

MIL-STD-1256A(WC)

4 June 1971

SUPERSEDING

MIL-STD-1256(WC)

2 December 1963

SA STD-101

28 November 1960

MILITARY STANDARD

RUBBER COATED PARTS

FOR

MACHINE GUN, 7.62MM, M60



FSC 1005

MIL-STD-1256A(WC)
4 June 1971

DEPARTMENT OF THE ARMY
U.S. ARMY MATERIEL COMMAND
WASHINGTON, D.C.

Rubber Coated Parts for Machine Gun, 7.62MM, M60

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1. This standard has been approved by the Department of the Army and is published to provide standards for rubber coated parts for the 7.62MM, M60 machine gun.

2. Recommended corrections, additions, or deletions should be addressed to the Commanding General, U.S. Army Weapons Command, Attn: SWERR-E-SE, Rock Island, Illinois 61201.

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1. SCOPE

1.1 This document establishes standard comparison gages for workmanship type defects for rubber coated parts for the 7.62MM, M60 Machine Gun.

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2. REFERENCED DOCUMENTS

2.1 The issues of the following documents in effect on the date of the invitation for bids form a part of this standard to the extent specified herein:

GOVERNMENTAL DRAWINGS

U.S. ARMY WEAPONS COMMAND

B7269126 - Bumper Assembly, Cam.
D7269138 - Pad Assembly, Cheek.
D7269231 - Handle Assembly, Carrying.
F7269190 - Shell Assembly, Forearm.
F7269203 - Housing Assembly, Trigger.
F11686712 - Shell Assembly, Butt Stock.

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3. DEFINITIONS

Not applicable.

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4. GENERAL REQUIREMENTS

4.1 The standard comparison gages established in this standard are in the form of photographs depicting borderline acceptable conditions for workmanship type defects commonly occurring in rubber coated parts for the M60 machine gun.

4.1.1 The application of these gages for acceptance inspection of the rubber coated parts is contained in Section 5 herein.

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5. DETAIL REQUIREMENT

5.1 STANDARD COMPARISON GAGES.

5.1.1 For the purpose of this standard and convenience in referencing, the comparison gages are grouped by the type of defect as follows:

Type of defect	Figure No.
Flash	1-1 through 1-6.
Trim	2-1 through 2-3.
Flash and trim	3-1 through 3-8.
Radial flash	4.1.
Ripple and trim	5-1.
Surface nicks	6-1 through 6-5.

5.1.2 The borderline acceptable conditions permitted on specific surfaces or areas of weapon parts are specified in 5.2. Parts containing defects which exceed the borderline acceptable condition depicted in the specified standard comparison gage or which occur on surfaces or areas other than specified for that part shall be rejected.

5.2 RUBBER COATED PARTS.

5.2.1 Cam bumper assembly - B7269126.

5.2.1.1 Figure 1-1 represents flash and loose flash conditions at the plate junction.

5.2.2 Cheek pad assembly - D7269138.

5.2.2.1 Figure 2-1 represents trim condition at the mold parting line.

5.2.2.2 Figure 2-2 represents trim condition on the two longitudinal edges of this assembly.

5.2.2.3 Figure 4-1 represents radial flash at the front surface of the large and small ends.

5.2.2.3.1 A thin tightly adhering flash is permitted on the inside of the large end provided it will not cause interference at assembly to the cover. A thin tightly adhering flash is permitted on the inside radius of the small end.

5.2.2.4 Figure 1-2 represents loose flash condition on the inside of the longitudinal edges.

5.2.2.5 Figure 6-1 represents surface nick condition on the large end of the assembly.

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5.2.2.6 Flash is permitted on the inside edge of all holes provided there is no interference at assembly.

5.2.3 Forearm shell assembly - F7269190.

5.2.3.1 Figures 3-1, 3-2, and 3-3 represent flash and trim conditions for the longitudinal edges.

5.2.3.2 Figures 2-3 and 5-1 represent trim conditions at the mold parting line.

5.2.3.3 Figure 5-1 also represents ripple condition caused when flash is removed from the square hole in the center of the bottom surface.

5.2.3.4 Figures 6-4 and 6-5 represent surface nick conditions applicable to this assembly.

5.2.3.5 A thin tightly adhering flash is permitted on the outside of the two U-shaped edges provided the flash will not cause interference at the assembly of the end caps.

5.2.4 Housing assembly, trigger - F7269203.

5.2.4.1 Figures 1-3, 1-4, 3-4, 3-5, 3-6 and 3-7 represent flash and trim conditions at the rivet holes, at the top edges, in the trigger opening and in the channel opening of this assembly.

5.2.4.2 Figures 6-2 and 6-3 represent surface nick conditions near the lower rear section of the trigger guard.

5.2.4.3 A thin tightly adhering coating is permitted at the bottom of the holes in each end of this assembly.

5.2.5 Carrying handle assembly - D7269231.

5.2.5.1 Figure 1-5 represents flash condition at the forward end of the rubber handle. This flash must be tight and adhering.

5.2.5.2 Figure 3-8 represents flash and trim condition at the mold parting line.

5.2.6 Butt stock shell assembly - F11686712.

5.2.6.1 Figure 1-6 represents flash conditions at the front section of the cheek pad radius.

5.2.6.2 Figures 6-4 and 6-5 represent surface nick condition at the lower rear section of this assembly.

5.2.6.3 All loose flash in the inside edge of the small end (receiver opening) must be removed. Buffing is not necessary for this flash removal.

5.2.6.4 A thin tightly adhering rubber coating is permitted on the butt plate surface provided the flash will not cause interference at assembly.

