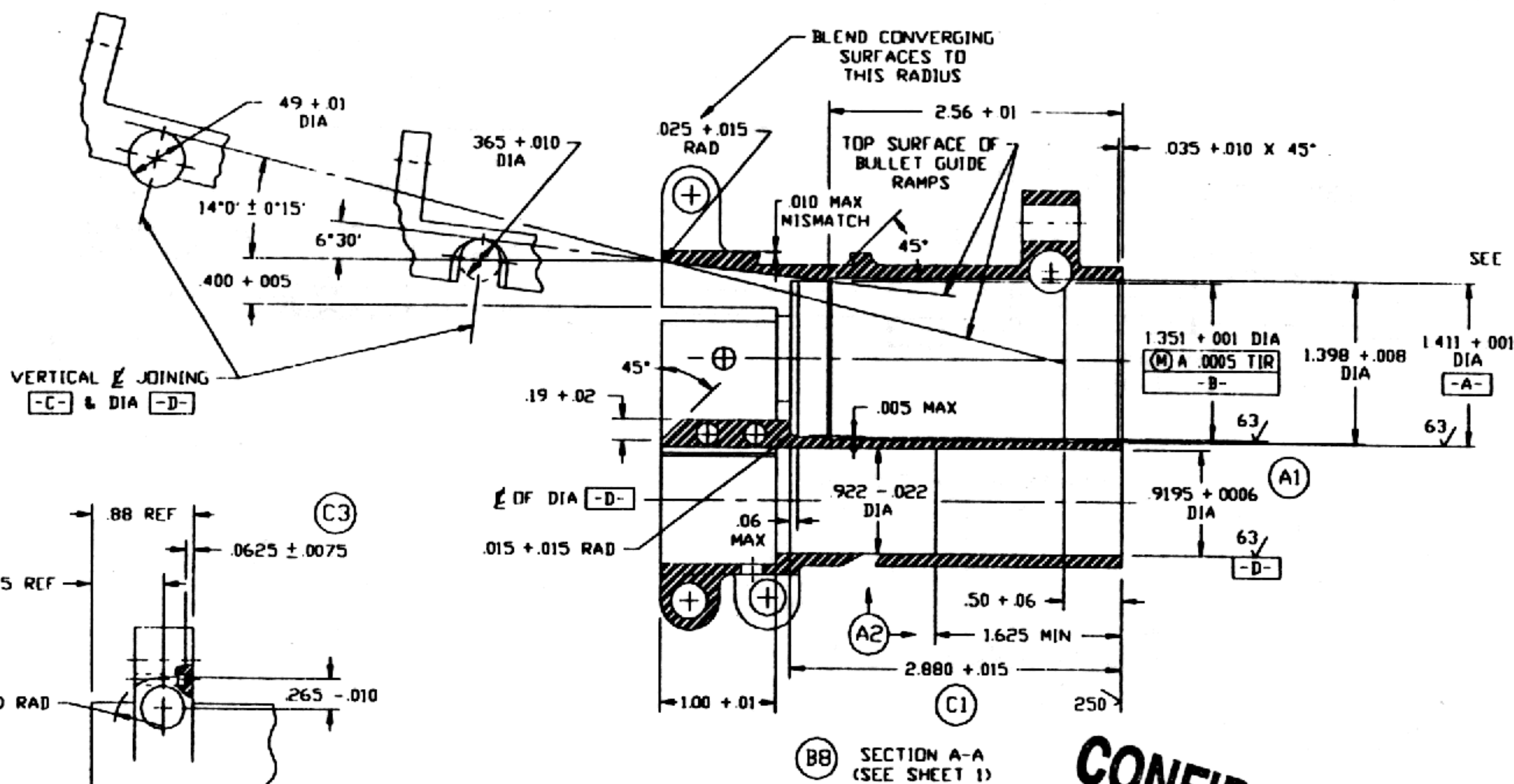
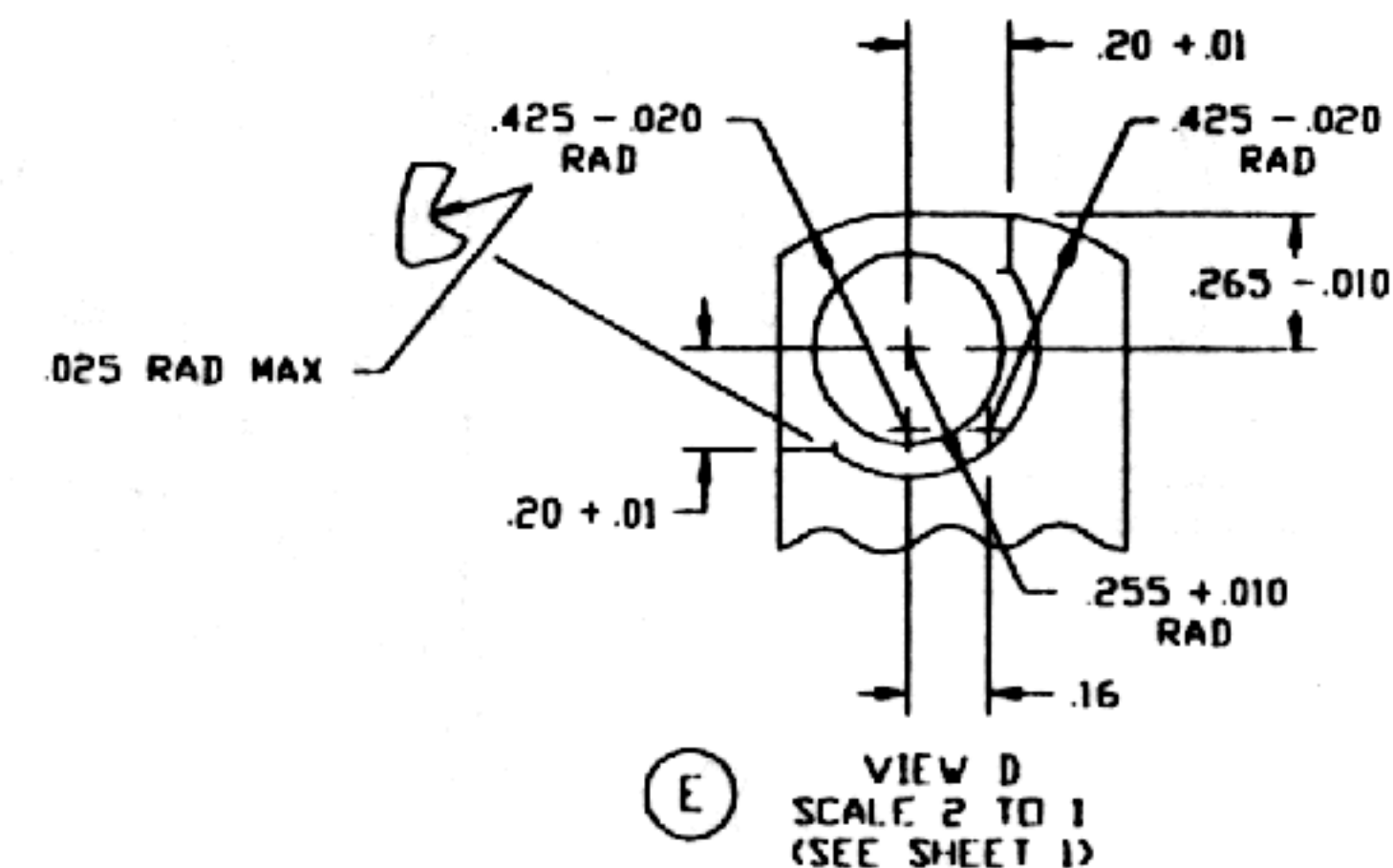
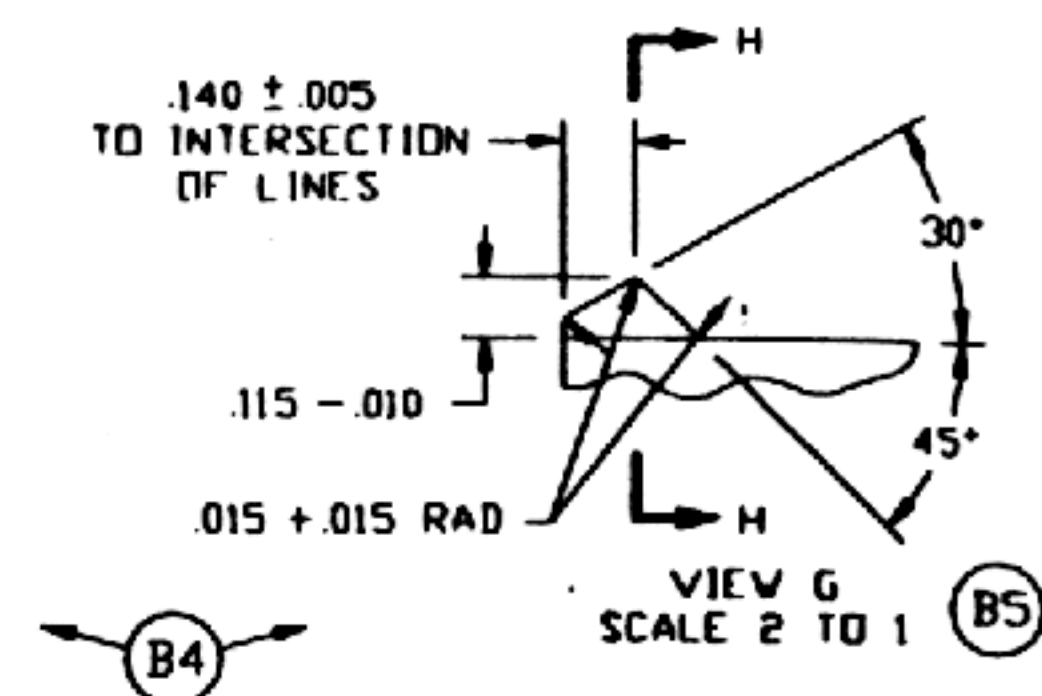
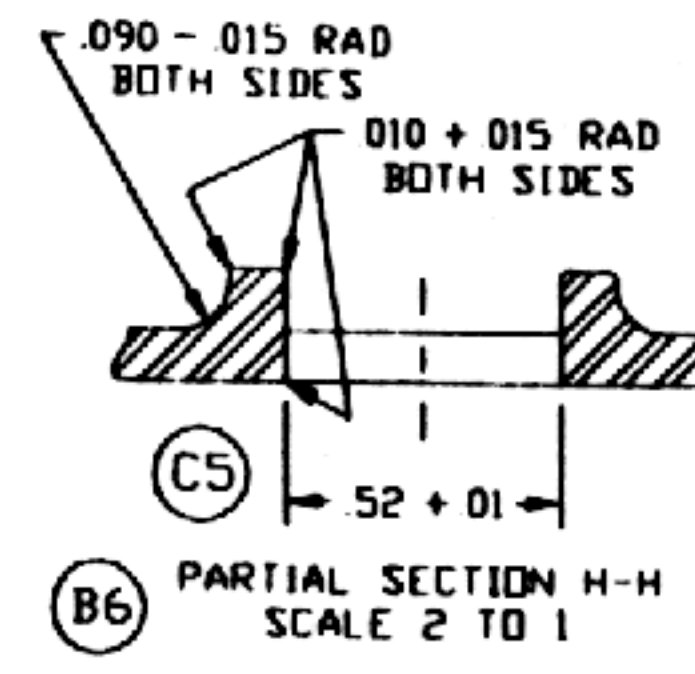
