

M1911-A1 REDUX

re·dux (rē-dŭks')

adjective

Brought back; returned. Used postpositively.

Drawings of the Government Model M1911-A1 Semi-Automatic Pistol,
Originally Designed by John M. Browning for Colt Firearms Company,
CAD Modeled and Redrawn Using Present-Day Standards and Technology

by Rio Benson, Rio Benson Consulting ©2012

FROM RIO BENSON, RIO BENSON CONSULTING, ON THE PREPARATION OF THESE DOCUMENTS

To qualify my efforts in the development of this drawing package: As a Machine and Mechanical Designer, I've been preparing drawings to DOD-100/1000 and ASME/ANSI Y14 standards, for a living, for more than a half century. I am a shooter and a firearms enthusiast with sporting experience since my mid-teens and significant military firearms experience from my late teens to my late-twenties. I am also an avid fan of John M. Browning and the "original" M1911.

Historically, when the drawings for John M. Browning's Colt M1911 were first created, there was little in the way of 'consensus' standards to guide the designers and manufacturers of the day in either drawing format or in DOD documentation of materials and finishes. For the most part, these were added, hit or miss, in later drawing revisions. Furthermore, due to the original design's flawless practicality and its amazing longevity, the government's involvement, and the fact that in the ensuing 100-plus years of production the M1911 design has been officially fabricated by several different manufacturers, the drawings have gone through many, many revisions and redraws in order to accommodate all these various interests. These '*mandated by committee*' redraws and revisions were not always made by the most competent of designers, and strict document control was virtually non-existent at the time. All of this has led to an exceedingly sad state of credibility, legibility, and even the availability of legitimate M1911 drawings today.

Granted, the M1911 is still being produced by a multitude of manufacturers, but obviously not to the original drawings. The current manufacturers have their own documentation, including their own modifications and production improvements. Because of their competitiveness, there is little chance any of these current manufacturers will publish or furnish any part of their documentation, since they might be giving away some of their trade secrets. Of course, we must assume that none of these manufacturers have ever heard of "reverse engineering" [LOL].

With that being said, I have noticed numerous requests for M1911 drawings over the years, and now having the time, the knowledge, and the means, I decided to model the M1911 in 3D, using SolidWorks 2012, and then create updated drawings from those models. My source for the original[?] drawings came, free of charge, from the internet. As a drawing set for the M1911 these were better than nothing, but they were full of misinterpretations, errors, omissions, in addition to being very difficult to read. Unfortunately, that was all that was available.

Due to the poor legibility of the reduced drawing sizes, original drafting quality, and reproducibility of the source documents, and also of the collective questionable veracity of revision status, a number of assumptions and even interpolations had to be made in the creation of the subject documentation package. While every attempt was made regarding the maintenance of technical correctness and completeness, I (Rio Benson), or Rio Benson Consulting, cannot warrant or guarantee the package's accuracy or suitability for manufacture, and recommend its use be limited to only that of a source of interesting and historical information. This package is furnished free of charge, and the user must assume any and all liability in any connection with its use. The laws regarding intellectual property apply here. This documentation may be published and distributed freely as a complete package, without charge, provided nothing is altered in any way. Furthermore, this writing is an integral part of the package and must accompany it in any of its published forms. By the way, this package prints best on a tabloid (11 x 17 inch) printer, color or no. Only two sizes of drawing format were used, B (11 x 17) and D (22 x 34). The advantage of the D size is less format per drawing area. The D size printed on a tabloid sheet results in a half-size reproduction (half-size is not half a sheet; do your math) that is still quite legible for all but the legally blind.

All of the SolidWorks 2012 models and drawings created for this package are available from me, at riobenson@clear.net, for a small donation to help cover my expenses in materials, equipment, and time. While I will gladly assist anyone wishing it, technically, I am not in the habit of doing anyone's work for them without some form of compensation.

The approach to the updated modeling and redrawing contained in this package was as follows:

1. Wherever possible, 'turn-of-the-century' machine shop methodology and technology was used in determining the design intent of the original documentation.
2. Otherwise, no attempt was made to arbitrarily change any dimensions or tolerances, however costly they would be to reproduce. There were, however, a few instances where the "original" dimensions were geometrically impractical to fabricate or were incorrect, thus dictating a change. Furthermore, the application of current drafting standards required some additional minor changes. Overall, and as an added benefit, the changes made should make the drawings more legible, logical, and easier to read.
3. Manufacturing technology in materials, heat treatment, and finishes have changed considerably in the past several years, thereby making virtually all of the "original" drawing notes obsolete. In fact most of the standards and specifications originally referred to have been obsoleted or superseded. As a result the remaining drawing notes, referring primarily to materials, heat treatment, and finish, have been standardized and updated to what is currently available and more practical from a manufacturing standpoint, in this package.
4. Some of the newer methods in drafting technology, such as Geometric Dimensioning and Tolerancing, and particularly that of True-Position Dimensioning, have been purposefully avoided in this effort. These were not available for the original design, *nor were they necessary*. The use of these practices becomes economically feasible only in high volume production applications where the technical expertise is available, and the purchase and deployment of expensive Coordinate Measuring Machines (CMM) and costly templates and gages can be justified. Seldom, if ever, are the tried and true bilateral tolerancing methods of the past insufficient to manufacture excellent parts. Case-in-point, the decades old M1911-A1 design, itself, using no Geometric Tolerancing, has had a success and longevity that is unmatched throughout all industry. Go figure! [BG]
5. No attempt was made to make these drawings DOD compliant. The driving intent here was to illustrate dimensional accuracy and functionality of the overall design. Markings, references to inspection of surface hardness, and other superfluous military requirements were omitted. The optional alternative designs were generally used since they represent improved or simplified fabrication methods.

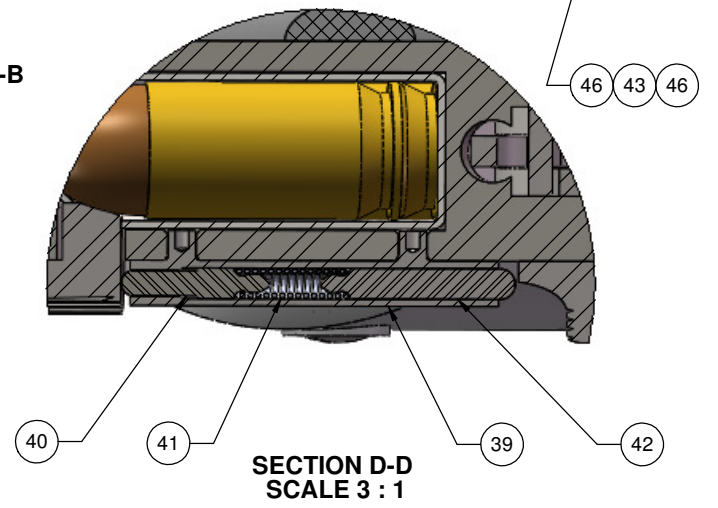
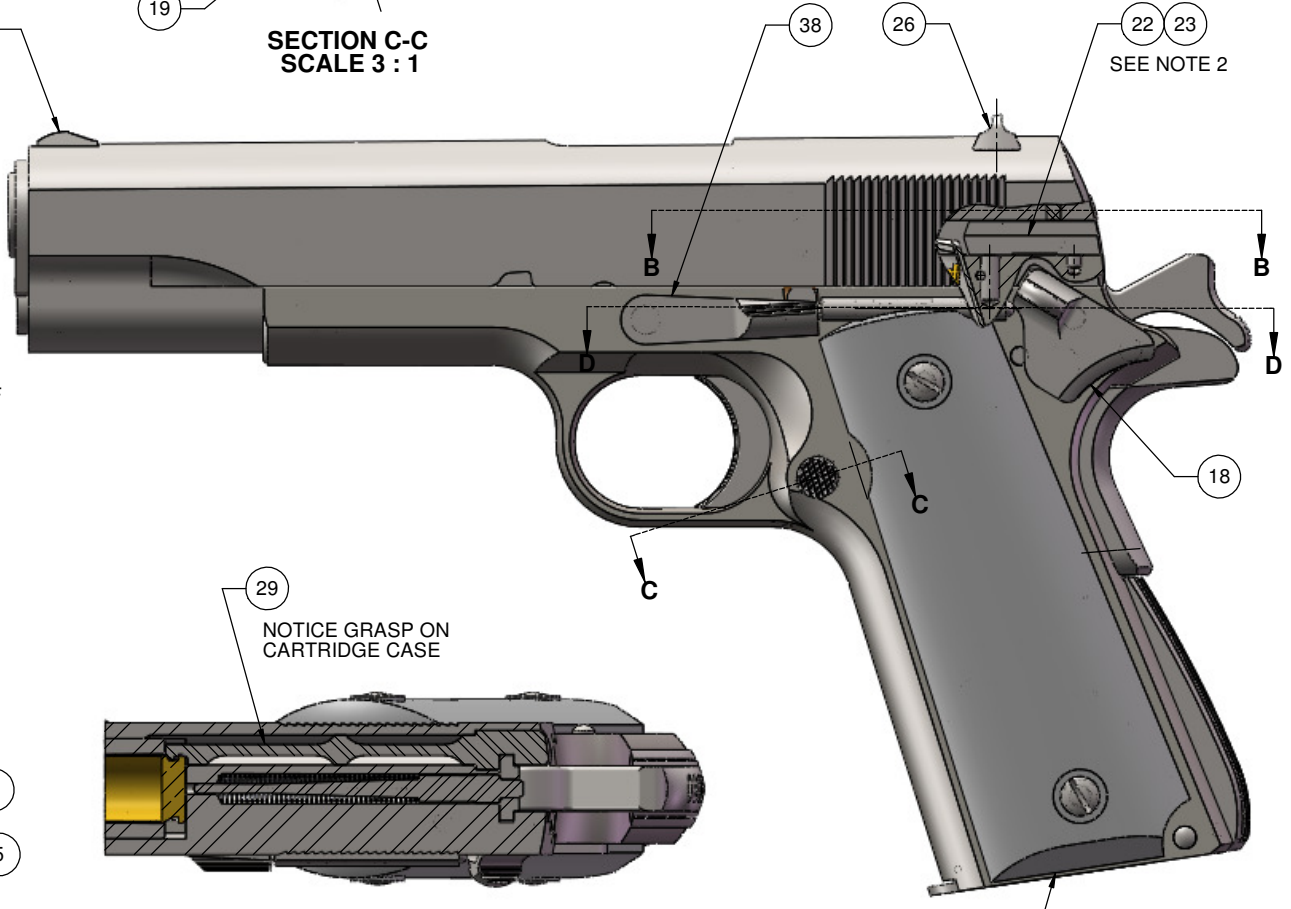
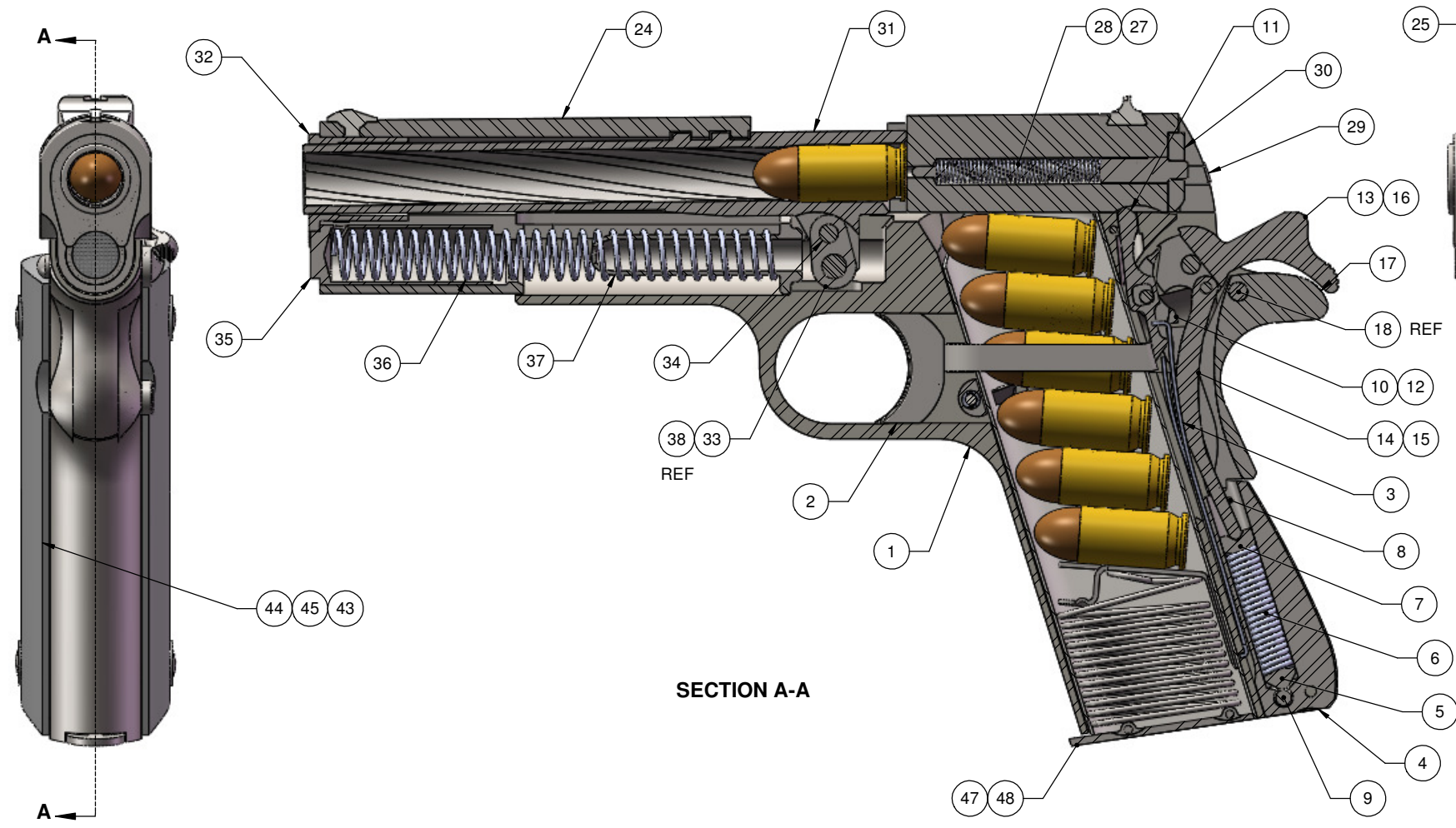
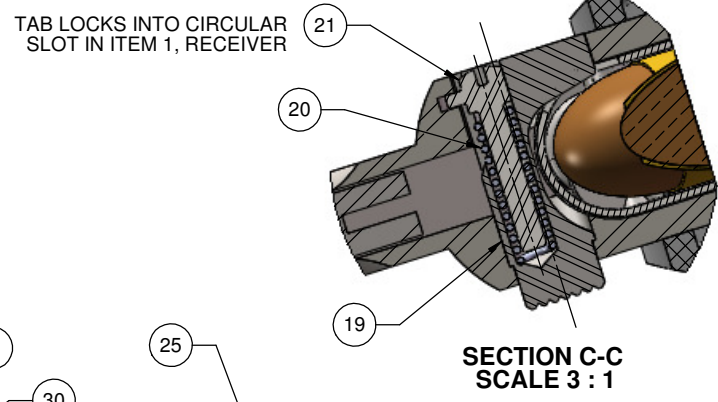
In the creation of this documentation package, a number of issues became quite obvious and apparent: To begin with, it is doubtful the multitude of the very complex and intricate features found on the many parts of the M1911-A1 were present, or even necessary, in John M. Browning's original design before Colt and the government got hold of it. This sort of complexity was just not his style, and moreover, is probably the result of too many cooks stirring the soup. The result is a firearm that may be too expensive to fabricate for today's consumer market, without radical simplification. Hence, resulting "copies" of the M1911-A1 are now being produced by many very expert manufacturers, that when disassembled and measured would bear some differences to what is described in this package. For **my money** and in my opinion, the modern "copies" are often better weapons than the so-called "original", and are probably closer to what John Browning originally intended. However, inadvertent tighter tolerances can and do defeat field use practicality.

Rio Benson, Rio Benson Consulting ©2012

www.Rio-Benson.com

REVISION HISTORY				
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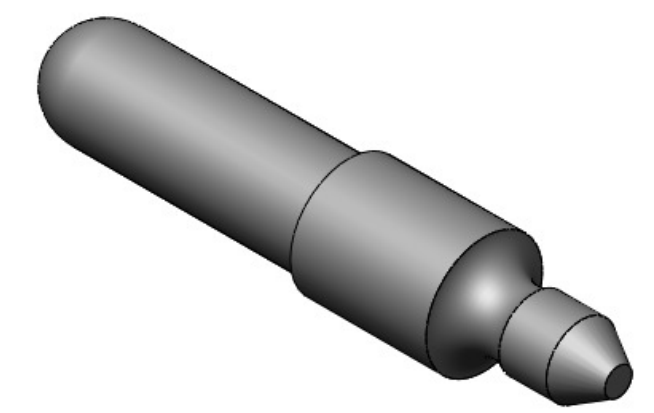
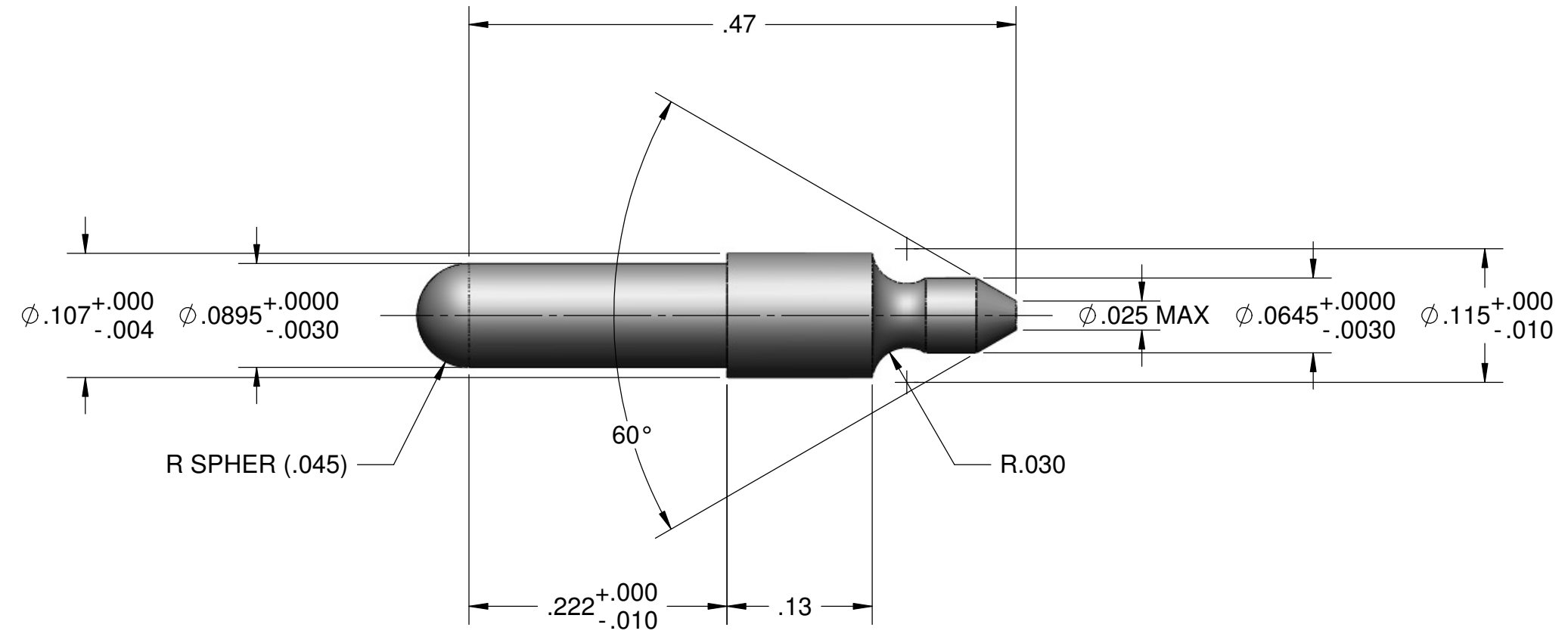
- NOTES:
- PISTOL IS SHOWN IN CONDITION ONE, COCKED, LOCKED AND LOADED.
 - $\varnothing .0625 \pm .0005$ MATCH DRILL AT ASSY THRU EXISTING HOLE IN ITEM 1, RECEIVER, AND LONG LEG OF ITEM 22, EJECTOR, PRIOR TO PRESS-FIT ITEM 23, EJECTOR PIN.



BOM Table				BOM Table			
ITEM	QTY.	PartNo	DESCRIPTION	ITEM	QTY.	PartNo	DESCRIPTION
1	1	6535359	RECEIVER	25	1	5013197	SIGHT, FRONT
2	1	6147780	TRIGGER ASSEMBLY	26	1	5013196	SIGHT, REAR
3	1	6008602	SPRING, SEAR [MFA]	27	1	5013204	SPRING, FIRING PIN
4	1	5503841	HOUSING, MAINSPRING	28	1	6008599	PIN, FIRING
5	1	5013213	PIN, RETAINER, MAINSPRING HOUSING	29	1	6008598	EXTRACTOR
6	1	5013208	MAINSPRING	30	1	5013205	STOP, FIRING PIN
7	1	5013209	CAP, MAINSPRING	31	1	7791193	BARREL
8	1	BC10091602	PIN, MAINSPRING CAP	32	1	6008596	BUSHING, BARREL
9	1	5013212	PIN, MAINSPRING HOUSING	33	1	7267771	LINK, BARREL
10	1	7268068	SEAR	34	1	5013199	PIN, BARREL LINK
11	1	6008603	DISCONNECTOR	35	1	5013201	PLUG, RECOIL SPRING
12	1	5013211	PIN, SEAR	36	1	5013200	SPRING, RECOIL
13	1	5503839	HAMMER	37	1	6008597	GUIDE, RECOIL SPRING
14	1	6008600	STRUT, HAMMER	38	1	6008595	STOP, SLIDE
15	1	5013207	PIN, HAMMER STRUT	39	1	6008594	TUBE, PLUNGER
16	1	5013206	PIN, HAMMER	40	1	5013193	PLUNGER, SLIDE STOP
17	1	6501828	SAFETY, GRIP	41	1	5013194	SPRING, PLUNGER
18	1	5503840	LOCK, SAFETY	42	1	5013195	PLUNGER, SAFETY LOCK
19	1	6008609	CATCH, MAGAZINE	43	4	6019022	BUSHING, STOCK SCREW
20	1	5013217	SPRING, MAGAZINE CATCH	44	1	5564062	STOCK, RH, PLASTIC
21	1	5013218	LOCK, MAGAZINE CATCH	45	4	6019023	SCREW, STOCK
22	1	6019204	EJECTOR	46	1	BC10090501	STOCK, LH, PLASTIC
23	1	5013203	PIN, EJECTOR	47	1	NONE	CARTRIDGE - REFERENCE ONLY
24	1	7790314	SLIDE	48	1	BC10091603	MAGAZINE ASSY

MODELED	BY	DATE	RIO BENSON CONSULTING 1467 Georgetowne Drive, Gastonia, NC 28054 • riobenson@clear.net
DRAWN	R Benson	09/25/2010	
MATERIAL			TITLE 3D MODELED AND DRAWN VERSION OF THE M1911-A1 .45 ACP PISTOL
HEAT TREAT			
FINISH			1st MADE FOR: M1911-A1 REDUX
SCALE: 3:2 WEIGHT: 2.93 LB SHEET 1 of 1			SIZE DWG NO. REV

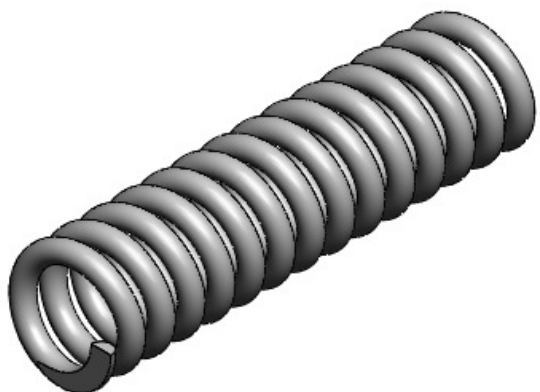
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±.5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: STL 1117 ASTM A108 HEAT TREAT: CASE DP .002-.005 RH 15-N 78-82 FINISH: MIL-STD-171, PARA 5.3.1.2		THIRD ANGLE 		PROJ: M1911-A1 REDUX	
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		DRAWN BY: R Benson APPROVED BY:		DATE: 08/29/2010		SIZE: B DWG/PART NO.: 5013193 SCALE: 8:1 WEIGHT: 0.00 LBS SHEET 1 OF 1	

DATE PLOTTED: 5/25/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



MODEL SHOWN COMPRESSED FOR ASSEMBLY

DIAMETER OF WIRE018
DIAMETER OF COIL (OD)104 ±.003
FREE LENGTH	(.593)
ACTIVE COILS	12.5
TOTAL COILS	14.5
DIRECTION OF HELIX	CCW
LOAD AT COMPRESSED LENGTH OF400 = 2.50 ± .50 LB
SPRING RATE	(.160 LB/INCH)
SOLID LENGTH279 MAX
TYPE OF ENDS	SQUARED & GROUND
HOLE DIA INTO WHICH SPRING FITS FREELY109 MIN
ROD DIA OVER WHICH SPRING SLIDES FREELY	----- MAX

NOTES:

1. MANUFACTURE IAW TYPE 1, GRADE A, OF SAE AS 13572.
2. STRESS RELIEVE AT 450 °F FOR 20 MINUTES AFTER FORMING.

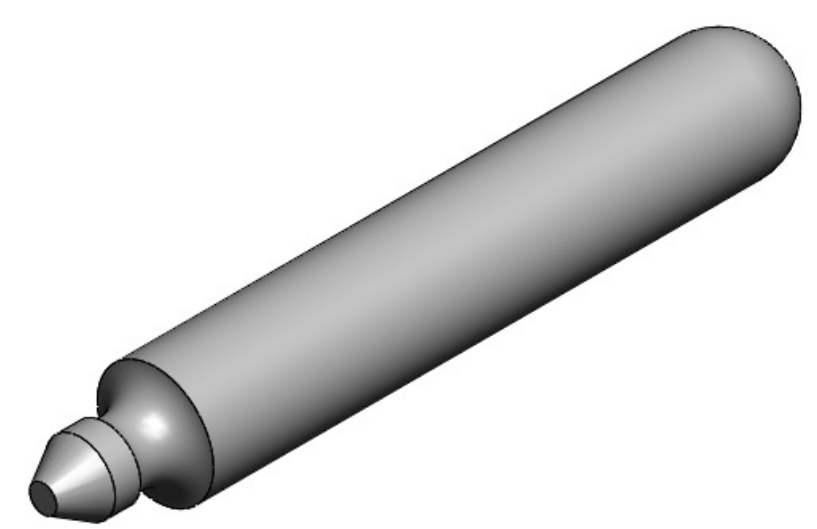
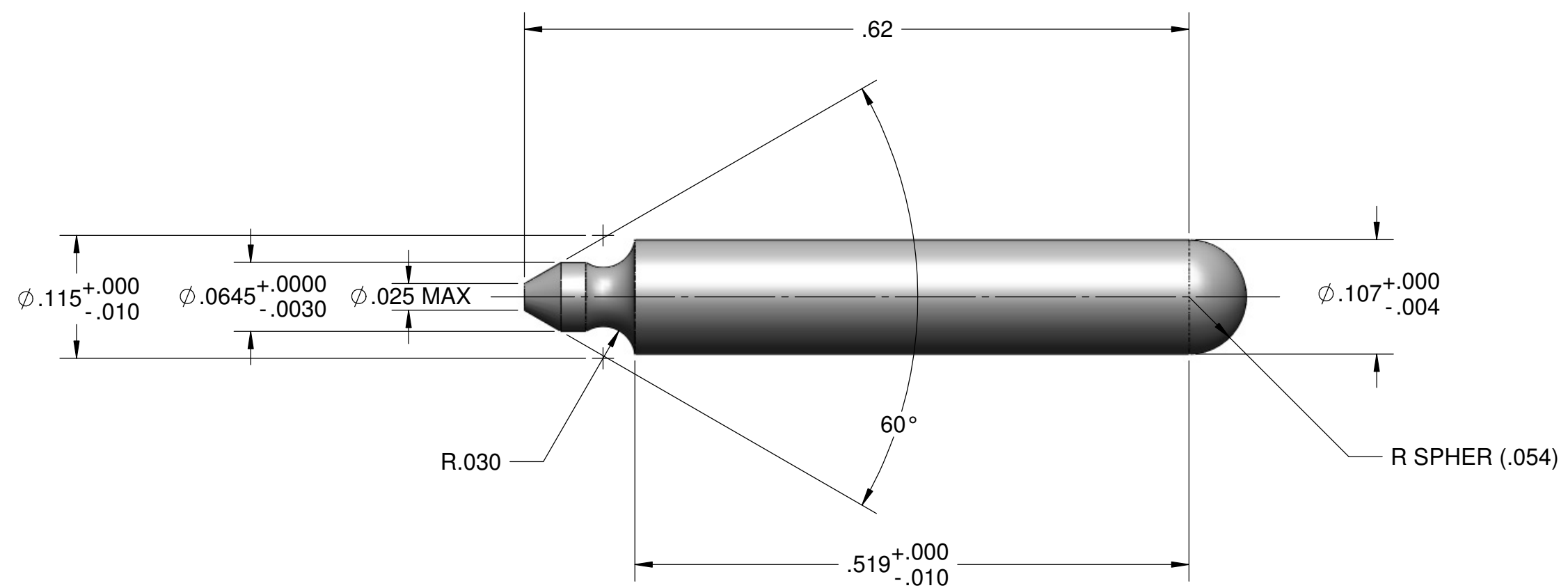
D
C
B
A

D
C
B
A

DATE PLOTTED: 5/21/2012

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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: STEEL MUSIC WIRE ASTM A228	THIRD ANGLE	PROJ: M1911-A1 REDUX		SIZE: B	DWG/PART NO.: 5013194	REV:
	QTY REQD PER NEXT ASSY =		HEAT TREAT: SEE NOTE 2	DRAWN BY: R Benson	DATE: 08/29/2010	SCALE: 8:1		WEIGHT: 0.00 LBS	SHEET 1 OF 1
	DO NOT SCALE DRAWING		FINISH:	APPROVED BY:					

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



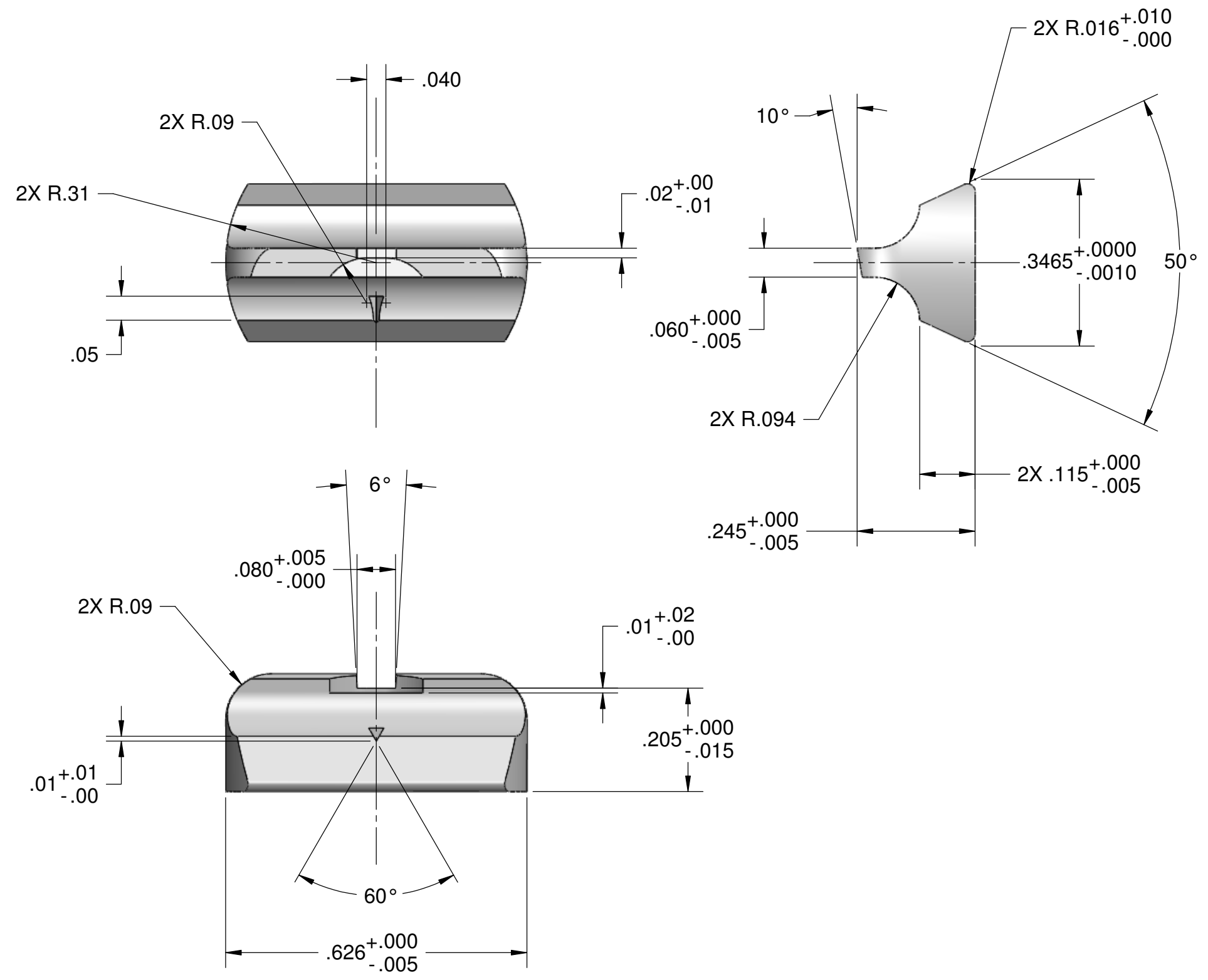
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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: STEEL 1117 ASTM A108	THIRD ANGLE 	PROJ: M1911-A1 REDUX		SIZE B	DWG/PART NO. 5013195	REV
	QTY REQD PER NEXT ASSY = 1		HEAT TREAT: CASE DP .002-.005 RH 15-N 78-82	DRAWN BY: R Benson	DATE 08/29/2010	SCALE: 8:1		WEIGHT: 0.00 LBS	SHEET 1 OF 1
	DO NOT SCALE DRAWING		FINISH: MIL-STD-171 PARA 5.3.1.2	APPROVED BY:	WEIGHT: 0.00 LBS		SHEET 1 OF 1		

DATE PLOTTED: 5/21/2012

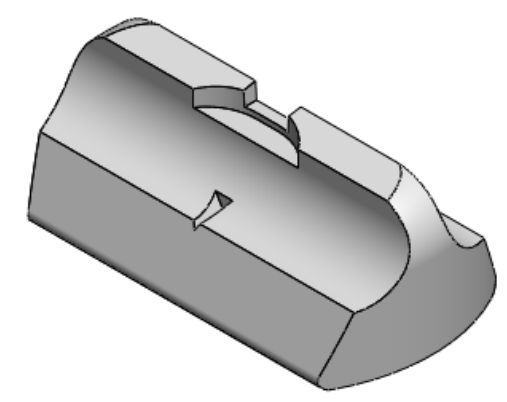
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD

D
C
B
A

D
C
B
A



NOTES:
 1. MATERIAL:
WROUGHT: STEEL, 1018, ASTM A108.
CAST: STEEL, IC-1020, ASTM A732.

