

U.S.

MARTIAL ARMS Collector

and *Springfield Research Newsletter*

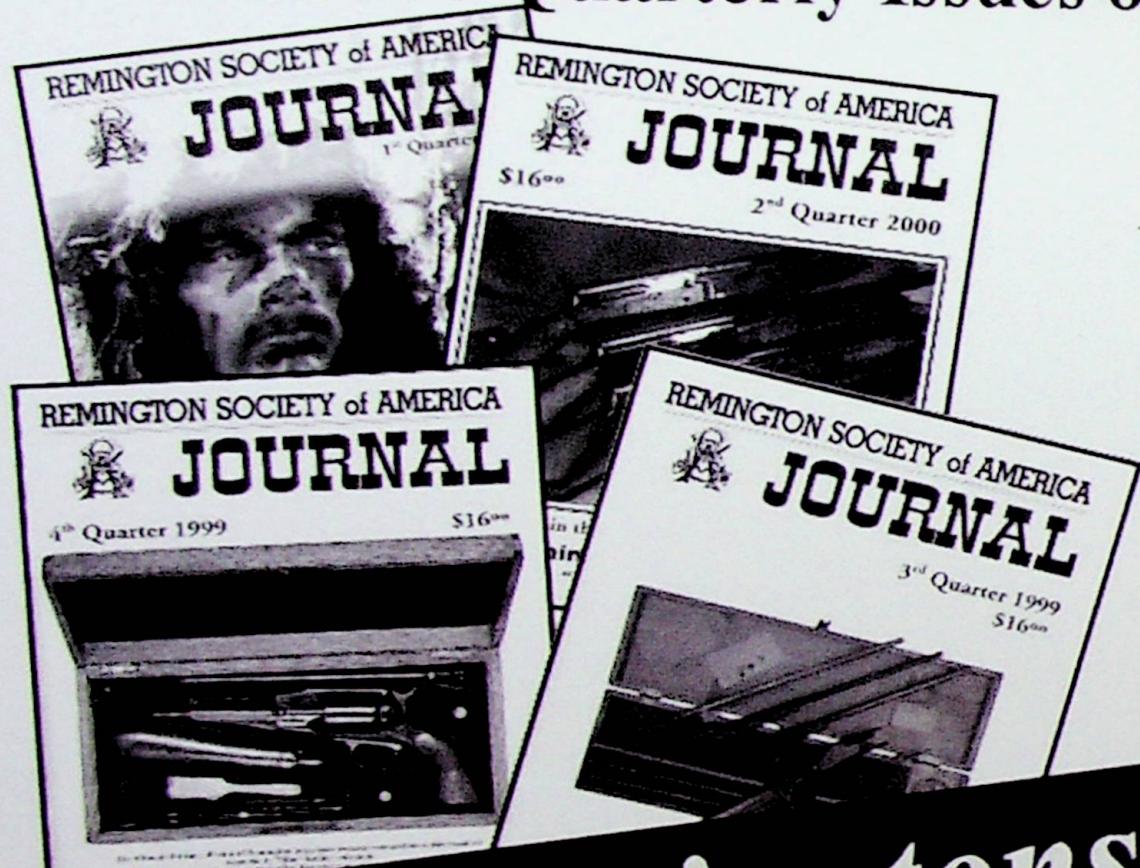


Number 119 June 2009

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Cover: Remington New Model Martial Army.

U.S. MARTIAL ARMS COLLECTOR



*And
Springfield
Research Service
Newsletter*

Number 119

June 2009

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MISCELLANEOUS NOTES

There have been many changes at recent gun shows throughout most areas in the U.S. The sale of modern pistols, military type rifles, and ammunition has skyrocketed. In many cases manufacturers and companies dealing in rifles, pistols, and major components are back ordered and cannot deliver without long waits. Retail shops seem to be able to sell all that they can acquire and are waiting to fill customer orders. This appears to be true of reloading components as well as many accessories. The prices are escalating for these products and manufacturers are at their capacities. Many types of ammunition are selling for several times the price that was charged last year. It is not uncommon to see pistol ammunition at \$ 20 per box and rifle ammunition at \$.50 per round. It would take a very lengthy discussion to determine the exact cause and rationale but there is a wide spread desire to buy both the weapons and ammunition.

At the other end of the spectrum there is the antique trade. Many antique dealers say that show sales are down except for the really fine quality at high prices.

There appears to be sparse inventories of fine antiques at many gun shows.

A brief review of high end auction results appear to have sales of fine weapons selling at a slightly lower price than a year ago. It seems that there are some very fine weapons being sold at comparative lower prices.

It is a good market for those that have the funds to take advantage of this latest trend. We will need to look at the markets over the next year with some general Washington issues that include a projected commercial real estate, the high end residential market, and the next phase of the credit card business. There are many economists projecting a longer adjustment

period for housing and unemployment rates. This will obviously affect the gun market.

Current interests

SRS receives many requests and inquiries for data on trapdoor 45/70 rifles and carbines. I am happy to say that there have been many new finds of Indian War era carbines and rifles. It is a continual environment where rare and very collectable weapons are being uncovered. Many people see weapons being brought into gun shops and to gun shows to seek information, and find a source to get rid of an old gun. There is a minimum amount of information available to the average person. One finds a weapon and has no interest and usually wants to get rid of it for a variety of reasons. The result runs from asking questions concerning its worth or just simply wanting to sell it for what is offered. The result is that most dealers do not have any information on the history according to the serial number. Often it is mis described unless the dealer talks to others and finds data in a reference book. Many rare guns have not been accurately researched. In general terms, most serial numbers are never researched.

Unfortunately unknowing sellers do not get a value that is appropriate and many buyers do not value most guns at their real value.

A weapon that is found in an attic or a family item that has been handed down is on a journey of unknown time until someone researches the item. The other extreme is the common weapon that is offered as a rare collectors item with a high price or a weapon that has been altered, refinished or has new or false parts. This occurs both intentionally or unintentionally..

Unfortunately anything can happen and there are no real common standards.

We find guns at gun shows that are described as issued to a very interesting

military unit with inaccurate or false SRS information. The most common statement is that it is numerically near another verified serial number and that makes it a verified SRS documented gun. This is false information and any buyer should be wary and never buy a weapon on hearsay or questionable information. All SRS letters have specific data that is unique to the specific number which is based on a U.S. Government document. There were three different signatures for all SRS letters over all of the years of operation. Anything that is in addition to the three unique signatures or any data that is not signed is very questionable.