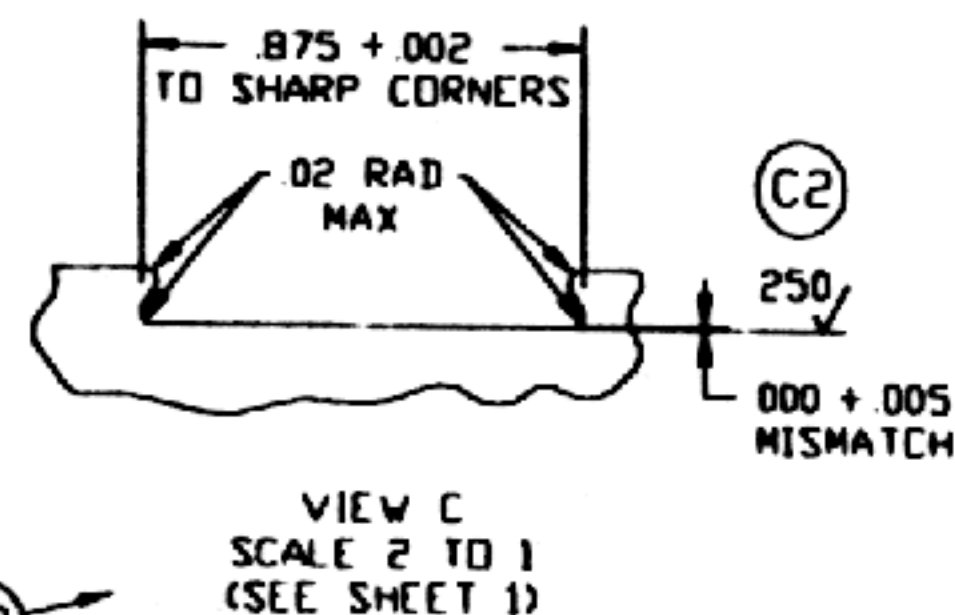
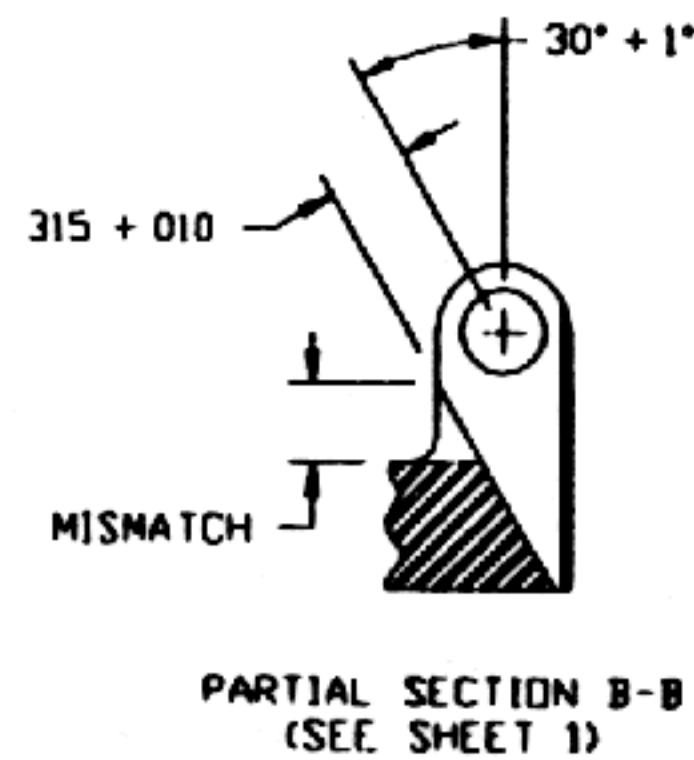
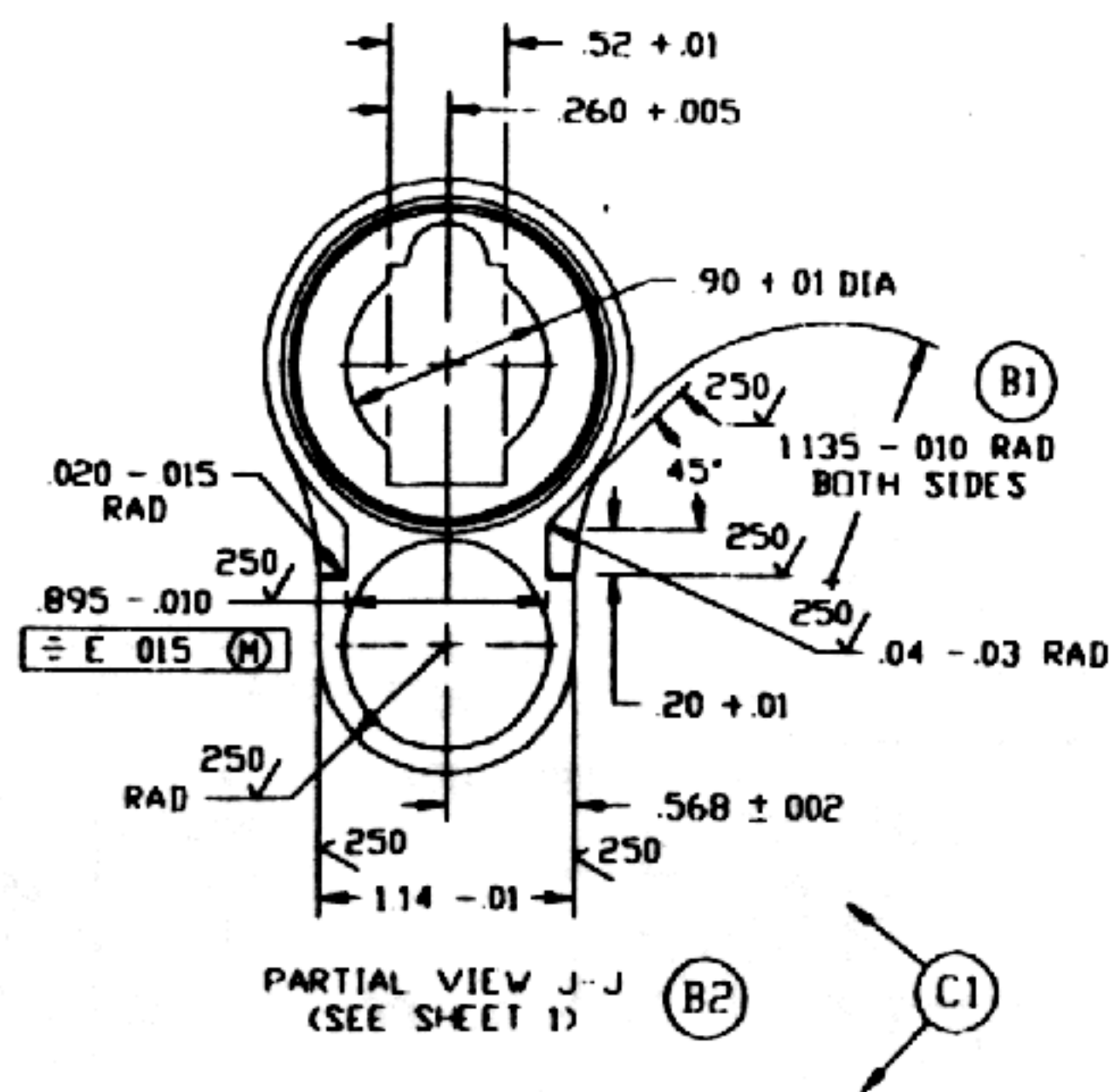
NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60D