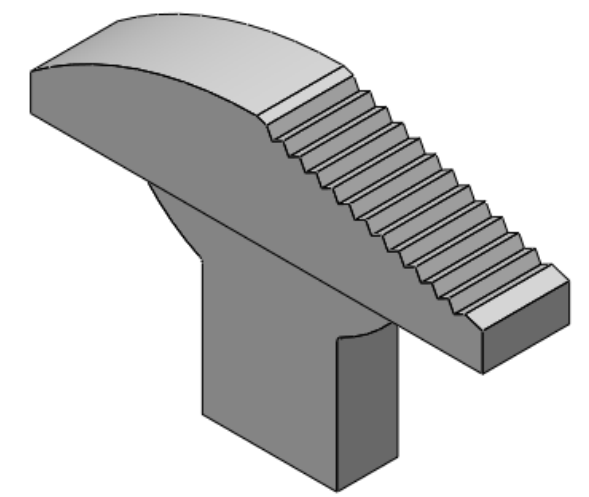
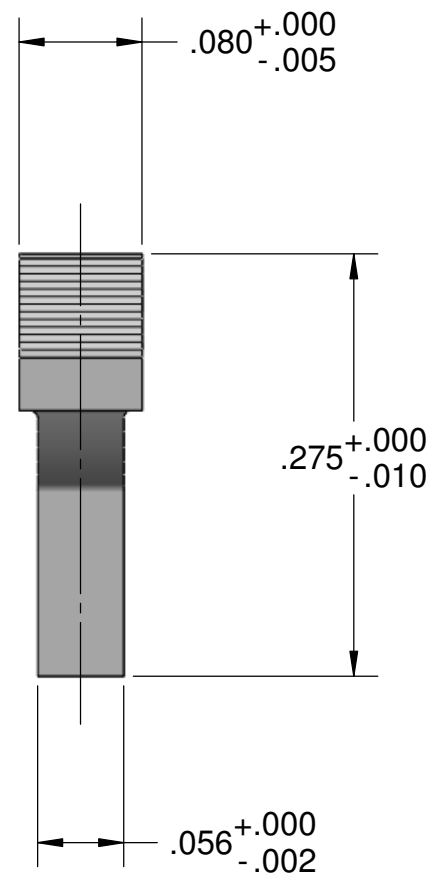
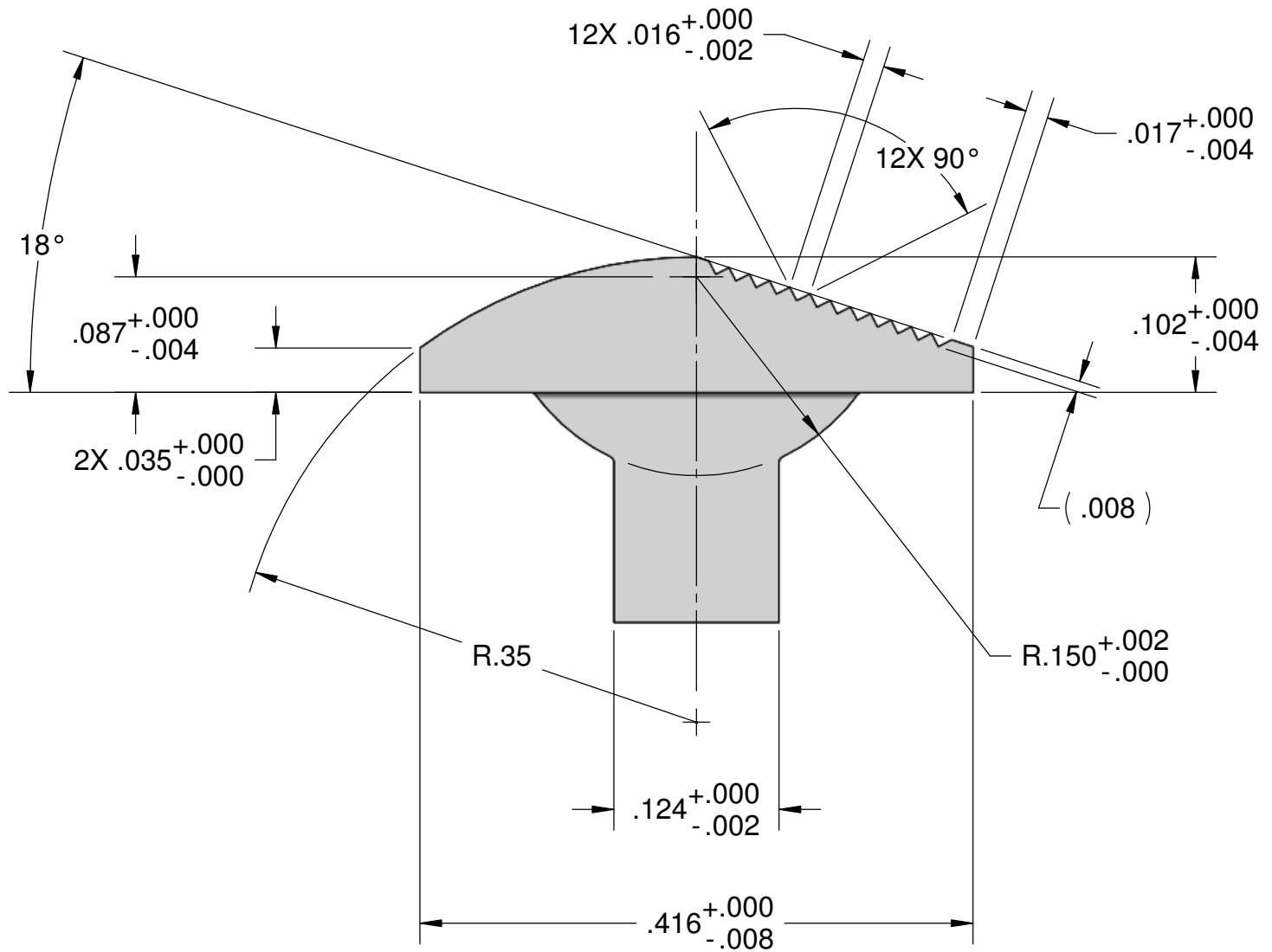


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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: SEE NOTE 1		THIRD ANGLE		PROJ: M1911-A1 REDUX	
	QTY REQD PER NEXT ASSY = 1		HEAT TREAT:		DRAWN BY: R Benson		DATE: 08/29/2010	
	DO NOT SCALE DRAWING		FINISH: MIL-STD-171 PARA 5.3.1.2		APPROVED BY:		SIZE: B	
						DWG/PART NO.: 5013196	REV:	
						SCALE: 4:1	WEIGHT: 0.01 LBS	SHEET 1 OF 1

8 7 6 5 4 3 2 1

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



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QTY REQD PER NEXT ASSY = 1

DO NOT SCALE DRAWING

RIO BENSON CONSULTING

1467 Georgetowne Drive
 Gastonia, North Carolina 28054
 riobenson@clear.net

TITLE: **SIGHT, FRONT**

UNLESS OTHERWISE SPECIFIED [UOS]:
 DIMENSIONS ARE IN INCHES.
 TOLERANCES PER DECIMAL PLACE:
 X = ±.05, XX = ±.02, XXX = ±.005, XXXX = ±.0005
 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN.
 REMOVE ALL BURRS AND SHARP EDGES .02 MAX
 INTERPRET DRAWING IAW ANSI Y14.5M -1994

MATERIAL: STEEL 1018
 ASTM A108
 HEAT TREAT:
 FINISH: MIL-STD-171
 PARA 5.3.1.2

THIRD ANGLE

 DRAWN BY:
 APPROVED BY:

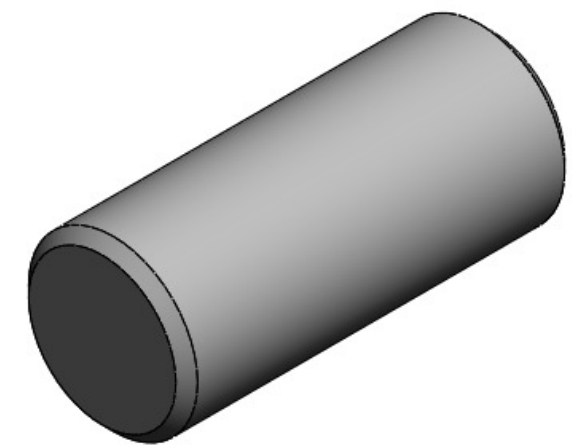
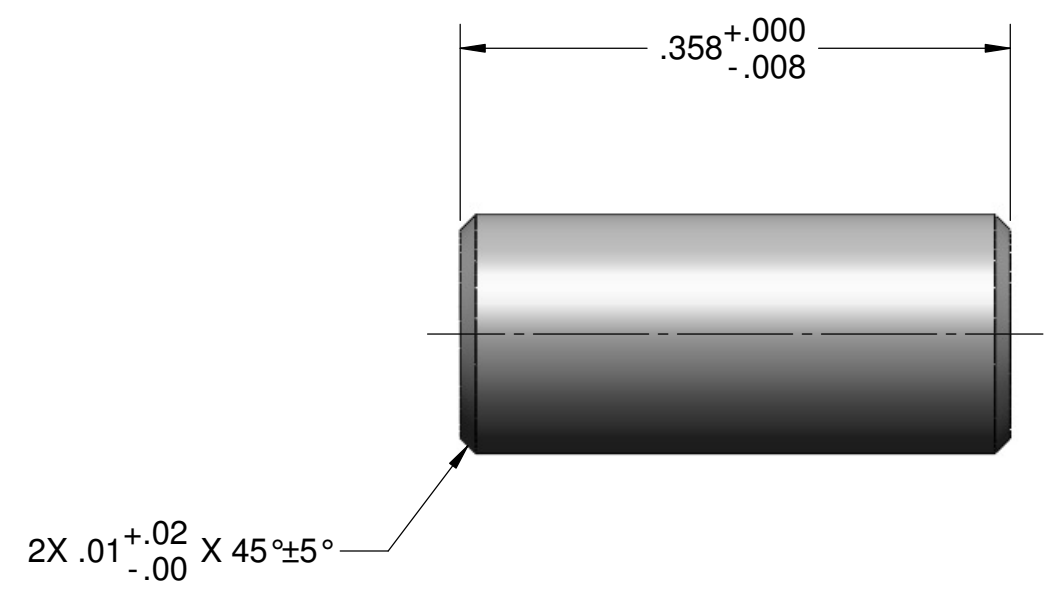
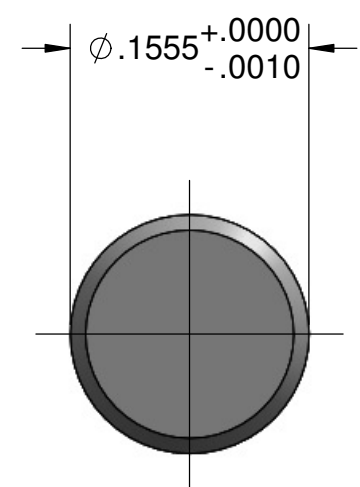
PROJ: M1911-A1 REDUX

NAME	DATE
R Benson	08/30/2010

SIZE	DWG/PART NO.	REV
B	5013197	
SCALE: 8:1	WEIGHT: 0.00 LBS	SHEET 1 OF 1

DATE PLOTTED: 5/22/2012

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REV	DESCRIPTION	DATE	APPRVD



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, XX = ±.02, XXX = ±.005, XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: DRILL ROD O2 ASTM A681	THIRD ANGLE 	PROJ: M1911-A1 REDUX		SIZE B	DWG/PART NO. 5013199	REV
	QTY REQD PER NEXT ASSY = 1		HEAT TREAT: RH C 43.5-50	DRAWN BY: R Benson	DATE 08/05/2010	SCALE: 8:1		WEIGHT: 0.00 LBS	SHEET 1 OF 1
	DO NOT SCALE DRAWING		FINISH: MIL-STD-171 PARA 5.3.1.2	APPROVED BY:					

DATE PLOTTED: 5/22/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



MODEL SHOWN COMPRESSED FOR ASSEMBLY

DIAMETER OF WIRE043
DIAMETER OF COIL (OD)430 ±.005
FREE LENGTH	(6.55)
ACTIVE COILS	29
TOTAL COILS	30
DIRECTION OF HELIX	CCW
LOAD AT COMPRESSED LENGTH OF	3.72 = 8.00 ± .50 LB
LOAD AT COMPRESSED LENGTH OF	1.81 = 13.55 ± .60 LB
SPRING RATE	(2.88 LB/INCH)
SOLID LENGTH	1.375 MAX
TYPE OF ENDS	NOT SQUARED OR CLOSED
HOLE DIA INTO WHICH SPRING FITS FREELY448 MIN
ROD DIA OVER WHICH SPRING SLIDES FREELY336 MAX *
CRIMP ONE END OF COIL TO326 +.000 -.010 ID

* EXCEPT FOR CRIMPED END.

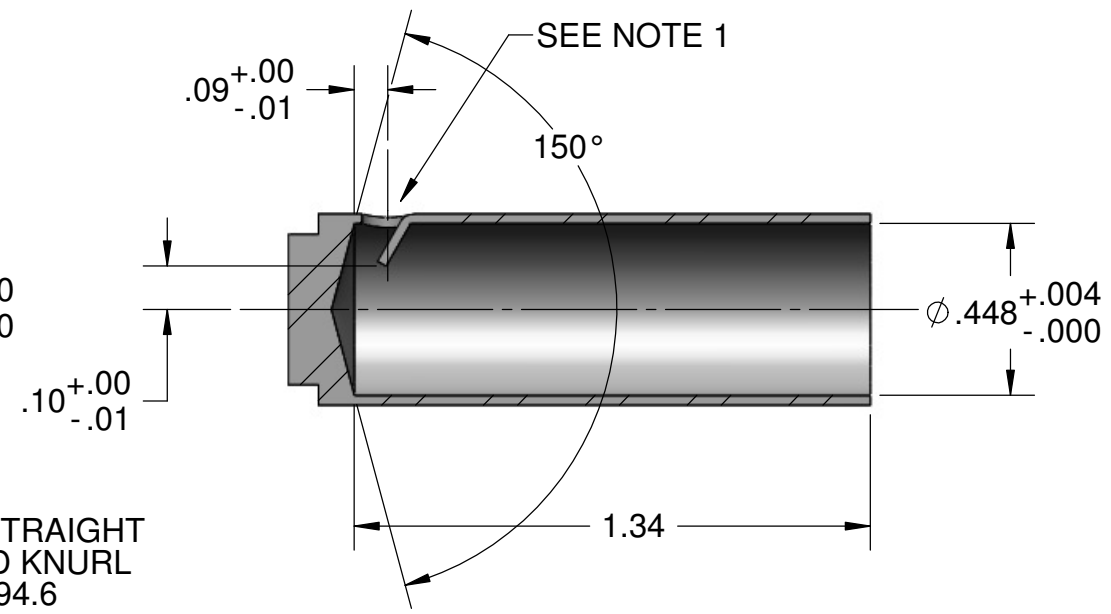
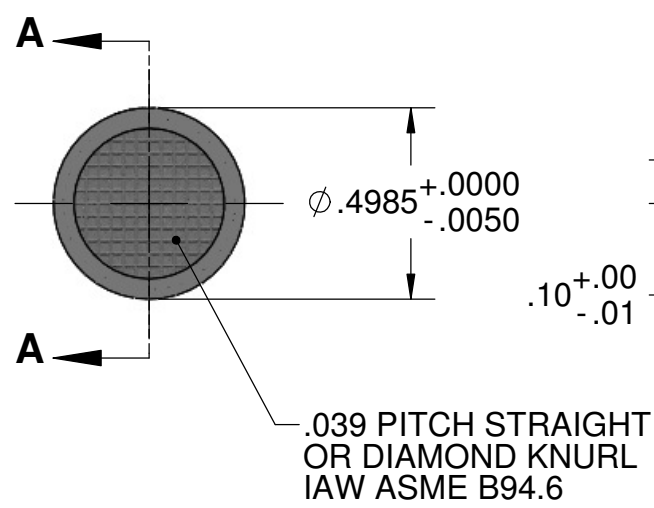
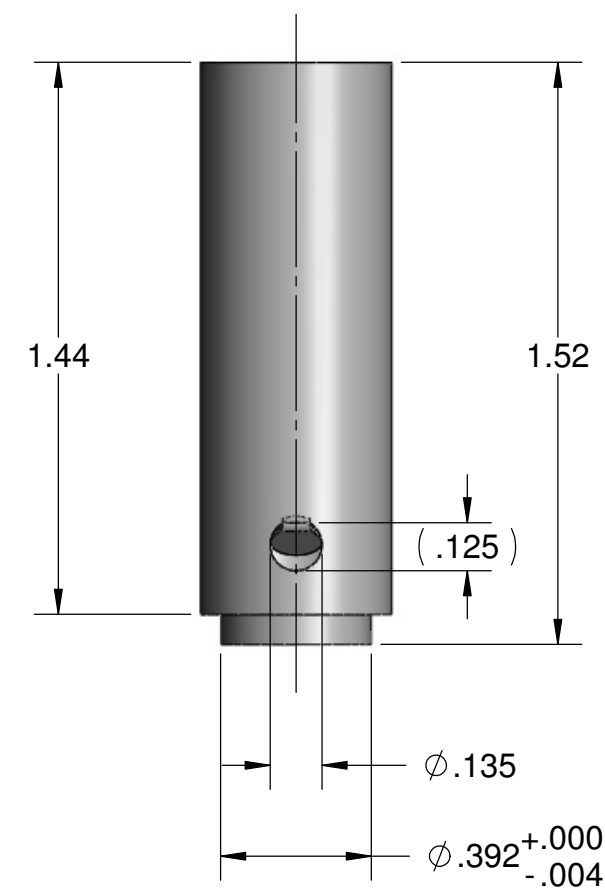
NOTES:

1. MANUFACTURE IAW TYPE 1, GRADE A, OF SAE AS 13572.
2. STRESS RELIEVE AT 450°F FOR 20 MINUTES AFTER FORMING.

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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±.5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: MUSIC WIRE, STEEL ASTM A228	THIRD ANGLE 	PROJ: M1911-A1 REDUX		SIZE B	DWG/PART NO. 5013200	REV
	QTY REQD PER NEXT ASSY = 1		HEAT TREAT: SEE NOTE 2	DRAWN BY: R Benson	DATE 08/30/2010	SCALE: 1:1		WEIGHT: 0.01 LBS	SHEET 1 OF 1
	DO NOT SCALE DRAWING		FINISH:	APPROVED BY:					

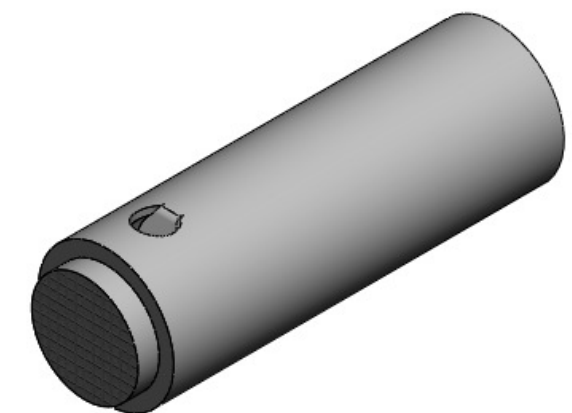
DATE PLOTTED: 5/22/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



NOTES:

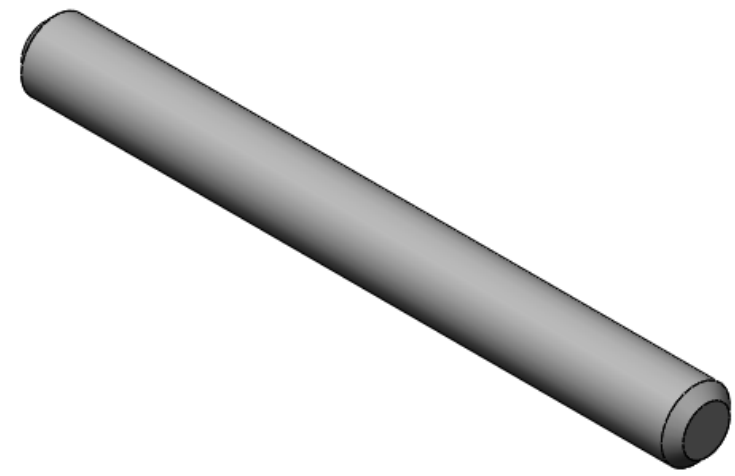
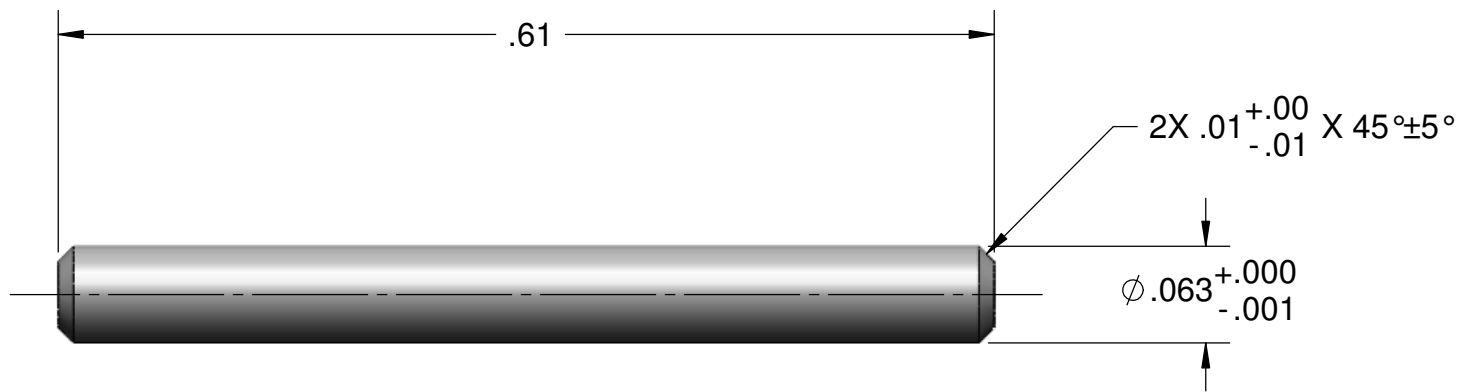
- HELICAL COMPRESSION SPRING OF $\phi .043$ WIRE, $.430$ OD, $.218$ PITCH SHALL ENTER FOR A MINIMUM DISTANCE OF $1/4$ COIL.



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = $\pm .05$, XX = $\pm .02$, XXX = $\pm .005$, XXXX = $\pm .0005$ ANGLES = $\pm 5^\circ$, MACHINED FINISH = 63-125 μ IN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: STEEL 1018 ASTM A108	THIRD ANGLE 	PROJ: M1911-A1 REDUX		SIZE: B	DWG/PART NO.: 5013201	REV:
	QTY REQD PER NEXT ASSY = 1		HEAT TREAT:	DRAWN BY: R Benson	DATE: 08/30/2010	SCALE: 2:1		WEIGHT: 0.02 LBS	SHEET 1 OF 1
	DO NOT SCALE DRAWING		FINISH: MIL-STD-171 PARA 5.3.1.2	APPROVED BY:					

DATE PLOTTED: 5/22/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: DRILL ROD, O2 ASTM A681	THIRD ANGLE 	PROJ: M1911-A1 REDUX		SIZE B	DWG/PART NO. 5013203	REV
	QTY REQD PER NEXT ASSY = 1		HEAT TREAT: RH C 34.5-41	DRAWN BY: R Benson	DATE 08/30/2010	SCALE: 8:1		WEIGHT: 0.00 LBS	SHEET 1 OF 1
	DO NOT SCALE DRAWING		FINISH: MIL-STD-171 PARA 5.3.1.2	APPROVED BY:					

DATE PLOTTED: 5/22/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



MODEL IS SHOWN COMPRESSED FOR ASSEMBLY

DIAMETER OF WIRE026
DIAMETER OF COIL (OD)207 ±.005
FREE LENGTH	(1.70)
ACTIVE COILS	38
TOTAL COILS	40
DIRECTION OF HELIX	OPTIONAL
LOAD AT COMPRESSED LENGTH OF	1.36 = 1.030 ± .135 LB
SPRING RATE	(3.0 LB/INCH)
SOLID LENGTH	1.066 MAX
TYPE OF ENDS	SQUARED AND GROUND
HOLE DIA INTO WHICH SPRING FITS FREELY219 MIN
ROD DIA OVER WHICH SPRING SLIDES FREELY150 MAX *
CRIMP ONE END OF COIL TO135 +.010 -.000 ID

* EXCEPT FOR CRIMPED END.

NOTES:

1. MANUFACTURE IAW TYPE 1, GRADE A, OF SAE AS 13572.
2. STRESS RELIEVE AT 450°F FOR 20 MINUTES AFTER FORMING.

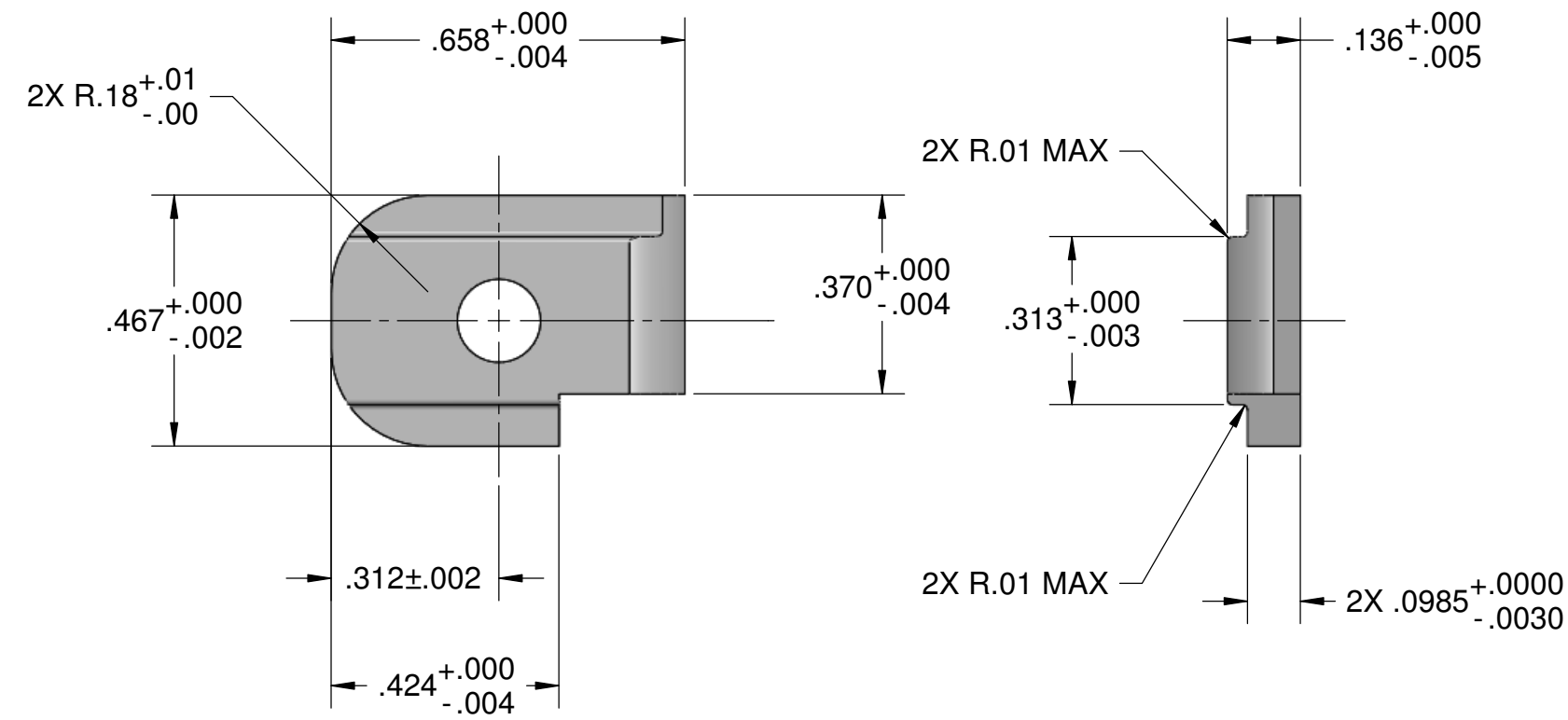
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DATE PLOTTED: 5/22/2012

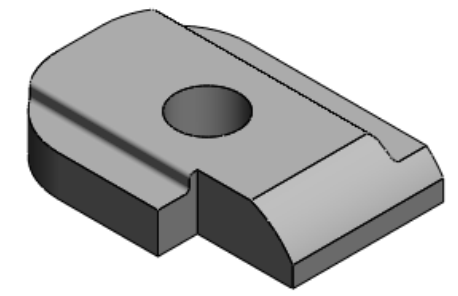
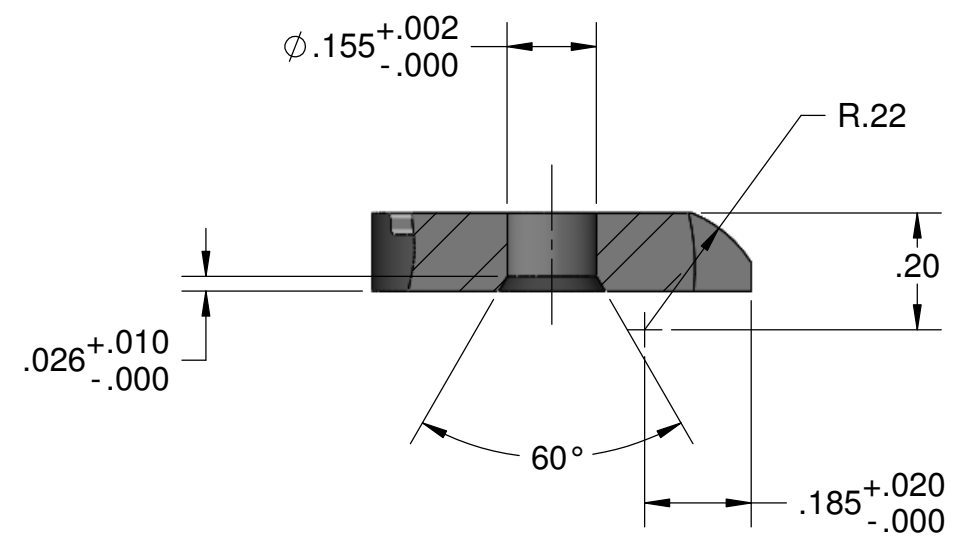
PROPRIETARY AND CONFIDENTIAL: THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RIO BENSON CONSULTING. ANY REVIEW, RETRANSMISSION, DISSEMINATION, COPYING OR OTHER USE OF, OR THE TAKING OF ANY ACTION IN RELIANCE UPON THIS INFORMATION BY PERSONS OR ENTITIES OTHER THAN THE THE INTENDED RECIPIENT, IS PROHIBITED.	RIO BENSON CONSULTING		1467 Georgetowne Drive Gastonia, North Carolina 28054 riobenson@clear.net		TITLE: SPRING, FIRING PIN				
	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±.5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: MUSIC WIRE, STEEL ASTM A228	THIRD ANGLE	PROJ: M1911-A1 REDUX		SIZE: B	DWG/PART NO.: 5013204	REV:
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		HEAT TREAT: SEE NOTE 2	FINISH:	DRAWN BY: R Benson	DATE:	SCALE: 3:1	WEIGHT: 0.00 LBS	SHEET 1 OF 1

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



NOTES:

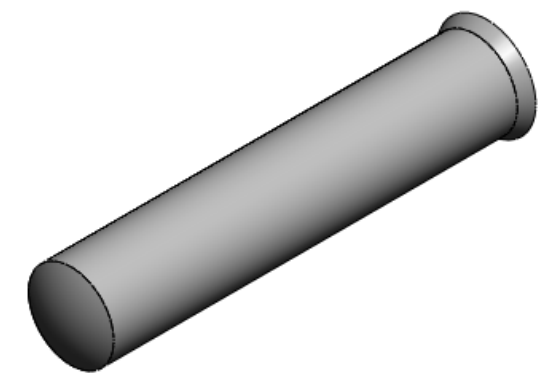
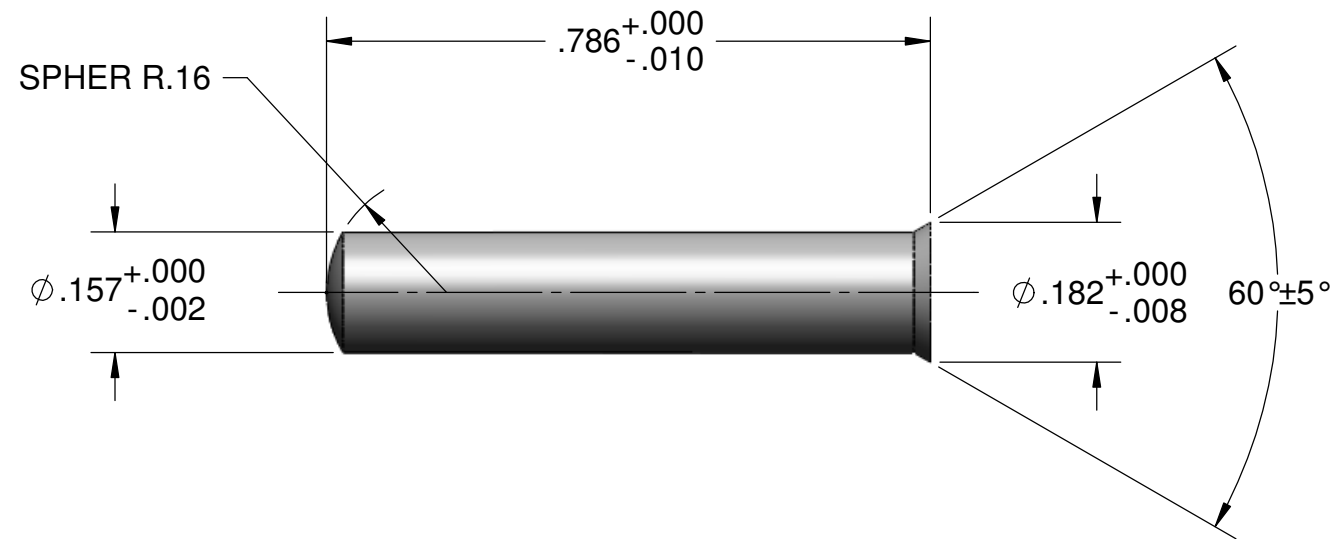
- MATERIAL:
WROUGHT: STEEL, 4140, ASTM A108;
AUSTENITIC GRAIN SIZE 6 OR FINER.
CAST: STEEL, IC 4140, ASTM A732.