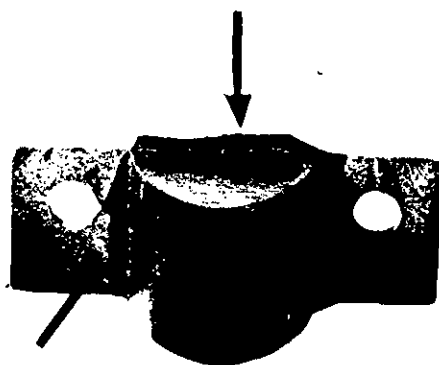


Figure 1-1, Flash



Figure 1-2, Flash

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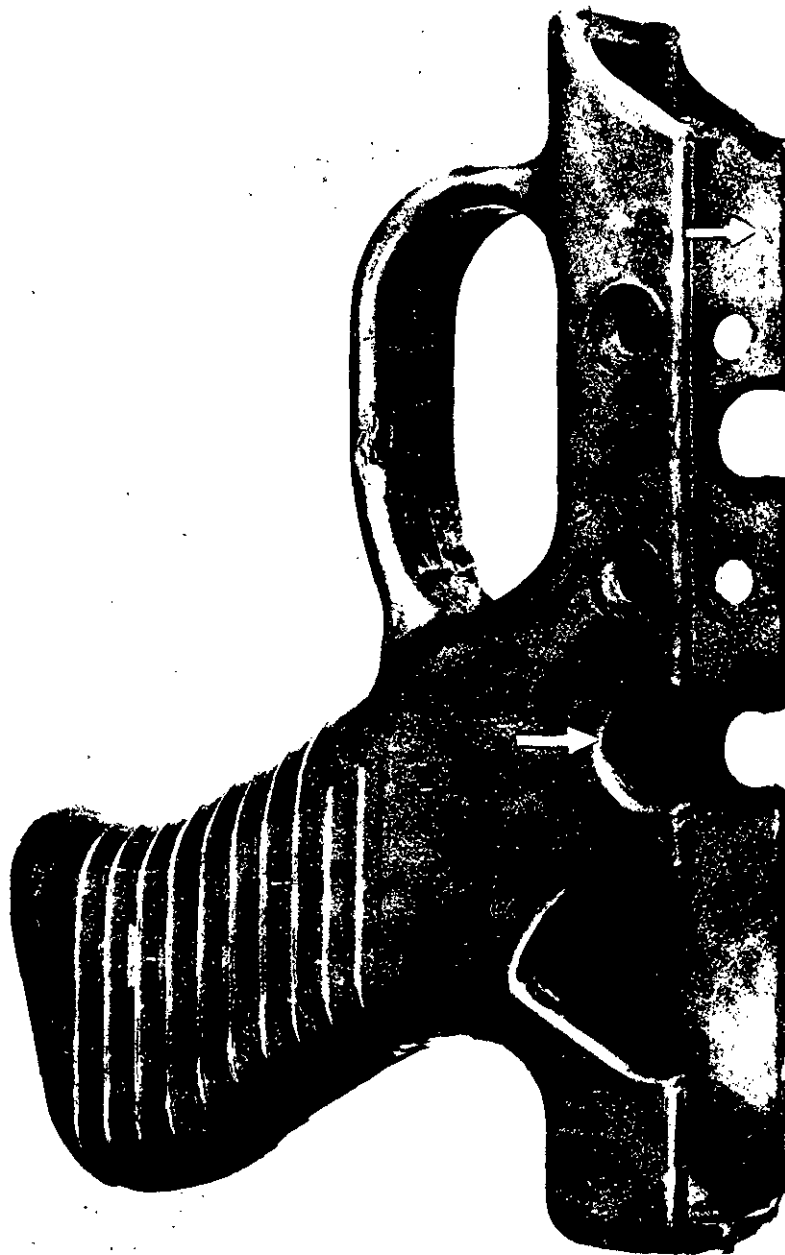


Figure 1-3, Flash

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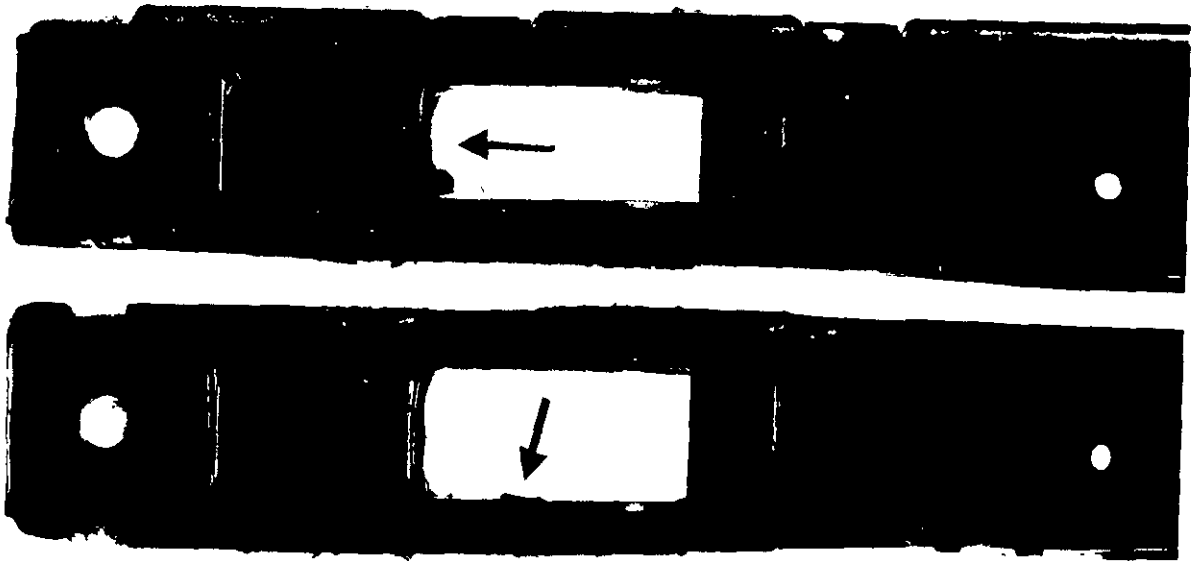