CODE IDENT NO. 19204
 DRAWN FROM ORD PART NO. 11686307 SHEET 1 OF 2
 ROCK ISLAND ARSENAL
 DEPT OF THE ARMY
 ROCK ISLAND, ILL.

SYM	DESCRIPTION
A	SEE ED SA29002
B	(1-14) SEE ED SA30032
C	(1-15) SEE ED B2128
D	(1-2) SEE ED HRD 82232
E	(1-4) SEE ERR HDR 10724
F	(2) SEE ERR HDR 30781
G	(2) SEE HDR 75E0036-0002

SCALE	MATERIAL	CKD.	TOLERANCES
FULL	SEE NOTE 10		DEC $\pm .02$
	FINISH SEE NOTE 1		H H 2 PL $\pm .31$
			DEC $\pm .005$
			H H 3 PL $\pm .127$
			ANGLES $\pm .5^\circ$

TITLE: M60 RECEIVER



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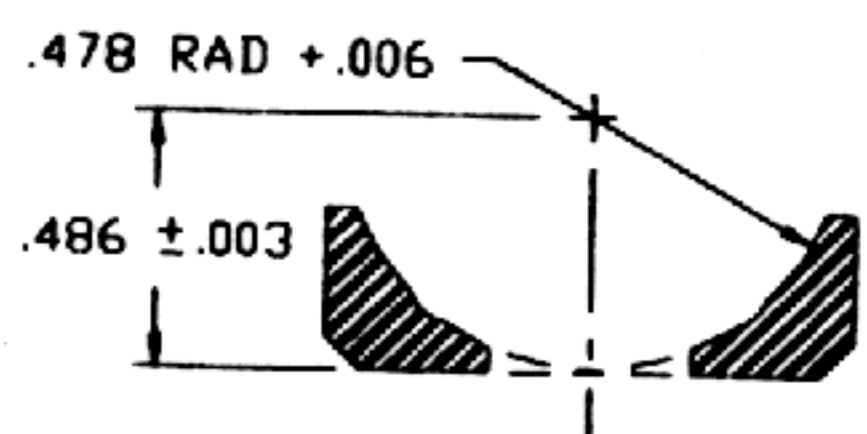
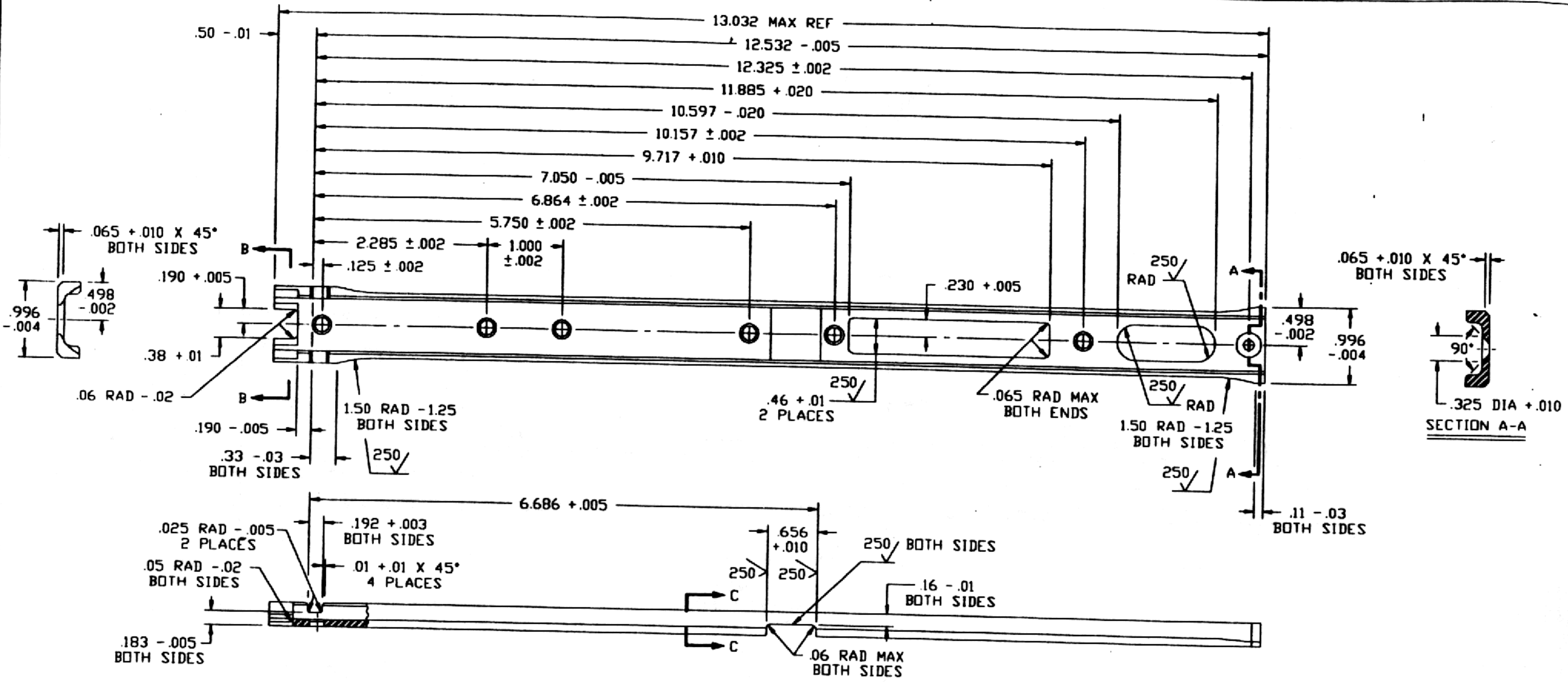
RESTRICTED MATERIAL

SYM	DESCRIPTION
A	(1-2) SEE ED SA29002
B	(1-9) SEE ED SA30032
C	(1-6) SEE ED 82128
D	NO CHANGE
E	(1) SEE ERR HOR 10724
F	SEE ERR HOR 30781
G	NO CHANGE

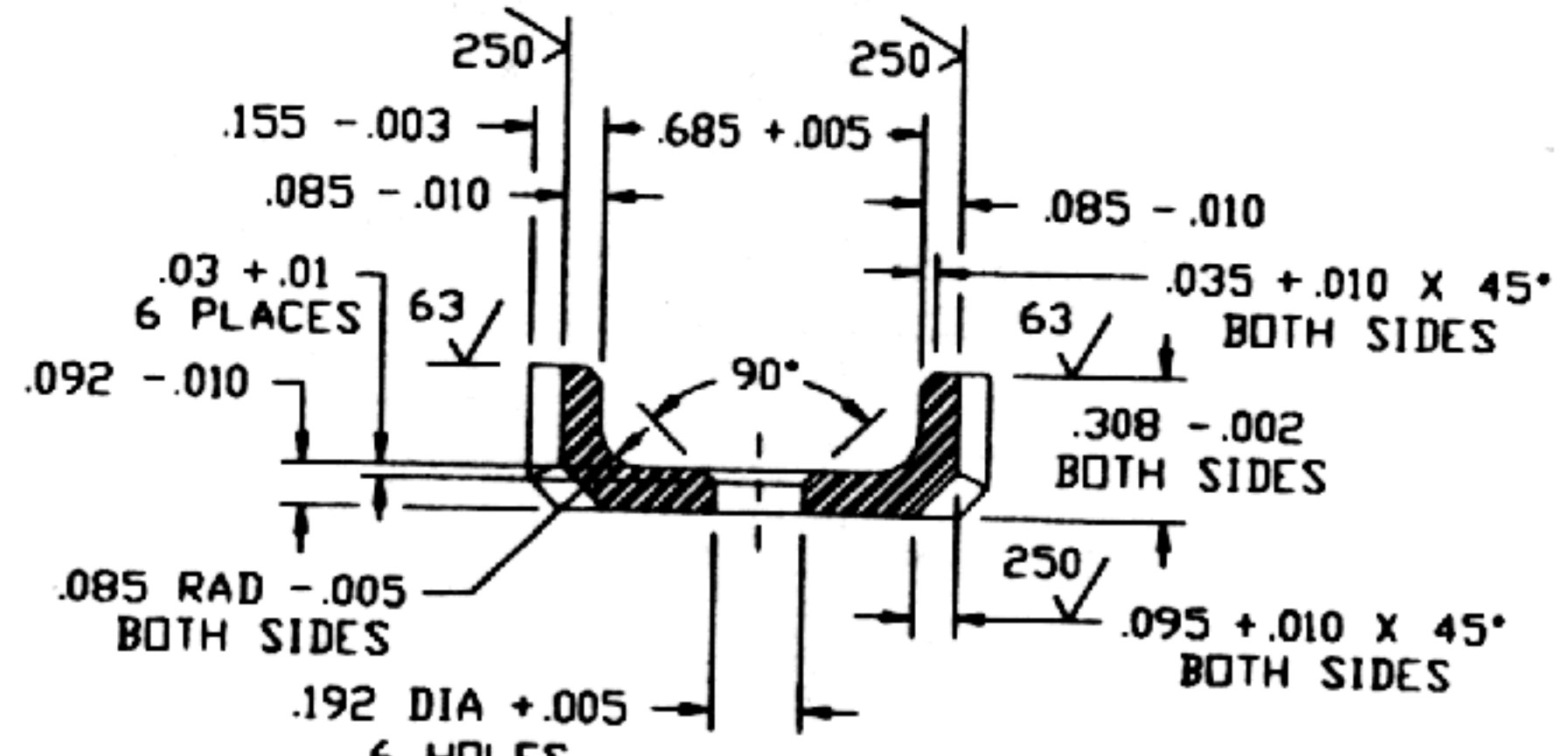
NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60D

