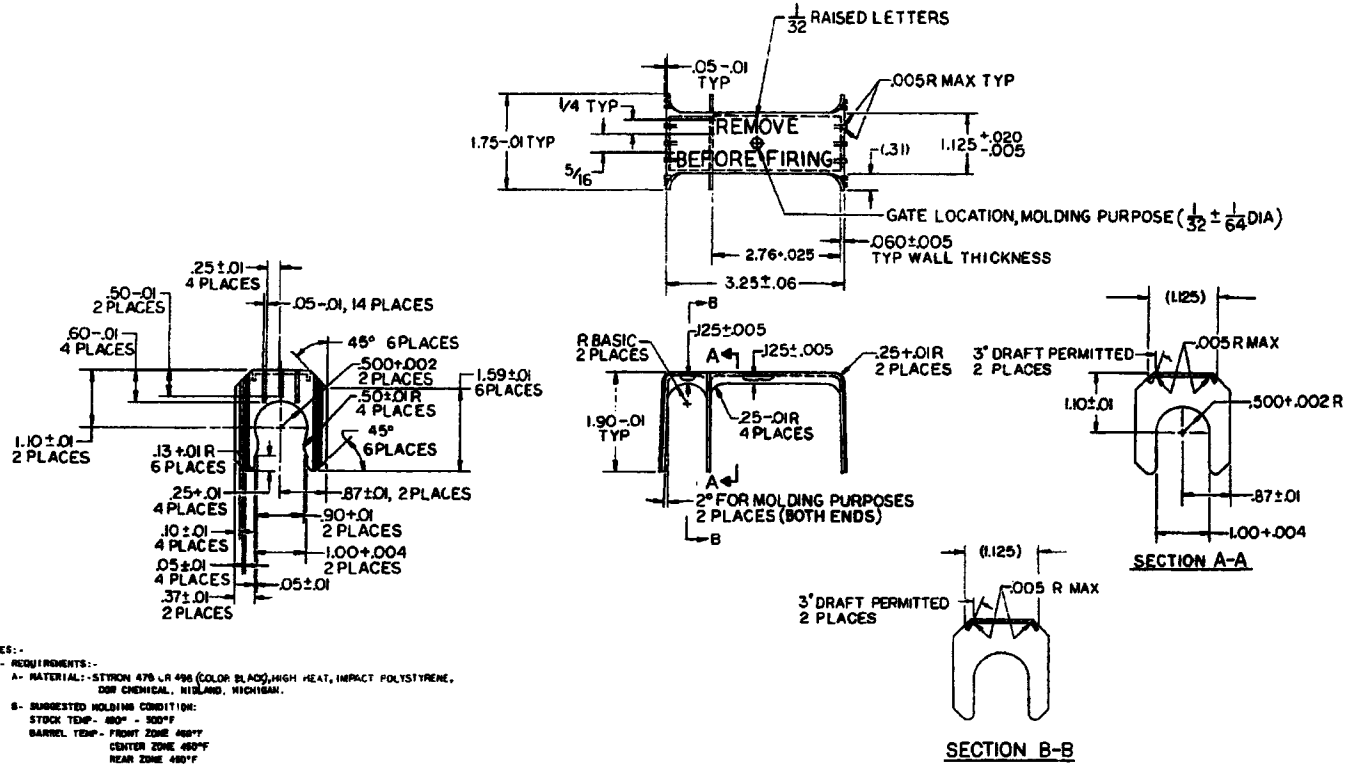
REVISIONS			
SYM	DESCRIPTION	DATE	APPROVAL
A	CHANGED: DIA 2.40+.01" TO 2.50+.01" .500±.002" 2 PLACES TO .500+.001" 2 PLACES .500±.002R TO .500+.002R	77-01-21	[illegible]
B	ERR 7700046-4	77-01-26	[illegible]
C	NOR A0J2000 [illegible]	[illegible]	[illegible]
D	NOR A3J2015 83-12-15	84-02-07	[illegible]
E	NOR M3K2023/890811	900213	[illegible]
F	NOR [illegible]	[illegible]	[illegible]
G	NOR M2J3040/92-12-28	93-01-14	[illegible]
H	NOR M6J3024 960422	960606	HJS
J	NOR R7K2009/970407	970505	DR
K	NOR R7K2054 980121	980213	JB
L	NOR R0J2068 010118	010315	TPT
M	NOR R2K2032/020826	020924	HJS



NOTES:-

1- REQUIREMENTS:-

A- MATERIAL:-STYRON 476 LR 498 (COLOR BLACK), HIGH HEAT, IMPACT POLYSTYRENE, DOW CHEMICAL, MIDLAND, MICHIGAN.

B- SUGGESTED MOLDING CONDITION:
STOCK TEMP- 480° - 500°F
BARREL TEMP- FRONT ZONE 460°F
CENTER ZONE 460°F
REAR ZONE 460°F
INJECTION TIME - 15 SEC
INJECTION PRESSURE - 1,200 PSI
MOLDING TIME- 10 SEC
MOLDING PRESSURE- 600 PSI
COOLING TIME- 10 SEC

C- NO SILICON MOLD RELEASE IS TO BE USED. IF NECESSARY, USE ONLY A WATER SOLUBLE MOLD RELEASE.

2- IDENTIFICATION OF THE "SUGGESTED SOURCES OF SUPPLY" HEREIN IS NOT TO BE CONSTRUED AS A GUARANTEE OF PRESENT OR CONTINUED AVAILABILITY AS A SOURCE OF SUPPLY FOR THE ITEM.

3- SUGGESTED SOURCES OF SUPPLY:-

FIVE STAR MOLDING
1339 CONTINENTAL DRIVE
EAU CLAIRE, WI 54701

DART POLYMERS, INC.
2400 HARBOR ROAD
P.O. BOX 390
OWENSBORO, KENTUCKY 42302
ITEM IDENT NO. DART P5304

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CURRENT DESIGN ACTIVITY CAGE CODE 19203
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

SPECIFICATION CONTROL DRAWING

PART NO. 9299246

9299245
NEXT ASSY
USED ON
APPLICATION

SOM/ ORD. N720, N720A1, N721, N722, N888 AND 1X767

MECHANICAL PROPERTIES

DO NOT SCALE DRAWING
UNLESS CONDITIONS OTHERWISE
DIMENSIONS ARE IN INCHES
TOLERANCES ON DECIMALS ±
FRACTIONS ± ANGLES ±

ORIGINAL DATE OF DRAWING
17 OCT 1975

DRAWN LR
CHECKED [illegible]
APPR [illegible]
APPR [illegible]

U.S. ARMY ARMAMENT COMMAND
PICATINNY ARSENAL, DOVER, NEW JERSEY 07801

SPACER

SIZE D
CAGE CODE 19203
9299246
SCALE 1/1
SHEET