Serial Number Oddities

It is still difficult to easily explain that most military weapons are not in serial number sequence nor in an exact production schedule. Springfield Armory did not have a conventional production line. The identical model of a weapon could be assembled at ten or more locations by different personnel with parts chosen at random from existing supplies. Using the Krag rifle as an example, there were as many as 15,000 receivers in the supply system at one time. Any one receiver could be assembled alongside another receiver by the same technician at the same assembly location. Both with completely different serial numbers that were hundreds or thousands of numbers apart. Shipment checking of sample crates of ten resulted in no consecutive weapon numbers found in the same crate.

This test and survey was done because of a Congressional inquiry concerning data on numbers of weapons manufactured with a royalty paid.

A verified serial number may increase the value of a weapon anywhere from a small premium to a great deal of money. The most sought after weapons are Custer carbines and revolvers, and weapons used

at San Juan Hill during the Spanish American War. There are many others such as experimental item, weapons issued to senior military and political personnel and those issued in famous battles. Many unique item include weapons used by the USMC, OSS, sniper rifles from all wars, and all items from historic United States operations. A record must exist from United States documents that specify the exact serial number. We are fortunate to have found a large amount of data that has serial numbers, sale of the item to an individual, and the Springfield Armory description of the specific weapon. Other data may only have the military unit and date. It is however, very sought after by military collectors.

Springfield Research Letters

We are continually writing letters for our subscribers. Our back up has slowed to a certain extent but we are always searching for the needed data to write a complete letter. Many times, the Archives can not locate a source document that we previously checked out. This causes major problems and if there is no back up, the data may be lost forever. The recent somewhat amusing occurrence at the Archives is in the area of rules of research. I recently arrived at one of the buildings with a government issued and dated photo ID card. I required another badge issued as a temporary visitor badge. I proceeded through several areas of inspection and proceeded to research several original Civil War books. My standard uniform is a blue blazer with khaki pants and loafers. When I took my blazer off and put it on the back of my library chair, a government security type rushed over to me and instructed me to put my jacket back on immediately. It was OK to have a soiled T shirt or sandals and cutoffs but I must wear my jacket or not have it with me.

This was before leaving when I was checked, all papers including personal papers brought in with me were checked and looked over by guards at two different positions. They excel at their jobs.

Recent Activity

Our web site has had a continual activity of one thousand to fifteen hundred hits per month.

SRS will provide the following letters for 2009.

Basic letter- This letter provides information from the SRS data base that was compiled over many years of research. This letter will include information on a weapon and its use such as military unit, date, and possible secondary information. It will not include specific data on names or combat use that requires travel and research through extensive visits at government facilities. This category will include **Sales letter information** with any available sales documents and other similar data. We receive many requests for 1903 sales rifles, NRA sporters, National Match rifles, International rifles, Colt, Smith & Wesson pistols, and General Officers weapons. We will provide Springfield records of DCM sales documents if available.

Research letter -This letter requires travel to government facilities and research government. It takes a minimum of one day of analysis and requires travel, research, and review at government facilities. These efforts will be limited in number and may take several months to accomplish. Competition of the search is based on time and availability to visit the government facilities as well as their regulations.

Additional data will be listed on our web as it becomes available.

usmartialarmscollector.com

We are always interested in receiving

photos VIA the internet for rare or unique weapons. We continue to add many more photos for our research and data base. It is an asset for the U.S. Martial Arms Magazine and SRS Newsletter. Our only limits continue to be the time and effort available to do research at government facilities.

Springfield Research Service Data Base

Website access to the serial number data base was shut down. This was necessary due to many misuses of the data. We are now in the process of developing a new on line service. We will be working on this over the next year. There are still dealers using SRS data as a sales thrust saying that a weapon is close to a known number and therefore this rifle belongs to the same military unit. This is bad information and is not accurate .Misleading information can be made and it is not authorized by SRS. All SRS data is copyrighted and no authorization has been given for its use. Our subscribers to the US Martial Arms Collector Magazine and Springfield Research Newsletter deserve the benefits of SRS and may email a request for a serial number at any time. We will respond with a yes or no that we have data on that specific number. There is no charge for subscribers. We are doing research on starting up another on line serial number capability. This will take an extended amount of time and the results will be printed and on our web site. Mail requires extra time for an answer to a number request. A subscriber can request a letter with basic and research information.

Please see our web site:

usmartialarmscollector.com

Please send inquiries and questions to:

editor@usmartialarmscollector.com

An inquiry can be made by mail to SRS Box 126 Cabin John, MD 20818. This may take an extended time to look up the number and send a letter by mail.

We also review activity on the various web sites and find that our readers should be the ones that benefit from our data base, book sales, and other products. Plans are underway to expand some of our products with additional manuals and books. As we develop the products, they will be put in the magazine and on the US Martial Arms Collector web site. We may include more data on the web site, if it is of interest and benefits our readers.

Data on Books, and Web Page

Demand and capability to produce documents will be the factors for expansion. All manuals and documents will be copies of original government documents.

We will continue setting up a plan to list articles of specific interest with issue number on the web page. The lost software has been corrected and we will start a process of emailing a list of articles for the early magazines (1 through 40). This will be in response to subscribers that email a request for an outline of past articles.

Krag Rifle Story

Original new second editions with serial numbers are available for \$ 100 postpaid. They are limited in the number and are below costs posted by many book dealers. It is not expected that the supply will last.

Serial numbers

The data base continues to grow and is well over 100,000 numbers. There are no plans to publish serial number books.

Web site is: usmartialarmscollector.com

All of our products are only available for our subscribers and are mailed from: **U.S. Martial Arms Collector Box 126 Cabin John, MD 20818.**

Back issues of the U.S. Martial Arms Collector Magazine and Springfield Research Newsletter are available from number 1 through 118 and can be ordered from **U.S. Martial Arms Collector Box**

126 Cabin John, MD 20818.

A few issues of The U.S. Martial Arms Collector Magazines may be available as copies only.

Past publications requires us to store most old issues and keep them air conditioned. We will do this as long as practical.

Springfield Research Service

The Springfield Research Service web site is open: usmartialarmscollector.com.