Figure 1-4, Flash

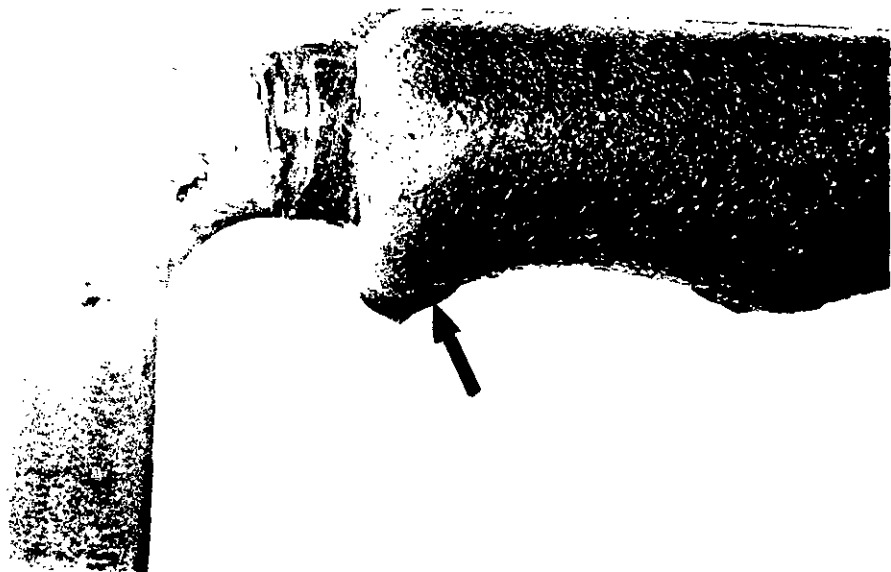


Figure 1-5, Flash

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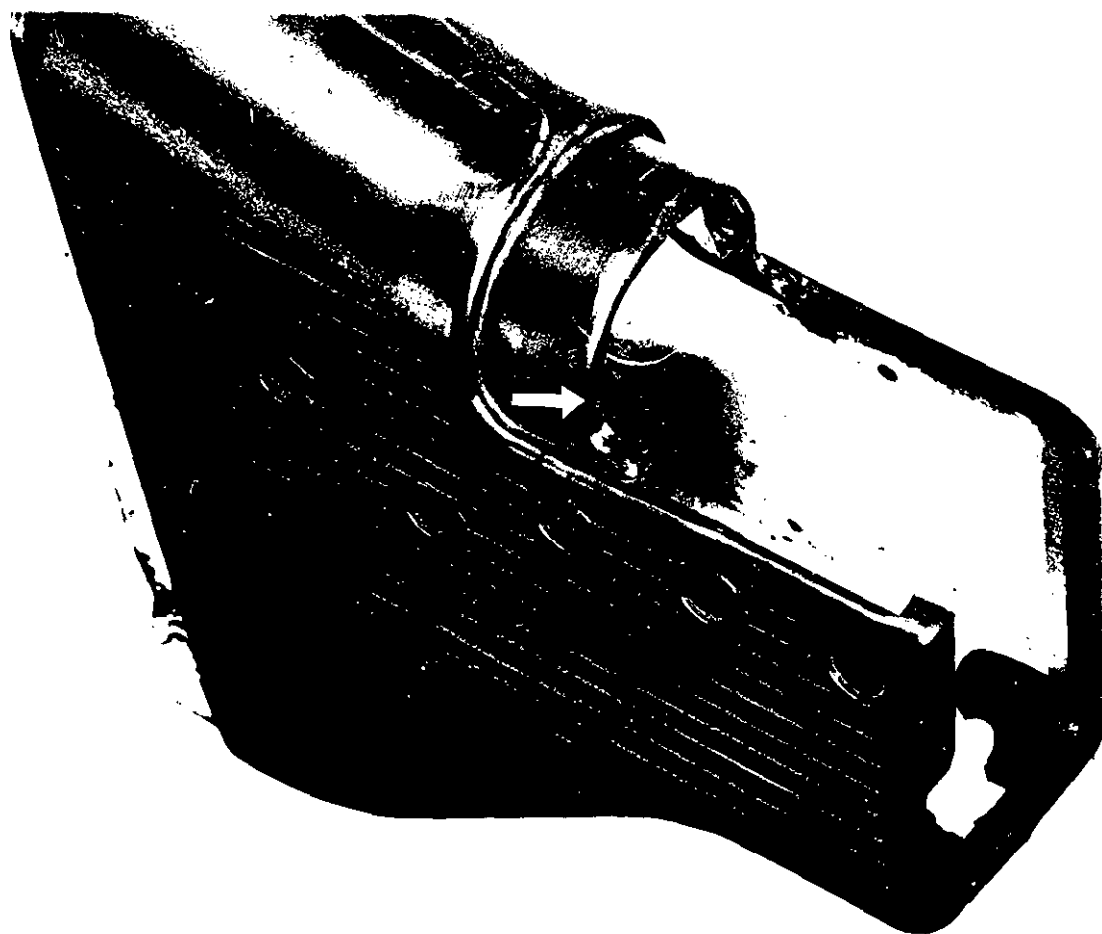