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M-1994		MATERIAL: SEE NOTE 1 HEAT TREAT: RH C 43.5-50 FINISH: MIL-STD-171 PARA 5.3.1.2		THIRD ANGLE 		PROJ: M1911-A1 REDUX	
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		DRAWN BY: R Benson APPROVED BY:		NAME: R Benson DATE: 08/30/2010		SIZE: B DWG/PART NO.: 5013205	
					SCALE: 3:1 WEIGHT: 0.01 LBS		REV: SHEET 1 OF 1	

DATE PLOTTED: 5/22/2012

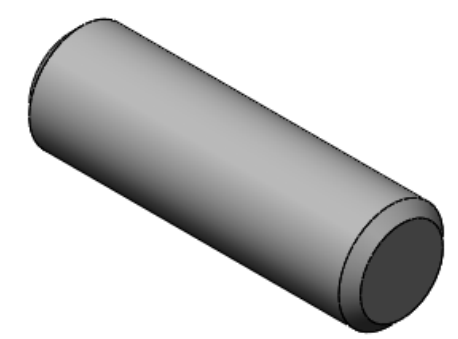
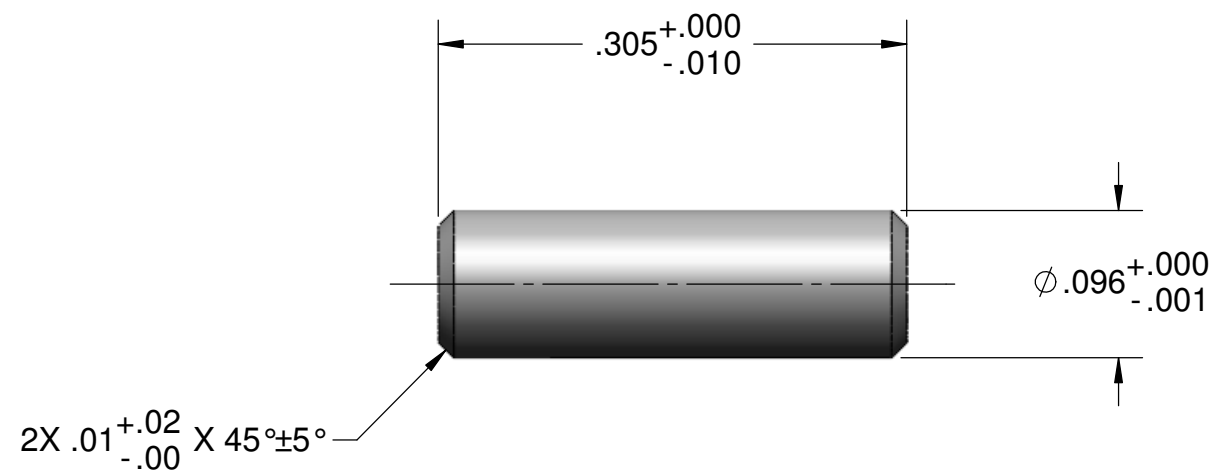
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: DRILL ROD, O2 ASTM A681	THIRD ANGLE 	PROJ: M1911-A1 REDUX		SIZE B	DWG/PART NO. 5013206	REV
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		HEAT TREAT: RH C 48-52	DRAWN BY: R Benson	DATE 08/30/2010	SCALE: 4:1	WEIGHT: 0.00 LBS	SHEET 1 OF 1	

DATE PLOTTED: 5/22/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 µIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: DRILL ROD, O2 ASTM A681	THIRD ANGLE 	PROJ: M1911-A1		SIZE: B	DWG/PART NO.: 5013207	REV:
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		HEAT TREAT: RH C 39.5-46	DRAWN BY: R Benson	DATE: 08/31/2010	SCALE: 8:1	WEIGHT: 0.00 LBS	SHEET 1 OF 1	

DATE PLOTTED: 5/22/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



MODEL IS SHOWN COMPRESSED FOR ASSEMBLY

DIAMETER OF WIRE045
DIAMETER OF COIL (OD)273 +.000 -.003
FREE LENGTH	(2.156)
ACTIVE COILS	19.5
TOTAL COILS	21.5
DIRECTION OF HELIX	CCW
LOAD AT COMPRESSED LENGTH OF	1.312 = 22.0 ± 2.0 LB
LOAD AT COMPRESSED LENGTH OF	1.062 = 29.5 ± 2.0 LB
SPRING RATE	(27.69 LB/INCH)
SOLID LENGTH968 MAX
TYPE OF ENDS	CLOSED, SQUARED & GROUND
ROD DIA OVER WHICH SPRING SLIDES FREELY174 MAX*
CRIMP BOTH END COILS TO160 +.008 -.000 ID

NOTES:

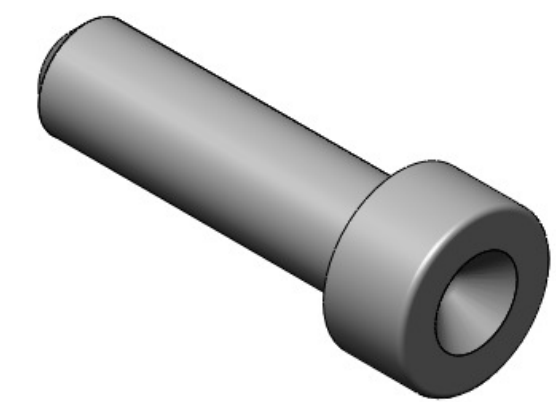
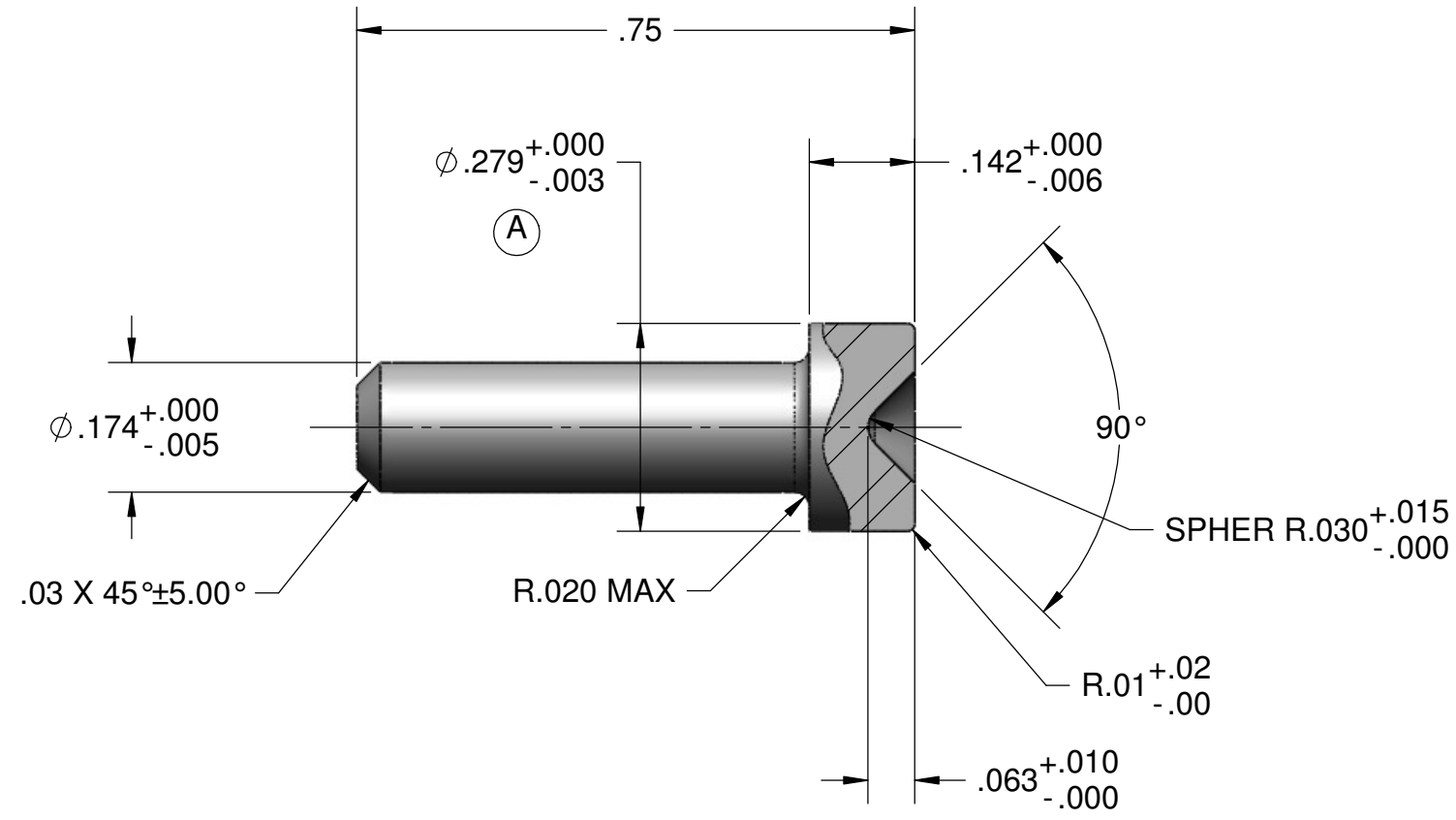
1. MANUFACTURE IAW TYPE 1, GRADE A, OF SAE AS 13572.
2. STRESS RELIEVE AT 450 °F FOR 20 MINUTES AFTER FORMING.

*EXCEPT FOR CRIMPED ENDS: CHECK AT A STAGE OF MANUFACTURE OR BY CUTTING OFF CRIMP IN SAMPLE.

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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±.5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: MUSIC WIRE, STEEL ASTM A228	THIRD ANGLE 	PROJ: M1911-A1 REDUX		SIZE: B	DWG/PART NO.: 5013208	REV:
	QTY REQD PER NEXT ASSY = 1	HEAT TREAT: SEE NOTE 2	FINISH:	DRAWN BY: R Benson	DATE: 08/31/2010	SCALE: 2:1	WEIGHT: 0.01 LBS	SHEET 1 OF 1	

DATE PLOTTED: 5/22/2012

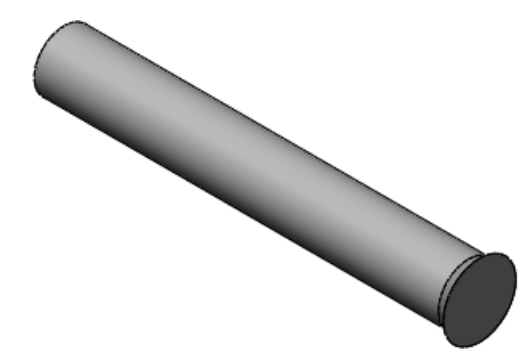
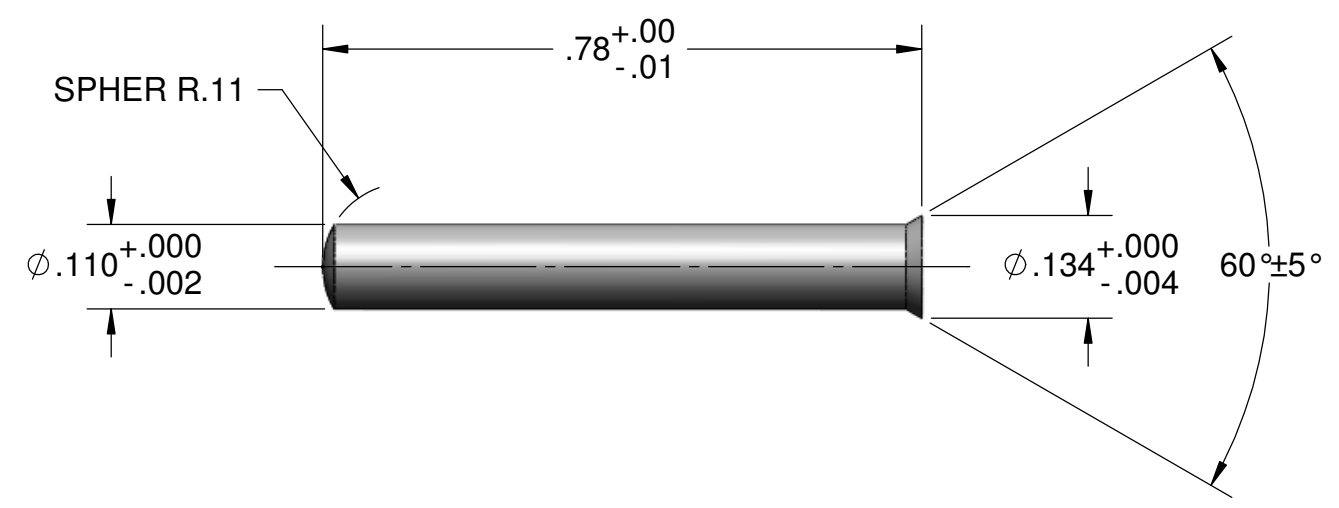
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD
A	ADDED MISSING ϕ .279 DIMENSION	11/07/2010	R Benson



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = $\pm .05$, XX = $\pm .02$, XXX = $\pm .005$, XXXX = $\pm .0005$ ANGLES = $\pm 5^\circ$, MACHINED FINISH = 63-125 μ IN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: STEEL 1117 ASTM A108 HEAT TREAT: CASE DP .003-.005 RH C 48-52 FINISH: MIL-STD-171 PARA 5.3.1.2		THIRD ANGLE 		PROJ: M1911-A1 REDUX	
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		DRAWN BY: R Benson APPROVED BY:		DATE: 08/31/2010		SIZE: B	DWG/PART NO.: 5013209
				SCALE: 4:1		WEIGHT: 0.01 LBS	SHEET 1 OF 1	

DATE PLOTTED: 5/22/2012

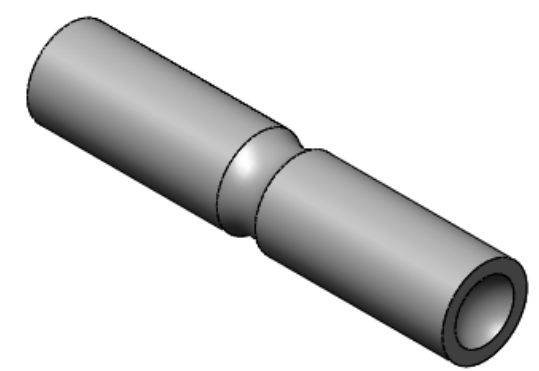
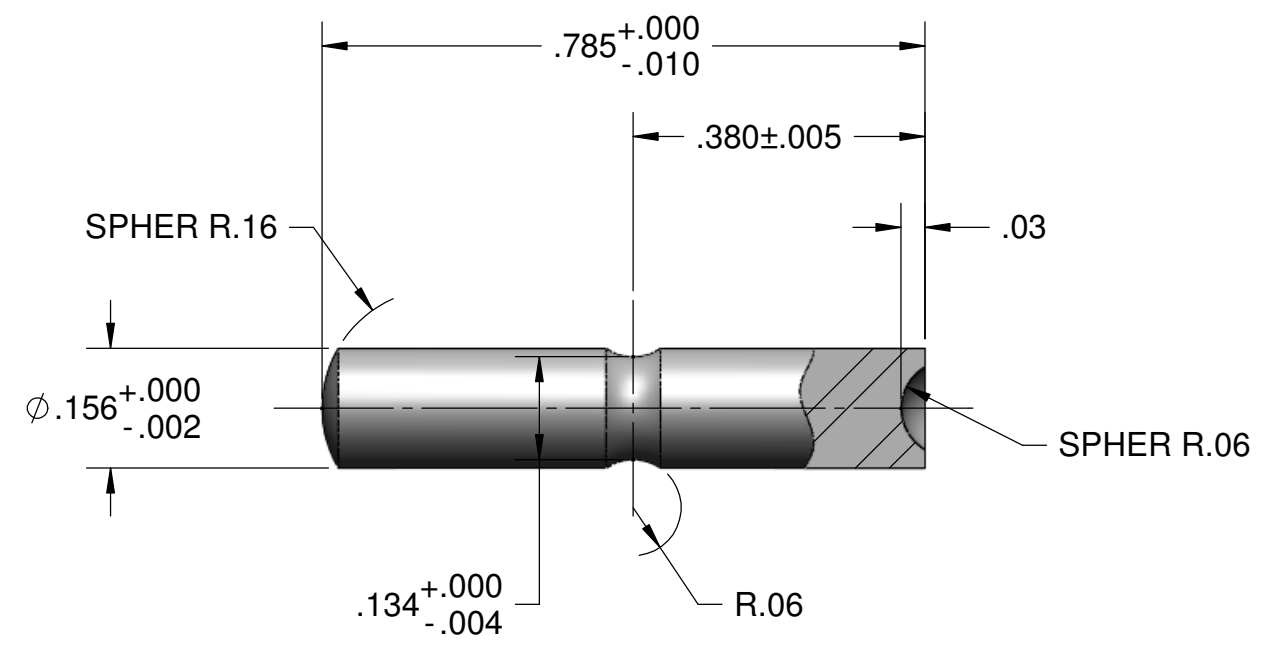
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: DRILL ROD, O2 ASTM A681	THIRD ANGLE 	PROJ: M1911-A1 REDUX		SIZE B	DWG/PART NO. 5013211	REV
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		HEAT TREAT: RH C 48-52	DRAWN BY: R Benson	DATE 08/31/2010	SCALE: 4:1		WEIGHT: 0.00 LBS	SHEET 1 OF 1

DATE PLOTTED: 5/22/2012

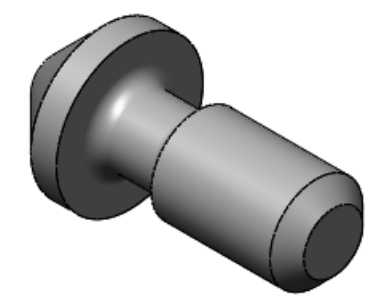
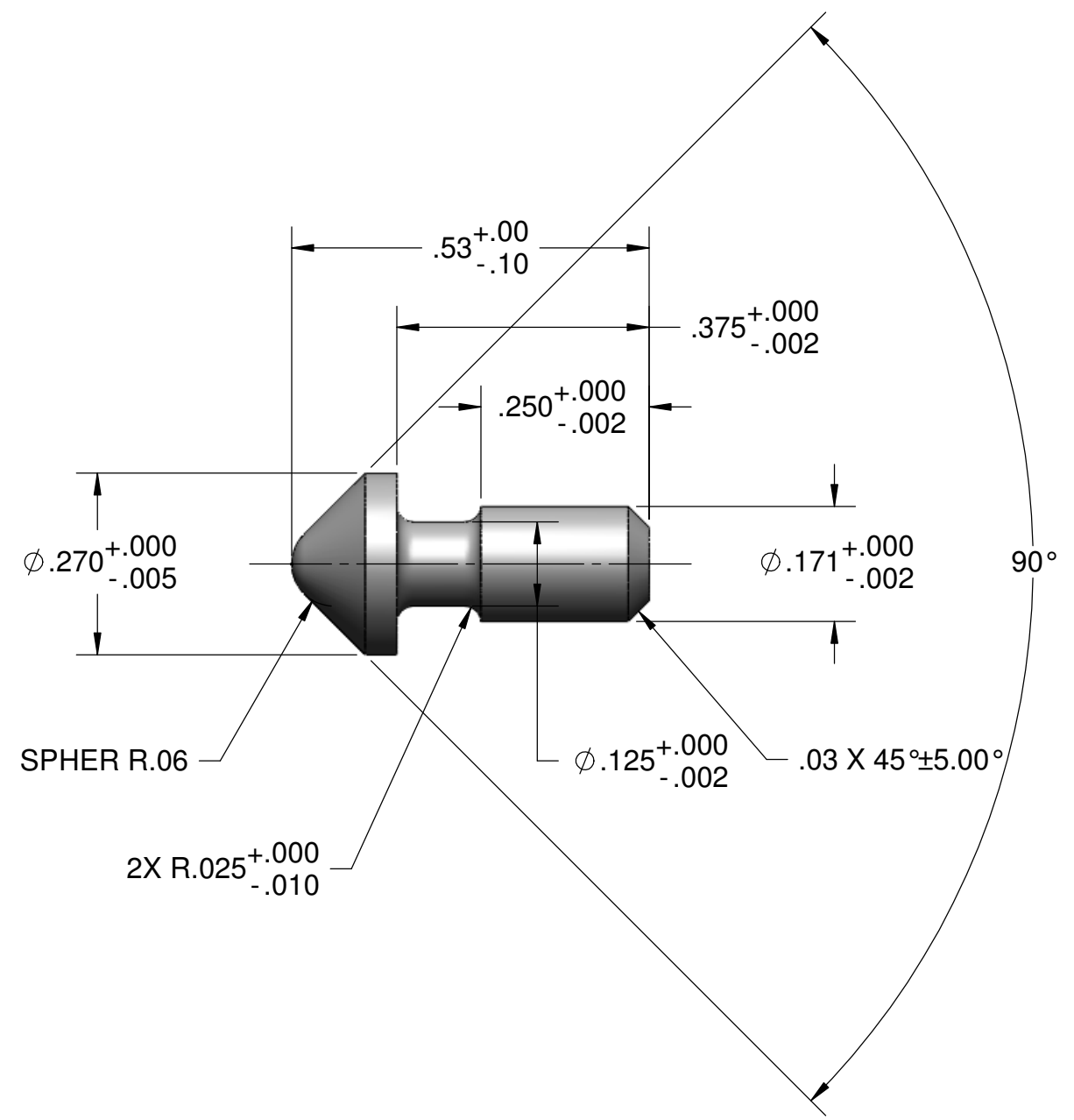
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 µIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: DRILL ROD, O2 ASTM A681 HEAT TREAT: RH C 43.5-50		THIRD ANGLE 		PROJ: M1911-A1 REDUX
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		FINISH: MIL-STD-171 PARA 5.3.1.2		DRAWN BY: R Benson DATE: 08/31/2010		SIZE: B DWG/PART NO.: 5013212
				APPROVED BY:		SCALE: 4:1 WEIGHT: 0.00 LBS SHEET 1 OF 1	REV

DATE PLOTTED: 5/22/2012

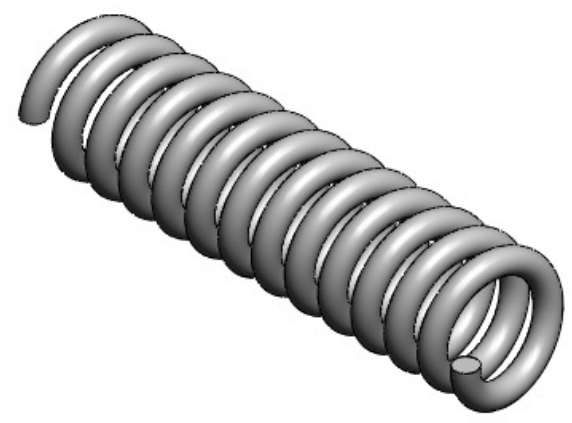
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 µIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: STEEL 1117 ASTM A108 HEAT TREAT: CASE DP .003-.005 RH C 48-52 FINISH: MIL-STD-171 PARA 5.3.1.2		THIRD ANGLE 		PROJ: M1911-A1 REDUX		
	QTY REQD PER NEXT ASSY = 1		DRAWN BY: R Benson		DATE: 08/31/2010		SIZE: B	DWG/PART NO.: 5013213	REV:
	DO NOT SCALE DRAWING		APPROVED BY:		SCALE: 4:1		WEIGHT: 0.00 LBS	SHEET 1 OF 1	

DATE PLOTTED: 5/22/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



MODEL SHOWN COMPRESSED FOR ASSEMBLY

DIAMETER OF WIRE	(.026)
INSIDE DIAMETER (ID), FREE, NOT LESS THAN091
OUTSIDE DIAMETER (OD), SOLID, NOT MORE THAN149
FREE LENGTH (APPROX)708
ACTIVE COILS	(11)
TOTAL COILS	(13)
DIRECTION OF HELIX	CW
LOAD AT COMPRESSED LENGTH OF550 = 5.7 ± .5 LB
LOAD AT COMPRESSED LENGTH OF456 = 8.5 ± .7 LB
SOLID LENGTH364 MAX
TYPE OF ENDS	PLAIN (OPEN ENDS, NOT GROUND)
HOLE DIA INTO WHICH SPRING FITS FREELY152 MIN
REDUCE ID OF LAST COIL ON BOTH ENDS TO085 +.000 -.010

NOTES:

1. MANUFACTURE IAW TYPE 1, GRADE A, OF SAE AS 13572.
2. STRESS RELIEVE AT 450°F FOR 20 MINUTES AFTER FORMING.

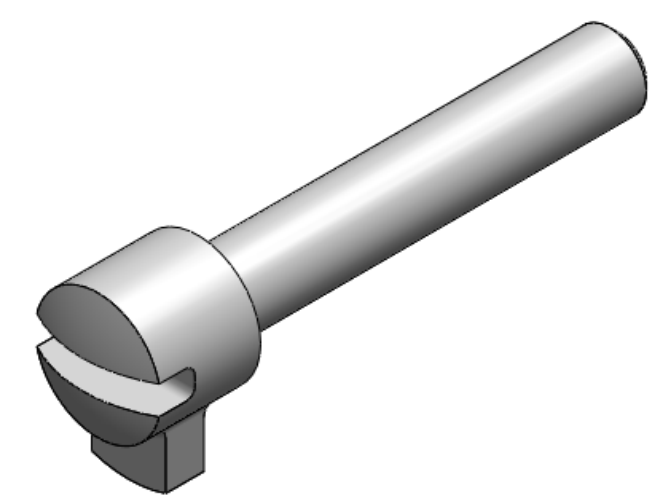
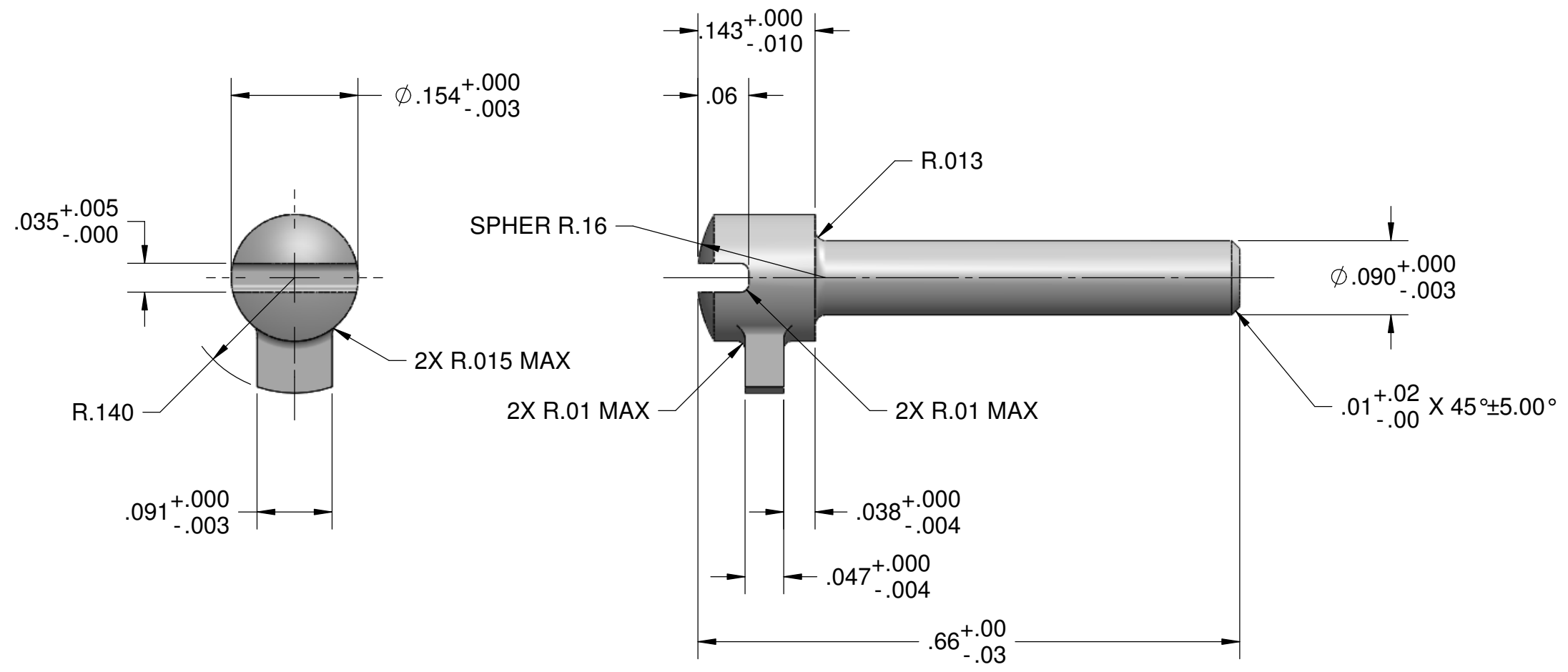
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A

DATE PLOTTED: 5/22/2012

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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±.5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: MUSIC WIRE, STEEL ASTM A228 HEAT TREAT: SEE NOTE 2		THIRD ANGLE 		PROJ: M1911-A1 REDUX	
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		FINISH:		DRAWN BY: R Benson DATE: 08/31/2010		SIZE: B DWG/PART NO.: 5013217	
				APPROVED BY:		SCALE: 6:1 WEIGHT: 0.00 LBS SHEET 1 OF 1		

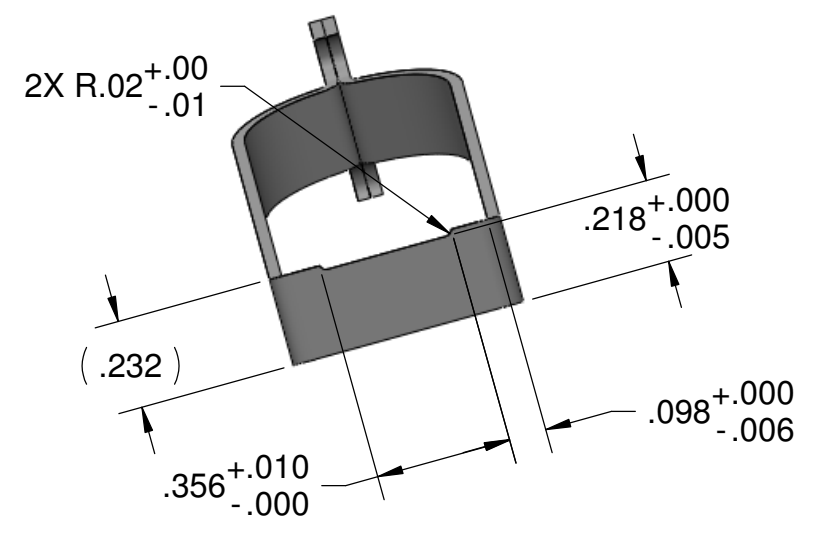
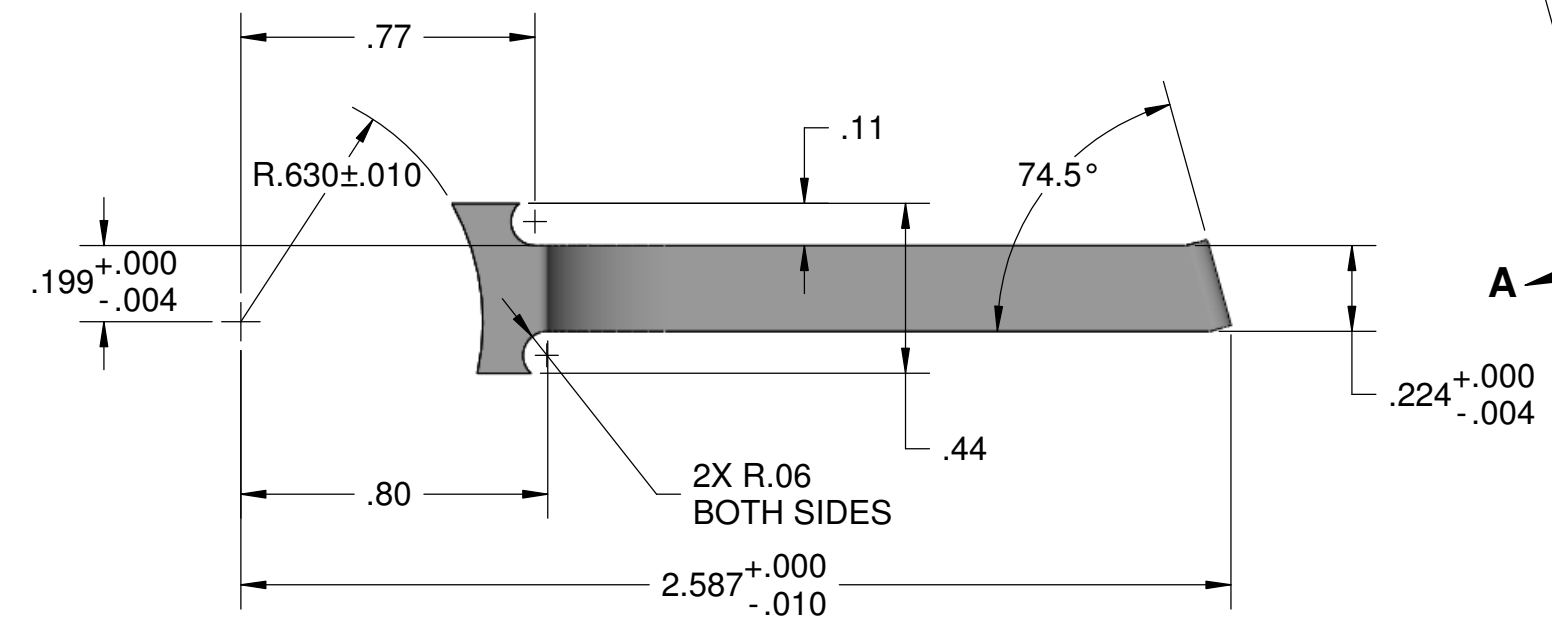
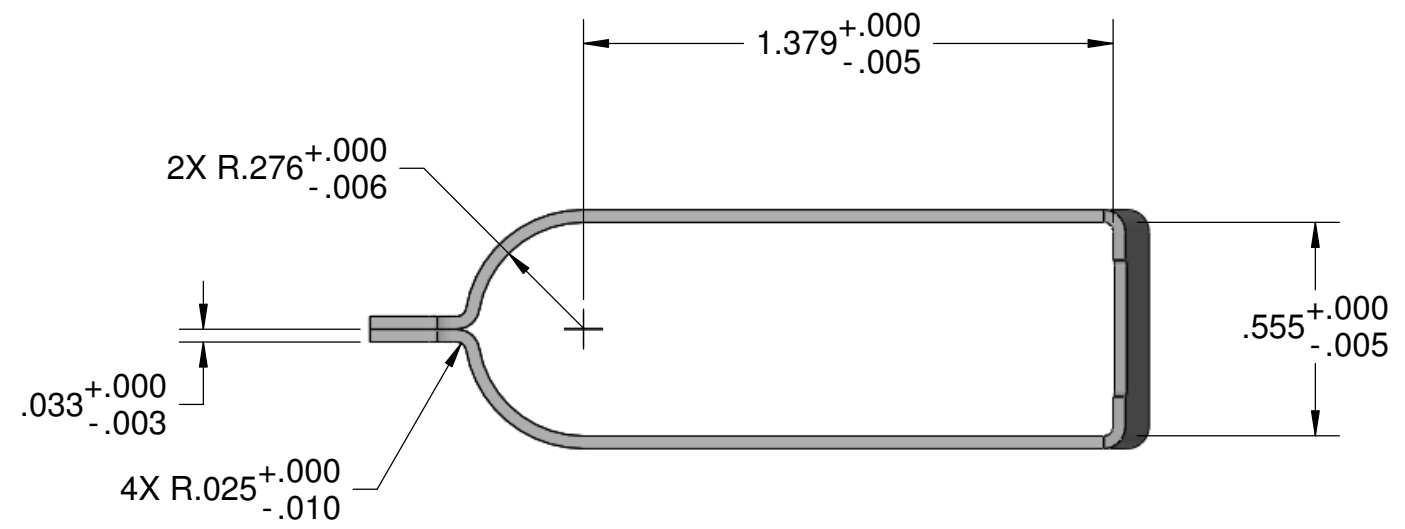
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



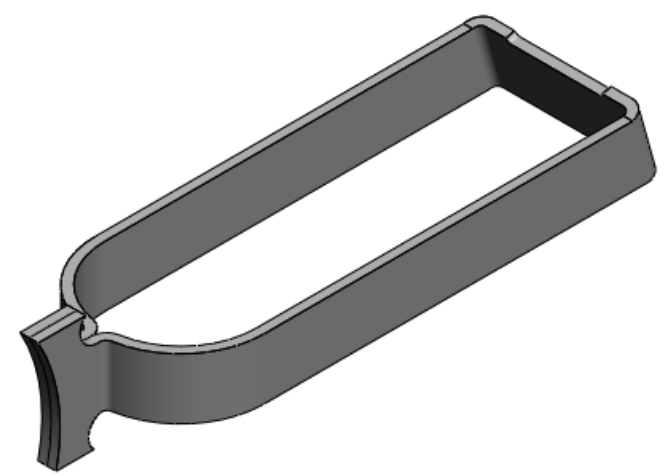
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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: STEEL 1117 ASTM A108 HEAT TREAT: CASE DP .003-.005 RH C 48-52 FINISH: MIL-STD-171 PARA 5.3.1.2		THIRD ANGLE 		PROJ: M1911-A1 REDUX	
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		DRAWN BY: R Benson APPROVED BY:		NAME: R Benson DATE: 08/31/2010		SIZE: B DWG/PART NO.: 5013218 SCALE: 6:1 WEIGHT: 0.00 LBS SHEET 1 OF 1	