SRS Letters & Costs

Letters have resumed. SRS will include two different letter types:

Basic letter (and sales letters) \$ 50.

Research letter (requires more than one day of travel, access to government facility and research) \$ 175 (orders are available for 2009).

Cover

The revolver pictured is an excellent Remington New Model Army that is in near perfect condition. Courtesy of Doug Carlson and photographed by Paul Goodwin,

Interest and Comments

All comments and questions on U.S. Martial hand guns and long arms are welcome.

1903 Shop manual

We have the 1903 Shop manual available again. It was lost for several years and is of interest to collectors. The cost is \$ 20.00 postpaid. We have other military model shop manuals that have been copied directly from original documents. They include the M14, Commercial rifles used by the armed forces, and other miscellaneous models.

They are reproduced one at a time as subscribers order them. Please give feedback if there is interest in these documents.

Letters Received & Answered

I recently purchased a Trapdoor Officer's model made up on a military barrel and receiver. The serial number is 240560, and is an 1873 rifle. Is this in your database? How can I join or get information on this rifle and its history if known? I know that this is not an authentic Officer's Model in that they were not serial numbered.

Thanks

We do not have that number in the SRS data base. You can subscribe to our magazine by visiting our web site at: usmartialarmscollector.com Editor

I recently received a Krag from my father who has had it since his father (my grandfather) whom he said used it in WW1. I am wondering if you can tell me anything else about it from the serial number. It is a Model 1898 from Springfield Armory and the serial number is 140962.

We do not have data on that serial number. Editor

I am interested in purchasing the books with the 03 serial numbers. What is total price with shipping? And how do you want payment, Money order, check, PayPal? Name and address to send payment to.. Please advise.

We do not have serial number listings by sub categories such as 1903 Springfields. We will start accepting credit card payments in June 2009. Checks can be sent to SRS box 126 Cabin John, MD 20818. Editor

I would like to buy a copy of "The Krag Rifle Story" by Frank Mallory. Would you have a copy of this for sale? If not, do you know of anyone else who still offers this book for sale? Many thanks in advance, **Subscribers can order a copy for \$100.**

SRS Box 126 cabin John, MD 20818 Editor

Question/comment: I would like to become a subscriber for the purpose of determining the name of the person to whom a Rock Island 1903 Springfield rifle serial number 73000. Are you set up to accept debit cards?

Yes, CREDIT CARDS ACCEPTED as of June 2009. Editor

Re: Colt 1851 Navy. I know it doesn't prove anything, but is 77 to a standard location, a union cavalry unit, or somewhere more exotic?

Unfortunately, we do not have that data. Can any reader offer help. Editor

Yes, I know, and I understand that SRS has found data on one shipment of 1,000 Colt 1860s that had serials over a range of 20,000 or so, and as you say there is no way to tell how mixed up they got after received by the government.

Thanks. Editor

I was wondering if you could possibly tell me when my Springfield model 1873 rifle was made. The serial Number is 5532. And secondarily could you give an approximate value. The metal is good shape but the stock has be varnished it appears.

Sorry, we do not have data on that serial number. We do not give values for weapons. Editor

Trading Post

We offer no charge listings for non commercial subscribers. There has been little activity in this area and we need feedback on any interest for Wanted, For sale or Trade items.

Currently we have one request- Wanted Whitney Plymouth Rifle Bayonet for rifle # 114.(please contact editor if you have any data on the bayonet or know of its whereabouts). Thanks Editor

Guns Lettered

Springfield NRA Sporter Model 1903 rifle serial no. 1255645
April 12, 1923 Springfield Armory, Massachusetts
Ogden Depot May 4, 1939

Colt 1903 Pistol serial no. 569965, issued to a General Officer by the U.S. Army.
Issued To: Brigadier General R. F. Schirm
May 19, 1954

U. S. Springfield Model 1903 serial no. 420018, issued to Company A 6th Pennsylvania National Guard, October 27, 1890.

Colt Model 1911 Pistol serial no. 82446 Maxwell Field September 10, 1943.

Springfield Model 1922, M2 rifle serial no. 720
Capt. John Nesick, F.A. Fort Hoyle, MD November 27, 1933.

Springfield Model 1903, Type T, serial no. 1266213 DCM sales program, 28" Barrel.
State of Washington, (dj. General Camp Lewis, Washington. May 4, 1927.

Springfield Model 1903, serial no. 1326246 DCM sales program.
Lt. A.T. Walker Sept, 17, 1930.

Remington M1861 Old Army revolver serial no. 3577, Company I, 1st MO Volunteer Calvary. 1863.

U.S. M1 Garand Rifle, serial no. 6087869 U. S. M1 Cal. .30, National Match.
New Hampshire State R & P Association.
October 27, 1982.

U. S. M1 Garand Rifle, serial no. 5413669DCM sales program.
New Hampshire State R & P Association. October 27, 1982.

Colt U.S. Navy Model 1851 Navy revolver serial number 141987, Company M, 10th Michigan Volunteer Calvary. September 9, 1865.

SPENCER Carbine serial number 58126, Company M, 1th New York MTD Rifles
JUNE 12, 1865.

SHARPS Carbine serial number 9675, Company C, 1st California Calvary. 1862. 1st California Calvary to U.S. Army.
February 16, 1862

U.S. Springfield serial no. 553726, please be advised that the records of the U. S. Ordnance Dept. Company E 9th New York Volunteer Infantry, in 1898

Remington Model 51

The model 51 was manufactured by Remington Arms Company and marked Remington Arms-Union Metallic Cartridge Co. Inc. Remington Ilion Wks. Ilion N.Y. U.S.A. Pedersen's Patent Pending.

Production ran from 1918 to 1934 in calibers 32 ACP and 380 ACP. This civilian pistol had a limited production of 65,000 pistols made prior to World War 2.

Requirements for special pistols during the war were filled by United States Government contracts to buy existing stocks of commercial arms. The small amount of pistols purchased has brought out a group of weapons that are in great demand by collectors.

The Model 51 had the ability to be easily carried and concealed. It had a seven round detachable magazine with a single stack configuration. The pistol had a blued finish with a three and one quarter inch barrel and weighed twenty one ounces. Part of its unique design is that no screws were used in construction including the grips..