CODE IDENT NO. 19204
 DRAWN FROM ORD PART NO. 11686307 SHEET 2 OF 2
 ROCK ISLAND ARSENAL
 DEPT OF THE ARMY
 ROCK ISLAND, ILL.

SCALE: FULL	MATERIAL: SEE SHEET 1	CKD.	TOLERANCES
DWN.	FINISH: SEE SHEET 1	DATE	DEC 2 PL ± .02
TITLE: M60 RECEIVER	REV.		M H ± .31
			DEC 3 PL ± .005
			M H ± .127
			ANGLES ± .5°
			NO.



SECTION B-B
ROTATED 90° CW
SCALE 2 TO 1



SECTION C-C
SCALE 2 TO 1

RESTRICTED MATERIAL

- NOTES:
- 1 FINISH 125/ EXCEPT AS NOTED.
 2. ALL EDGES SHALL BE BROKEN .005 ±.010 UNLESS OTHERWISE SPECIFIED.
 3. HEAT TREATMENT- HEAT AT 1535° TO 1565° F; OIL QUENCH. TEMPER ONE HOUR TO HARDNESS SPECIFIED. HEAT TREATMENT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
 4. HEAT TREAT BEFORE MACHINING.
 5. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS AT THE COMPONENT LEVEL. (L1)
 6. MATERIAL- STEEL QQ-S-624 4140, 8640, 8740.