DATE PLOTTED: 5/22/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



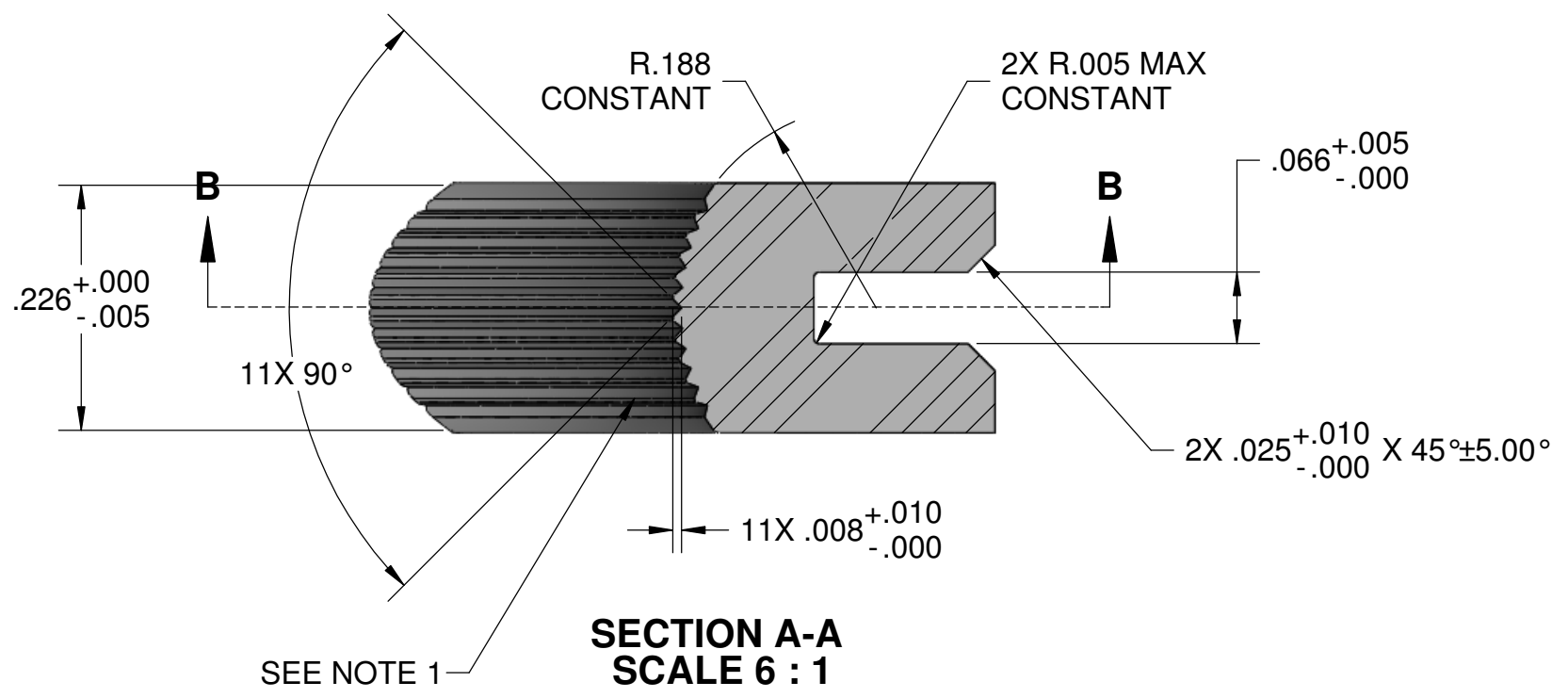
VIEW A-A



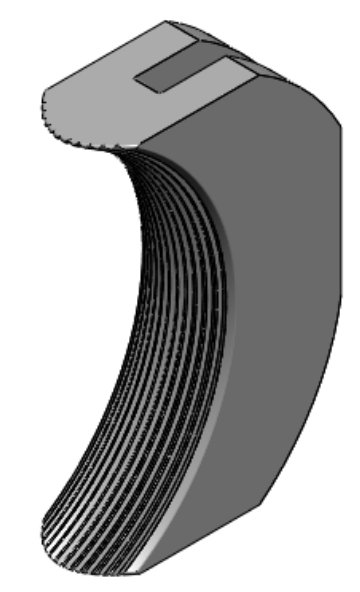
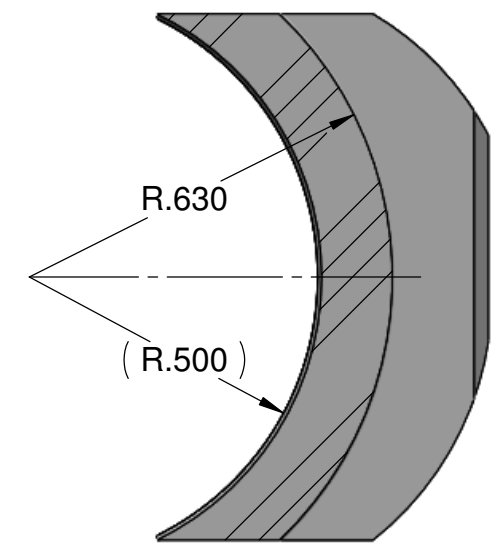
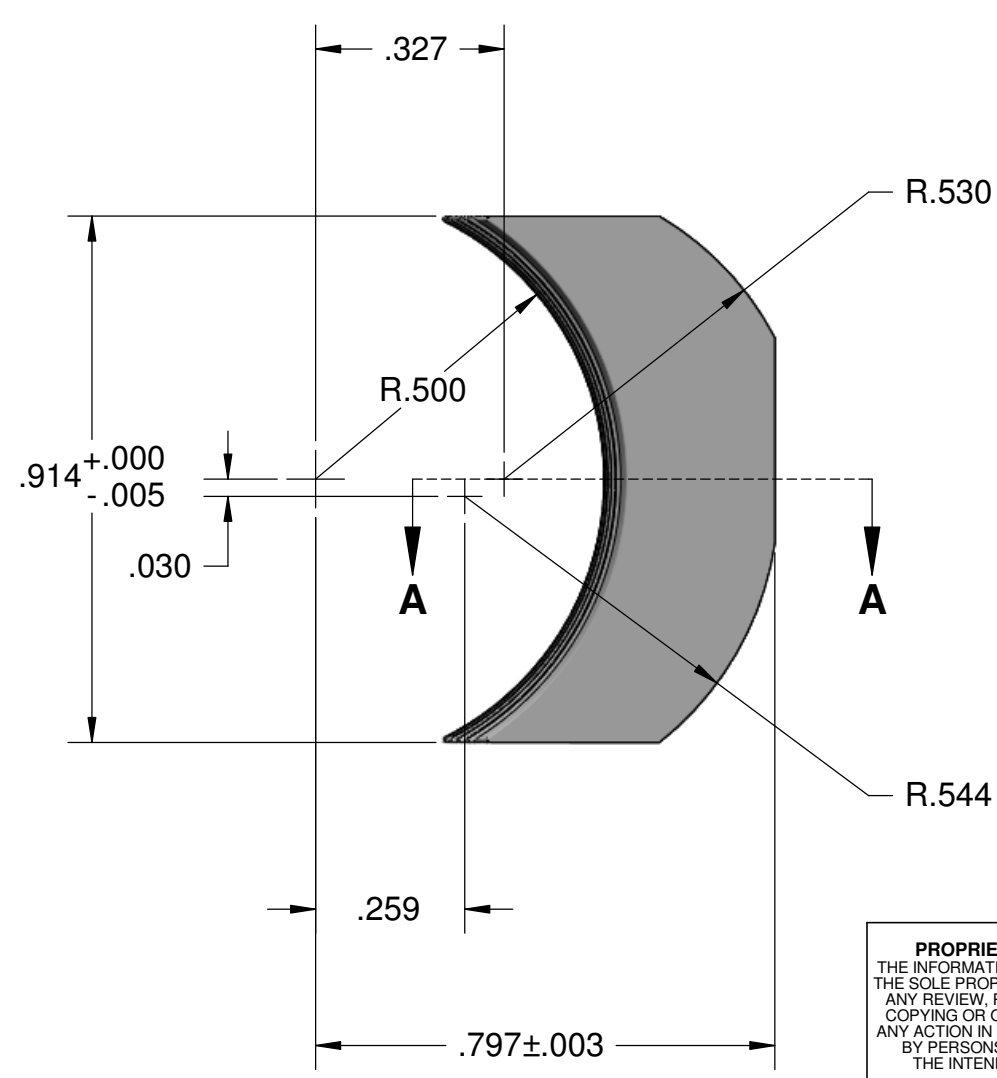
<p>PROPRIETARY AND CONFIDENTIAL: THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RIO BENSON CONSULTING. ANY REVIEW, RETRANSMISSION, DISSEMINATION, COPYING OR OTHER USE OF, OR THE TAKING OF ANY ACTION IN RELIANCE UPON THIS INFORMATION BY PERSONS OR ENTITIES OTHER THAN THE INTENDED RECIPIENT, IS PROHIBITED.</p>	<p>RIO BENSON CONSULTING</p>		<p>1467 Georgetowne Drive Gastonia, North Carolina 28054 riobenson@clear.net</p>		<p>TITLE: BOW, TRIGGER</p>				
	<p>UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994</p>		<p>MATERIAL: STEEL 1018 ASTM A108</p>	<p>THIRD ANGLE</p>	<p>PROJ: M1911-A1 REDUX</p>		<p>SIZE</p>	<p>DWG/PART NO.</p>	<p>REV</p>
	<p>QTY REQD PER NEXT ASSY = 1</p>		<p>HEAT TREAT:</p>	<p>DRAWN BY:</p>	<p>NAME</p>	<p>DATE</p>	<p>B</p>	<p>5153126</p>	<p> </p>
	<p>DO NOT SCALE DRAWING</p>		<p>FINISH: MIL-STD-171 PARA 5.3.1.2</p>	<p>APPROVED BY:</p>	<p>R Benson</p>	<p>09/01/2010</p>			

DATE PLOTTED: 5/23/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



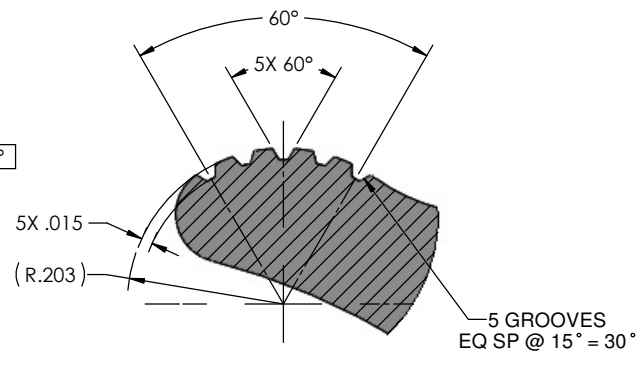
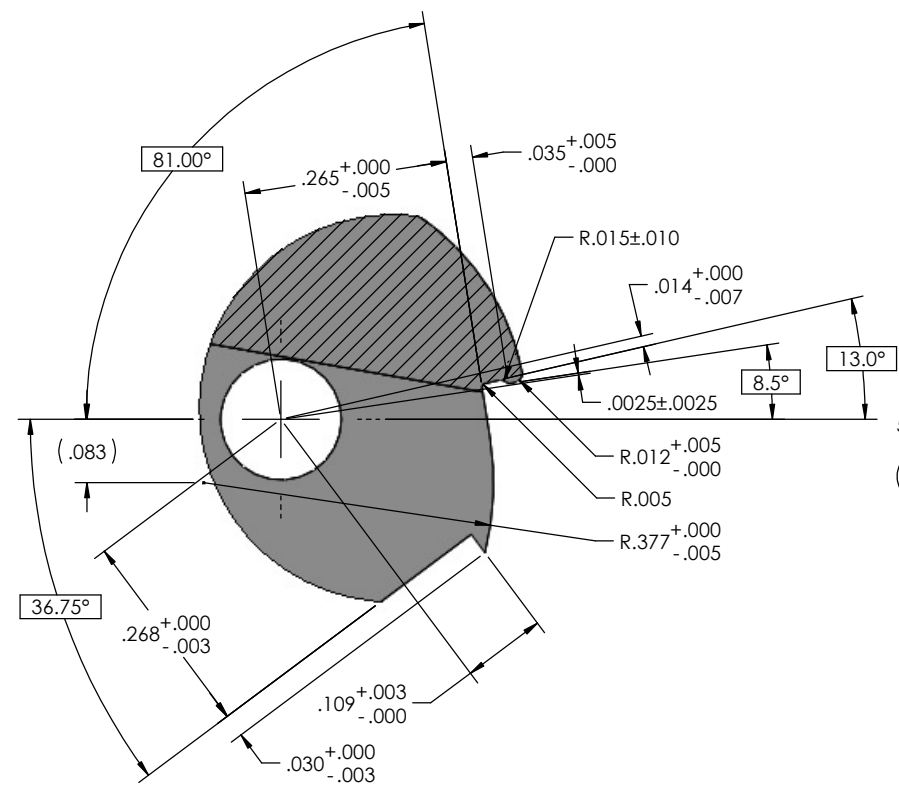
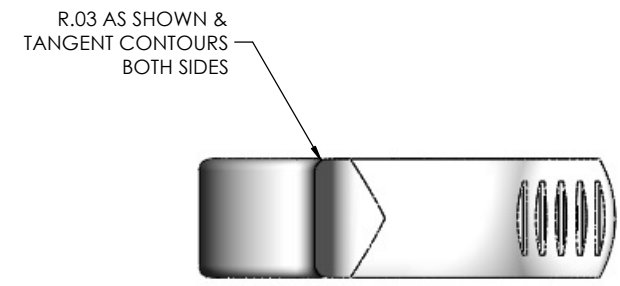
NOTES:
 1. 11 CONTOURED GROOVES EQUALLY SPACED AT 5° AND CENTERED ABOUT CENTERLINE. GROOVES ARE CONTOURED ALONG BOTH THE R.500 AND R.188 SURFACES.



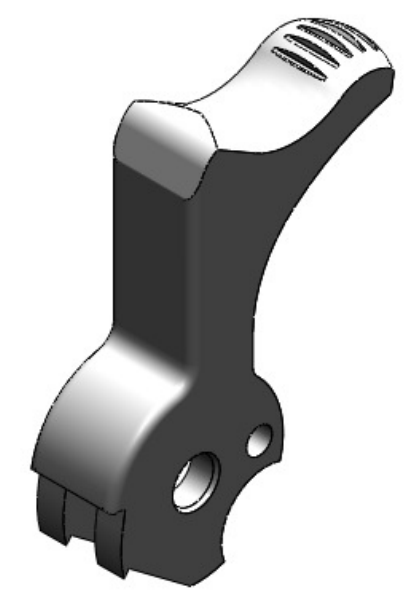
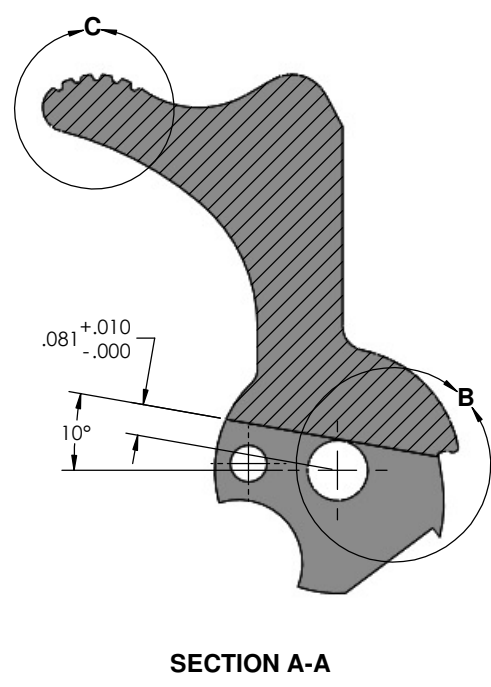
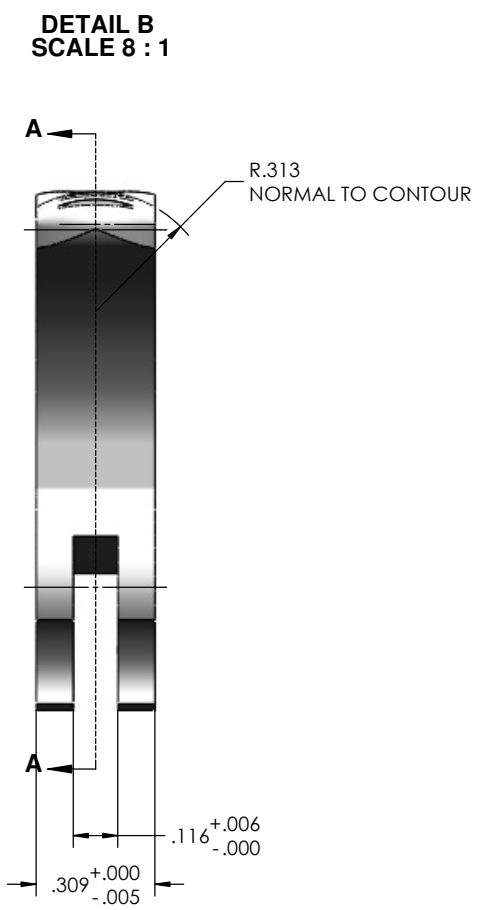
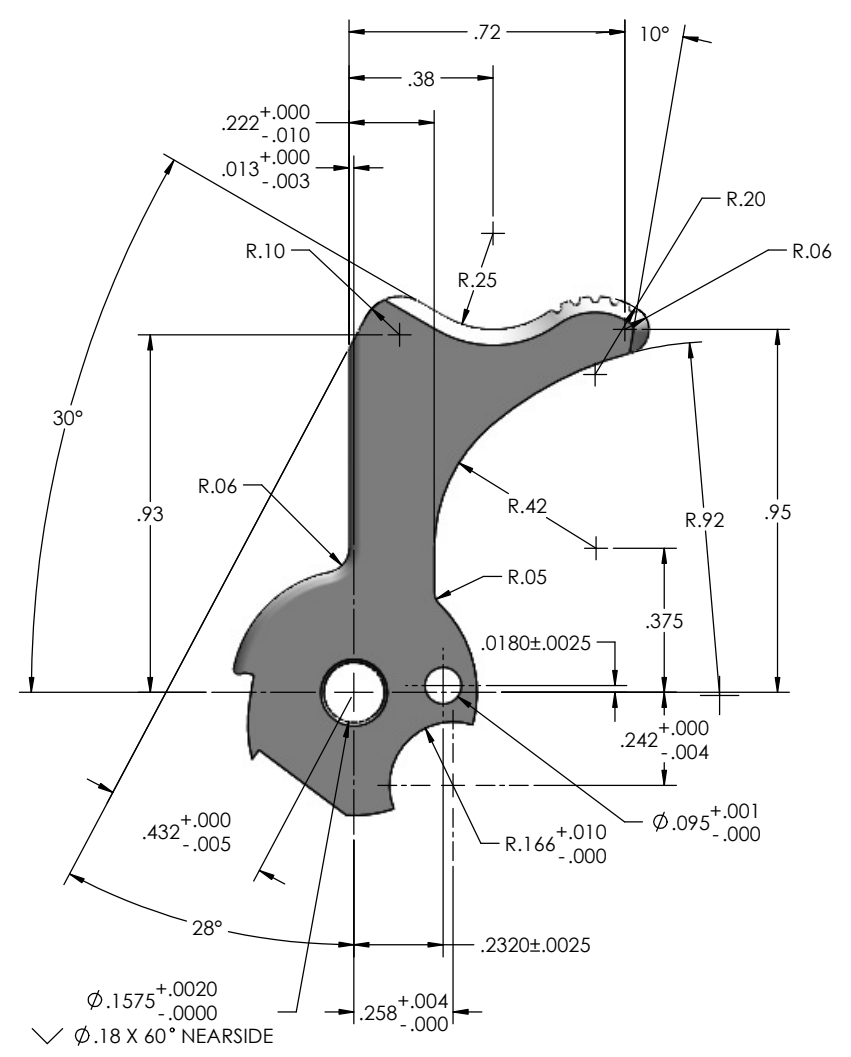
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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: STEEL 1018 ASTM A108	THIRD ANGLE	PROJ: M1911-A1 REDUX		SIZE: B	DWG/PART NO.: 5153127	REV:
	QTY REQD PER NEXT ASSY = 1		HEAT TREAT:	DRAWN BY: R Benson	DATE: 09/01/2010	SCALE: 3:1		WEIGHT: 0.00 LBS	SHEET 1 OF 1
	DO NOT SCALE DRAWING		FINISH: MIL-STD-171 PARA 5.3.1.2	APPROVED BY:	WEIGHT: 0.00 LBS		SHEET 1 OF 1		

DATE PLOTTED: 5/23/2012

REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD
ALL	A	REVISED & REDRAWN PER MORE LEGIBLE DATA	11/07/2010	R Benson



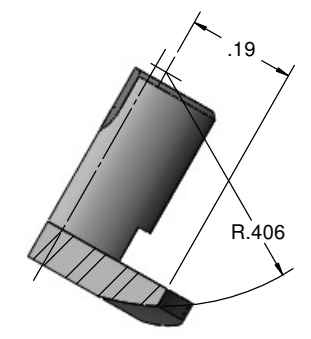
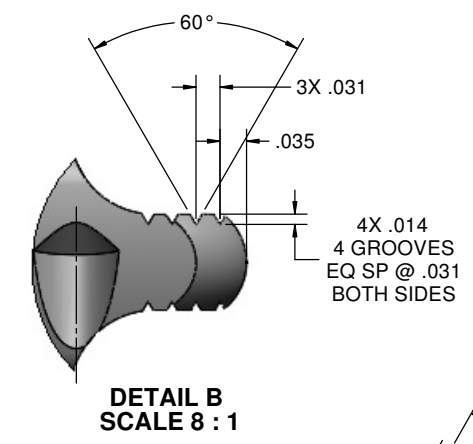
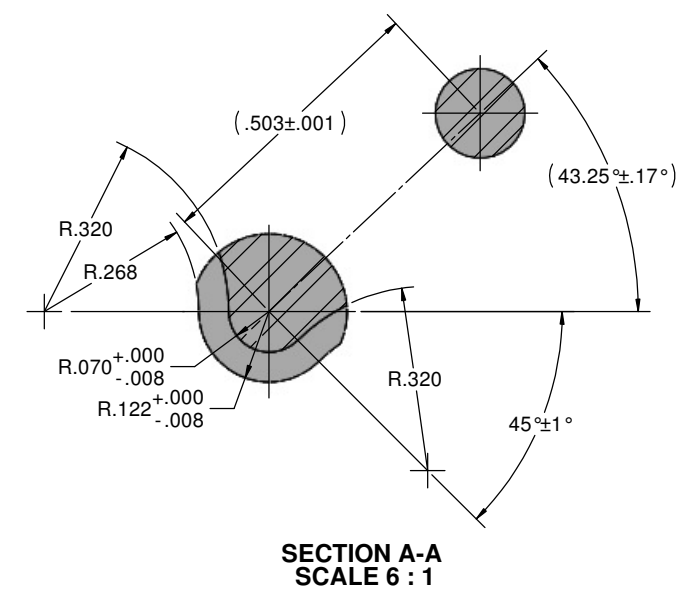
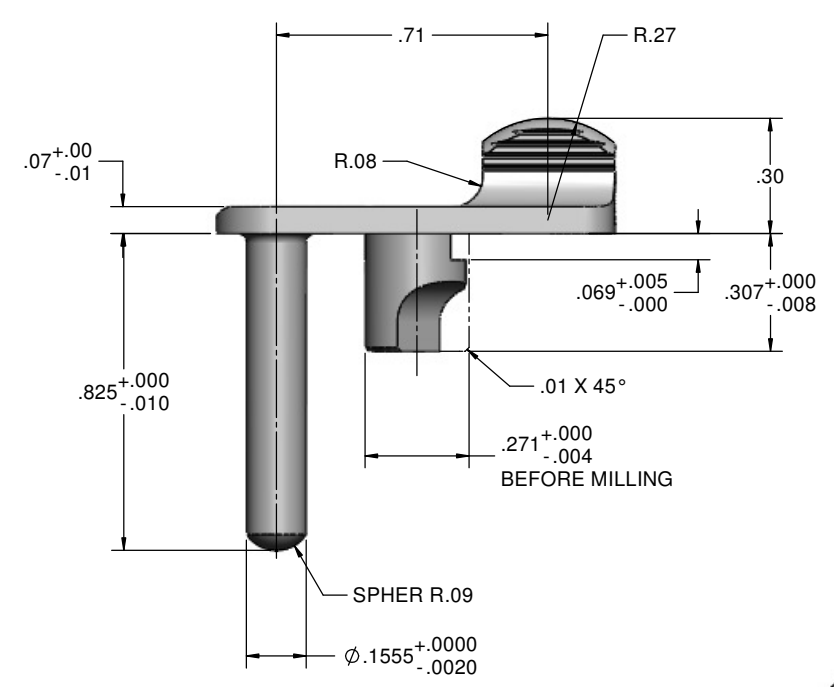
NOTES:
 1. MATERIAL:
 WROUGHT: STEEL, 4140, ASTM A108,
 AUSTENITIC GRAIN SIZE 6 OR FINER.
 CASTING: STEEL, IC 4140, ASTM A732.



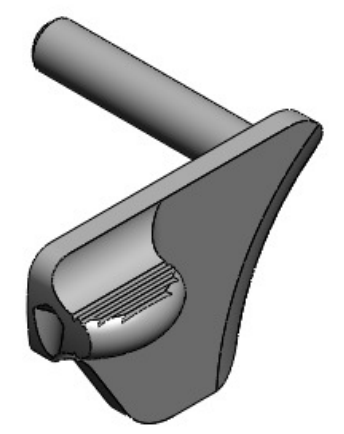
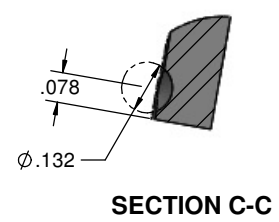
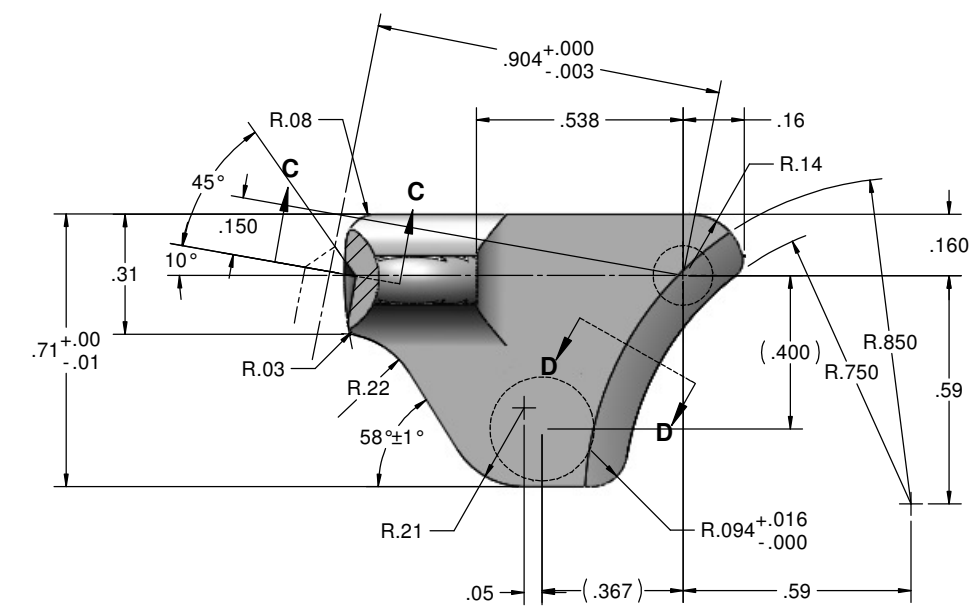
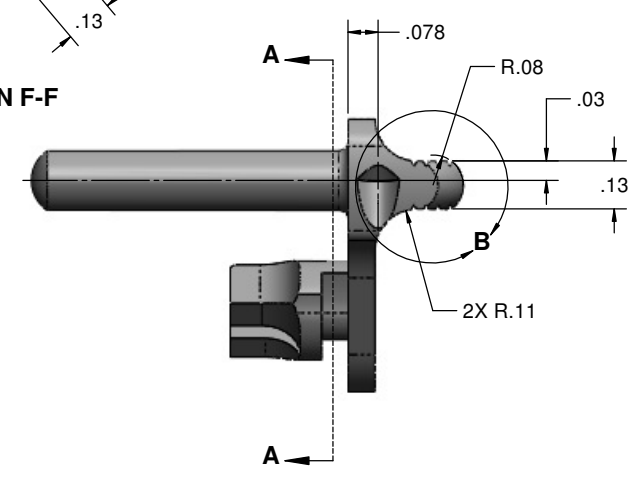
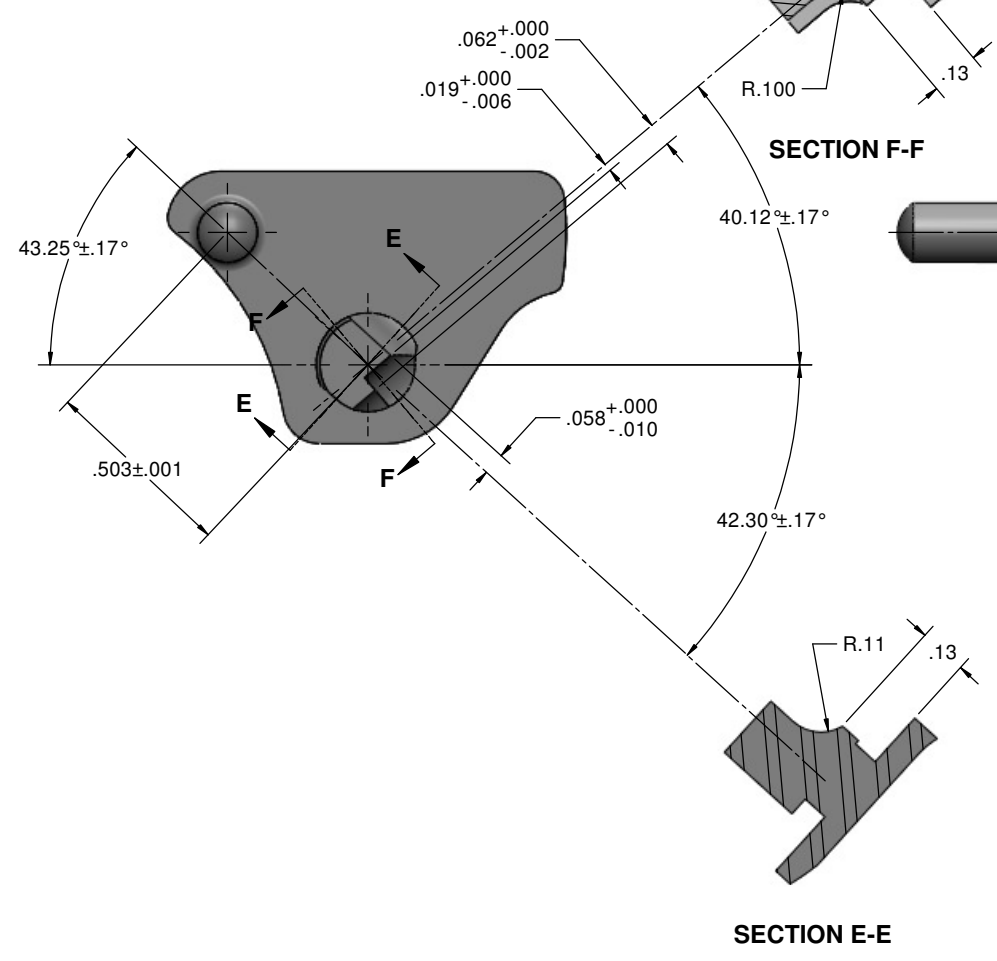
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DIMENSIONS: PER DECIMAL PLACE X = ±.05, XX = ±.02, XXX = ±.01, XXXX = ±.005 ANGLES = ±5° MACHINED FINISH = 32-125 μm REMOVE ALL BURRS AND SHARP EDGES. (D) MAX. INTERPRET DRAWING IAW ANSI Y14.5-1994.	MATERIAL: SEE NOTE 1 HEAT TREAT: RH C 43.5 - 50	PROJECT: M1911-A1 NAME: _____ DATE: _____	SIZE: D DWG/PART NO.: 5503839	SCALE: 4:1 WEIGHT: 0.04 LBS	REV: A SHEET 1 OF 1
QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING	APPROVED BY: _____	DRAWN BY: _____	DATE: _____	SCALE: 4:1 WEIGHT: 0.04 LBS	SHEET 1 OF 1

DATE PLOTTED: 5/23/2012

REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD



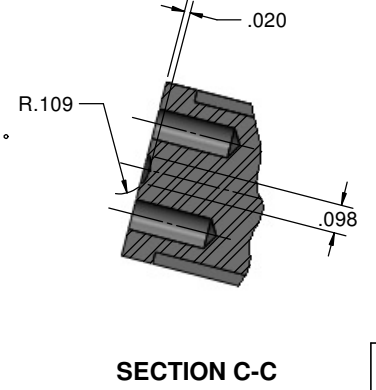
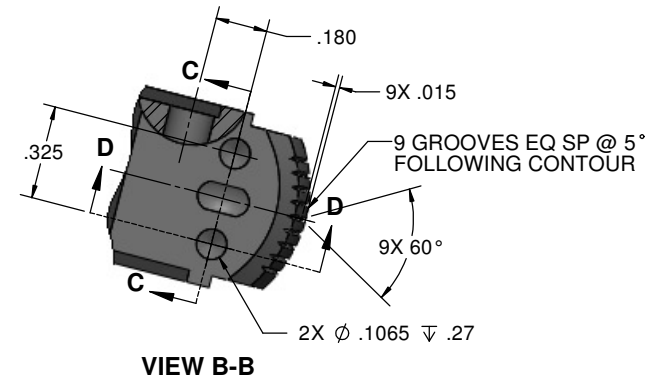
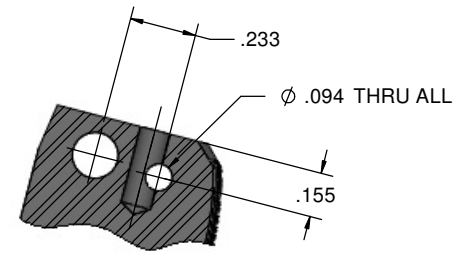
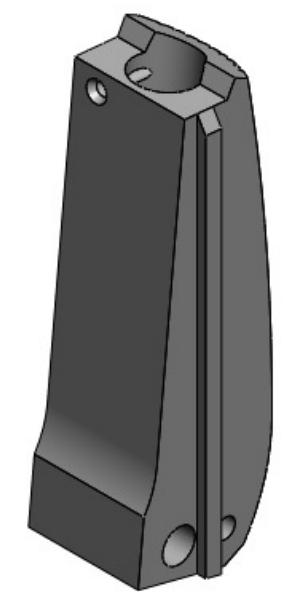
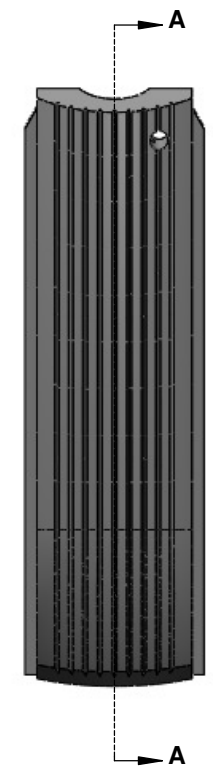
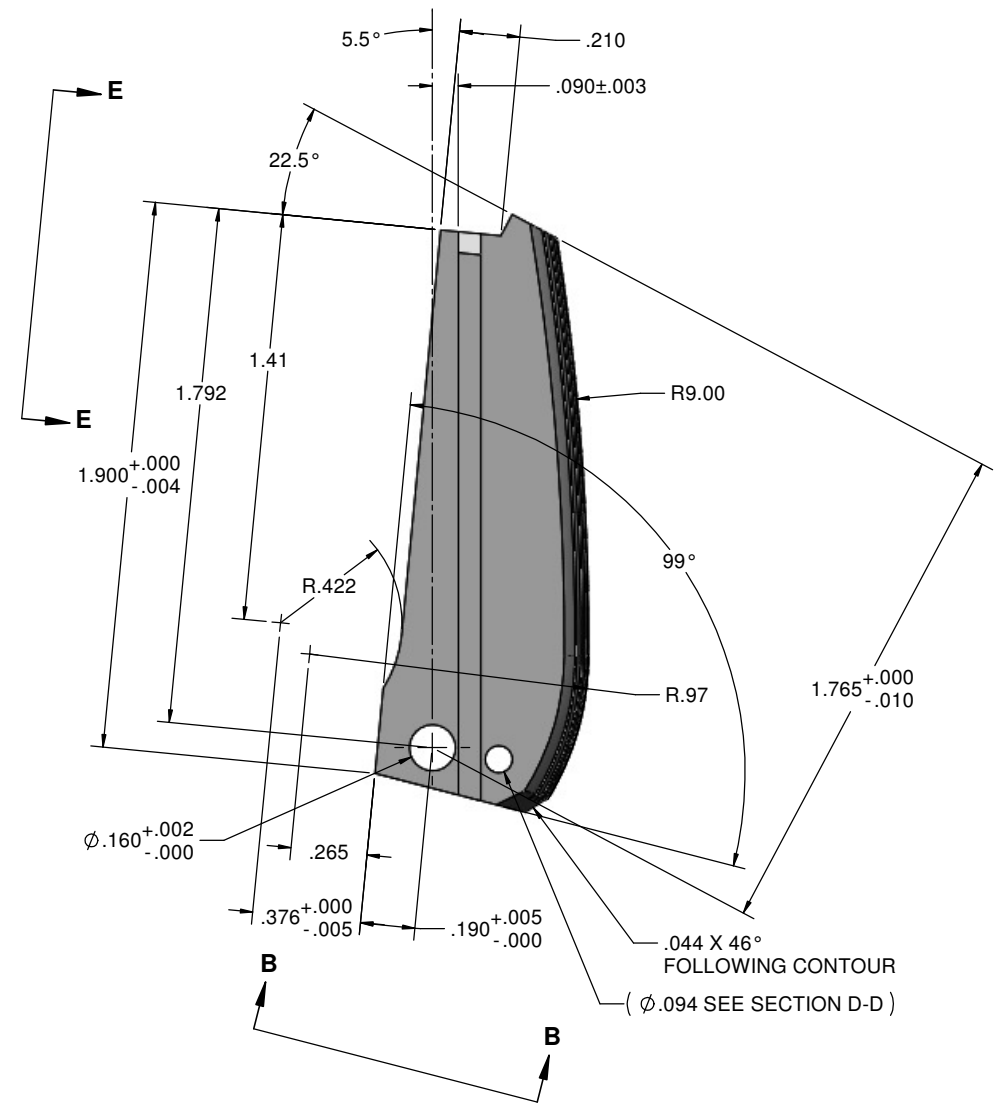
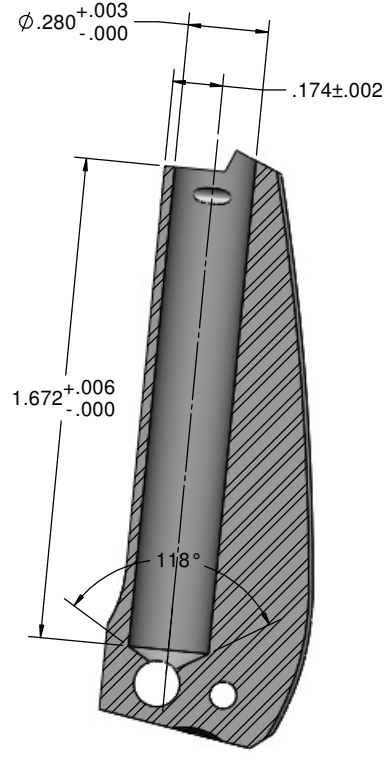
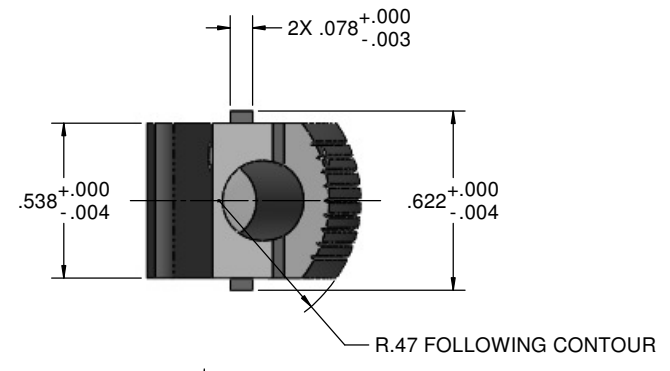
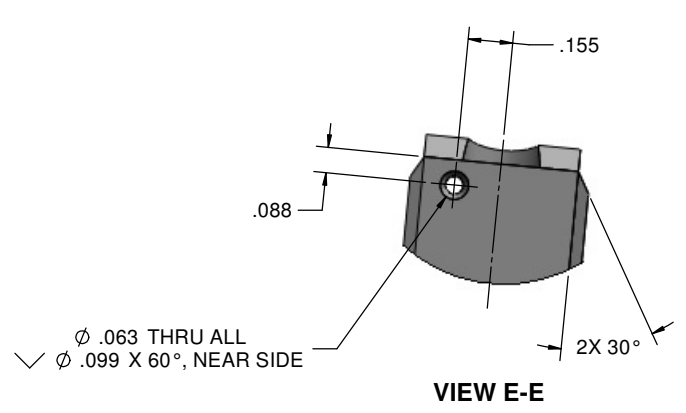
NOTES:
 1. MATERIAL:
 WROUGHT: STEEL, 4140, ASTM A108;
 AUSTENITIC GRAIN SIZE 6 OR FINER.
 CASTING: STEEL, IC 4140, ASTM A732.