All pistols noted below were made in caliber 380 ACP for the Office of Special Services (OSS) during the war. We have found serial numbers for a small number of these pistols. A collector would be very fortunate to find one with its unique usage by the OSS.



Known serial numbers issued to the OSS.

SERIAL	MODEL	MMDDYY
2610	.380	092043
4537	.380	060844
9464	.380	060844
35115	.380	092043
37321	.380	060844
39910	.380	092043
52159	.380	092043
60372	.380	051844
47491	.380	011544

Remington tested a heavier Model 53 in caliber 45 ACP prior to World War 2 but did not complete production or manufacture. Production of the Model 51 was terminated before World War 2 but the United States Government bought these weapons for critical operations. All were chambered for the 380 ACP caliber.

In addition to Remington, handguns were bought from Harrington & Richardson, High Standard, and Orgies. They included weapons of various types and calibers.

There were more significant numbers bought from Colt and Smith & Wesson. The war effort and demand for arming, training and selected operations looked at all possible sources of weapons and support equipment. It is probable that many items were used in historic situations throughout the world. It is hard to find and verify their origins and operations. Our search continues.

We look at future article information and many sources indicate other items that were used for special operations. We welcome any comments and factual information on

the use of rifles, handguns, and special weapons used in international conflicts.

Editors notes

We have found data on several other handguns and additional data on standard military weapons used by the OSS and other operations at embassies around the world.

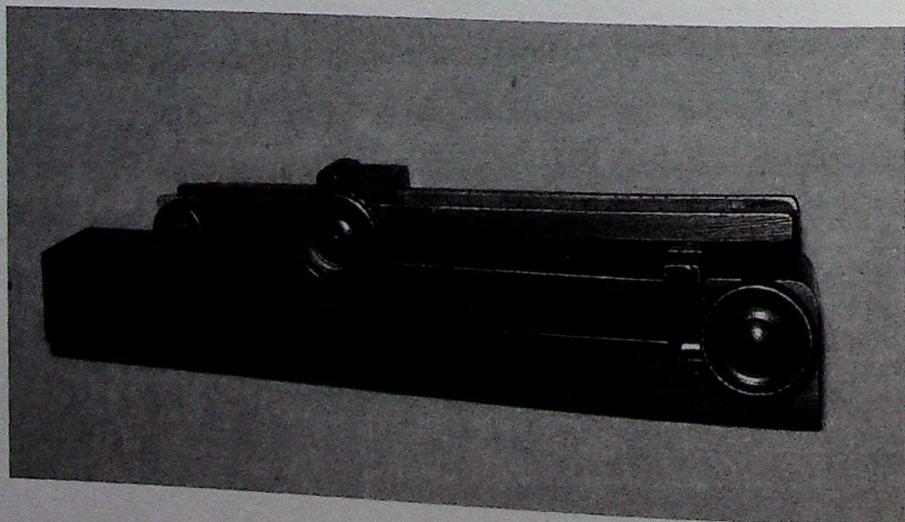
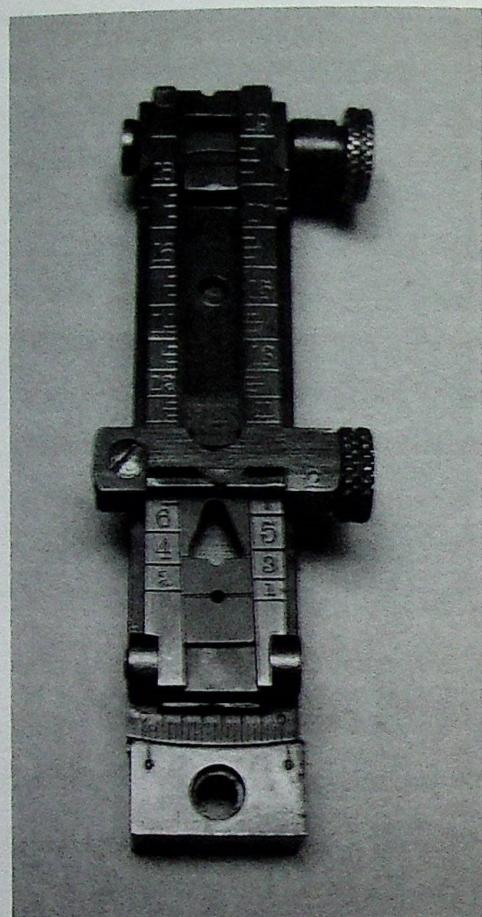
We know of Krag carbines used by the Marine guards in the 1930's and Winchester 6mm Lee rifles in use from the Spanish American war through 1925. Lee rifles were also used as guard guns for U.S. Presidents and other personnel. The use of Colt caliber 25ACP, 380 ACP, and 32 ACP have been found as General officer issues as well as other uses. The use of Smith & Wesson Lightweight revolvers were made for the USAF and the Army Air Corps.

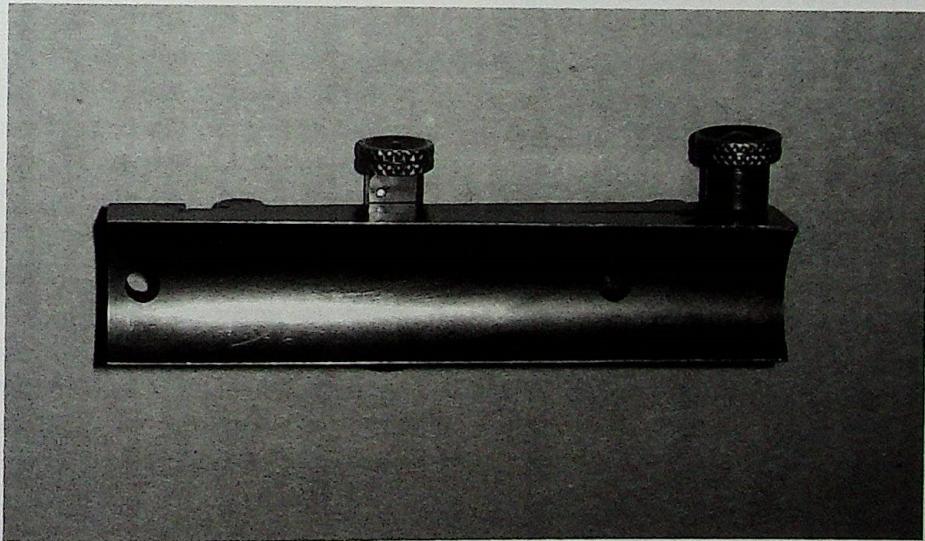
It appears that there are quite a few weapons used in addition to standard military firearms. Comments are sought on any weapons that were used by the U.S. Forces.