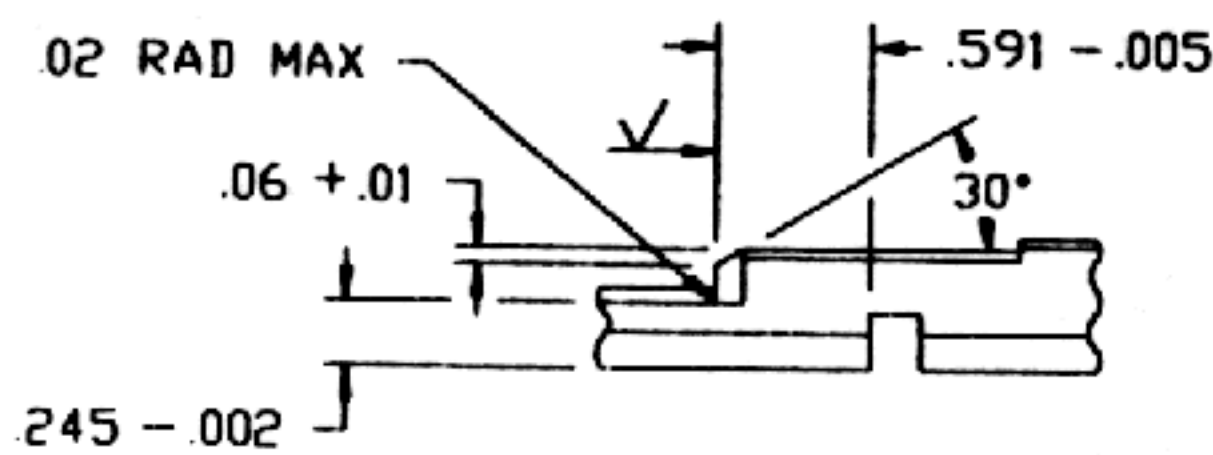
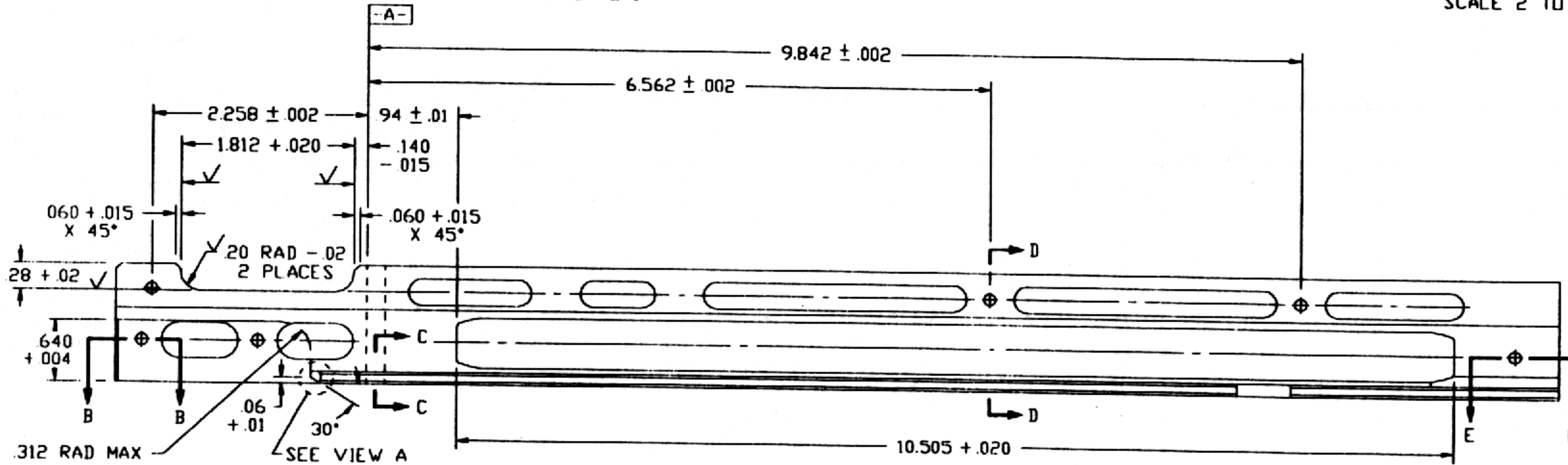
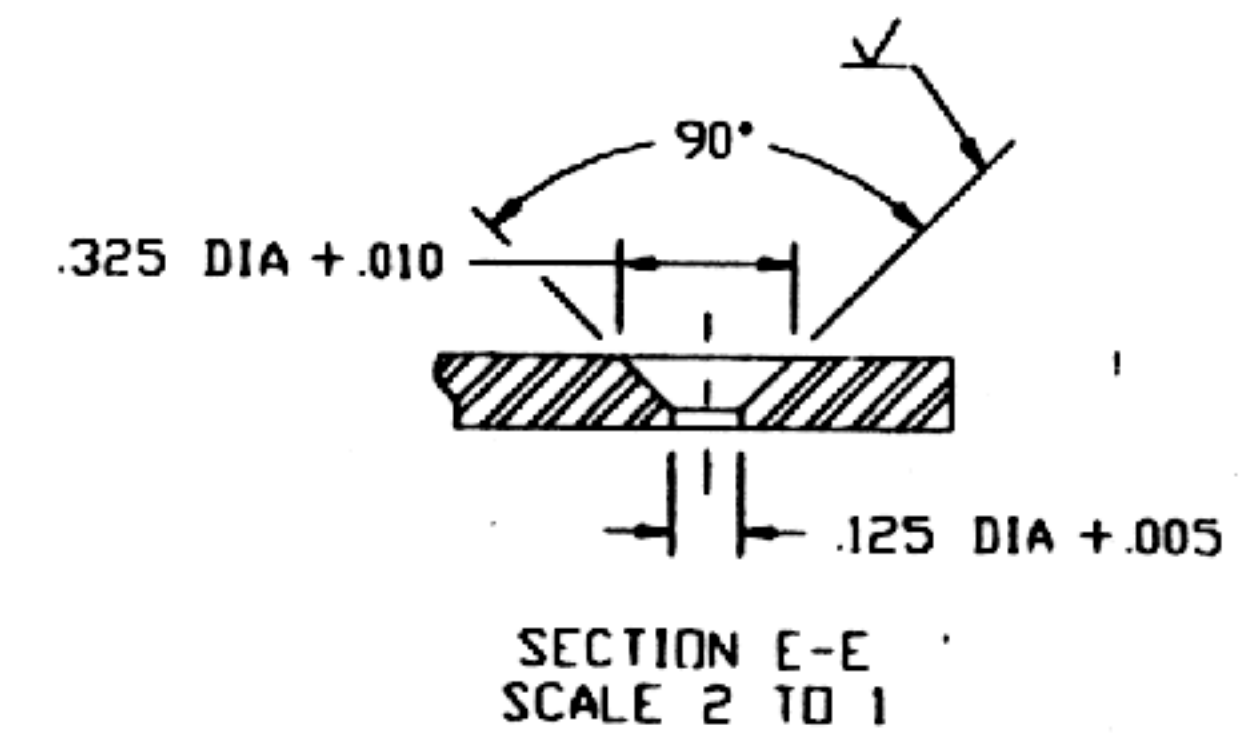