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		MATERIAL: SEE NOTE 1 HEAT TREAT: RH C 43.5-50 FINISH: MIL-STD-171 PARA 5.3.1.2	PROJECT: M1911-A1 REDUX NAME: _____ DATE: _____ DRAWN BY: _____ APPROVED BY: _____
QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING	SCALE: 4:1 WEIGHT: 0.02 LBS	SIZE: D DWG/PART NO.: 5503840	SHEET 1 OF 1

DATE PLOTTED: 5/23/2012

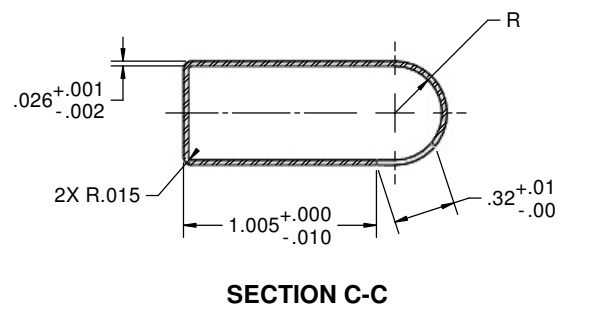
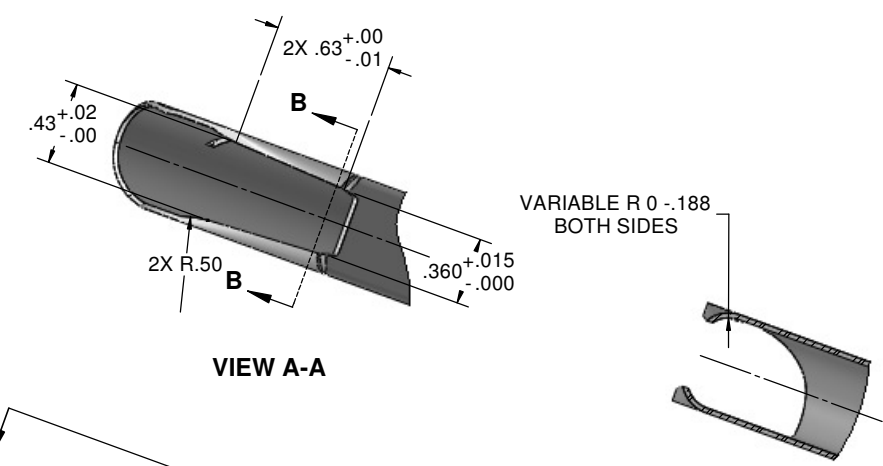
REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD



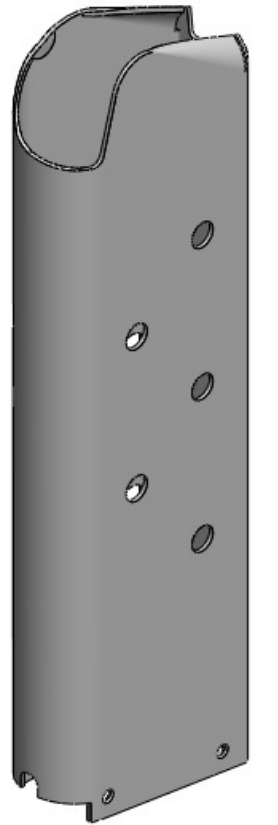
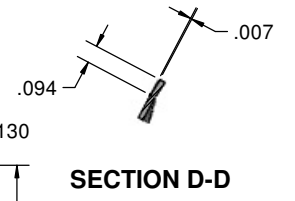
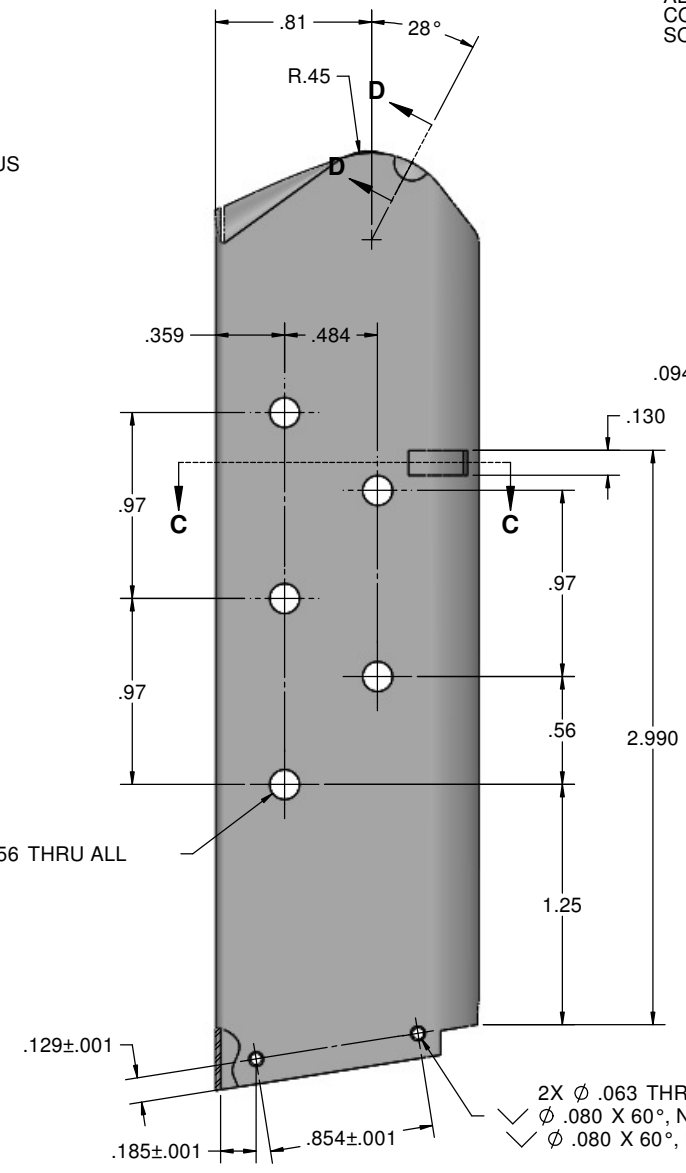
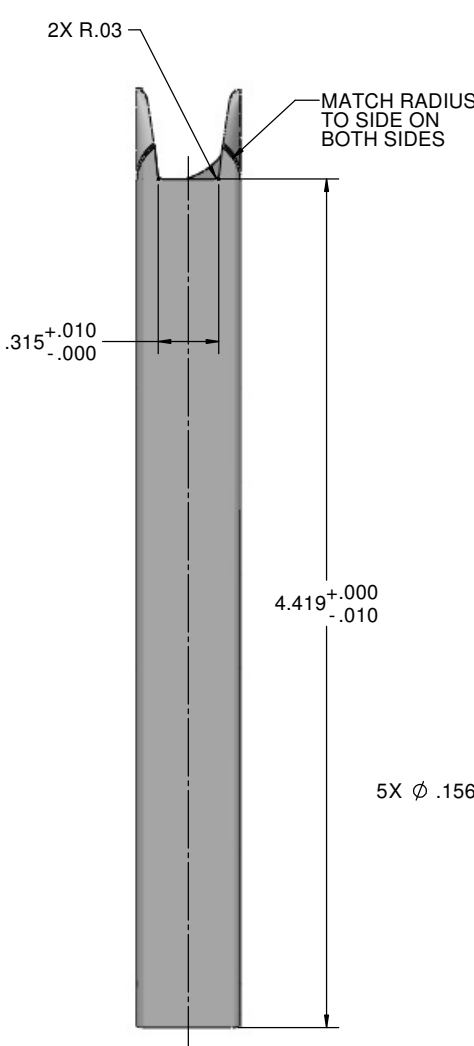
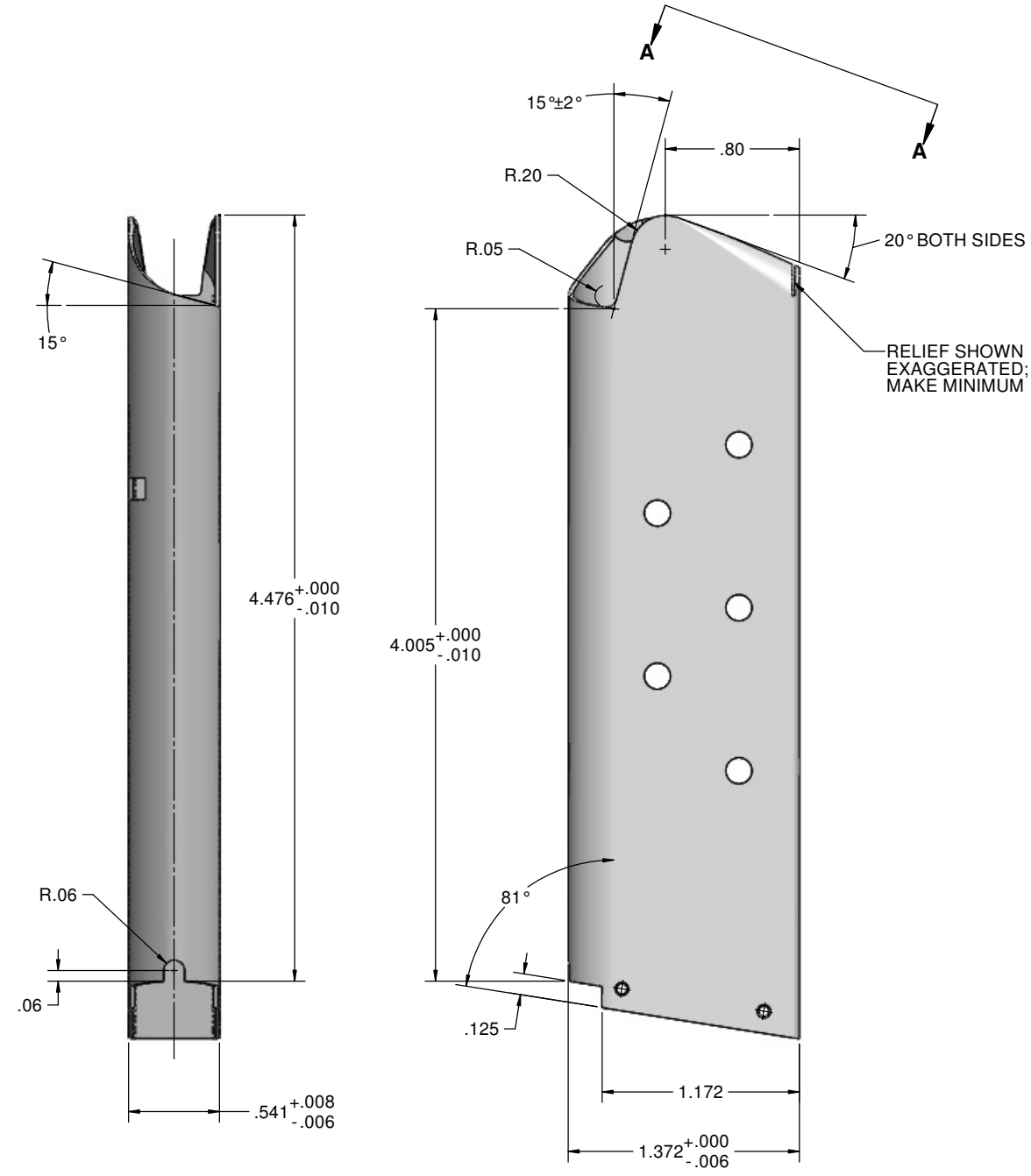
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DIMENSIONS ARE IN INCHES TOLERANCES: PER DECIMAL PLACE X = ±.05, XX = ±.02, XXX = ±.015, XXXX = ±.005 ANGLES = ±5° MACHINED FINISH = 32-75 μIN REMOVE ALL BURRS AND SHARP EDGES. (D) MAX. INTERPRET DRAWING IAW ANSI Y14.5-1994.	MATERIAL: STEEL 1018 OR 1117 ASTM A108 HEAT TREAT:	THIRD ANGLE PROJECTION	PROJECT: M1911-A1 REDUX	SIZE: D DWG/PART NO.: 5503841	REV:
QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING	DRAWN BY:	APPROVED BY:	NAME:	DATE:	SCALE: 3:1 WEIGHT: 0.02 LBS SHEET 1 OF 1

DATE PLOTTED: 5/23/2012

REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD



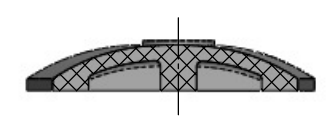
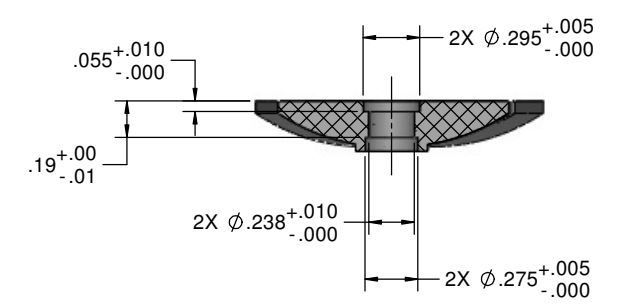
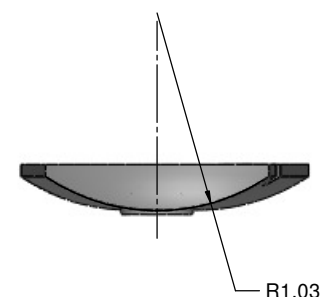
NOTES:
 1. THE 3D MODELING OF THIS COMPONENT IS AS ACCURATE AS THE CAD SOFTWARE WILL REASONABLY ALLOW. WHILE THE DIMENSIONS ARE BELIEVED TO BE CORRECT, THE ACTUAL PART MAY VARY VISIBLY SOMEWHAT FROM THAT SHOWN.



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		PROJECT: M1911-A1 REDUX	SIZE: DWG/PART NO.
QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING	UNLESS OTHERWISE SPECIFIED (UOS): DIMENSIONS ARE IN INCHES TOLERANCES: PER DECIMAL PLACE: X = ±.05, XX = ±.02, XXX = ±.015, XXXX = ±.005 ANGLES = ±5° MACHINED FINISH = ±.0125 μIN REMOVE ALL BURRS AND SHARP EDGES. (D) MAX INTERPRET DRAWING IAW ANS Y14.3-1994.	MATERIAL: TUBE, STEEL IAW ASTM A519 HEAT TREAT: FINISH: ELECTROLESS NICKEL PLATE	DRAWN BY: R Benson DATE: 09/05/2010 APPROVED BY:
SCALE: 2:1	WEIGHT: 0.11 LBS	SHEET 1 OF 1	PART NO. 5508695

DATE PLOTTED: 5/23/2012

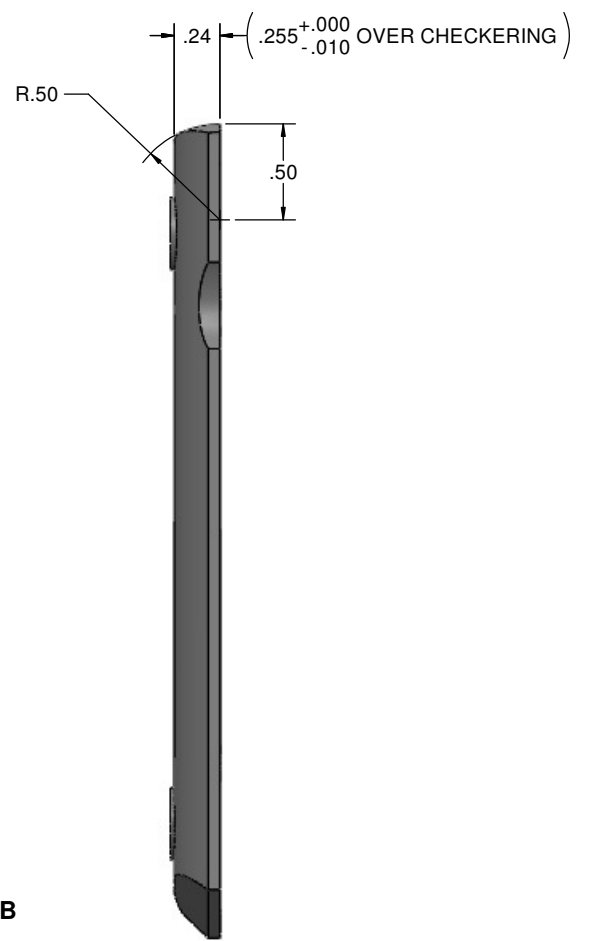
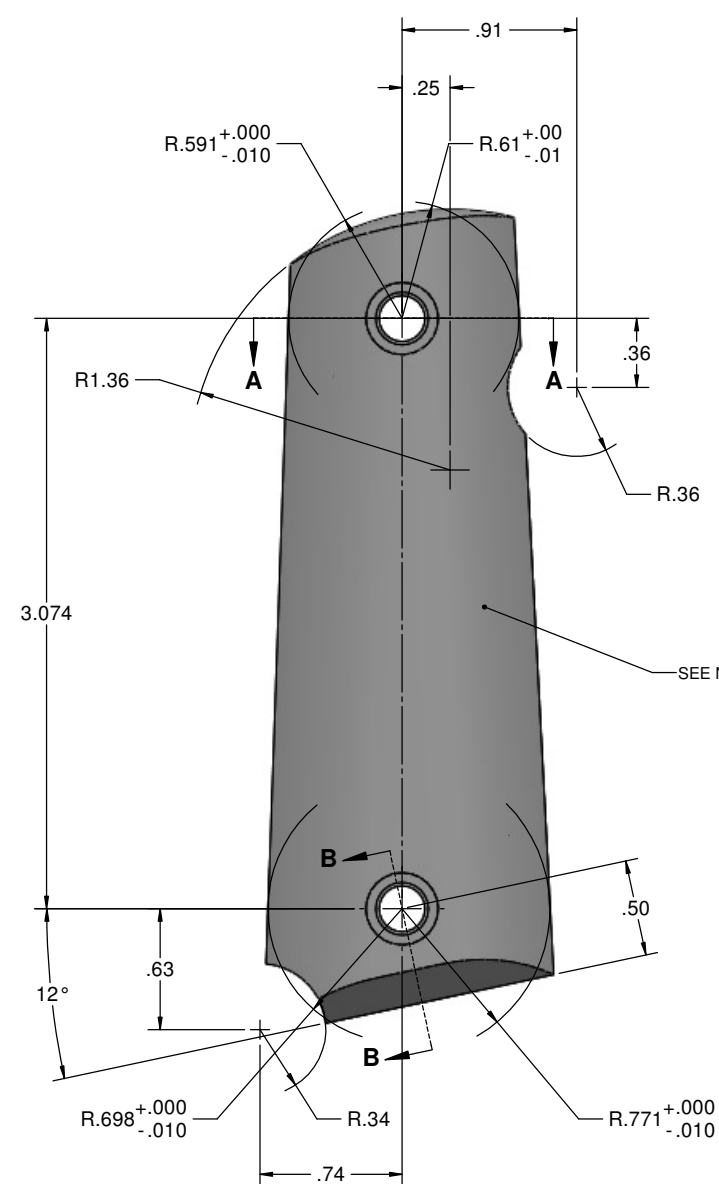
REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD



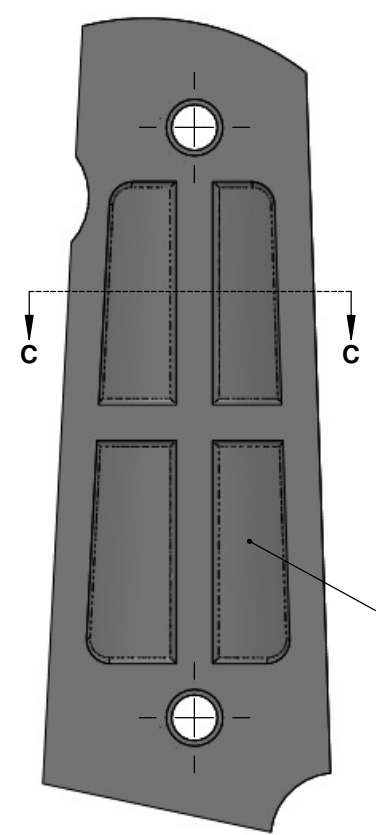
SECTION C-C

SECTION A-A

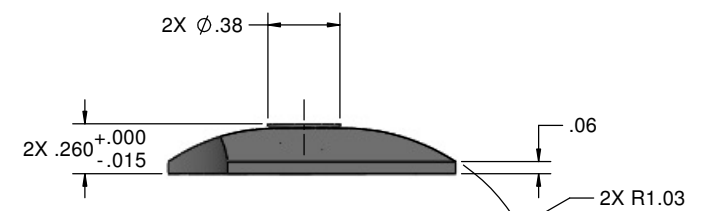
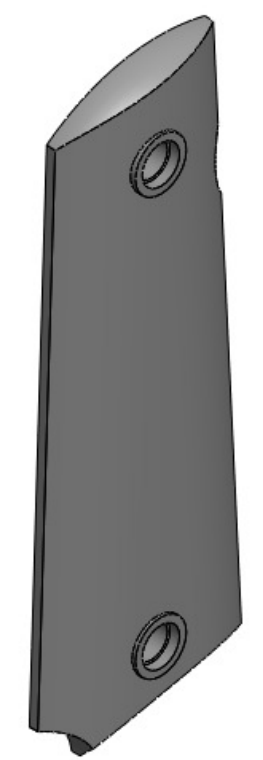
- NOTES: (UNLESS OTHERWISE SPECIFIED)
1. RECESSES SHOWN ARE NONFUNCTIONAL, AND ARE PERMITTED WITHIN REASONABLE LIMITS FOR STABILITY OF THE MOLDED PRODUCT.
 2. MATERIAL: MOLDING PLASTIC IAW ASTM D5948, PHENOLIC, TYPE CFI-20. COLOR: NO. 20045, 20059 OR 20062 OF TABLE II, FED STD NO. 595; SEMI-GLOSS BROWN.
 3. CHECKERING IS 20° DIAGONAL DIAMOND, 90° GROOVES, .06 CENTER TO CENTER ON THE DIAGONAL.



SECTION B-B



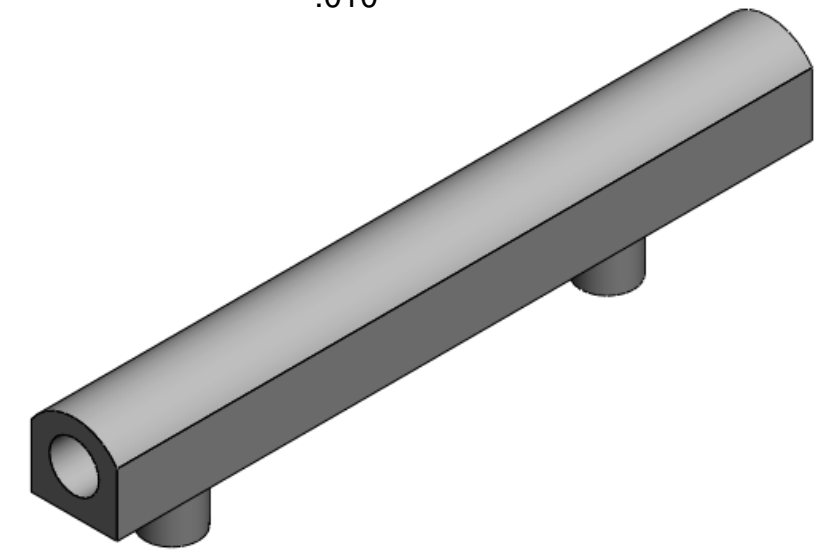
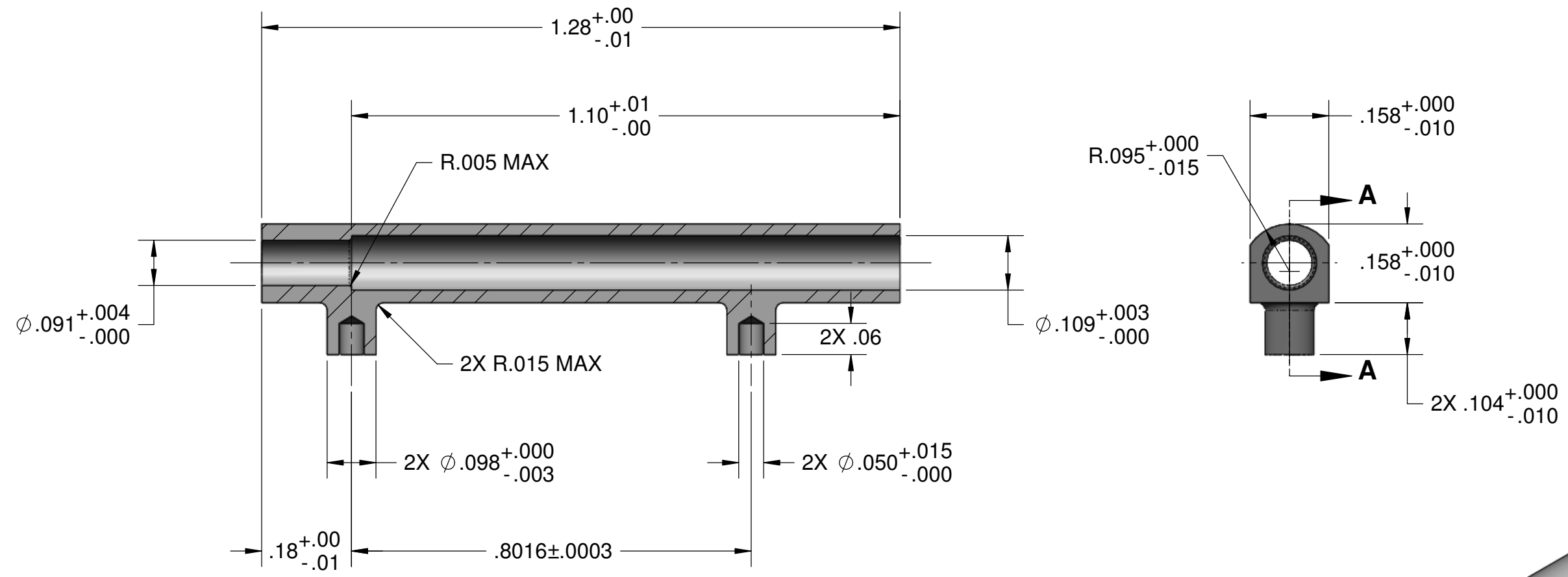
SEE NOTE 1



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UNLESS OTHERWISE SPECIFIED (UOS): DIMENSIONS ARE IN INCHES. TOLERANCES: PER DECIMAL PLACE: X = ±.05, XX = ±.02, XXX = ±.015, XXXX = ±.005. ANGLES = ±5° MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES. (D) MAX. INTERPRET DRAWING IAW ANSI Y14.3-1994.	MATERIAL: SEE NOTE 2 HEAT TREAT:	THIRD ANGLE PROJECTION	PROJECT: M1911-A1 NAME: DATE:	SIZE: D DWG/PART NO.: 5564062	REV:
QTY REQ'D PER NEXT ASSY = 1 DO NOT SCALE DRAWING	FINISH:	DRAWN BY:	APPROVED BY:	SCALE: 2:1 WEIGHT: 0.02 LBS	SHEET 1 OF 1

DATE PLOTTED: 5/23/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD

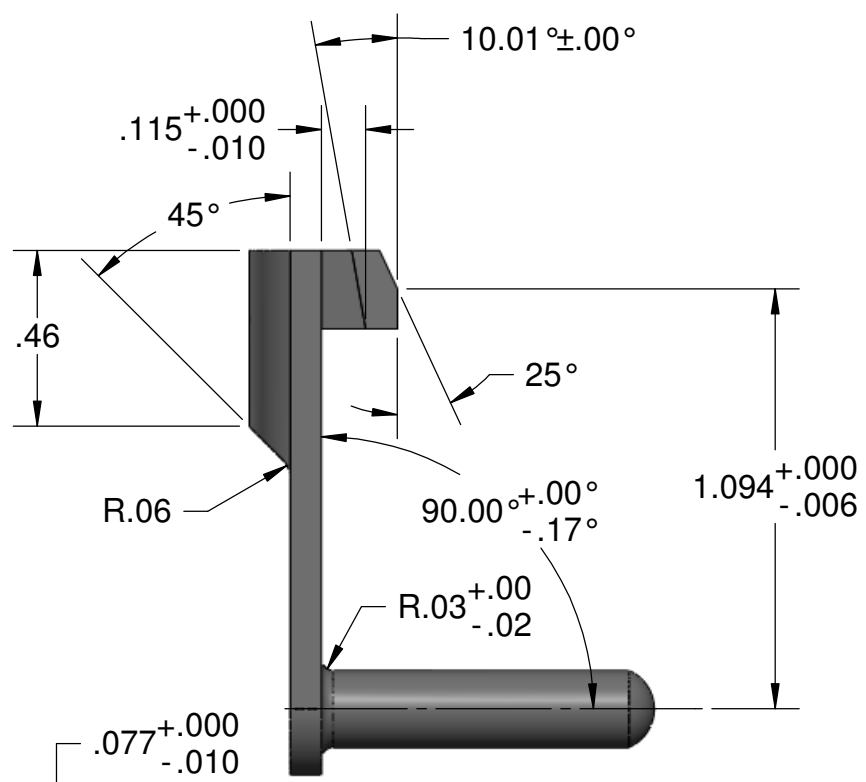
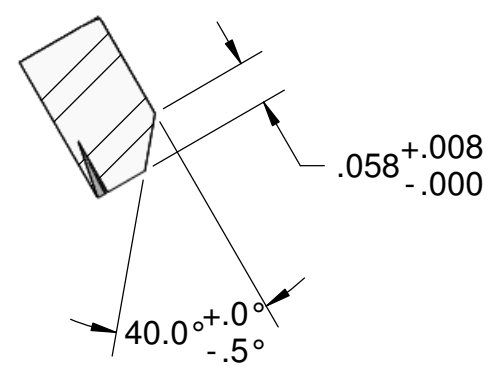
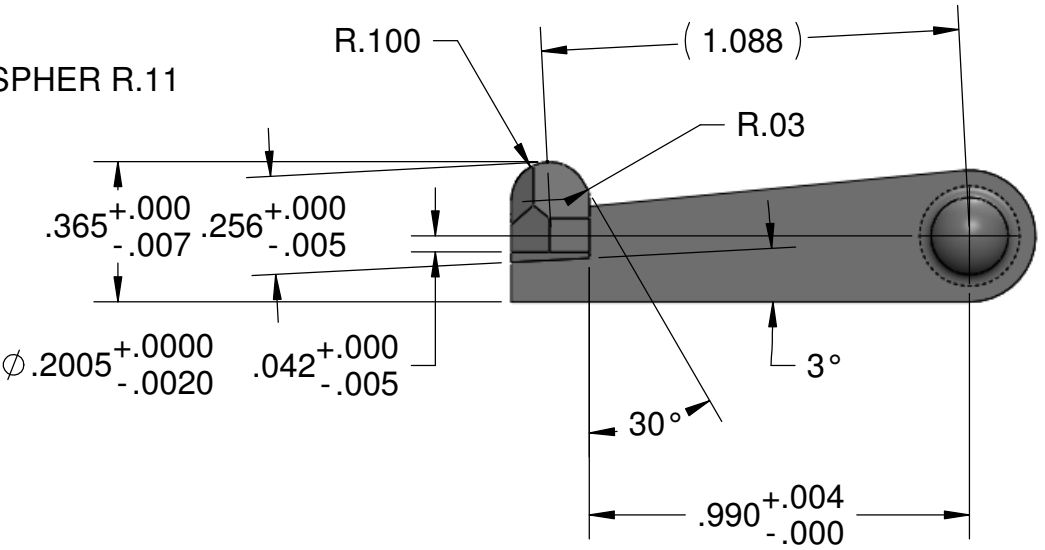
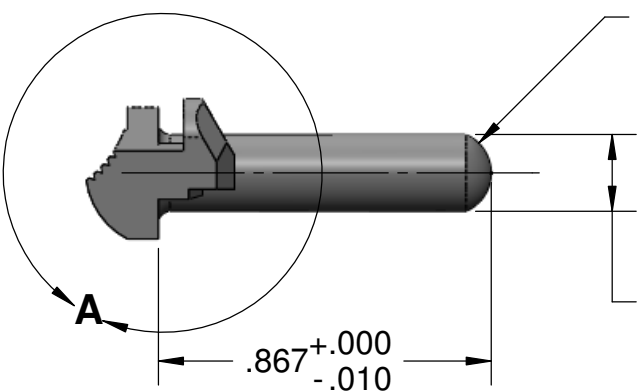
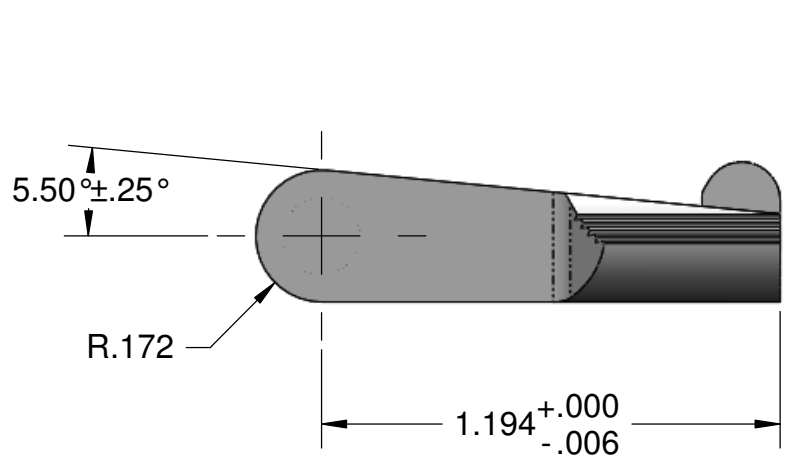


SECTION A-A

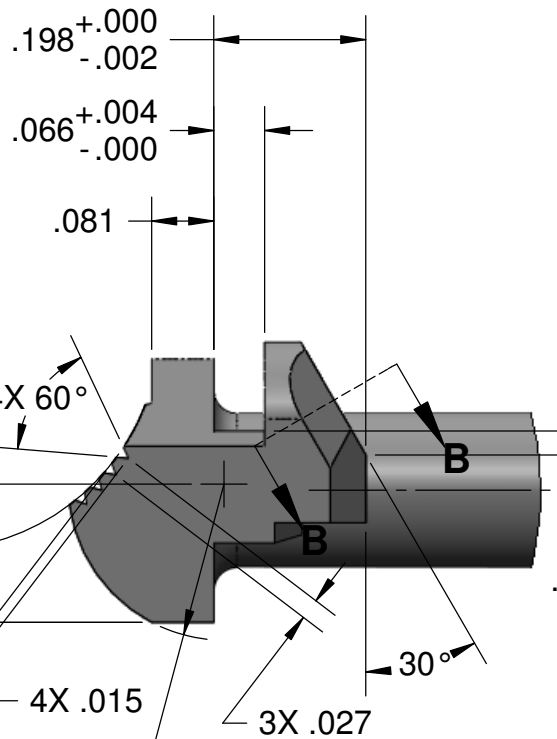
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	<p>UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, XX = ±.02, XXX = ±.005, XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994</p>		<p>MATERIAL: STEEL 1018 ASTM A108</p>	<p>THIRD ANGLE</p>	<p>PROJ: M1911-A1 REDUX</p>	<p>SIZE: B</p>	<p>DWG/PART NO.: 6008594</p>	<p>REV</p>
	<p>QTY REQD PER NEXT ASSY = 1</p>	<p>HEAT TREAT: PARA 5.3.1.2</p>	<p>DRAWN BY: R Benson</p>	<p>DATE: 09/06/2010</p>	<p>SCALE: 4:1</p>	<p>WEIGHT: 0.00 LBS</p>	<p>SHEET 1 OF 1</p>	
	<p>DO NOT SCALE DRAWING</p>	<p>FINISH: MIL-STD-171</p>	<p>APPROVED BY:</p>					