The Model 1905 Krag Rifle Sight

The Krag rifle and carbine remained in service long after the 1903 Springfield rifle was introduced and used by the U. S. military. The Krag rifle stayed as the standard for the U.S. Navy almost two decades after the 1903 was produced for the U.S. Army. The 1905 Krag rifle sight was authorized and produced in very small quantities by the Springfield Armory. Col. Frank Pipp signed off on the drawings on June 14, 1906. The sight was designated "Rear Sight, Model of 1905, U.S. Magazine Rifle, Model of 1898". The fixed base was 3.3786 inches in length and was fitted to the Krag barrel using the same type of screws with the same spacing as used for the other Krag rear sights.

No alterations were made to the barrel. The fixed base was new and machined to match the barrel contour with similar machining as the 1903 2400 yard rear sight. The leaf assembly was graduated to 2000.





The rifle required a new front sight and hand guard to work with the rear sight. The front sight used the same fixed base with a dovetail modification and a moveable sight and blade secured by a screw holding the moveable stud in place. It was drilled and tapped in the front of the fixed base.

The hand guard was altered to accommodate the bigger rear sight. At least two weapons have been found and the total small number manufactured is unknown.
Sight courtesy of Doug Rainbow. Data and photos from SRS files.

U.S. Martial Arms Collector 119-11

U.S. Marines NRA Sporter Rifles

The 400 NRA rifles owned by the USMC during World War 2 has been an illusive weapon for collectors. There is no doubt that they existed but there have been no documentation found to show their disposition, use, or final configuration. The Justice Department owned the weapons before the war and sold them to the USMC. There were 300 rifles in serviceable condition and 100 with bad barrels. Other observations of odd 1903 barrels include a 1942 dated series of barrels made as a replacement. They have a slightly different contour and no evidence of any rear sight or rear sight base. There have been observations of NRA sporters with this type of barrel but no documentation to date. The barrels observed had a blued finish and 1942 is the only date that has been seen so far. The underneath of the barrel has quite a few markings including steel lot numbers, steel markings believed to be the company providing the blanks, and star gage markings. Other marks may be the drawing numbers. It is possible that the barrels were made as replacements for the 100 rifles with bad barrels that were sold to the USMC. No data has been found to confirm this. The FBI Institute was located at Quantico Marine Base in Virginia and Justice Department personnel and other agency personnel are still being trained at Quantico today. It is believed that the items were to be purchased with several options for their use. They included: use as spare parts, restocked and made into service rifles, and held for training or other operations. In March of 1942 discussions were held and a transfer of the weapons was made without transportation to another location. We have not found documents on exact work done or issue to USMC personnel. The attached documents are part of the research that has

been uncovered. The USMC personnel involved include Major Van Orden, the well known USMC sniper developer, and manufacturer of Van Orden rifles for the USMC. His activities also include the sought after Winchester series of sniper rifles.

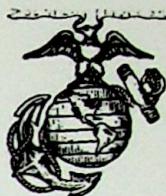
Major Blanchard and Colonel Waller as well as the Commandant of the USMC and the director of the FBI are all listed in the correspondence.

The search for an original rifle in its original form and finish and any rifle that has been modified by the USMC is on and may lead to a very nice find. It has been a conversation for years over the status of NRA Sporters with modifications that are unknown. This includes different barrels, sights, and other work. No observations have been noted of parkerized weapons or service rifles with drilled and tapped receivers that are known to be original to the gun. Examples of 1903 target rifles with star gaged barrels have been found in service condition with WW2 cartouches. There is no doubt that the war effort was underway and the USMC would have used all resources to have more weapons. Unfortunately, almost anything could have happened after the war as far as disposition, modifications, and later civilian use and modification.

Some fortunate collector is going to find one of these rifles and be confronted with trying to verify its history, or unknowingly use it, shoot it, or keep in his collection as it was acquired.

All of us now have another target to look for in the search for U.S. Military rifles.

IN REPLYING ADDRESS
THE MAJOR GENERAL COMMANDANT
AND REFER TO NO.
AO-42-1em



HEADQUARTERS U. S. MARINE CORPS
DIVISION OF PLANS AND POLICIES
WASHINGTON

From: The Director, Division of Plans and Policies.
To: The Commandant, U. S. Marine Corps.

CONFIRMATION OF VERBAL INSTRUCTIONS

BY [TELEPHONE
~~PERSONAL CONVERSATION~~

Time: 1600 Date: 6 March 1942

Between HQ, USMC, DP&P, GS, (Col. L.W.T. Waller, Jr.)
and Major George O. Van Orden, Quantico, Va.

Reference:

Subject matter: Major George O. Van Orden called from Quantico and reported the fact that he had received information from Mr. Glavin, Assistant Director of the FBI School, Quantico, that the FBI was discontinuing the use of .30 cal.

They have at Quantico, 400 Springfield Rifles with sporting stocks, of which 300 are in excellent condition and approximately 100 need rebarreling. He further stated that the FBI has at the FBI Institute, Quantico, 300,000 of caliber .30 M2 ammunition and probably 40,000 rounds in the field that they desire to dispose of and would be glad to sell it to the Marine Corps.

The 400 Sporting Springfields could be used for spare parts, if for nothing else, or restocked into service rifles.

215-2
215-12

GAB mea

March 28, 1942.

Sir:

This office has received information that the use of caliber .30 rifles is to be discontinued by the FBI, and that there are on hand at the FBI Institute, Quantico, Va., 411 Springfield rifles with sporting stocks, 30 of which are in excellent condition and approximately 100 in need of rebarreling. It has also been learned that the FBI Institute has 310,000 caliber .30 M2 cartridges at Quantico, and approximately 40,000 in the field.

The Marine Corps would like to purchase the rifles and ammunition, and in the event the sale meets with your approval, it is requested that this office be informed of the cost, in order that funds may be set up and a formal order placed with your Bureau.