Figure 1-6, Flash

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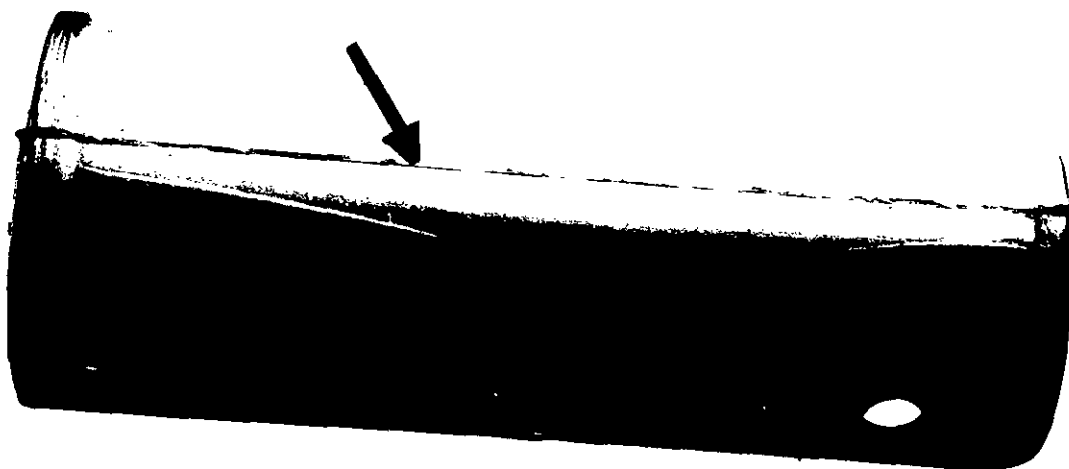