DATE PLOTTED: 5/23/2012

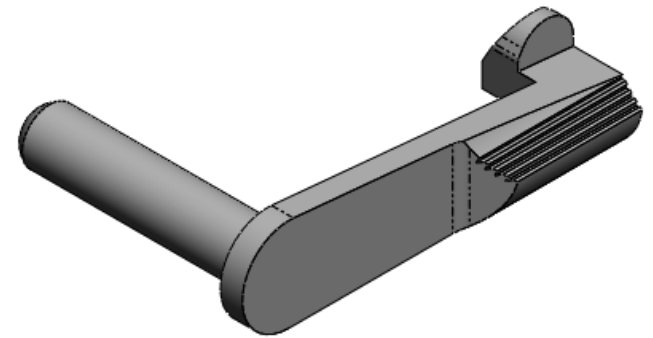
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



**SECTION B-B
SCALE 4 : 1**



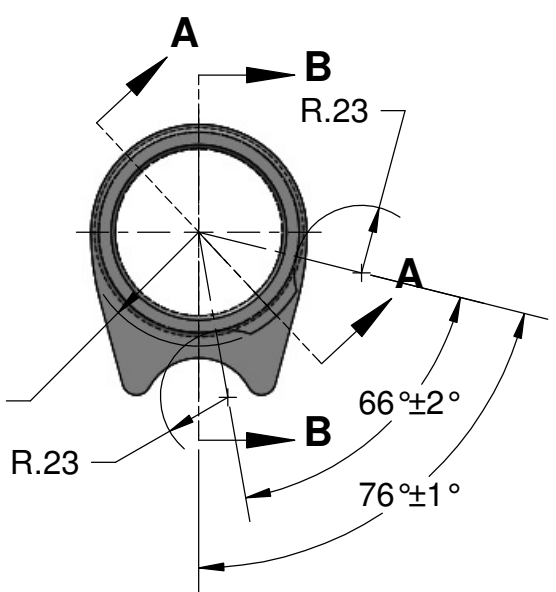
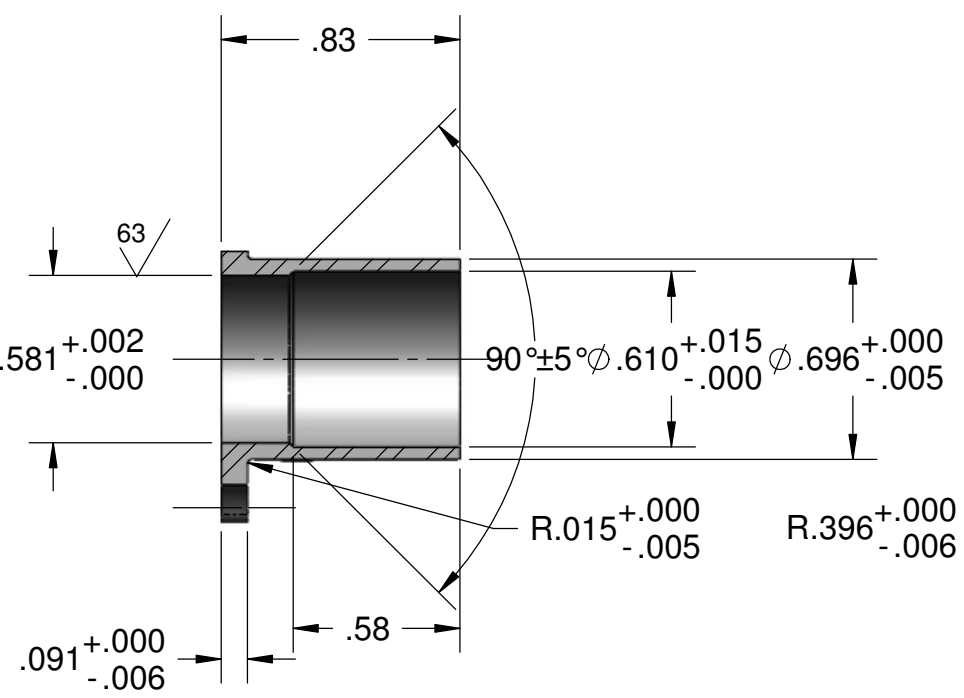
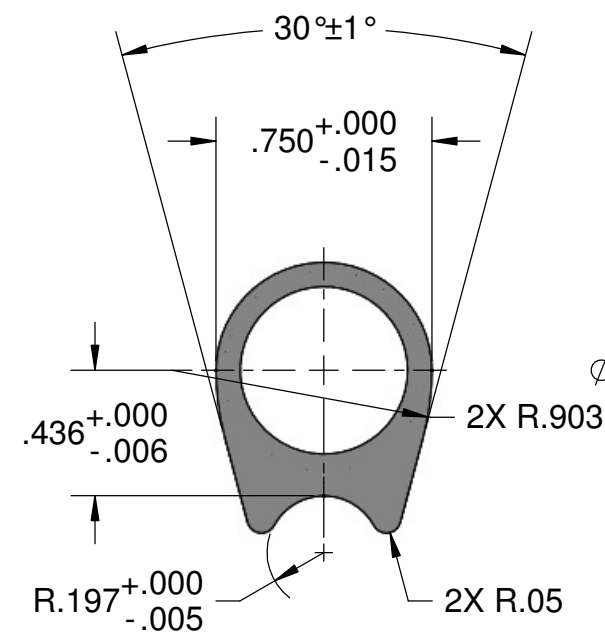
**DETAIL A
SCALE 4 : 1**



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	<p>UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS PER DECIMAL PLACE: X = ±.05, XX = ±.02, XXX = ±.005, XXXX = ±.0005 ANGLES = ±.5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994</p>		<p>MATERIAL: STEEL 4140 IAW ASTM A322 HEAT TREAT: RH C 43.5-50</p>		<p>THIRD ANGLE </p>		<p>PROJ: M1911-A1</p>	
	<p>QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING</p>		<p>FINISH: MIL-STD-171 PARA 5.3.1.2</p>		<p>DRAWN BY: R Benson APPROVED BY:</p>		<p>NAME: R Benson DATE: 09/06/2010</p>	
						<p>SIZE: B</p>	<p>DWG/PART NO.: 6008595</p>	<p>REV:</p>
						<p>SCALE: 2:1</p>	<p>WEIGHT: 0.02 LBS</p>	<p>SHEET 1 OF 1</p>

DATE PLOTTED: 5/23/2012

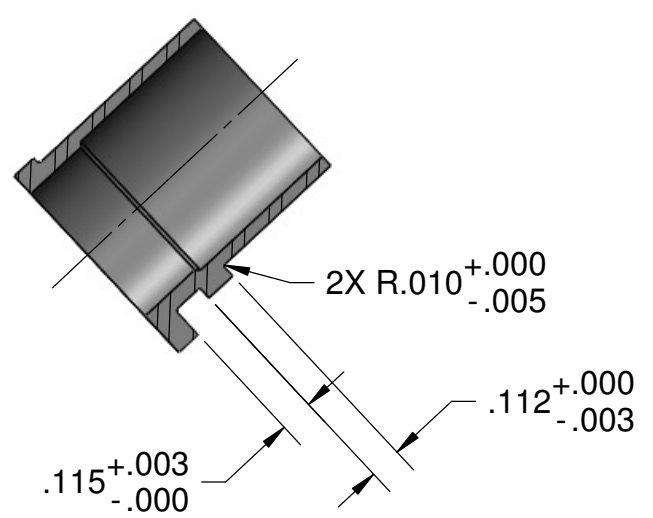
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



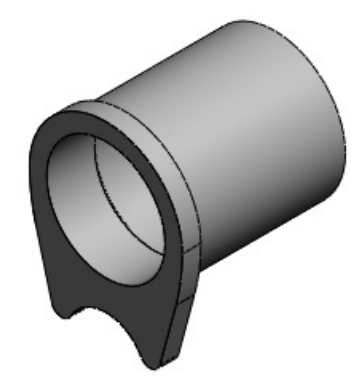
NOTES:

- MATERIAL:
WROUGHT: STEEL, 4140, ASTM A108;
 AUSTENITIC GRAIN SIZE 6 OR FINER.
CAST: STEEL, IC-4140, ASTM A732.

SECTION B-B

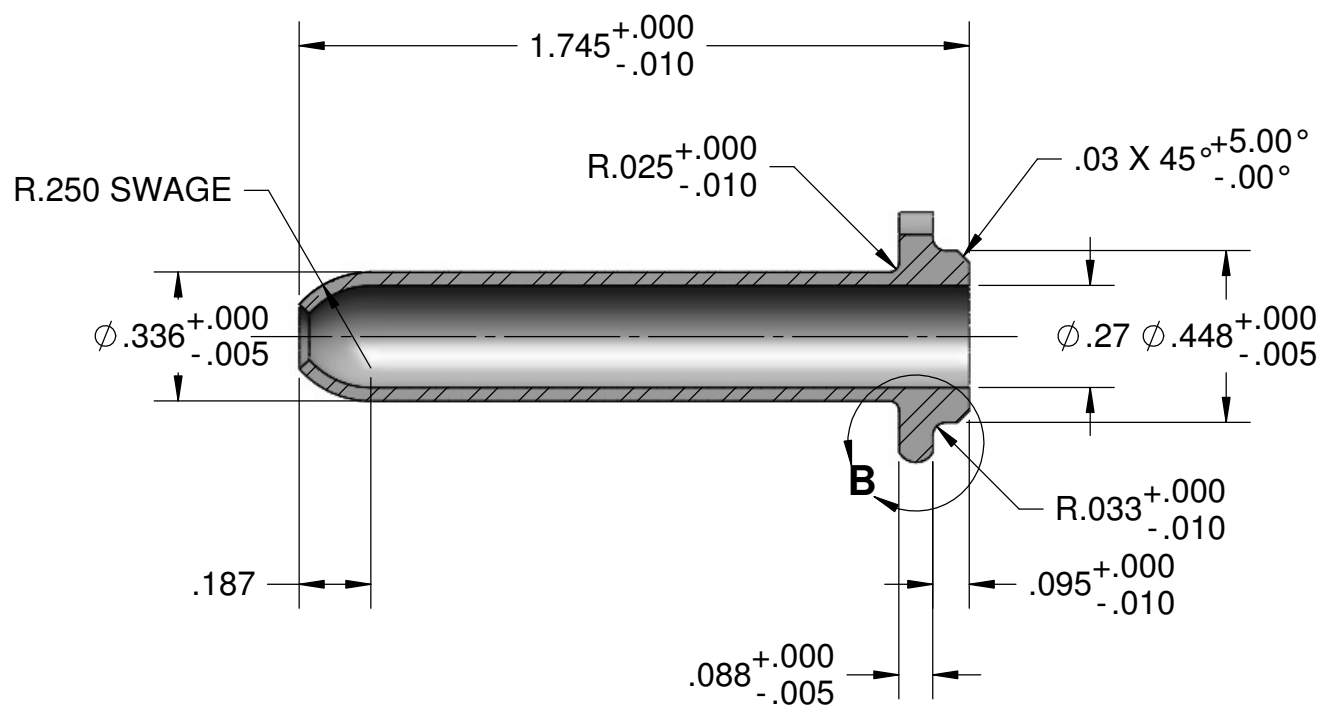


SECTION A-A

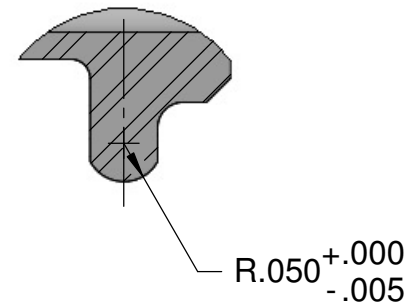
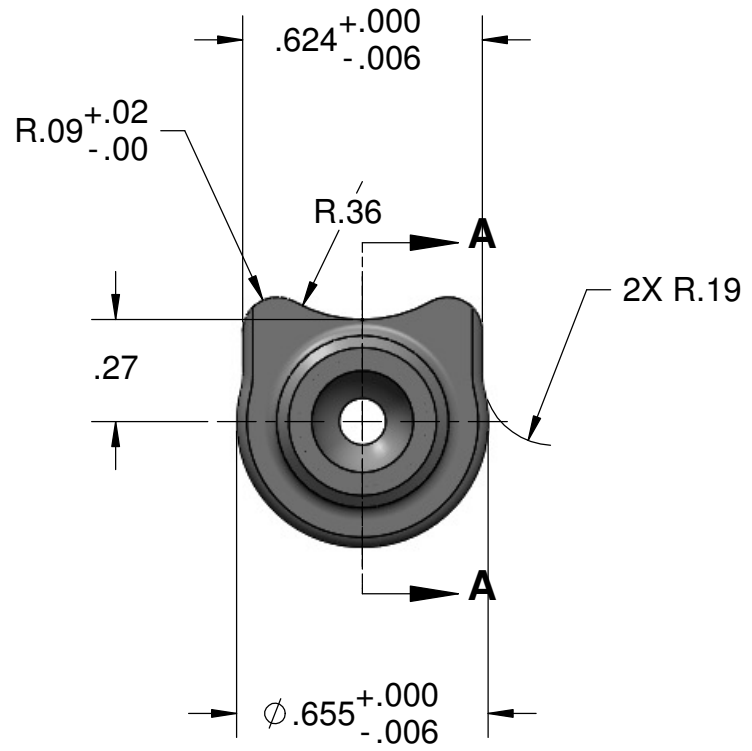


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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, XX = ±.02, XXX = ±.005, XXXX = ±.0005 ANGLES = ±.5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: SEE NOTE 1 HEAT TREAT: RH C 43.5-50 FINISH: MIL-STD-171 PARA 5.3.1.2		THIRD ANGLE 		PROJ: M1911-A1 REDUX
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		DRAWN BY: R Benson DATE: 09/07/2010		APPROVED BY:		SIZE: B DWG/PART NO.: 6008596
	SCALE: 3:2 WEIGHT: 0.03 LBS SHEET 1 OF 1		REV:		DATE PLOTTED: 5/23/2012		SHEET 1 OF 1

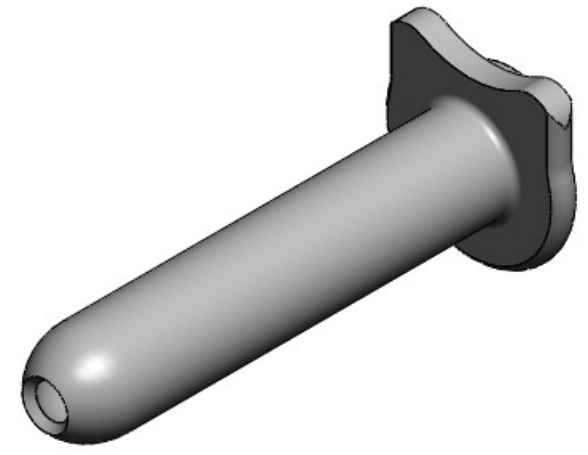
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



SECTION A-A



**DETAIL B
SCALE 4 : 1**

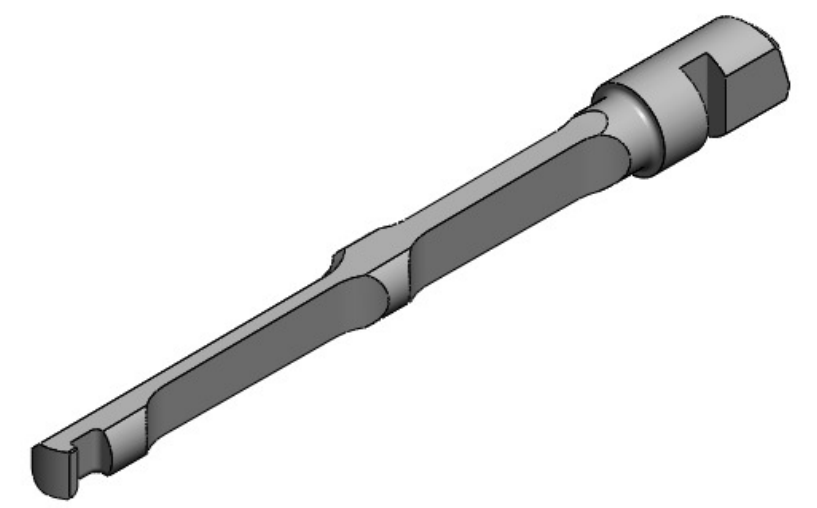
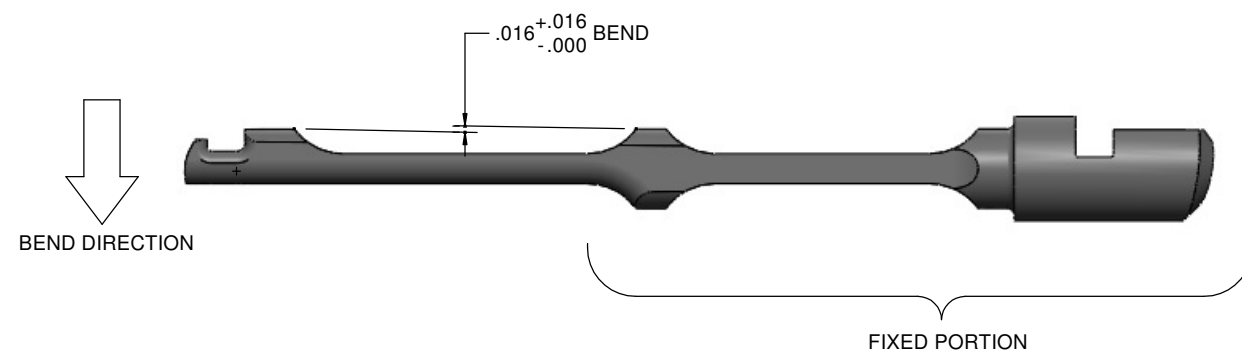
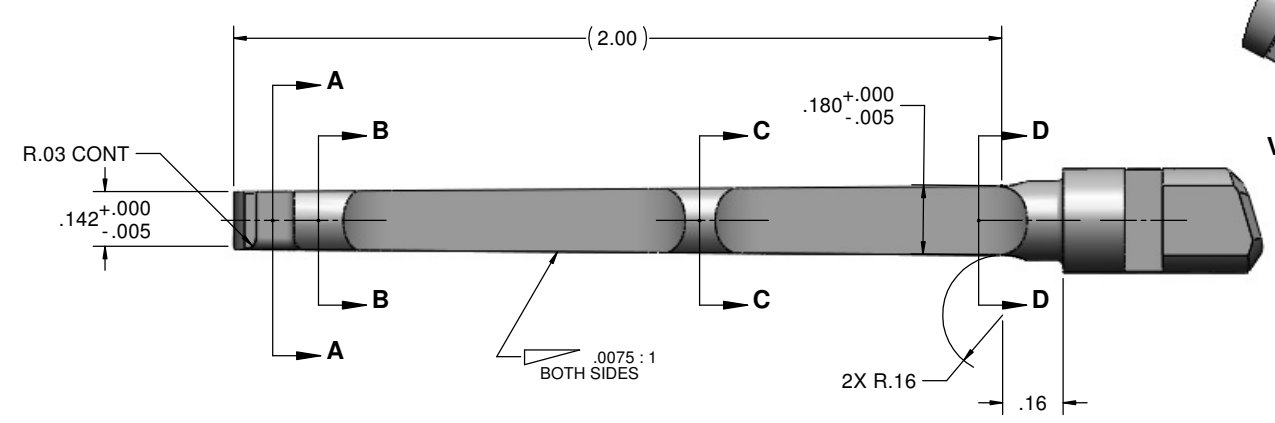
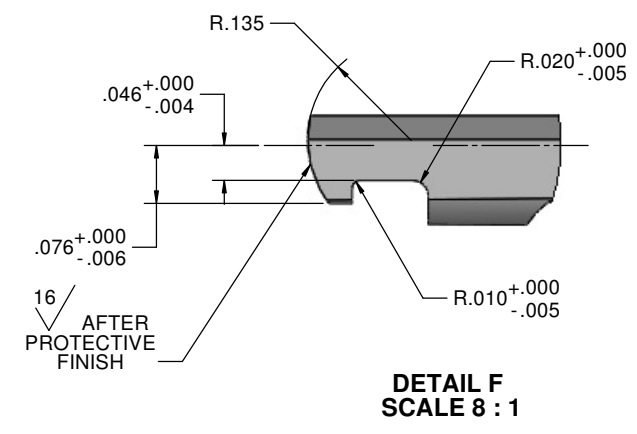
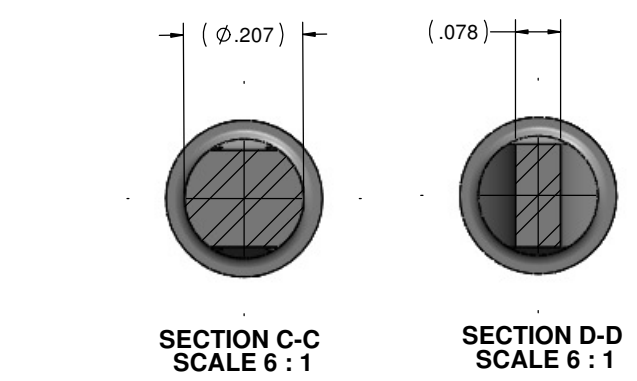
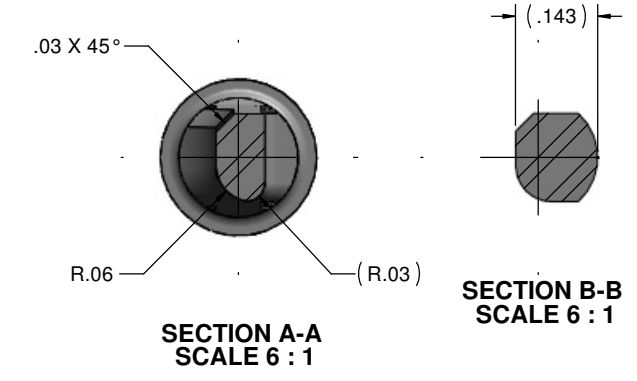
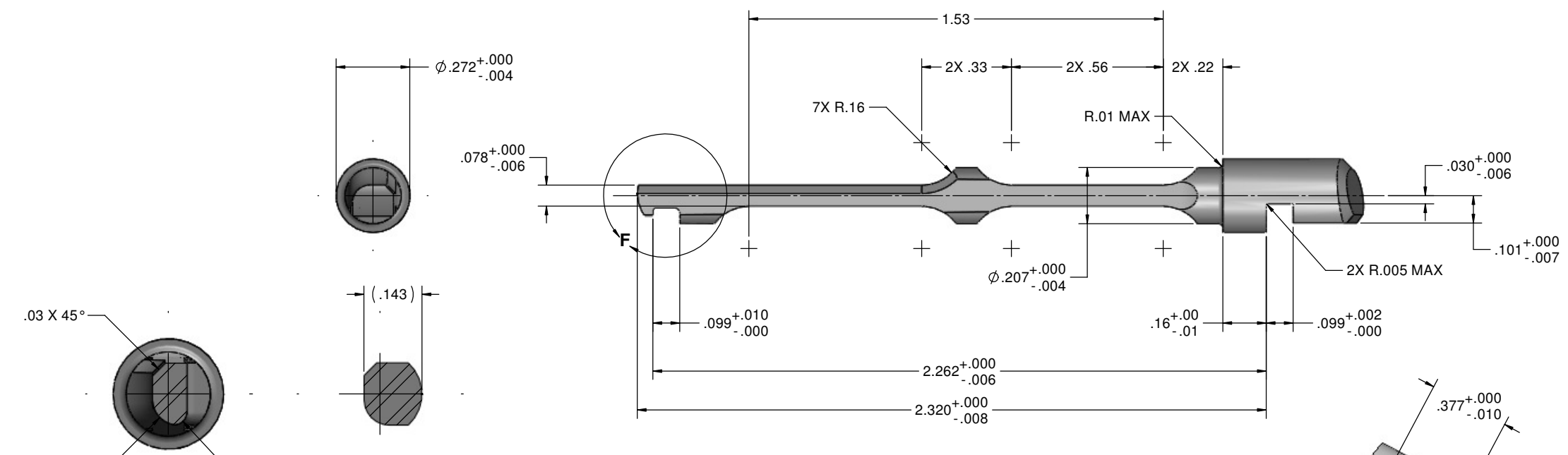


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	<p>UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, XX = ±.02, XXX = ±.005, XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994</p>		<p>MATERIAL: STEEL 1141 ASTM A311</p>	<p>THIRD ANGLE</p>	<p>PROJ: M1911-A1 REDUX</p>	<p>SIZE</p>	<p>DWG/PART NO.</p>	<p>REV</p>
	<p>QTY REQD PER NEXT ASSY = 1</p>	<p>HEAT TREAT: RH C 35-40</p>	<p>FINISH: MIL-STD-171 PARA 5.3.1.2</p>	<p>DRAWN BY: R Benson</p>	<p>DATE 09/07/2010</p>	<p>B</p>	<p>6008597</p>	
	<p>DO NOT SCALE DRAWING</p>			<p>APPROVED BY:</p>		<p>SCALE: 2:1</p>	<p>WEIGHT: 0.02 LBS</p>	<p>SHEET 1 OF 1</p>

DATE PLOTTED: 5/23/2012

REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD

NOTES:
 1. MATERIAL: STEEL, 1144, ASTM A108;
 AUSTENITIC GRAIN SIZE 7 OR FINER.



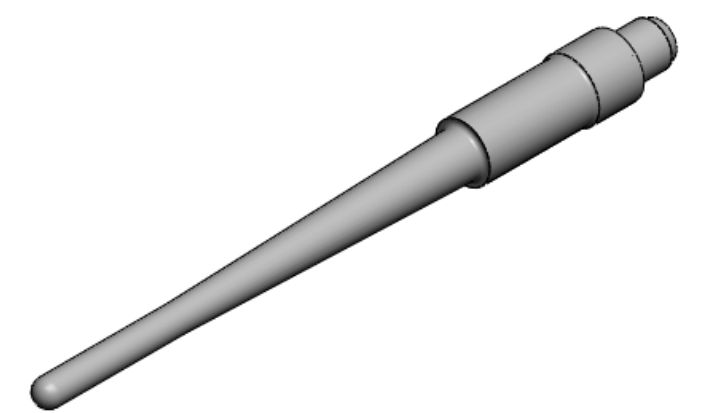
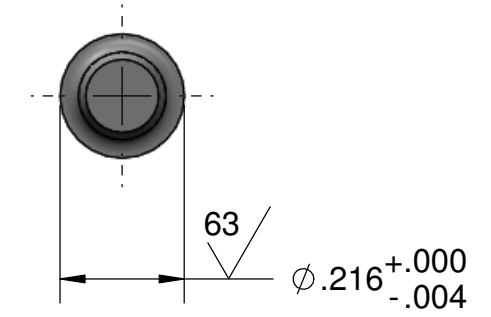
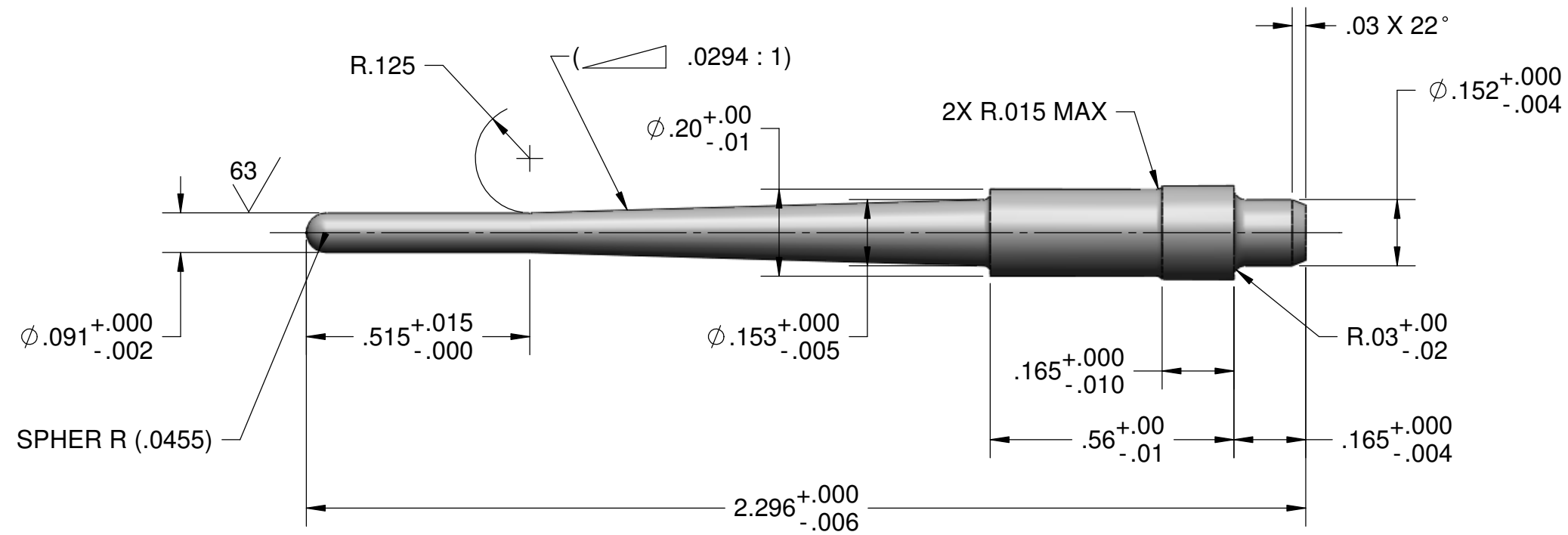
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		PROJECT: M1911-A1 REDUX	SIZE: DWG/PART NO.
QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING	MATERIAL: SEE NOTE 1 HEAT TREAT: RH C 48-52	DRAWN BY:	DATE:
UNLESS OTHERWISE SPECIFIED (UOS): DIMENSIONS ARE IN INCHES. TOLERANCES: PER DECIMAL PLACE: X = $\pm .05$, XX = $\pm .02$, XXX = $\pm .015$, XXXX = $\pm .005$, ANGLES = $\pm 5^\circ$ MACHINED FINISH = $63-125 \mu\text{in}$, REMOVE ALL BURRS AND SHARP EDGES. (D) MAX. INTERPRET DRAWING IAW ANS Y14.5-1994.	FINISH: MIL-STD-171 PARA 5.3.1.2	APPROVED BY:	SCALE: 4:1 WEIGHT: 0.02 LBS SHEET 1 OF 1

DATE PLOTTED: 5/23/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD

NOTES:

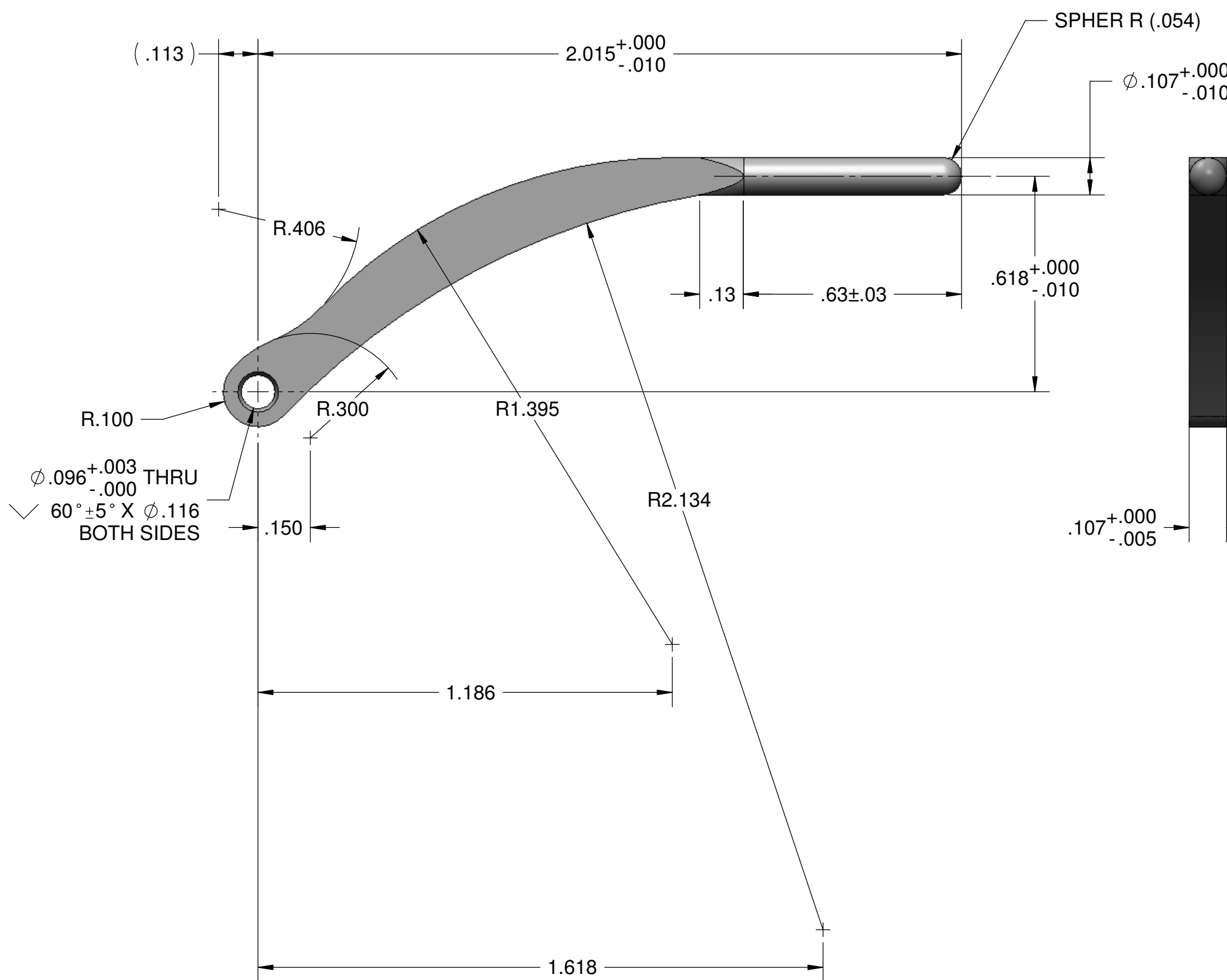
- MATERIAL: STEEL, 1144, ASTM A108; AUSTENITIC GRAIN SIZE 7 OR FINER.