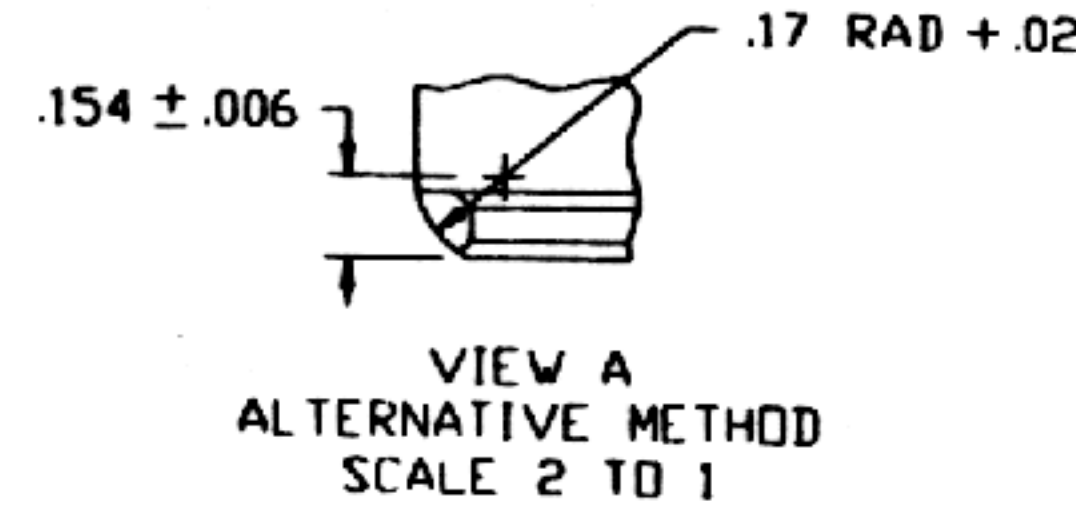
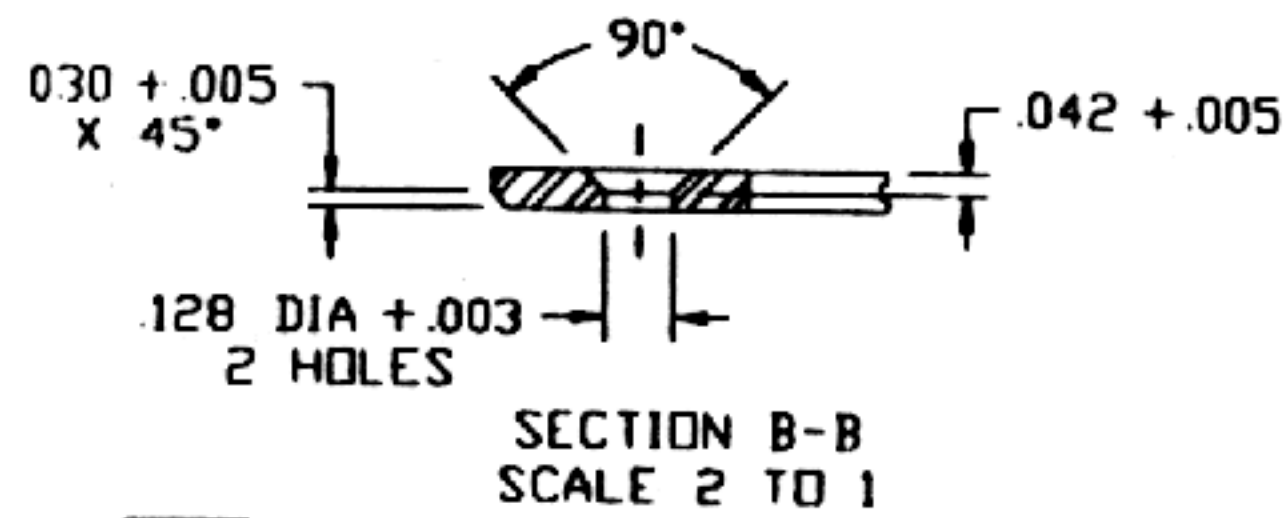
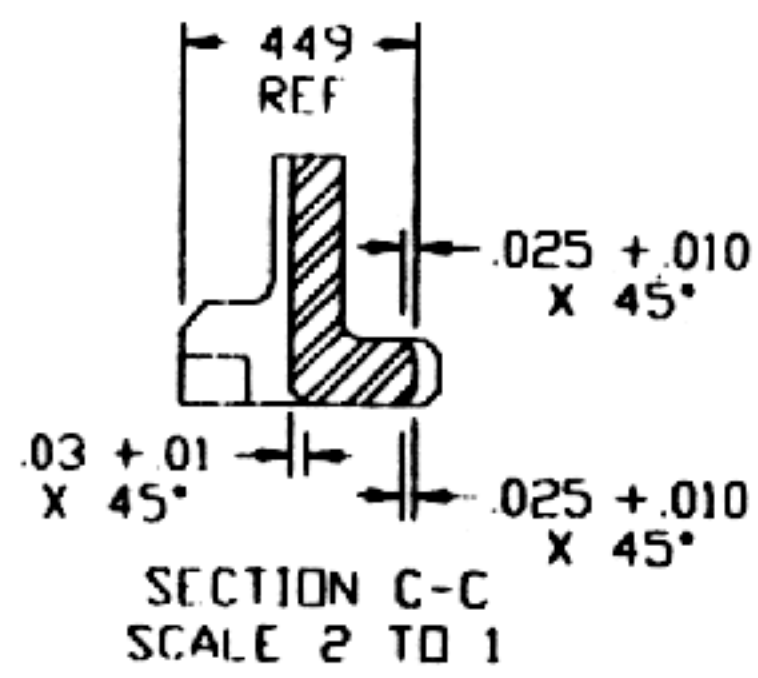
CONFIDENTIAL

NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.
	F11699805	M60D

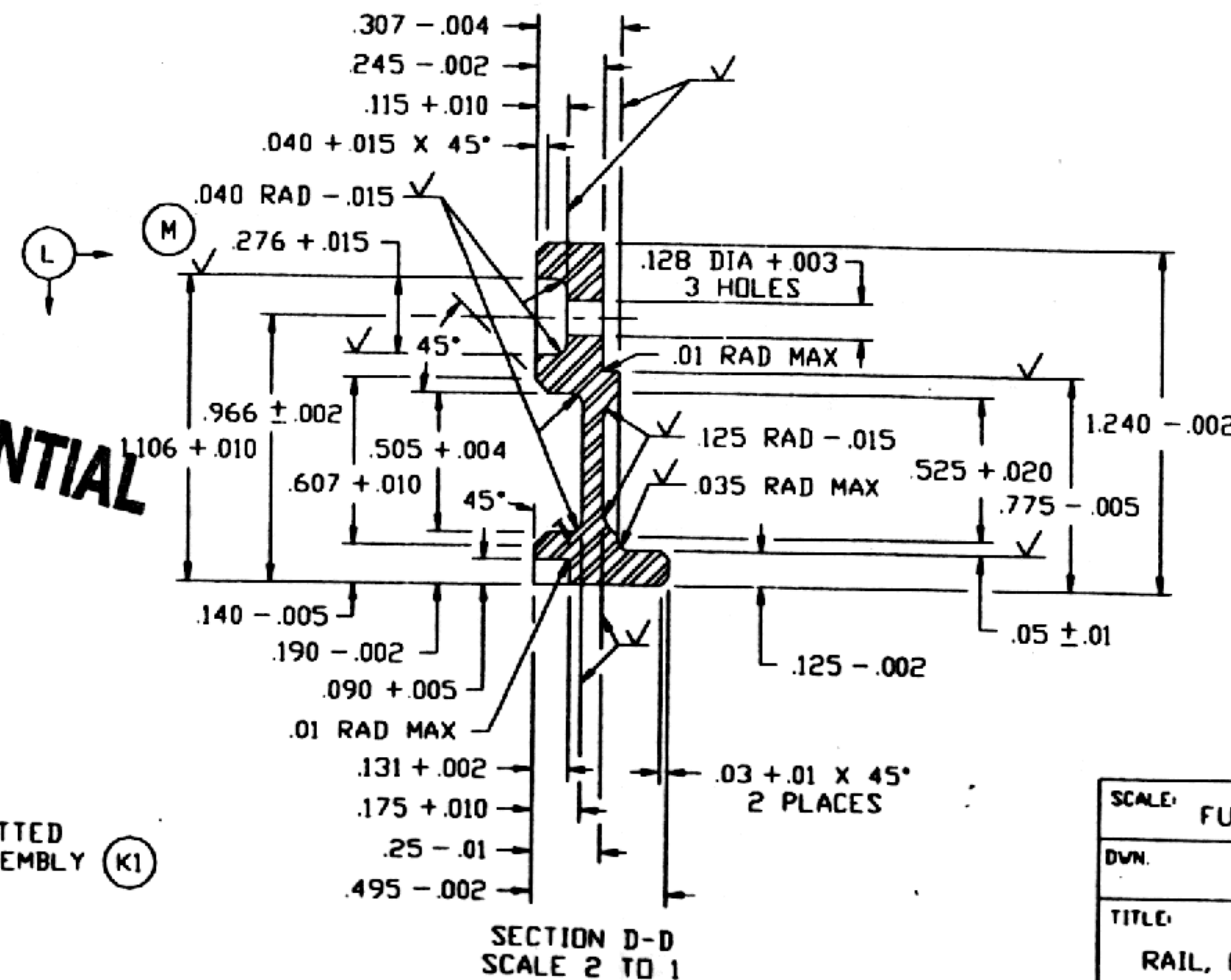
CODE IDENT NO. 19205
DRAWN FROM ORD PART NO. 7269259
SPRINGFIELD ARMORY ORDNANCE CORPS
DEPT OF THE ARMY
SPRINGFIELD 1, MASS

SYM	DESCRIPTION
K	REDRAWN WITH CHANGE SEE EO NO. SA30121
L	(1) SEE EO HRD 82232

SCALE: FULL	MATERIAL: SEE NOTE 6	CKD.	TOLERANCES DEC 2 PL ±.02 H H ±.51 DEC 3 PL ±.005 H H 3 PL ±.127 ANGLES ±.5°
DWN.	FINISH: SEE NOTE 1	DATE	
TITLE: M60 RAIL, RECEIVER, LOWER		REV.	NO.