Figure 2-1, Trim



Figure 2-2, Trim

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Figure 2-3, Trim

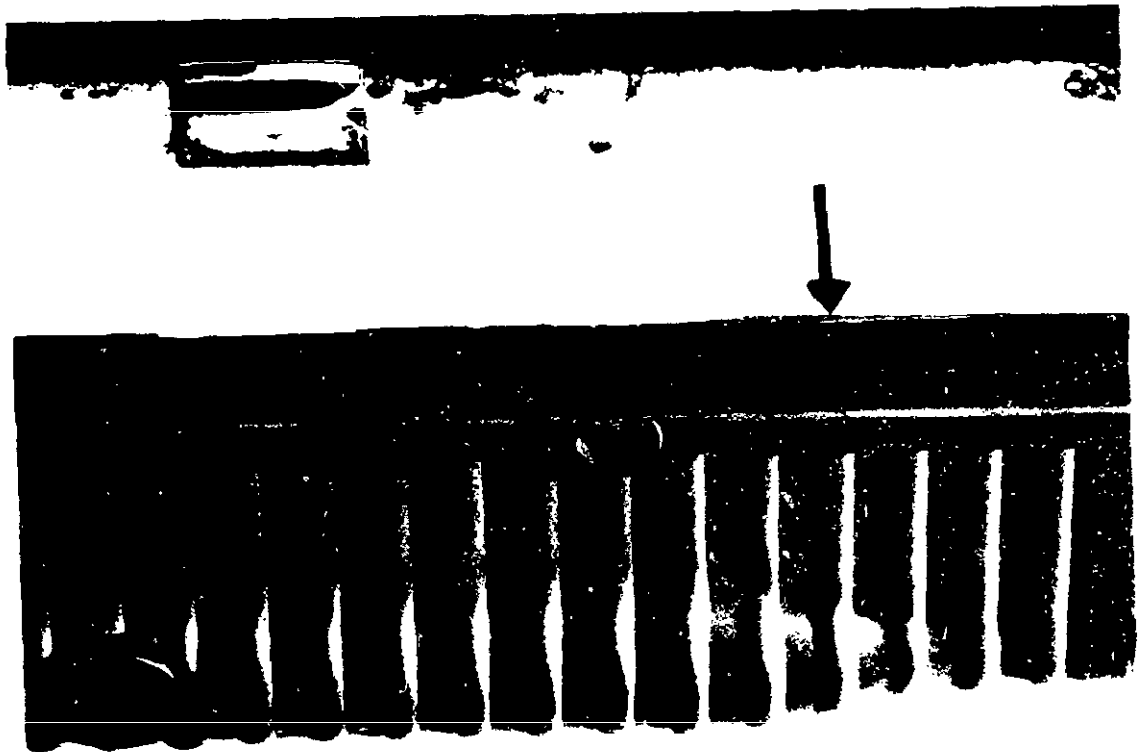


Figure 3-1, Flash and Trim

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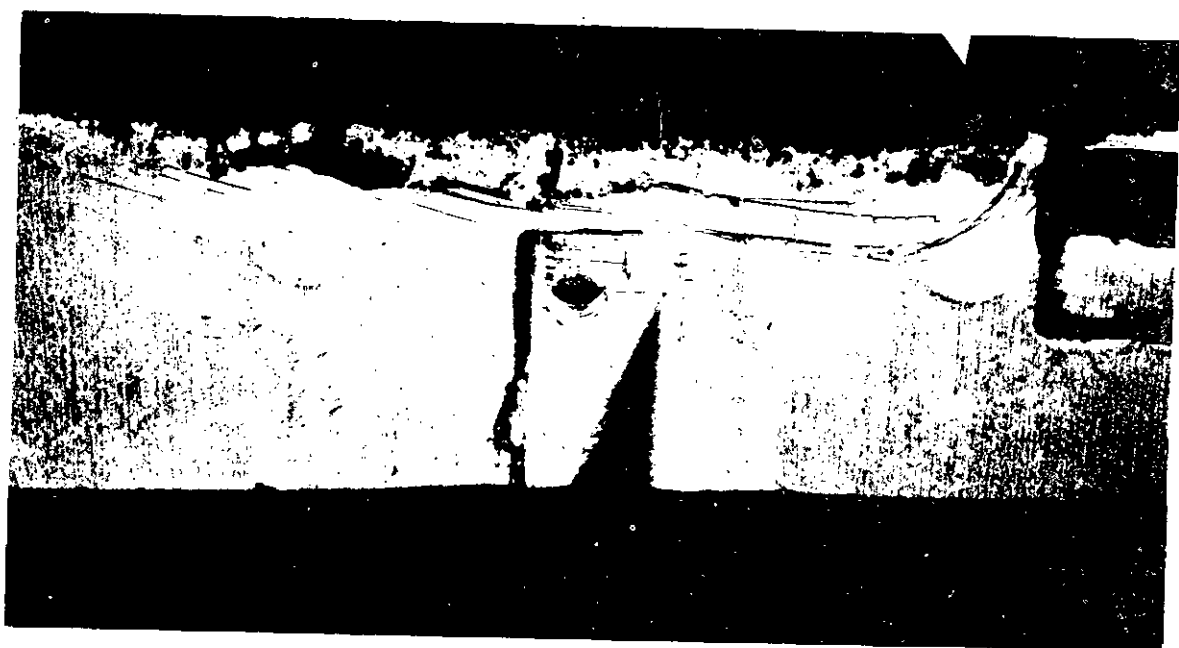