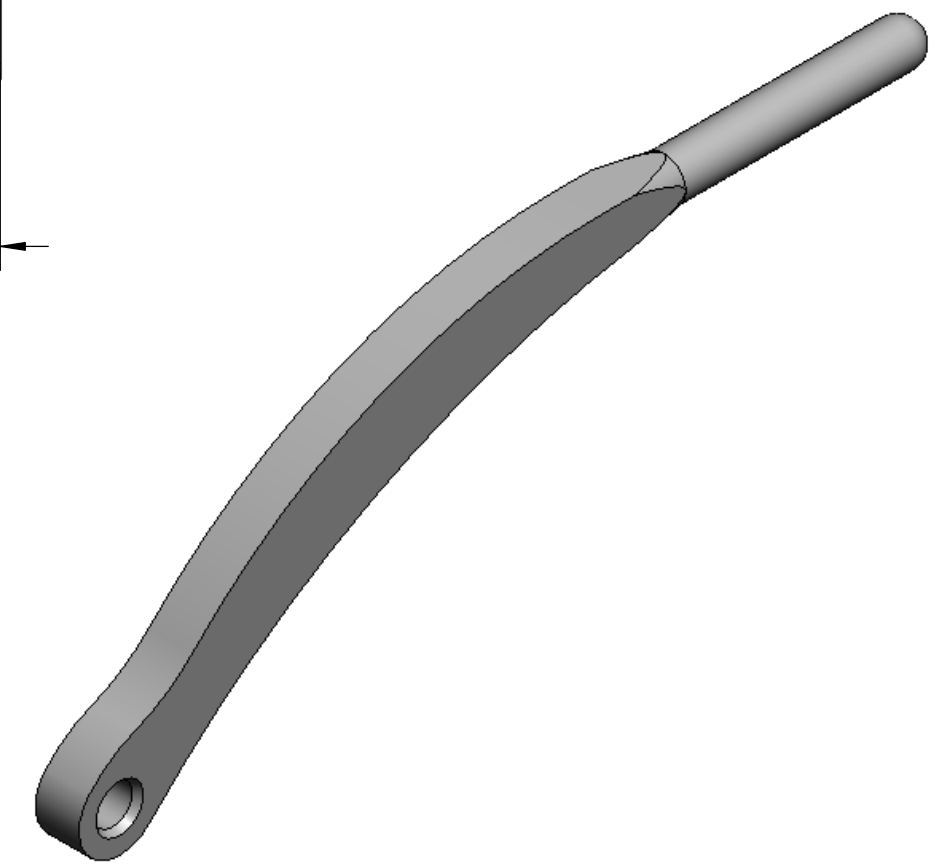
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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = $\pm .05$, XX = $\pm .02$, XXX = $\pm .005$, XXXX = $\pm .0005$ ANGLES = $\pm 5^\circ$, MACHINED FINISH = 63-125 μ IN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: SEE NOTE 1 HEAT TREAT: RH A 70.5-73.5 FINISH: MIL-STD-171 PARA 5.3.1.2		THIRD ANGLE 		PROJ: M1911-A1 REDUX
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		DRAWN BY: R Benson APPROVED BY:		DATE: 09/09/2010		SIZE: B
					DWG/PART NO.: 6008599		REV:
				SCALE: 3:1		WEIGHT: 0.01 LBS	SHEET 1 OF 1

DATE PLOTTED: 5/23/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



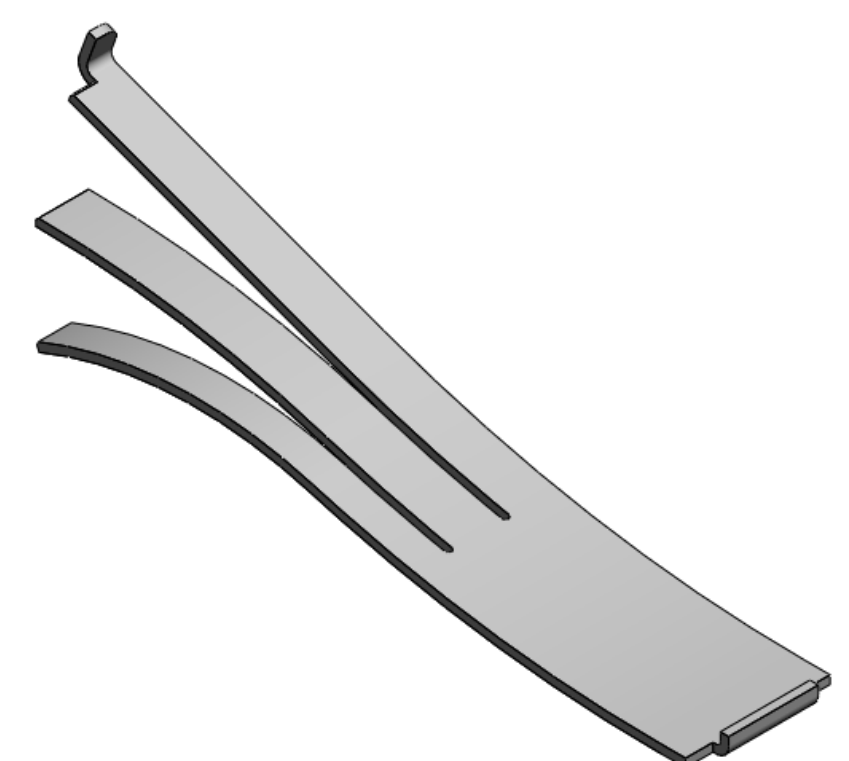
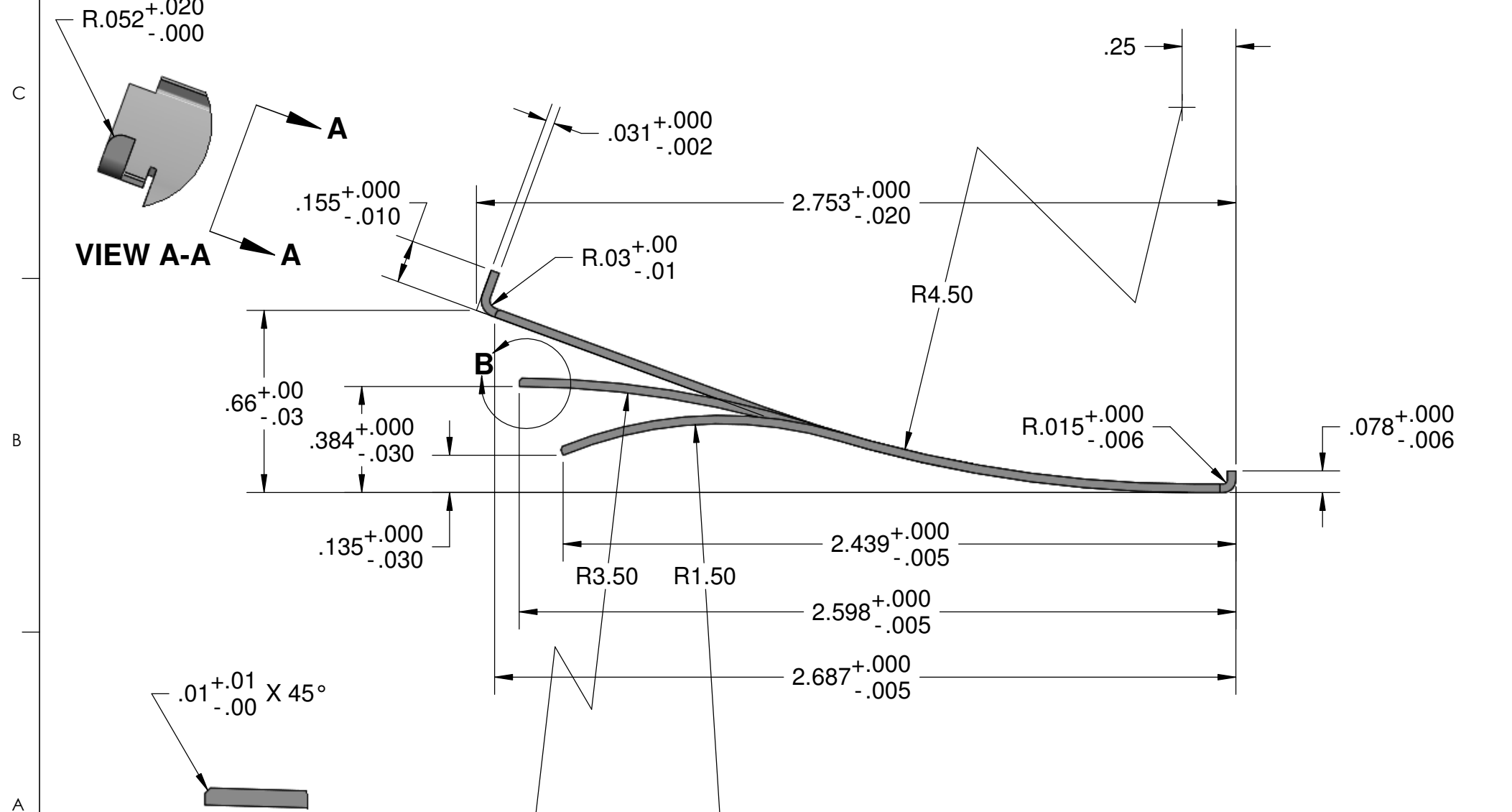
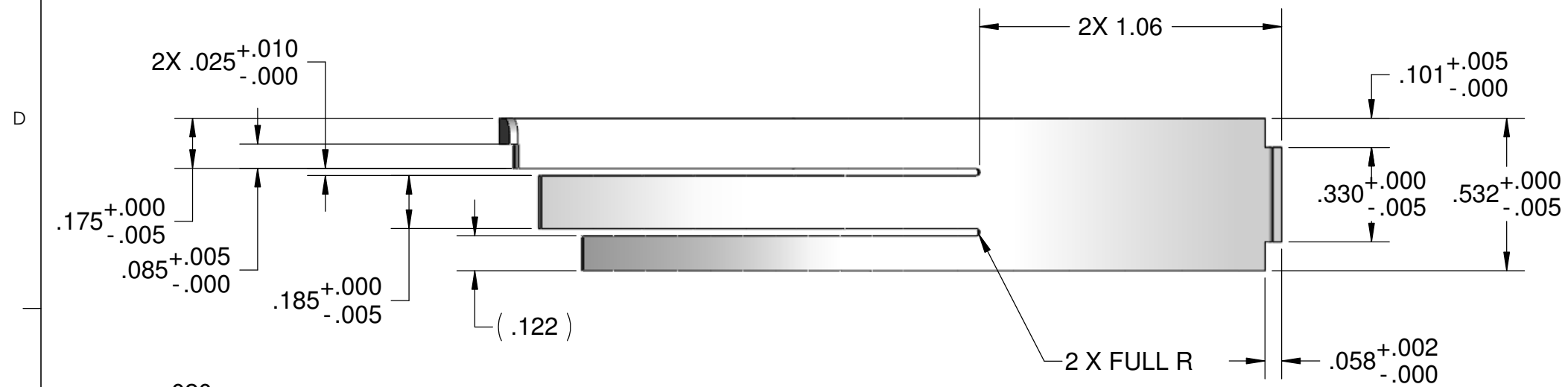
NOTES:
 1. MATERIAL: STEEL, 1144, ASTM A108;
 AUSTENITIC GRAIN SIZE 7 OF FINER.



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: SEE NOTE 1 HEAT TREAT: RH A 70.5-73.5 FINISH: MIL-STD-171 PARA 5.3.1.2		THIRD ANGLE 		PROJ: M1911-A1 REDUX
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		DRAWN BY: R Benson APPROVED BY:		DATE: 09/09/2010		SIZE: B
					DWG/PART NO.: 6008600		REV:
				SCALE: 3:1		WEIGHT: 0.01 LBS	SHEET 1 OF 1

DATE PLOTTED: 5/25/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD

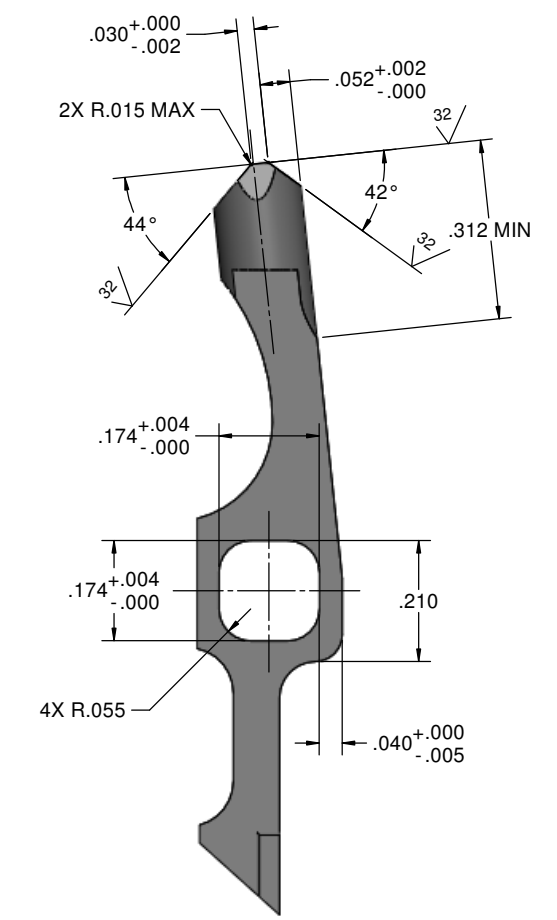
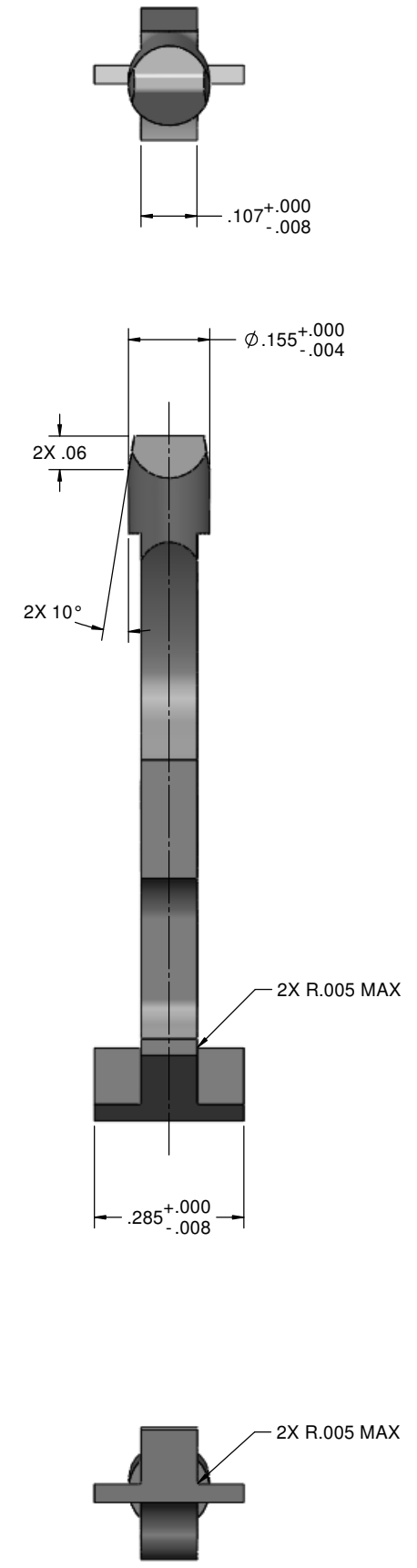
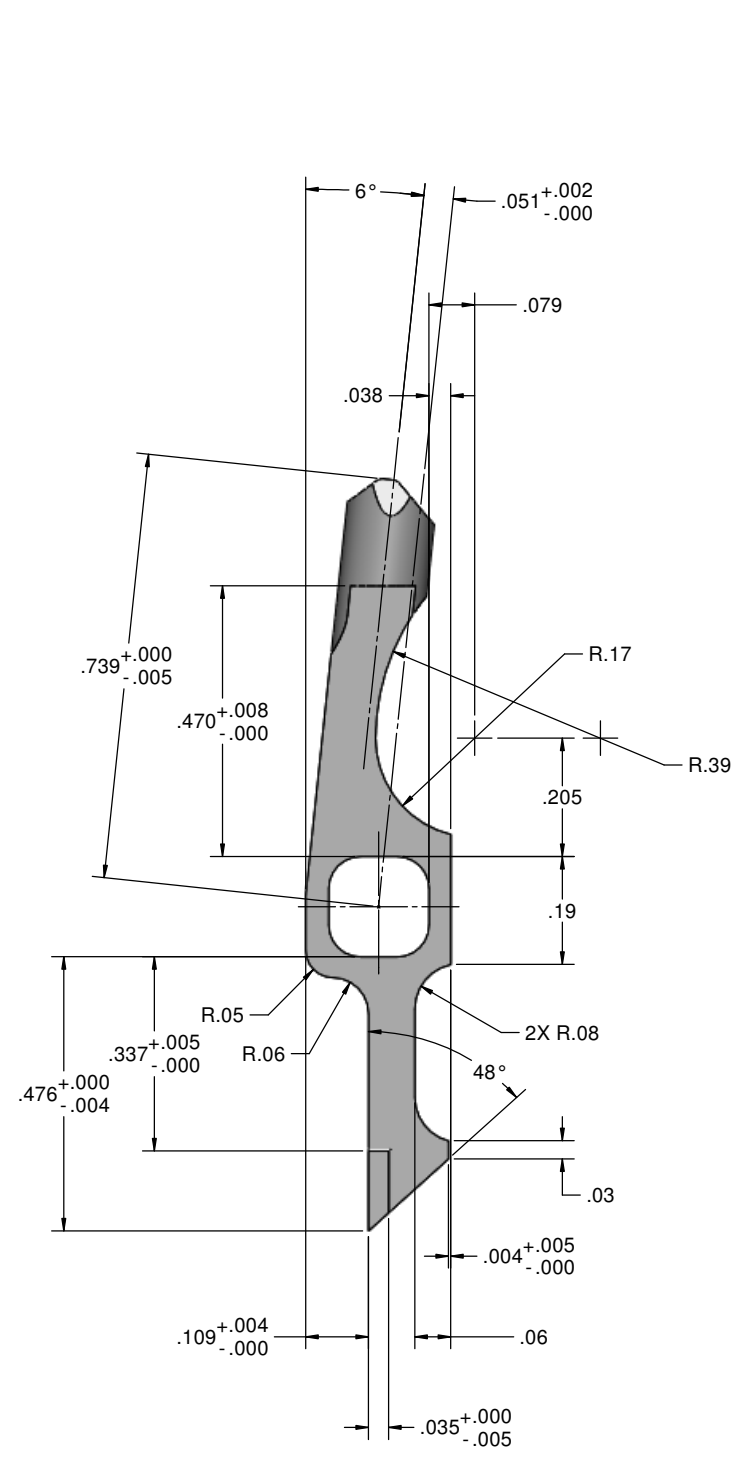


**DETAIL B
SCALE 4 : 1
3 PLACES**

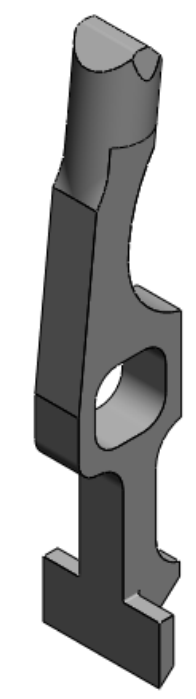
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		QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, XX = ±.02, XXX = ±.005, XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994	MATERIAL: STEEL 1090 ASTM A684 HEAT TREAT: RH A 72-75 FINISH: MIL-STD-171 PARA 5.3.1.2	THIRD ANGLE 	PROJ: M1911-A1 REDUX NAME: R Benson DATE: 09/10/2010 DRAWN BY: APPROVED BY:

DATE PLOTTED: 5/24/2012

REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD



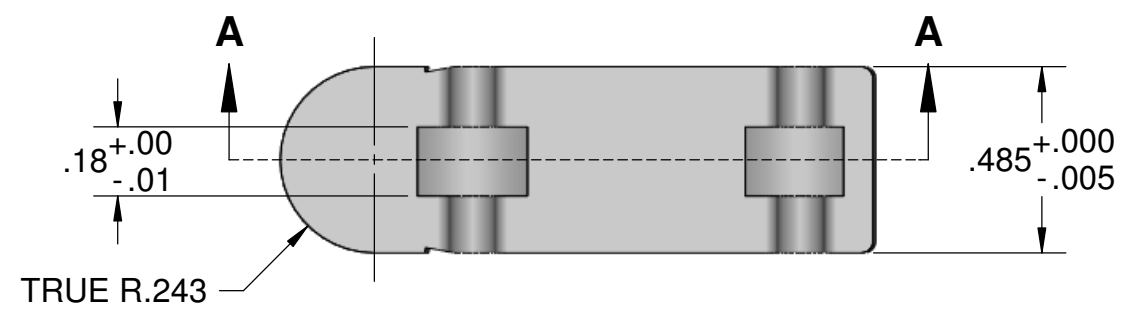
NOTES:
 1. MATERIAL: WROUGHT STEEL, 4140, ASTM A108; AUSTENITIC GRAIN SIZE 6 OR FINER. CAST: STEEL, IC4140, ASTM A732.



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		MATERIAL: SEE NOTE 1 HEAT TREAT: RH C 43.5-50 FINISH: MIL-STD-171 PARA 5.3.1.2	PROJECT: M1911-A1 REDUX NAME: _____ DATE: _____ DRAWN BY: _____ APPROVED BY: _____
QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING	UNLESS OTHERWISE SPECIFIED (UOS): DIMENSIONS ARE IN INCHES TOLERANCES: PER DECIMAL PLACE X = ±.05, XX = ±.02, XXX = ±.015, XXXX = ±.005 ANGLES = ±5° MACHINED FINISH = ±.0125 MAX REMOVE ALL BURRS AND SHARP EDGES. (D) MAX. INTERPRET DRAWING IAW ANSI Y14.5-1994.	SIZE: D DWG/PART NO.: 6008603 SCALE: 6:1 WEIGHT: 0.00 LBS	REV: _____ SHEET 1 OF 1

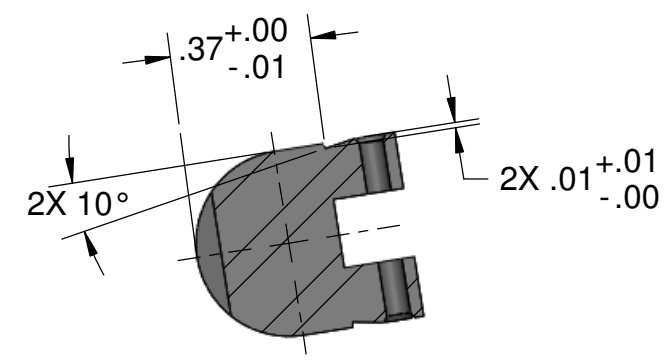
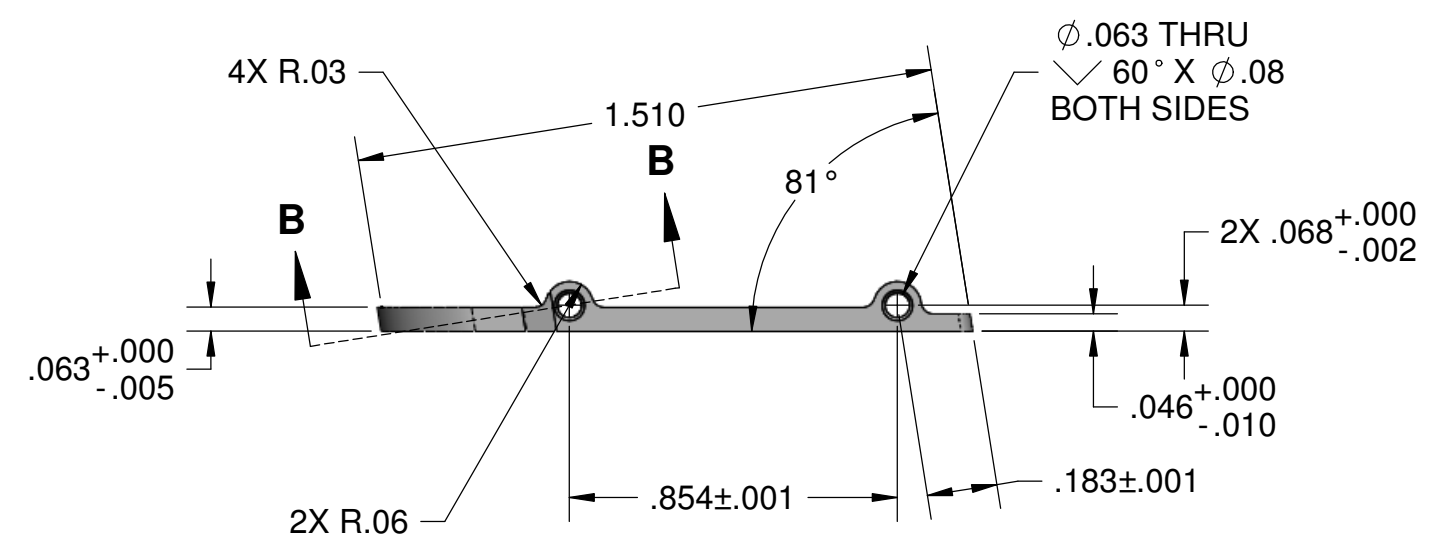
DATE PLOTTED: 5/25/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD

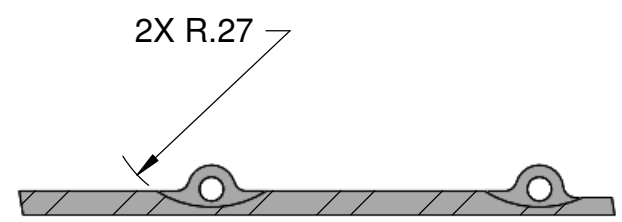


NOTES:

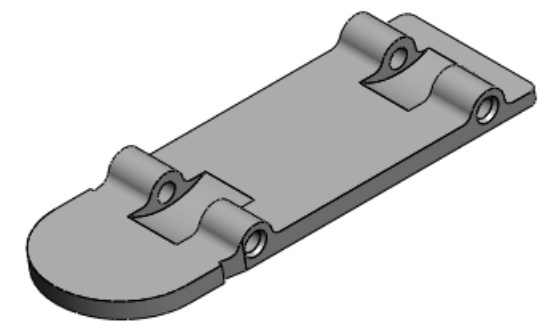
- MATERIAL:**
WROUGHT: STEEL, 1018, ASTM A108.
CAST: STEEL, IC1020, ASTM A732.



SECTION B-B



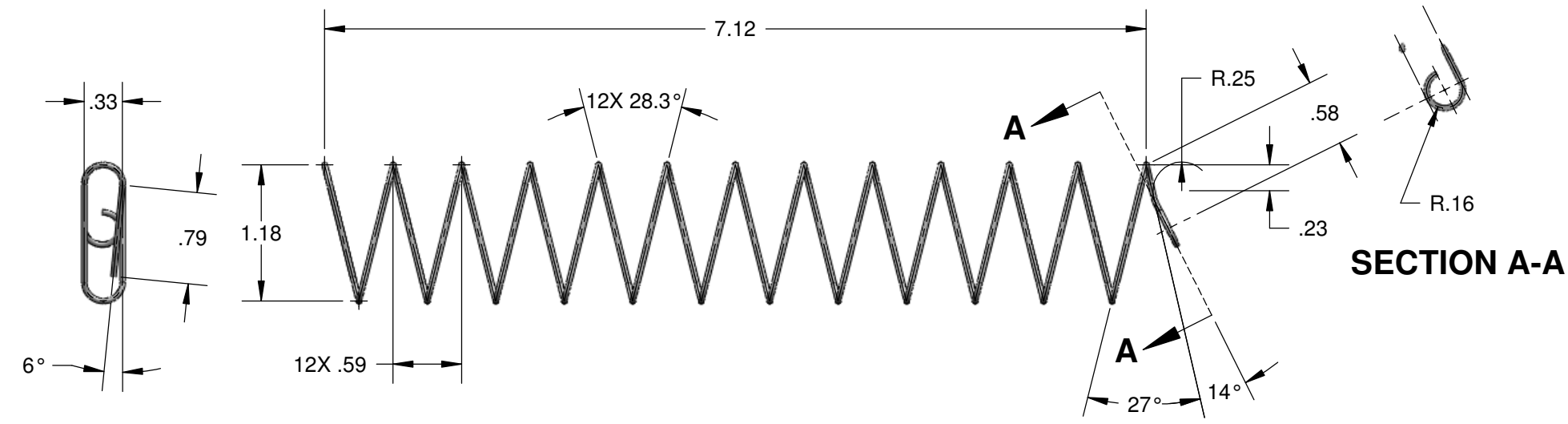
SECTION A-A



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = $\pm .05$, XX = $\pm .02$, XXX = $\pm .005$, XXXX = $\pm .0005$ ANGLES = $\pm 5^\circ$, MACHINED FINISH = 63-125 μ IN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: SEE NOTE 1		THIRD ANGLE		PROJ: M1911-A1 REDUX
	QTY REQD PER NEXT ASSY = 1		HEAT TREAT:		DRAWN BY: R Benson		DATE: 09/10/2010
	DO NOT SCALE DRAWING		FINISH: MIL-STD-171 PARA 5.3.1.2		APPROVED BY:		SCALE: 2:1
						DWG/PART NO. 6008606	
						WEIGHT: 0.01 LBS	
						SHEET 1 OF 1	

DATE PLOTTED: 5/24/2012

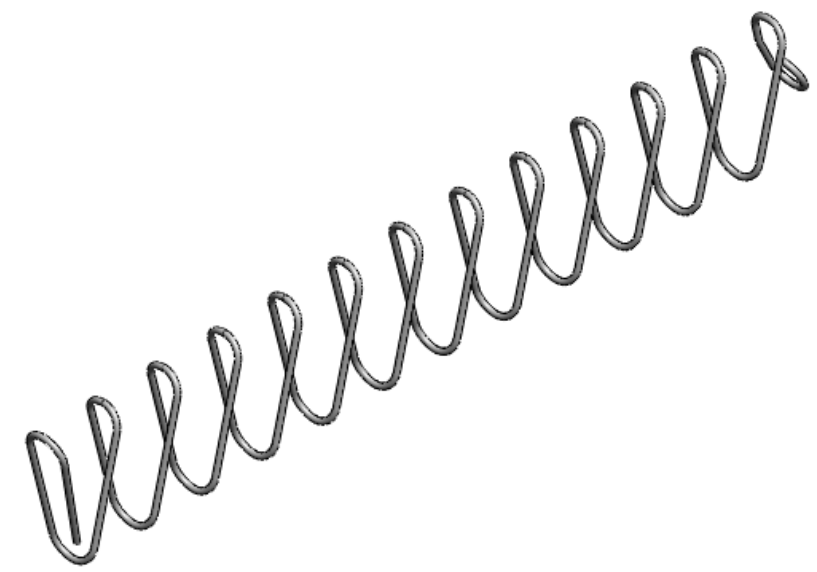
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



DIAMETER OF WIRE047±.001
DIAMETER OF COIL (OD)	N/A
FREE LENGTH	7.12
ACTIVE COILS	11.5
TOTAL COILS	12.5
DIRECTION OF HELIX	CCW
LOAD AT COMPRESSED LENGTH OF	N/A
LOAD AT COMPRESSED LENGTH OF	N/A
SPRING RATE	N/A
SOLID LENGTH	N/A
TYPE OF ENDS	IAW DRAWING DIMENSIONS
HOLE DIA INTO WHICH SPRING FITS FREELY	N/A
ROD DIA OVER WHICH SPRING SLIDES FREELY	N/A

NOTES:

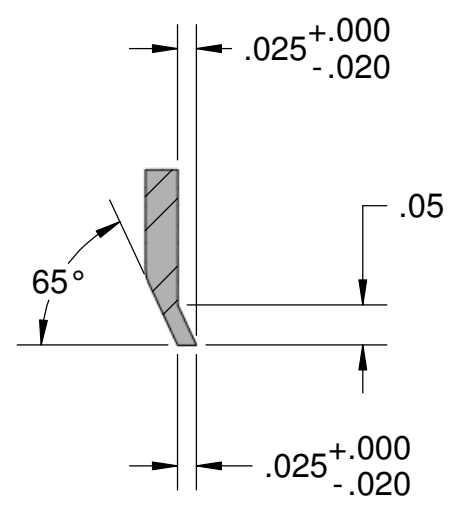
1. MANUFACTURE IAW TYPE 1, GRADE A, OF SAE AS13572.
2. STRESS RELIEVE AT 450°F FOR 30 MINUTES AFTER FORMING.



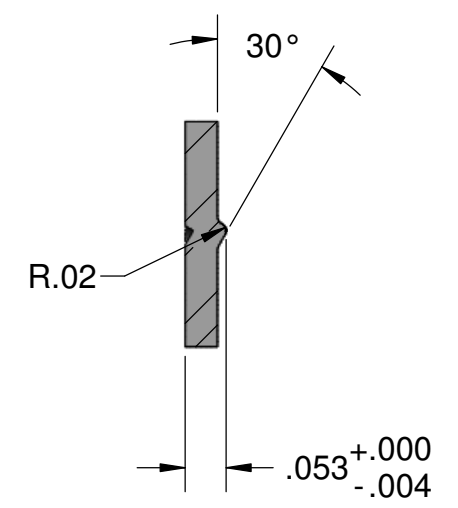
PROPRIETARY AND CONFIDENTIAL: THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RIO BENSON CONSULTING. ANY REVIEW, RETRANSMISSION, DISSEMINATION, COPYING OR OTHER USE OF, OR THE TAKING OF ANY ACTION IN RELIANCE UPON THIS INFORMATION BY PERSONS OR ENTITIES OTHER THAN THE INTENDED RECIPIENT, IS PROHIBITED.	RIO BENSON CONSULTING		1467 Georgetowne Drive Gastonia, North Carolina 28054 riobenson@clear.net		TITLE: SPRING, MAGAZINE			
	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±.5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: MUSIC WIRE, STEEL ASTM A228 HEAT TREAT: SEE NOTE 2		THIRD ANGLE 		PROJ: M1911-A1 REDUX	
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		FINISH:		DRAWN BY: R Benson DATE: 10/04/2010		SIZE: B DWG/PART NO.: 6008607	
				APPROVED BY:		SCALE: 3:4 WEIGHT: 0.00 LBS SHEET 1 OF 1		

DATE PLOTTED: 5/24/2012

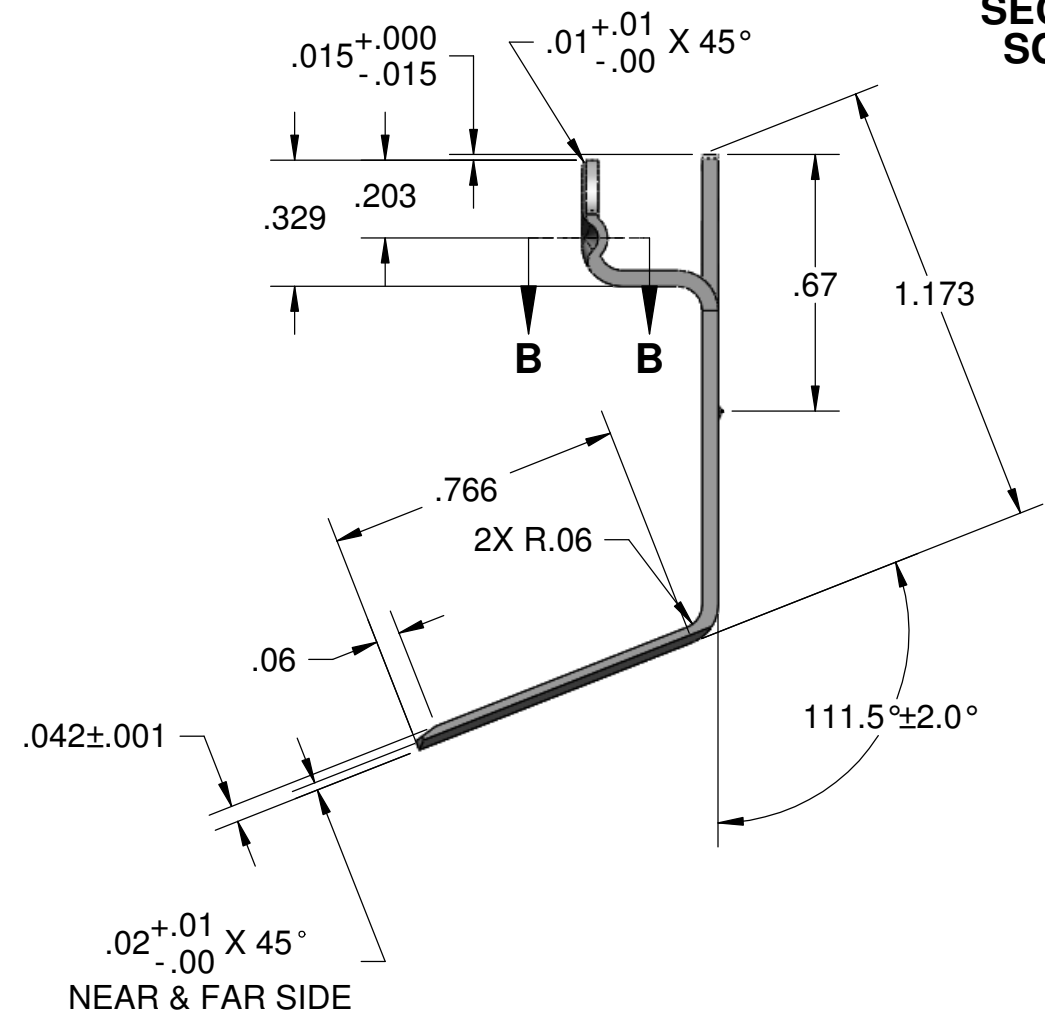
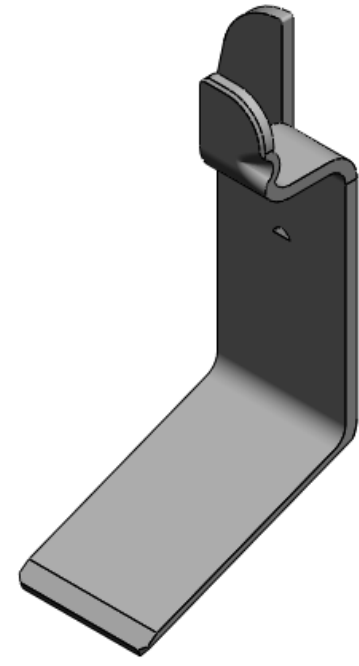
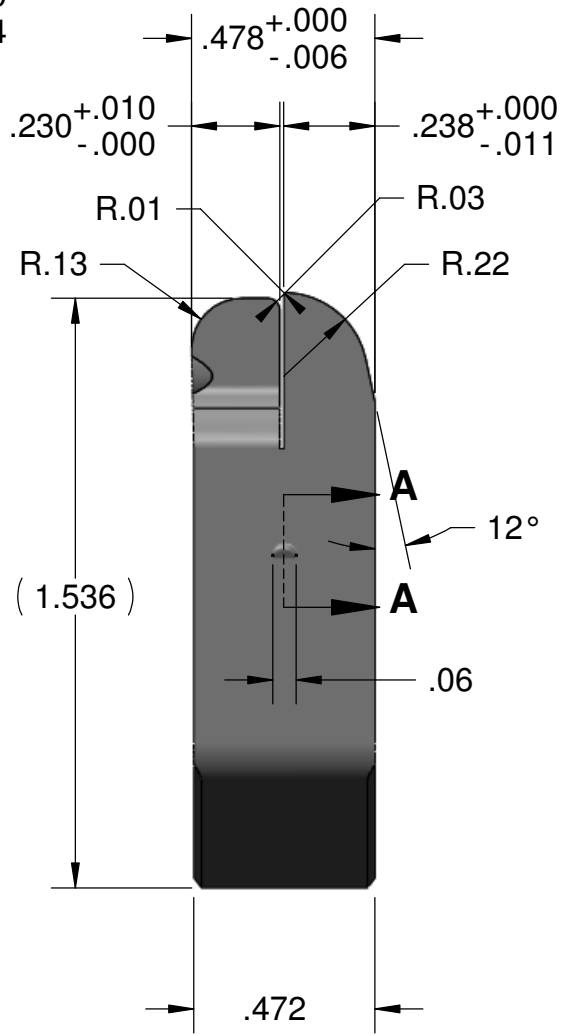
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