By direction of the Quartermaster:

Very respectfully,

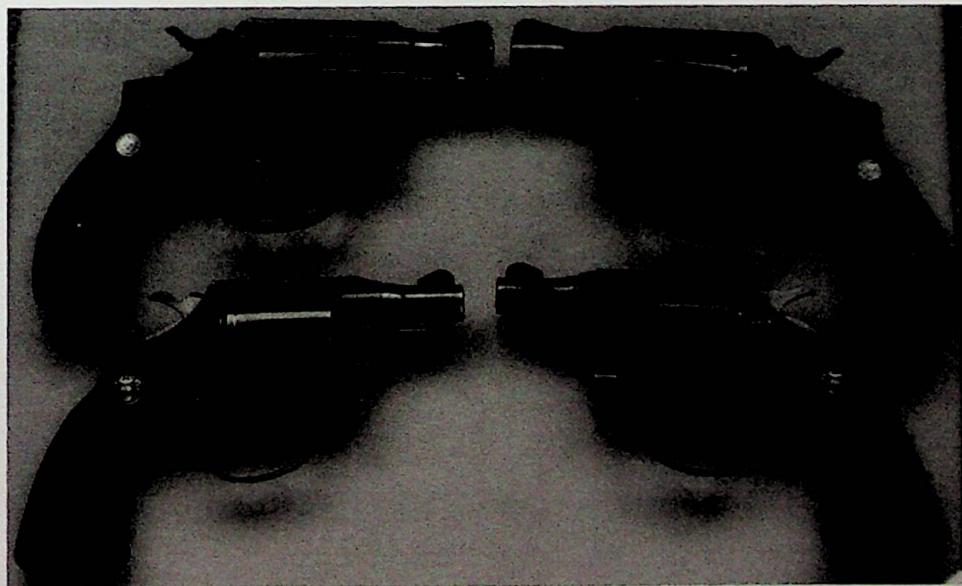
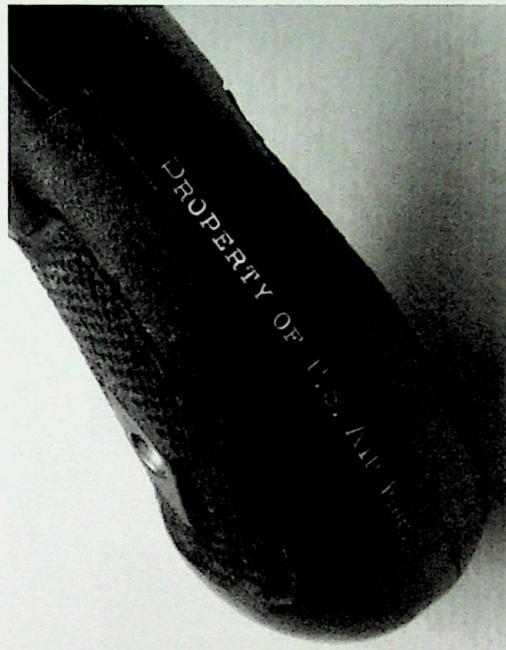
John D. Blanchard,
Major, U.S. Marine Corps.

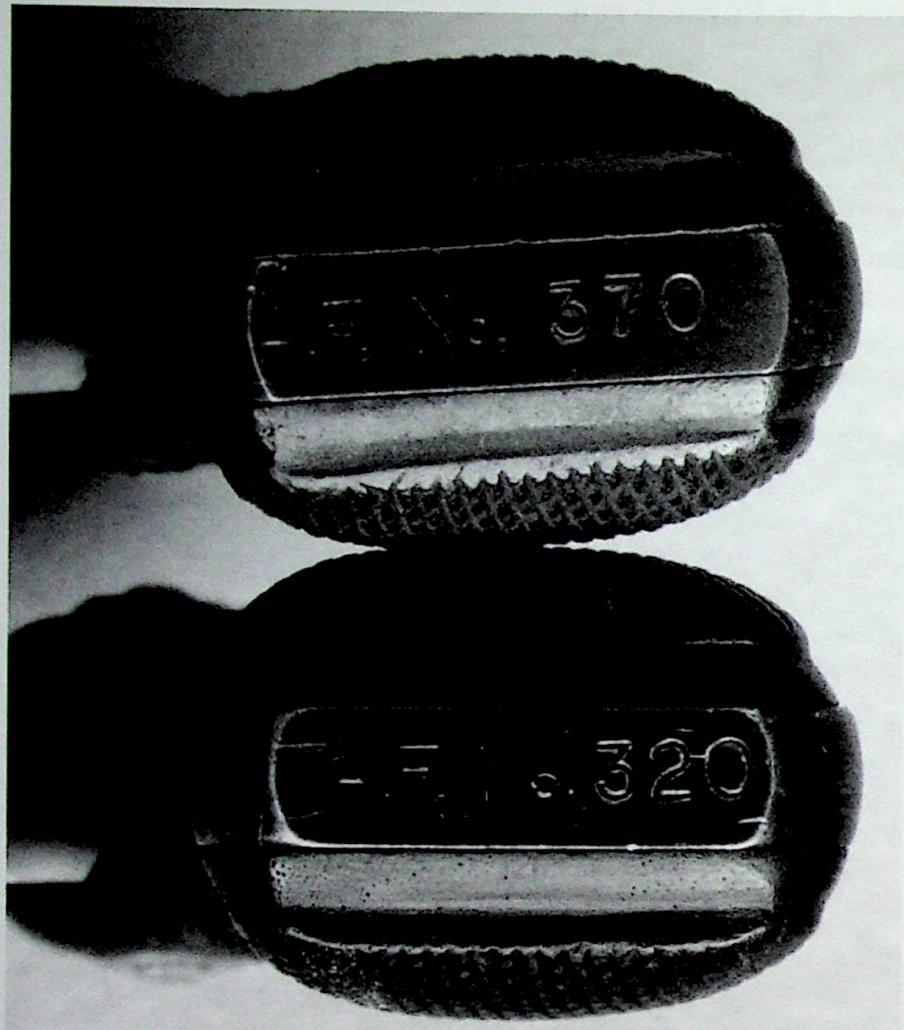
Copy to: Major George D. Van Orden, U.S. Marine Corps, Quantico,
Va.

The Director,
Federal Bureau of Investigation,
Department of Justice,
Washington, D. C.

United States Air Force Crew Revolvers

The following photos are examples of Smith & Wesson and Colt special order lightweight crew weapons. Examples are excellent original issue weapons.