Figure 3-2, Flash and Trim

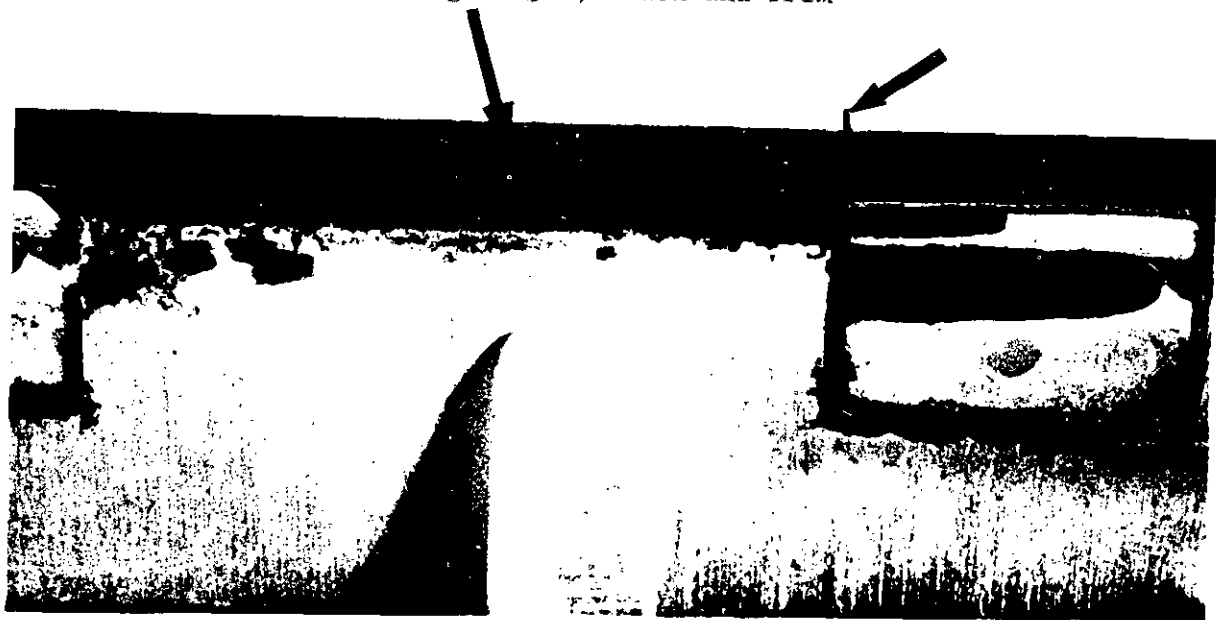


Figure 3-3, Flash and Trim

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Figure 3-4, Flash and Trim

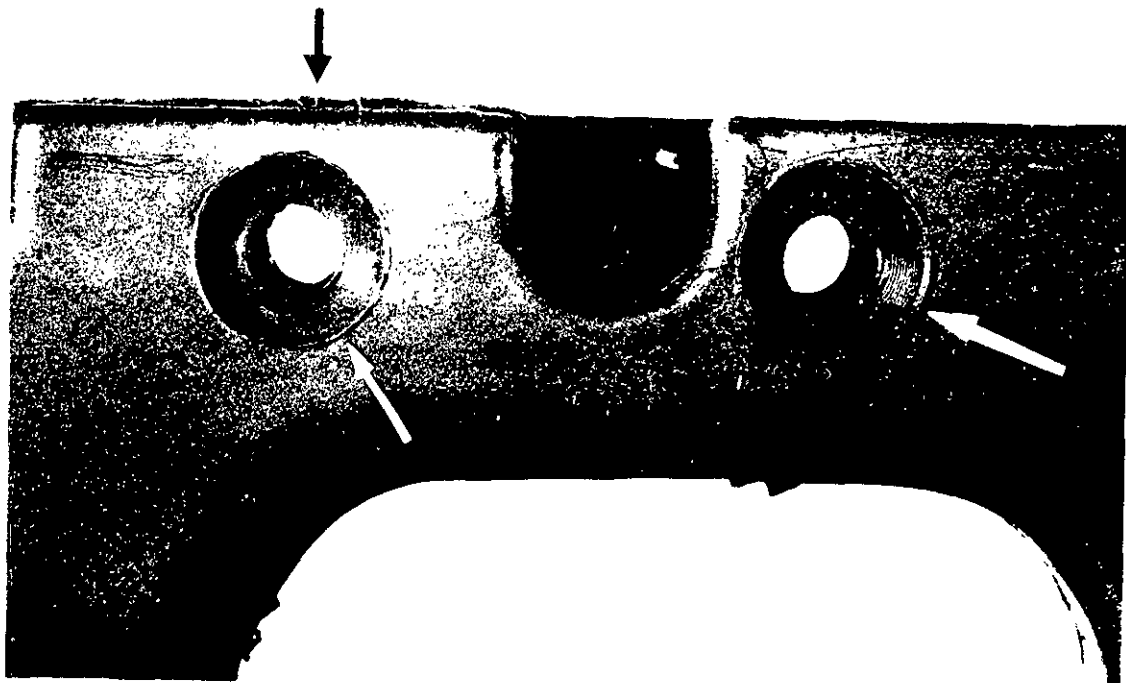


Figure 3-5, Flash and Trim

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Figure 3-6, Flash and Trim



Figure 3-7, Flash and Trim

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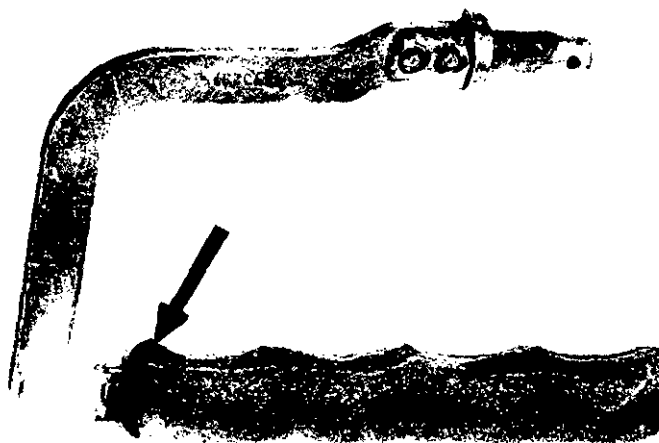


Figure 3-8, Flash and Trim

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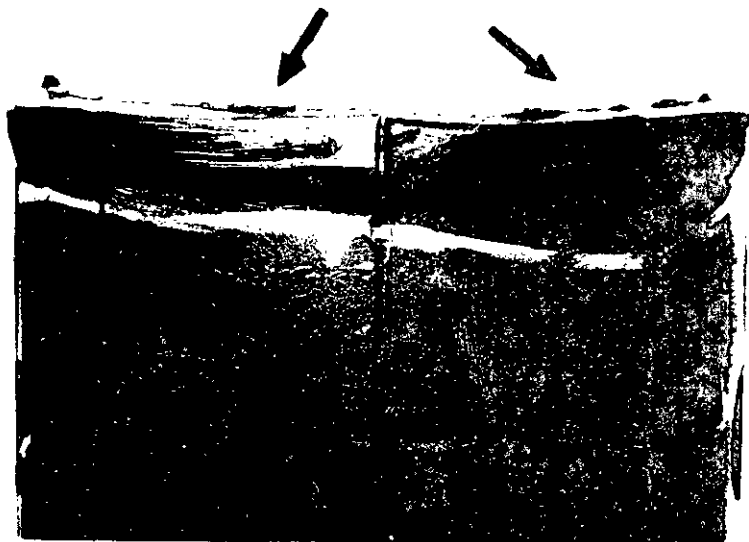


Figure 4-1, Radial Flash

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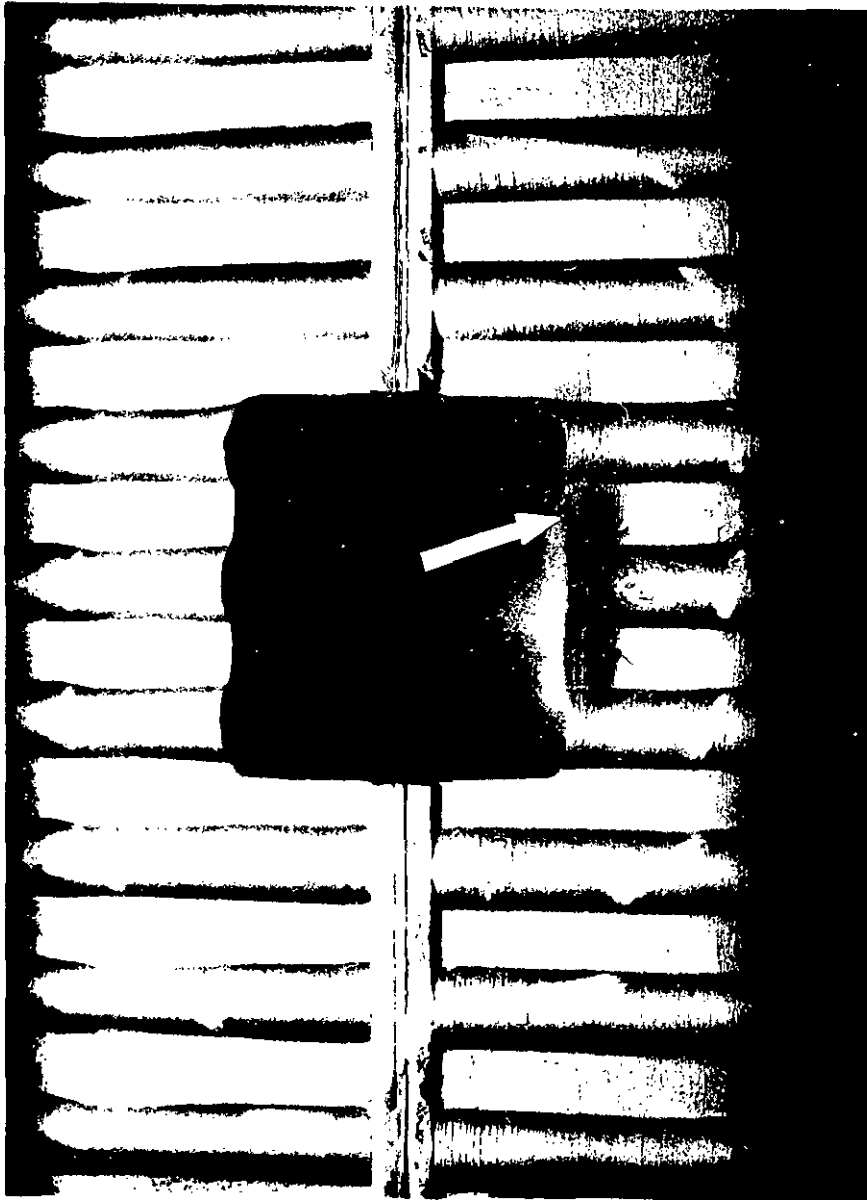