VIEW F-F (SEE SHEET 1)



CONFIDENTIAL

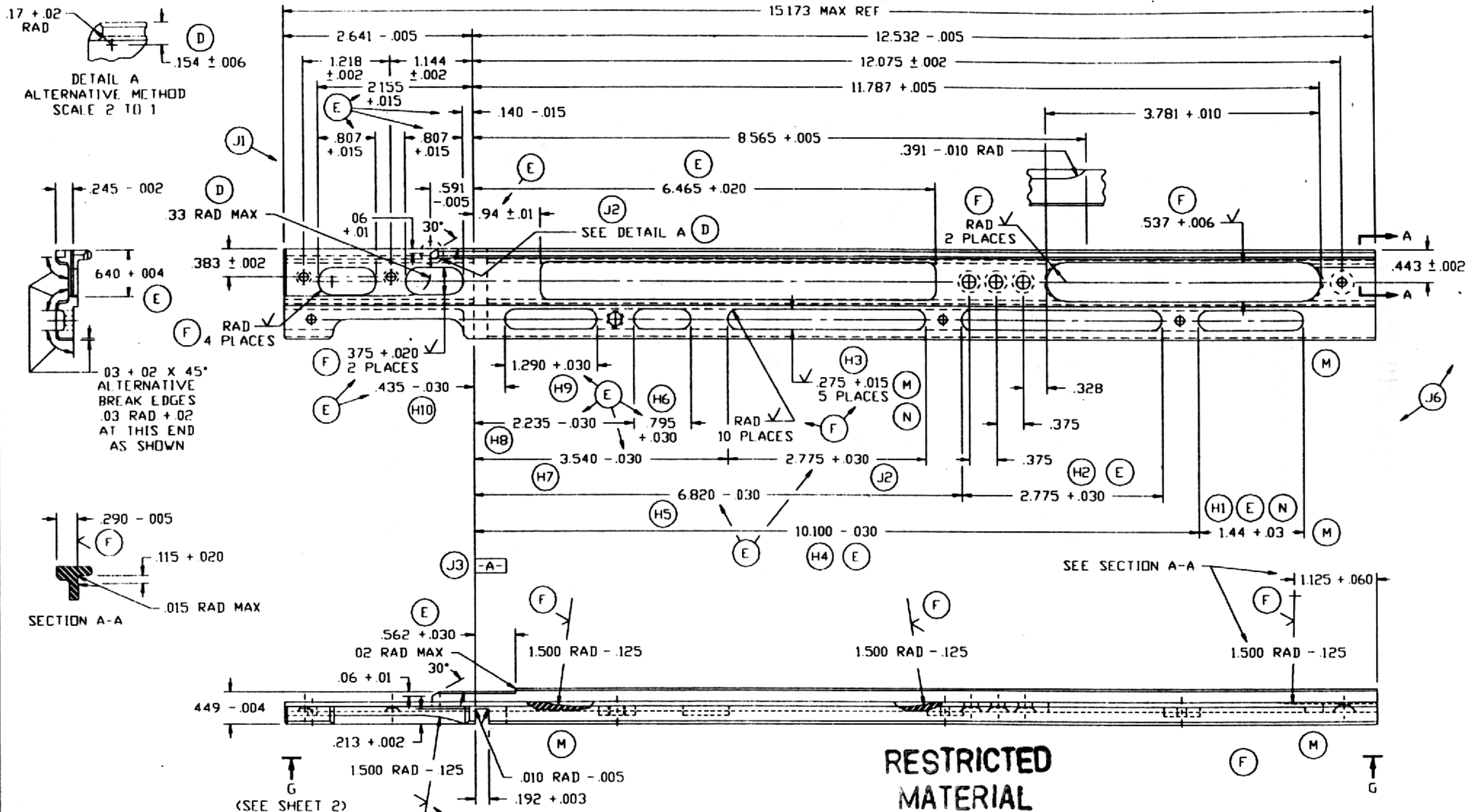
RESTRICTED MATERIAL

SYM	DESCRIPTION
J	REDRAWN WITH CHANGE SEE ED NO. 30122
K	(6) SEE ED HRD 82232
L	(1) SEE ERR HDR 10715
M	SEE ERR HDR 40604

CODE IDENT NO. 19204
 DRAWN FROM ORD PART NO. 7269258
 ROCK ISLAND ARSENAL
 DEPT OF THE ARMY
 ROCK ISLAND, ILL

NOTE:
 ALL RIVET HOLES AND THEIR COUNTERSINKS MAY BE OMITTED OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS APPLICABLE AT THE COMPONENT LEVEL. (K1)

SCALE: FULL	MATERIAL: SEE SHEET 1	CKD.	TOLERANCES
DWN.	FINISH: SEE SHEET 1	DATE	DEC 2 PL ±.02 M H ±.31
TITLE: M60 RAIL, RECEIVER, LEFT HAND	REV.	NO.	DEC 3 PL ±.005 M H ±.127 ANGLES ± 5°



- NOTES:
1. FINISH $125\sqrt{\text{V}}$ EXCEPT SURFACES MARKED $250\sqrt{\text{V}}$ FINISH $250\sqrt{\text{V}}$ (F)
 2. ALL EDGES SHALL BE BROKEN $.005 + .010$ UNLESS OTHERWISE SPECIFIED.
 3. HEAT AT 1535° TO 1565° F. OIL QUENCH. TEMPER 1 HOUR TO HARDNESS SPECIFIED. HEAT TREAT METHOD IS FOR GUIDANCE EXCEPT THAT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED.
 4. HEAT TREAT BEFORE MACHINING.
 5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171 (N)
 6. ALL RIVET HOLES AND THEIR C'SINKS MAY BE OMITTED OR LEFT UNDERSIZE PROVIDED THEY ARE PUT IN AT ASSEMBLY TO THE DIMENSIONAL REQUIREMENTS APPLICABLE AT THE COMPONENT LEVEL.
 7. MIL-W-13855 APPLIES. (L1) (M)
 8. MATERIAL - STEEL QQ-S-624 4140, 8640, 8740

CONFIDENTIAL

SYM	DESCRIPTION				
B		NEXT ASSEMBLY	F11686308	MG, 7.62 MM - M60, M60C.	
C	REDRAWN & REVISED SEE ED SA24642		F11699805	M60D	
D	REF ED NO. SA24924	CODE IDENT NO. 19204			
E	REF ED NO. SA26992	DRAWN FROM ORD PART NO. 7269260 (G1) (K)			
F	REF ED NO. SA27297	ROCK ISLAND ARSENAL			
G	(1-2) SEE ED SA28042	DEPT OF THE ARMY			
H	SEE ED NO SA28992	ROCK ISLAND, ILL			
J	(1-6) ED NO. SA	SCALE: FULL	MATERIAL: SEE NOTE 8	CKD.	TOLERANCES
K	SEE ED NO. SA14466	DWN.	FINISH: SEE NOTE 1	DATE	DEC 2 PL $\pm .02$
L	(1-2) SEE ED HRD 82232	TITLE: M60		REV.	DEC 3 PL $\pm .005$
M	(1-6) SEE ERR HDR 10715	RAIL, RECEIVER, RIGHT HAND			ANGLES $\pm 5^\circ$
N	(3) SEE ERR HDR 60604				NO.

LIST OF PARTS SUPPLIERS

**wholesale guns and ammo, inc.
232 blydenburgh rd.
central islip, NY 11722**

www.gunsnammo.com

**international military antiques , inc.
p.o.box 256 millington ,NJ 07946**

www.ima-usa.com

**inter ordnance of america l.p.
3305 westwood industrial drive
monroe , NC 28110**

www.inter-ordnance.com

**sarco , inc.
323 union st. p.o. box 98
stirling , NJ 07980**

**jeffs shooters supply
p.o.box 1054 trussville , AL 35173**

**rpb industries
p.o.box 367 avondale est. GA 30002**