U.S. Martial Arms Collector 119-16



U.S. Martial Arms Collector 119-17



Collectors Notes

The following chart shows serial numbers of 1911 pistols including the Harrington & Richardson cancelled contract.

PISTOL, AUTOMATIC CAL. .45, M1911A1						
Prod. Order	Manufacturer	District	Contract	Quantity	Serial Numbers	Reference Data
S-6265	Rem. Rand	Rochester	W-30-115	239000	2380014 - 2619013	Incl 001e0/121396
S-6214B	Ithaca Gun Co.	"	W-30-115 OHI-553	42599 42599	2619014 - 2661613	TT 14D79 R.O.B. 15 Mar. 1945
S-6267	"	"	W-30-115 OHI-553	32000 32000	2661614 - 2693113	TT 774/45 001e0/140 I.E. Co.
		Raritan		52	X2693014 - 2693005	Incl 00474.6/2827 Assigned 23 Apr. 49 Serial No. Inspected
	Colt's P.F.A.		Completed	710001 - 800000	"	00472/872 9/2/41
	Singer Sewing Machine Co.		500	800001 - 800500	"	"
	Harrington & Richardson		Contract cancelled	800501 - 856100	"	"
Alu	RIA	Augusta Ars.		856101 - 856300	"	00474.6/1338 10/23/41
				856301 - 856304	"	RIA 474.8/943, used with 00 474.6/2624 SA 474.6/2703 4/28/42 1/28/42
		RIA		856305 - 856404	"	SA 474.6/2700 RIA 474.8/943 00 474.6/2624
	Ithaca Gun			856405 - 910404	"	00474.6/3179 R.O.D. 400.16/15-25-R-010-45, SA 474.6/2714
	Rem. Rand			910405 - 1041404	"	00474.6/3179 R.O.D. 400.16/ 15-24-R-010-45 SA 474.6/2774
T	Un.Sw. & Sig			1041405 - 1092404	"	TT 7/3/43 to P.O.O.
	Colt's P.F.A.			1096605 - 1203673	"	TT 7/3/43 to S.O.D.
	Ithaca			1208674 - 1279673	"	TT 3/7/43
	Aum Ars.			1279674 - 1279693	"	***
	Rem. Rand			1279699 - 1441400	"	Letter 8/23/43 to R.O.D. and S.A.

111 Over (1)

ORDNANCE GROUP MATERIALS ENGINEERING DEPARTMENT	Thompson Ramo Wooldridge Inc. 23555 Euclid Avenue Cleveland 17, Ohio PROCESS SPECIFICATION	TAP-PS-380 SHEET 1 OF 3 ISSUED 2-27-64 REVISED
WELDING OF M-14 NATIONAL MATCH RECEIVER FR-560477		

1. Scope: This specification covers the preparation, assembly, preheat, weld and inspection of the M-14 national match receiver.
- 1.1 Records: Records shall be kept of welding, serial numbers, welder's symbol, date of weld and other pertinent information on welding and inspection.
2. Detail Requirements:
- 2.1 Part Preparation and Assembly: The selector shaft lock, FR 560335; selector shaft, FR 560275; sear release, FR 560490; and pin FR-481-02 are to be supplied to the assembly location free of protective finish. If grit blasting is used to remove the protective finish, precautions must be taken to remove all grit before assembly. Receivers are to be supplied in the hardened and tempered condition and the sear release lug area is to be cleaned by blasting. Parts are to be clean and dry before assembly and they are to be assembled in the semi automatic position.
3. Process: Welding shall be performed by the gas, tungsten arc welding process using 1/16" dia. 2% thoriated tungsten electrode.
4. Filler Wire: The filler wire shall be .020" diameter and conform to AMS 5679.
5. Welding Equipment:
 - 5.1 The machine source of current shall have good regulation in the area of current required.
 - 5.2 Current shall be direct using straight polarity at 40-50 amps.
 - 5.3 Argon flow to be 10 cfh.
 - 5.4 Electrode Cup No. 5.
6. All accessory equipment including holders, leads, ground connections, work handling equipment, etc., shall be kept in good repair and maintained within acceptable safety standards.
- 6.1 Fixture: Bench universal joint fixture with barrel chamber section welded to rod is to be used to hold the receiver in position for welding.
7. Qualification of Welders: Welders to qualify by welding a mock up of the receiver, selector and sear release assembly which must be acceptable to the magnetic particle inspection, visual standards and dimensional inspection standards set up for the assembly.



Thompson Ramo Wooldridge Inc.

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8. Welding Technique:

- 8.1 Preheat: Torch or furnace preheat assembly to 400°F. If a torch is used, for preheat use a contact pyrometer to check temperature.
- 8.2 Welding: Ordnance blueprint number 560477 contains sketches showing areas of welding and size of welds required. Sequence of welding is as follows:
 - A. Selector in semi automatic position; sear release forward against sear release lug of receiver; selector lock pushed in for minimum clearance with sear release.
 - B. Tack weld flange on selector shaft to sear release at bottom corner. Complete weld as shown in view C of 560477.
 - C. Tack weld sear release to forward portion of receiver sear release lug. Complete weld on inside and bottom of receiver lug and sear release. Weld outside of receiver lug and sear release. Reference drawing 560477, view B and note 5.
 - D. Weld sear release to rear section of receiver sear release lug. See drawing 560477 view A.
 - E. Plug weld selector shaft to selector lock. Plug weld pin - 2 places - on periphery of selector lock. Reference drawing 560477 section B-B.
 - F. Wire brush all welds.
- 8.3 Fillet welding to be accomplished by complete and even fusion of components into an immovable mass with a minimum amount of undercut. Plug welds are to be smooth with the surface of the selector lock to .020" above the surface per requirements of drawing 560477, section B-B. Plug welds may be ground to size requirements after welding.

9. Inspection:

- 9.1 Preparation: Weld area must be cleaned locally by blasting prior to visual and magnetic particle inspection.
- 9.2 Visual Inspection: Visual inspection to be made of welds for fillet size, fusion, undercut, porosity, inclusions, or other injurious defects.
- 9.3 Magnetic Particle Inspection: Inspect weld area by magnetic particle inspection for presence of cracks. Hold all assemblies showing cracks for Materials Engineering disposition.
- 9.4 Dimensional inspection of assembly to be made for conformance to applicable gages.