Figure 5-1, Ripple and Trim

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Figure 6-1, Surface Nick



Figure 6-2, Surface Nick

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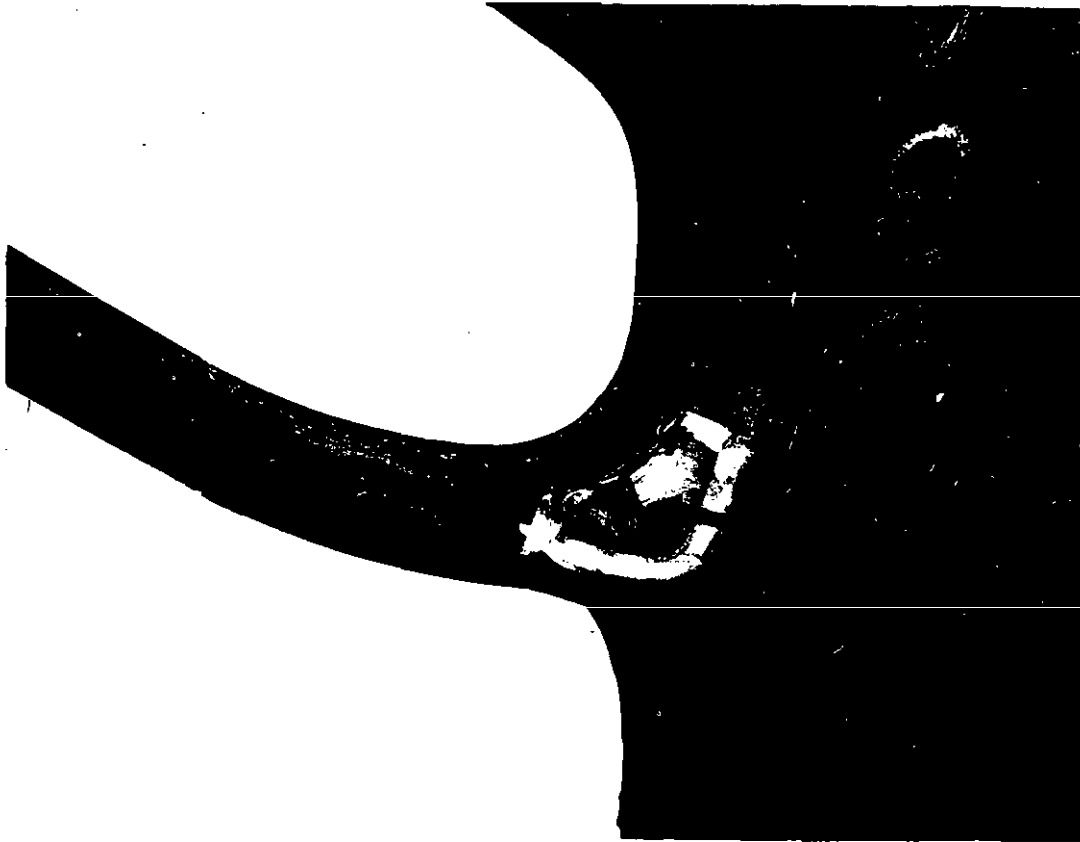