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10. Finish:

10.1 Acceptable receivers after welding and inspection are to be returned to the Plating Department for blast cleaning and phosphate coating.

10.2 Plug welds shall be coated per note 8 of drawing 560477.

Written by: R. D. Quinn
R. D. Quinn

Materials Engineering

Approved by: Randy J. Koen
Ordnance Production Engineering

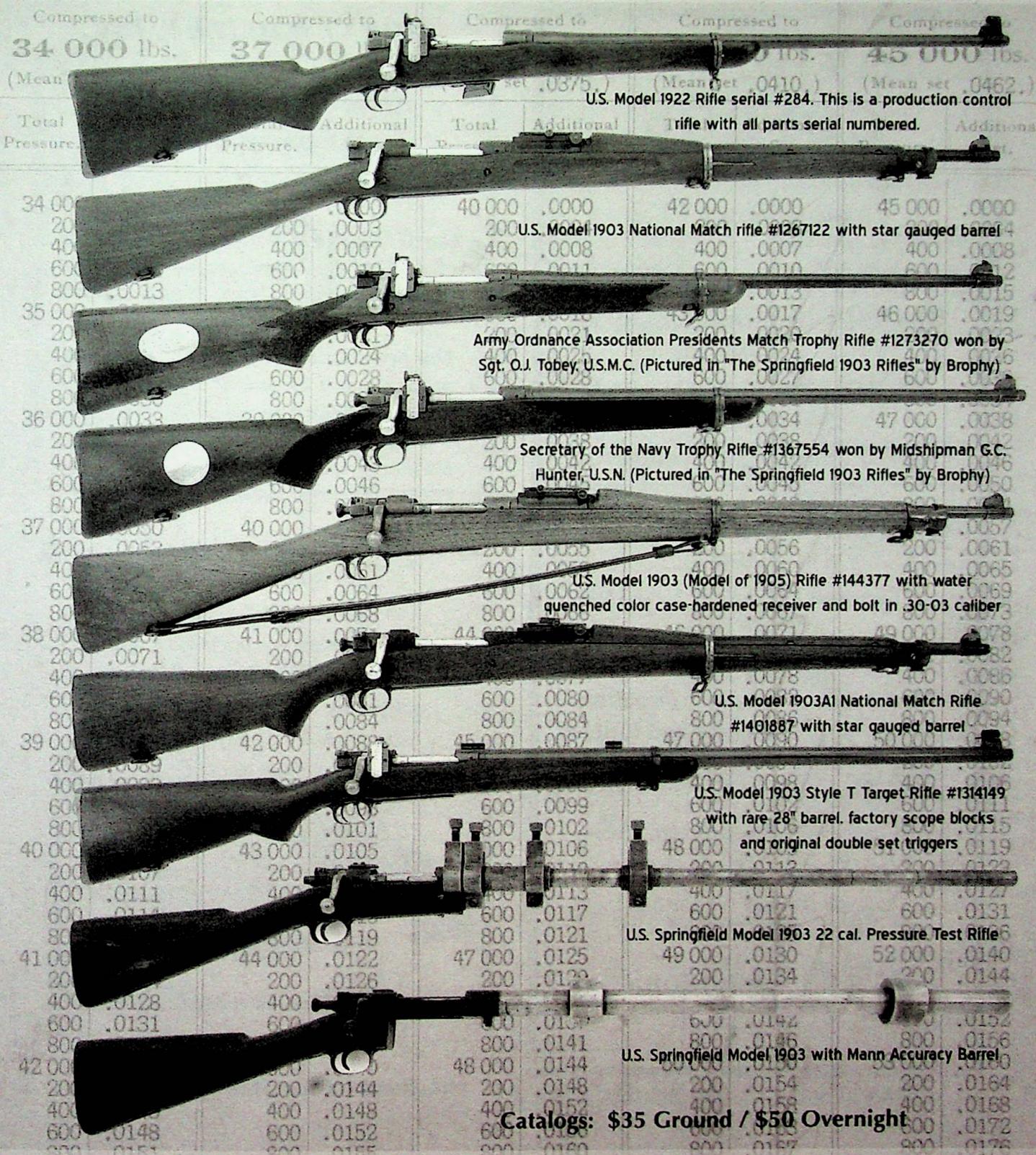
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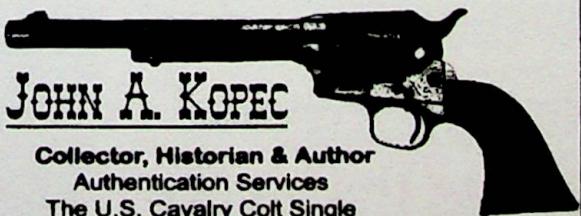
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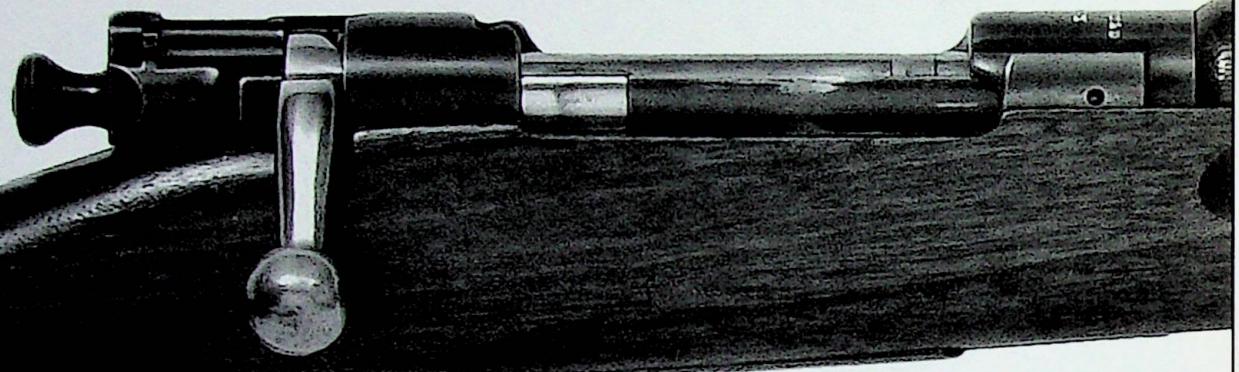
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