Figure 6-3, Surface Nick

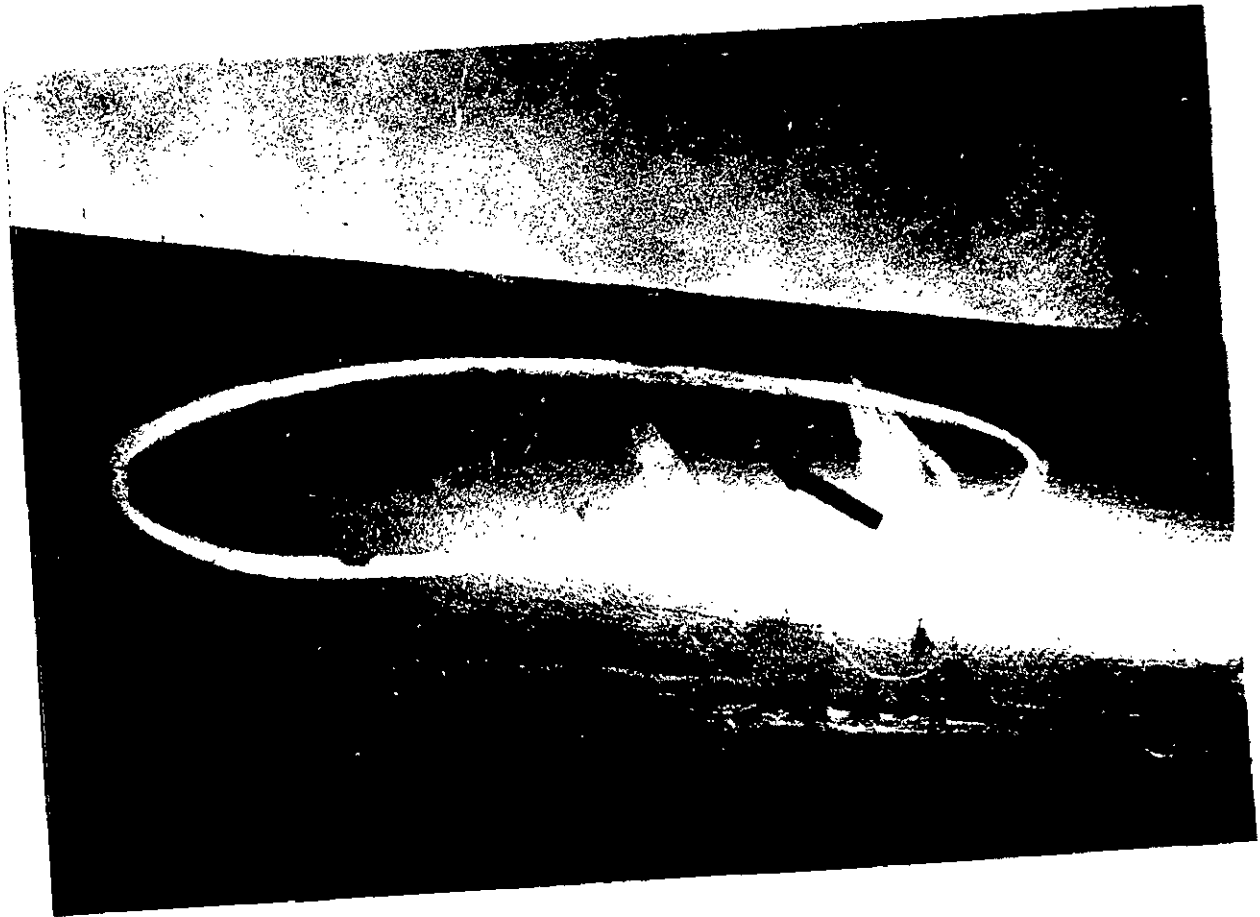


Figure 6-4, Surface Nick

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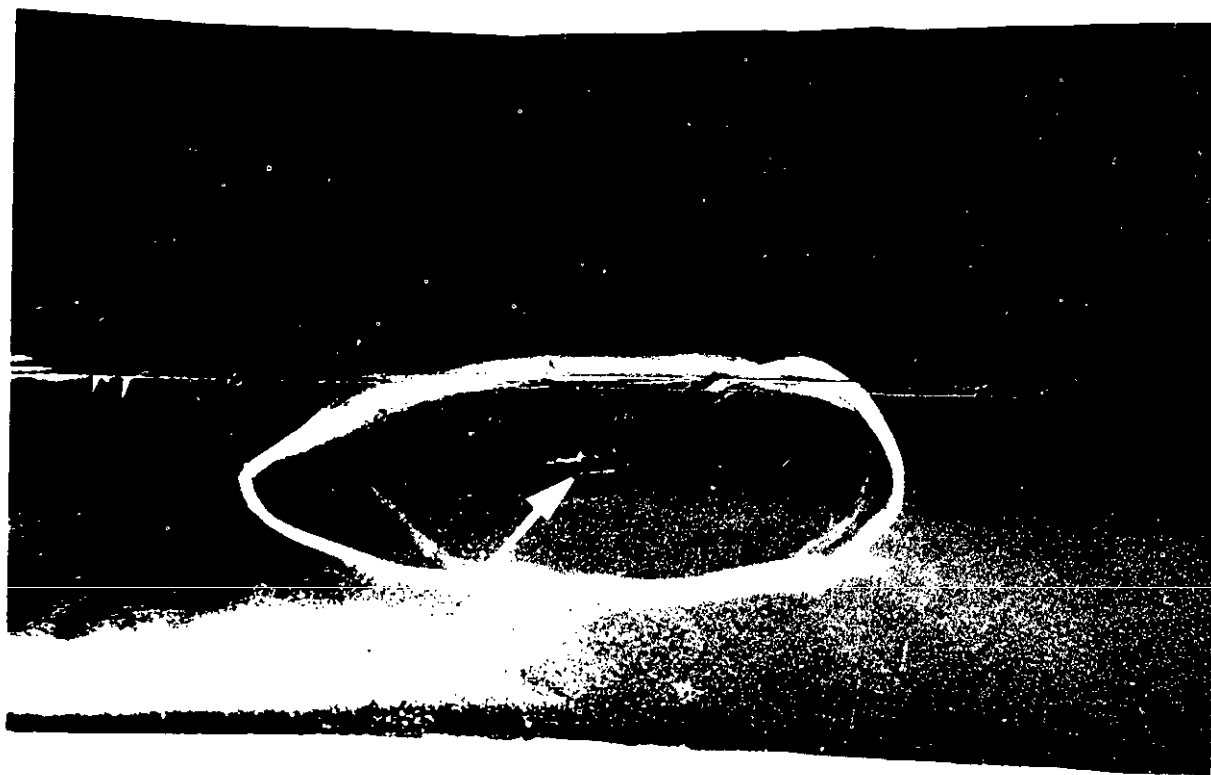


Figure 6-5, Surface Nick

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(When required for use in a contract, the applicable photographs as depicted in Figures contained herein, may be obtained from U.S. Army Weapons Command, Attn: SWERR-E-SE, Rock Island, Illinois 61201.)

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