**SECTION B-B
SCALE 4 : 1**



**SECTION A-A
SCALE 4 : 1**



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QTY REQD PER NEXT ASSY = 1

DO NOT SCALE DRAWING

RIO BENSON CONSULTING

UNLESS OTHERWISE SPECIFIED [UOS]:
DIMENSIONS ARE IN INCHES.
TOLERANCES PER DECIMAL PLACE:
X = ±.05, XX = ±.02, XXX = ±.005, XXXX = ±.0005
ANGLES = ±.5°, MACHINED FINISH = 63-125 μIN.
REMOVE ALL BURRS AND SHARP EDGES .02 MAX
INTERPRET DRAWING IAW ANSI Y14.5M -1994

1467 Georgetowne Drive
Gastonia, North Carolina 28054
riobenson@clear.net

MATERIAL: STL, CR, CS TYPE B
ASTM A1008

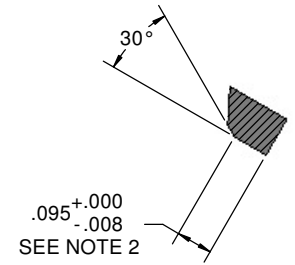
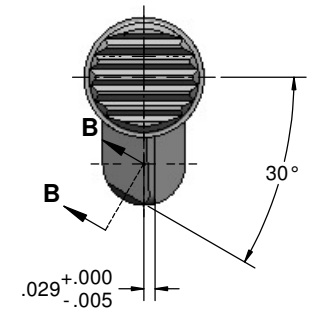
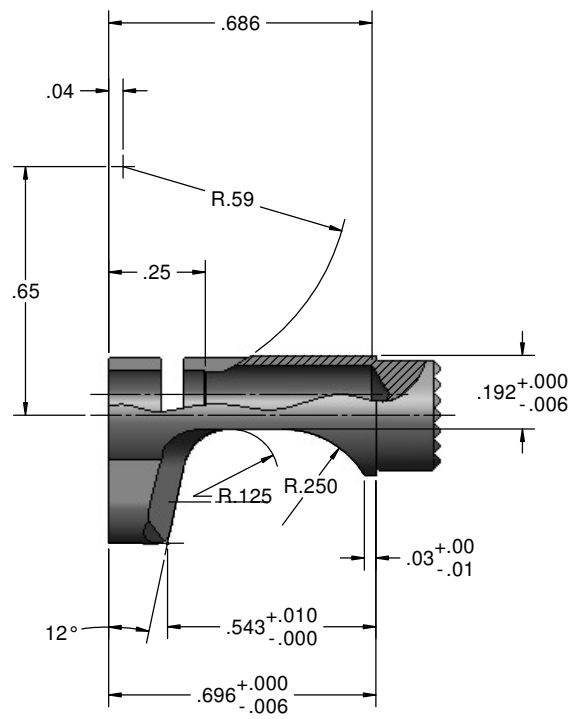
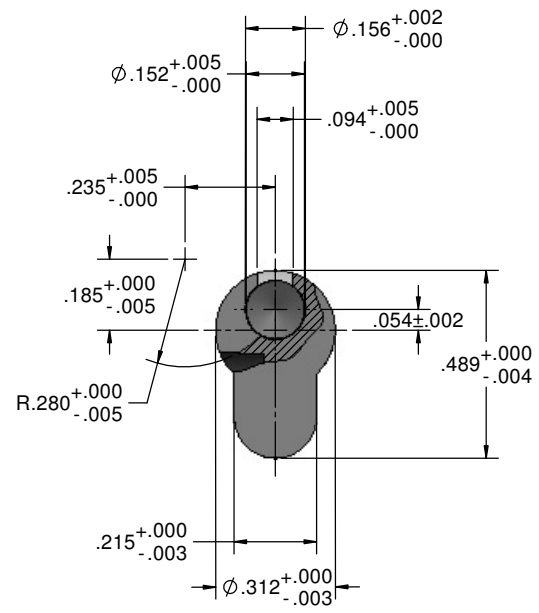
HEAT TREAT:

FINISH: MIL-STD-171
PARA 5.3.1.2

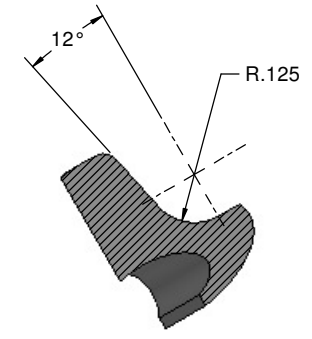
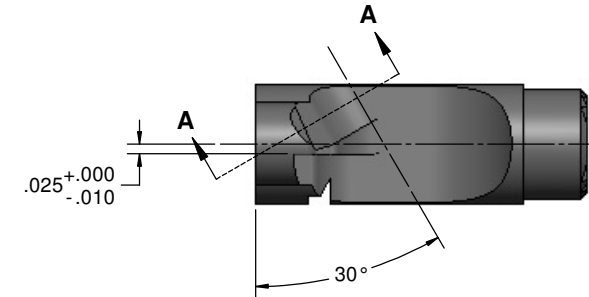
TITLE: FOLLOWER, MAGAZINE		SIZE	DWG/PART NO.	REV
PROJ: M1911-A1 REDUX		B	6008608	
NAME	DATE	SCALE: 2:1		
R Benson	09/10/2010	WEIGHT: 0.01 LBS	SHEET 1 OF 1	
DRAWN BY:	APPROVED BY:			

DATE PLOTTED: 5/24/2012

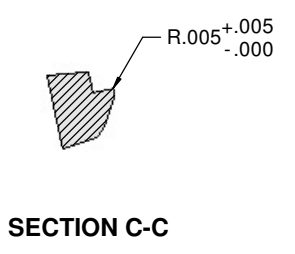
REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD



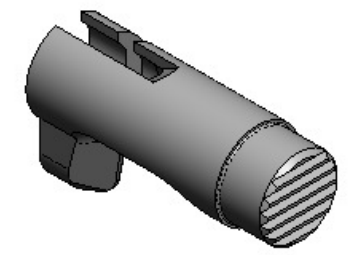
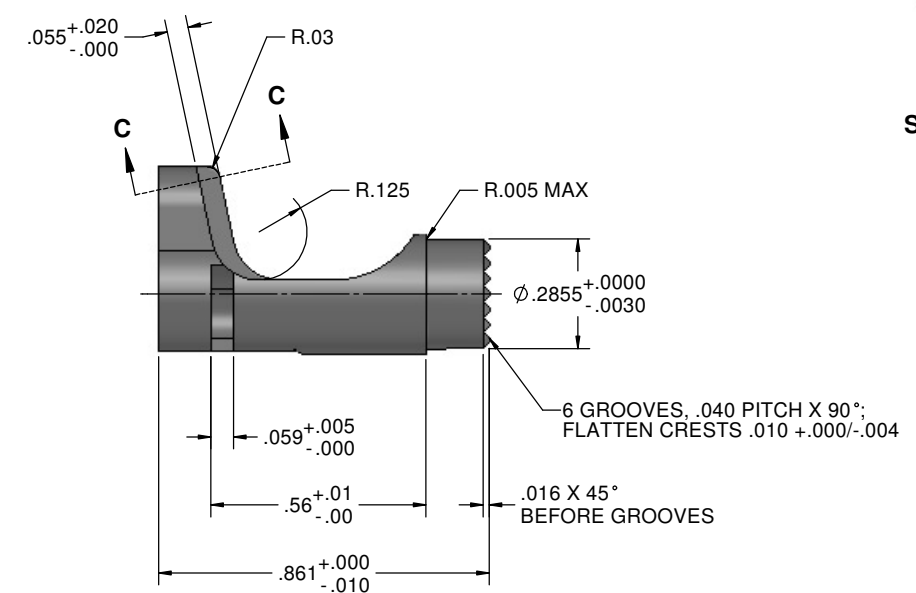
SECTION B-B



SECTION A-A



SECTION C-C



NOTES:

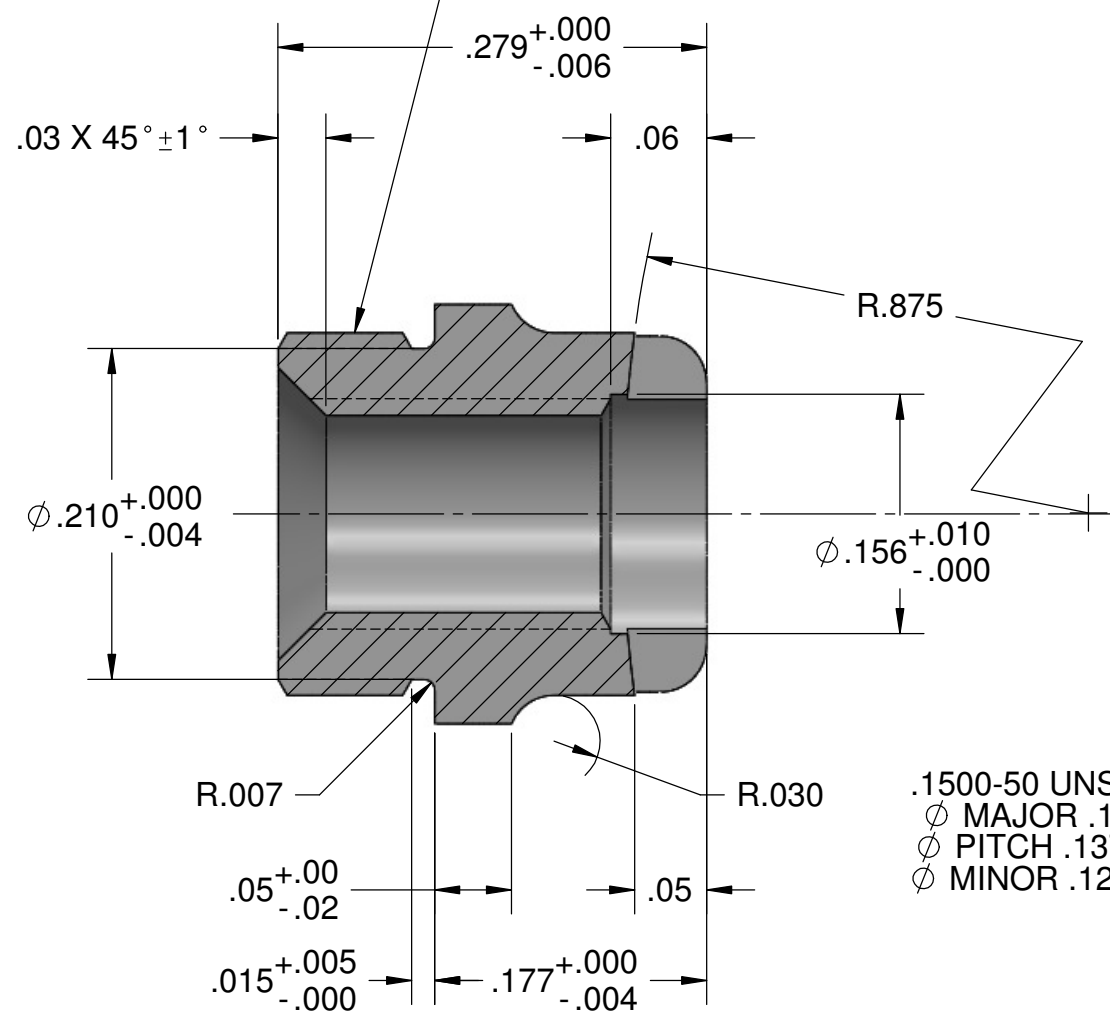
- MATERIAL:
WROUGHT: STEEL, 1117, ASTM A108.
CAST: STEEL, IC1117, ASTM A732.
- THIS DIMENSION OCCURS ONLY AT PRECISE ANGLE AND LOCATION SHOWN FOR SECTION B-B CUTTING PLANE IN PARENT VIEW.

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UNLESS OTHERWISE SPECIFIED (UOS): DIMENSIONS ARE IN INCHES TOLERANCES: PER DECIMAL PLACE X = ±.05, XX = ±.02, XXX = ±.015, XXXX = ±.005 ANGLES = ±5° MACHINED FINISH = 63-125 μIN REMOVE ALL BURRS AND SHARP EDGES. (D) MAX. INTERPRET DRAWING IAW ANS Y14.3-1994.		MATERIAL: SEE NOTE 1 HEAT TREAT: CASE DP .003-.005 RH 15-N 90-92 FINISH: MIL-STD-171 PARA 5.3.1.2		PROJECT: M1911-A1 REDUX SIZE: D DWG/PART NO.: 6008609	
QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		DRAWN BY: APPROVED BY:		SCALE: 4:1 WEIGHT: 0.01 LBS SHEET 1 OF 1	

DATE PLOTTED: 5/25/2012

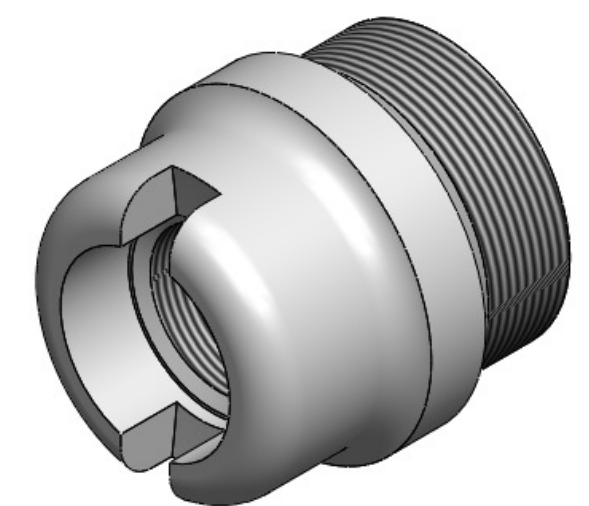
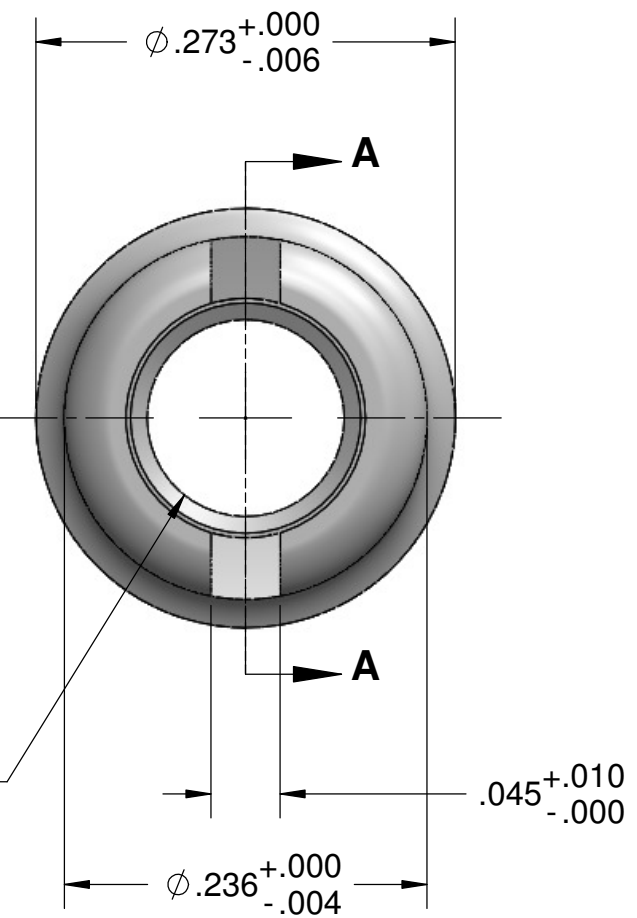
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD

.2360-60 UNS-2A THD
 Ø MAJOR .2360-.0039
 Ø PITCH .2252-.0027
 Ø MINOR .2155 MAX



SECTION A-A

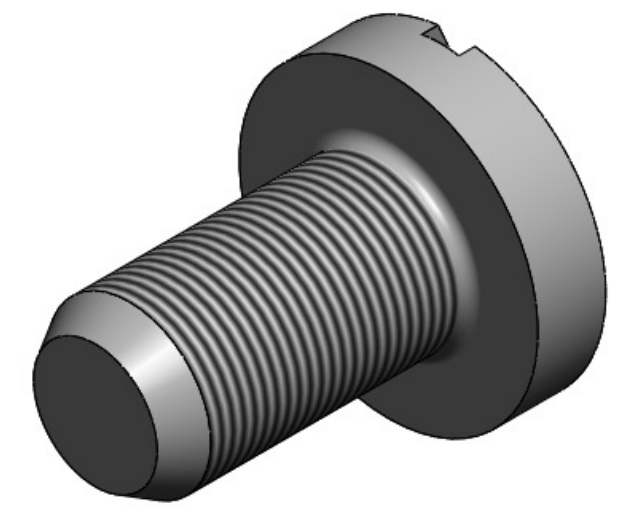
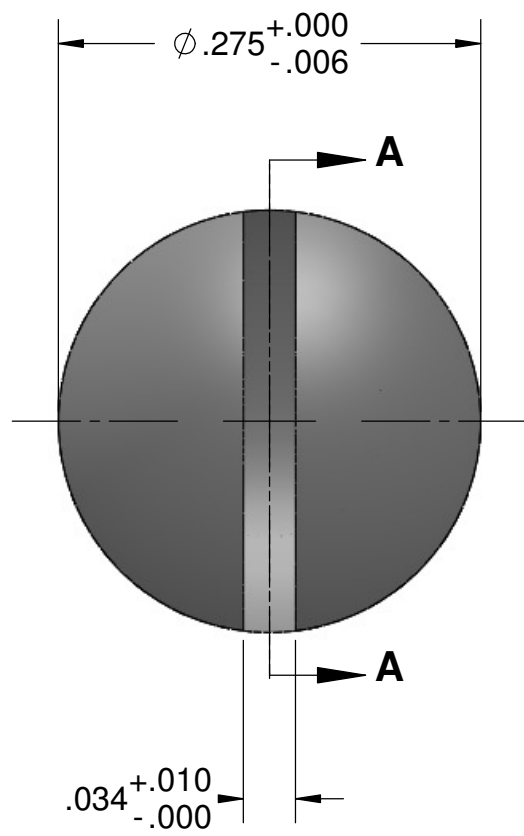
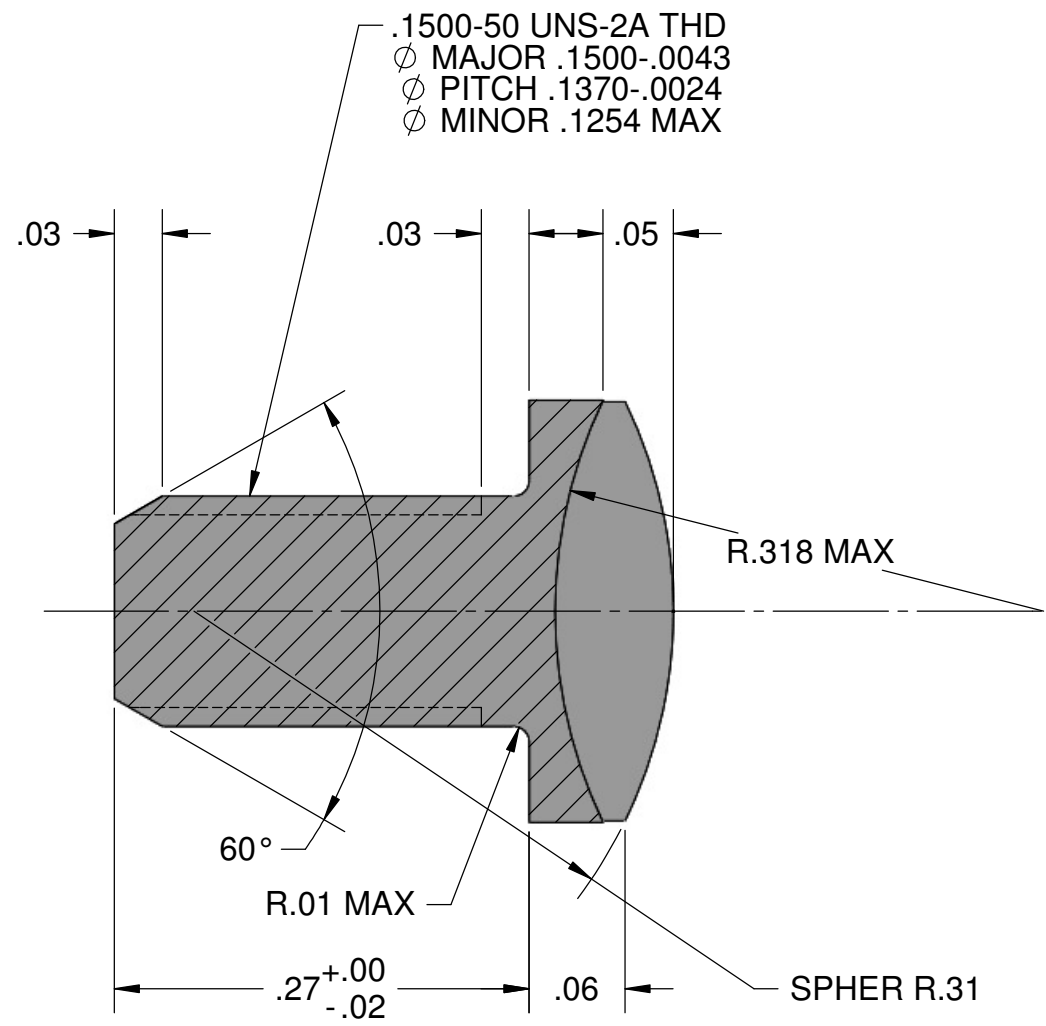
.1500-50 UNS-2B THD
 Ø MAJOR .1500 MIN
 Ø PITCH .1370+.0024
 Ø MINOR .1283+.0022



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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 µIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: STEEL 1117 ASTM A108	THIRD ANGLE 	PROJ: M1911-A1 REDUX		SIZE B	DWG/PART NO. 6019022	REV
	QTY REQD PER NEXT ASSY = 4		HEAT TREAT:	DRAWN BY: R Benson	DATE 09/11/2010	SCALE: 8:1		WEIGHT: 0.00 LBS	SHEET 1 OF 1
	DO NOT SCALE DRAWING		FINISH: MIL-STD-171 PARA 5.3.1.2	APPROVED BY:	WEIGHT: 0.00 LBS		SHEET 1 OF 1		

DATE PLOTTED: 5/24/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD

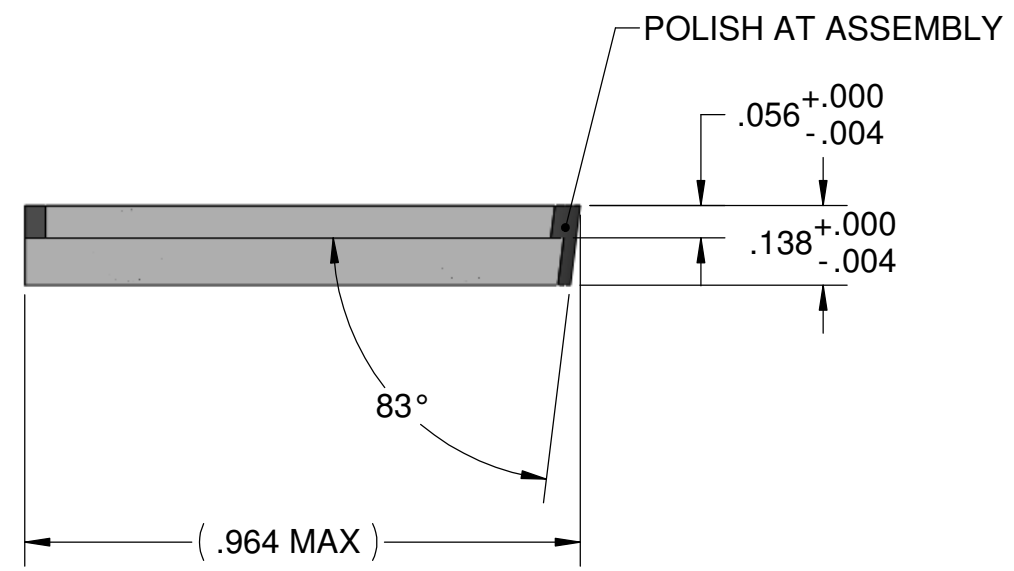


SECTION A-A

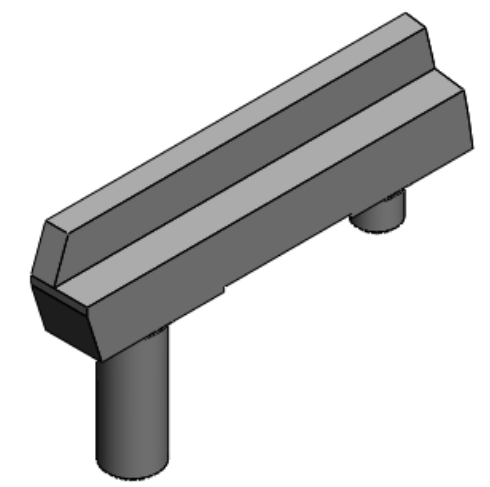
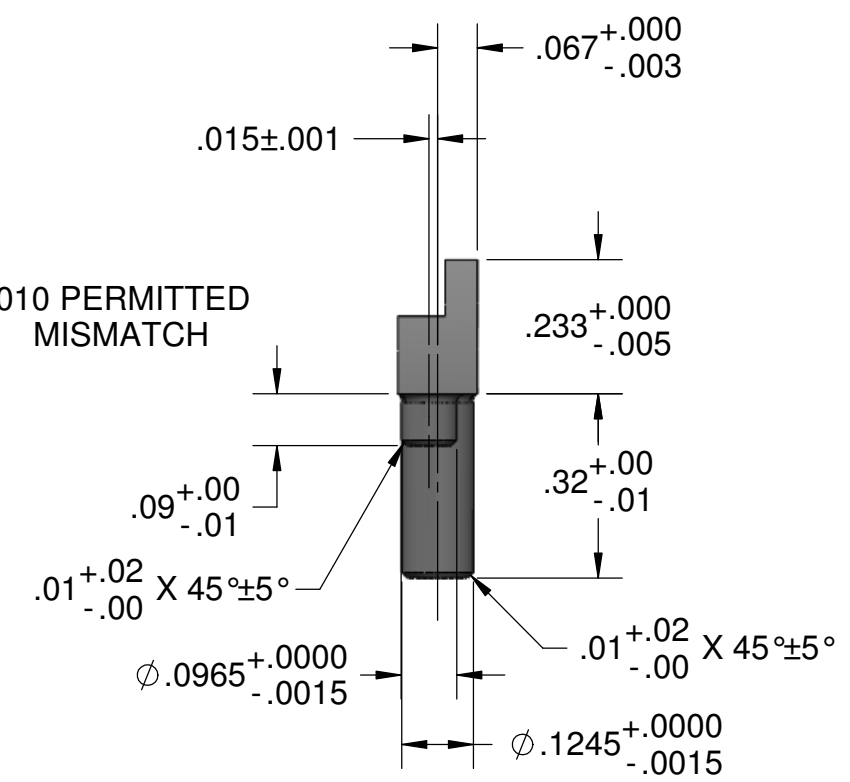
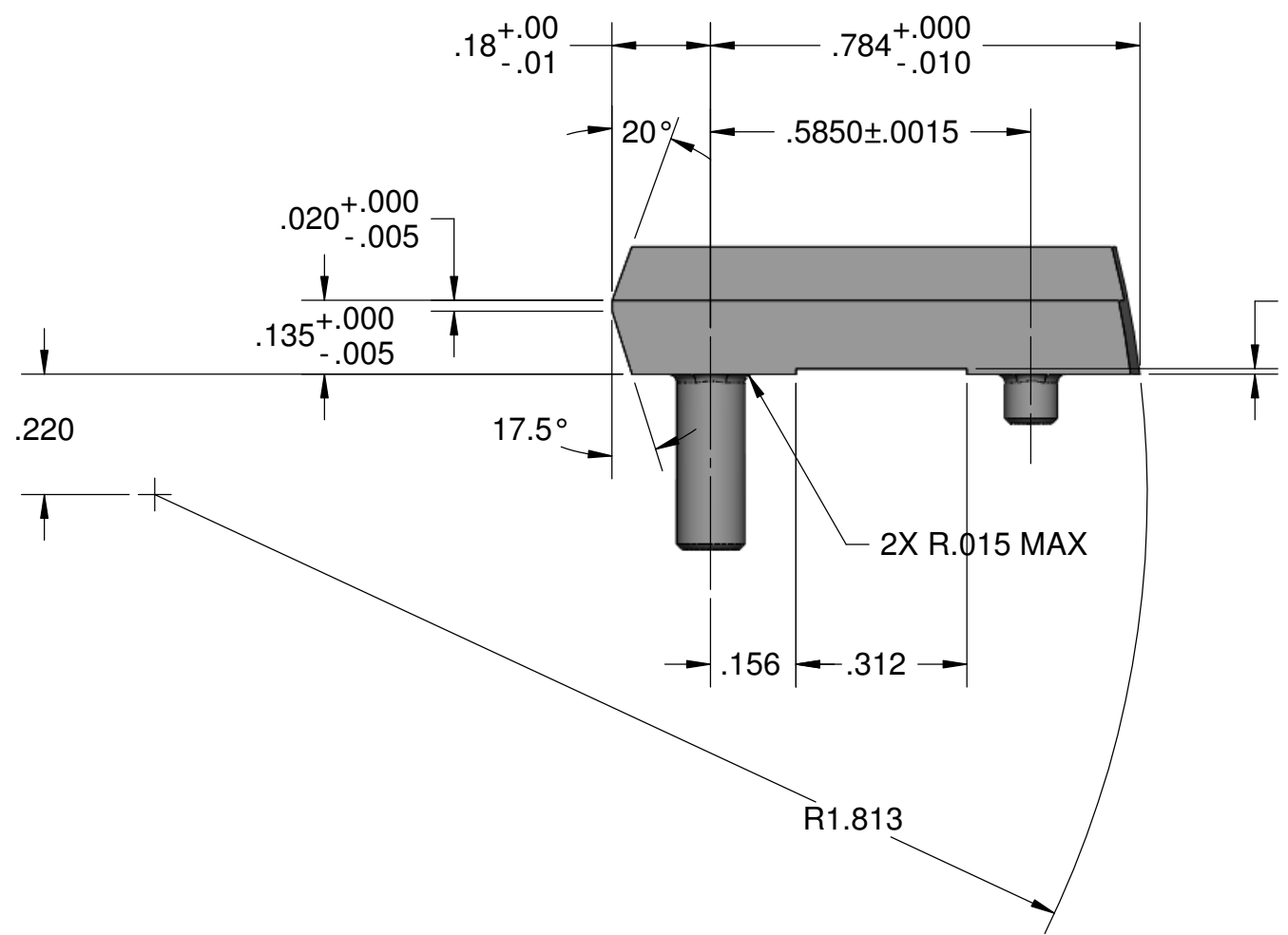
<p>PROPRIETARY AND CONFIDENTIAL: THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF RIO BENSON CONSULTING. ANY REVIEW, RETRANSMISSION, DISSEMINATION, COPYING OR OTHER USE OF, OR THE TAKING OF ANY ACTION IN RELIANCE UPON THIS INFORMATION BY PERSONS OR ENTITIES OTHER THAN THE THE INTENDED RECIPIENT, IS PROHIBITED.</p>	<p>RIO BENSON CONSULTING</p>		<p>1467 Georgetowne Drive Gastonia, North Carolina 28054 riobenson@clear.net</p>		<p>TITLE: SCREW, STOCK</p>				
	<p>UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994</p>		<p>MATERIAL: STEEL 1117 ASTM A108</p>		<p>THIRD ANGLE </p>		<p>PROJ: M1911-A1 REDUX</p>	<p>SIZE DWG/PART NO.</p>	<p>REV</p>
	<p>HEAT TREAT: CASE DP .002-.005 RH C 48-52</p>		<p>FINISH: MIL-STD-171 PARA 5.3.1.2</p>		<p>DRAWN BY: R Benson DATE: 09/12/2010</p>		<p>B</p>	<p>6019023</p>	
	<p>QTY REQD PER NEXT ASSY = 4</p>		<p>DO NOT SCALE DRAWING</p>		<p>APPROVED BY:</p>		<p>SCALE: 8:1</p>	<p>WEIGHT: 0.00 LBS</p>	<p>SHEET 1 OF 1</p>

DATE PLOTTED: 5/24/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



- NOTES:
- MATERIAL: STEEL, 1144, ASTM A311; AUSTENITIC GRAIN SIZE 6 OR FINER.
 - HEAT TREATMENT: HEAT LARGE PIN END 1450 TO 1500°F; OIL QUENCH. TEMPER 20 MINUTES AT HEAT TO RH C 48-52. LEAVE LONG PIN SOFT OR SOFTEN LONG PIN ONLY, SUFFICIENT FOR DRILLING.



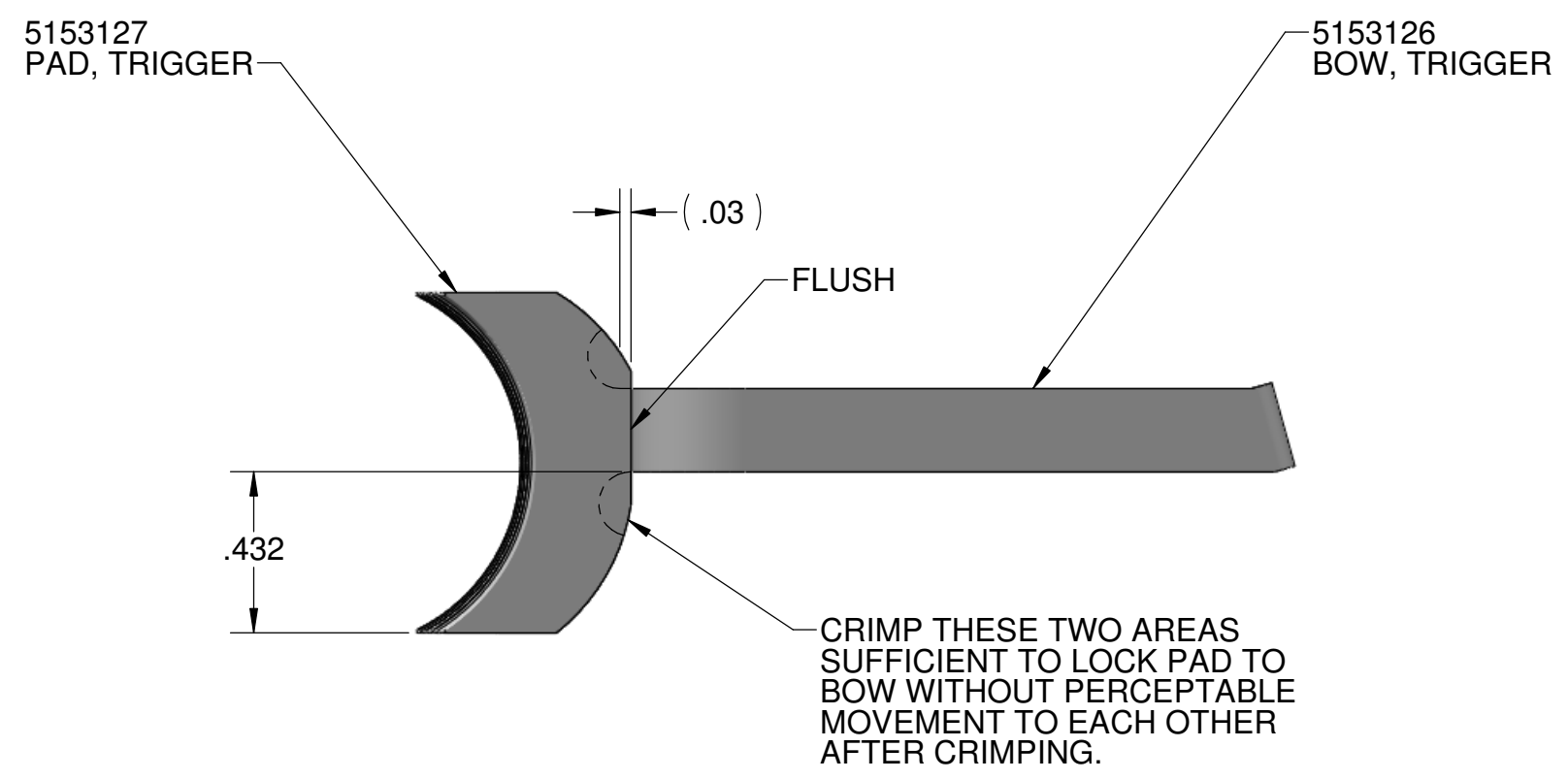
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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, XX = ±.02, XXX = ±.005, XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: SEE NOTE 1 HEAT TREAT: SEE NOTE 2 FINISH: MIL-STD-171 PARA 5.3.1.2		THIRD ANGLE 		PROJ: M1911-A1 REDUX
	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING		DRAWN BY: R Benson APPROVED BY:		NAME: R Benson DATE: 09/12/2010	SIZE: B DWG/PART NO.: 6019024	REV:

DATE PLOTTED: 5/24/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD

NOTES:

- REFINISH, IF NECESSARY AFTER CRIMPING, IAW PARA 5.3.1.2 OF MIL-STD-171.

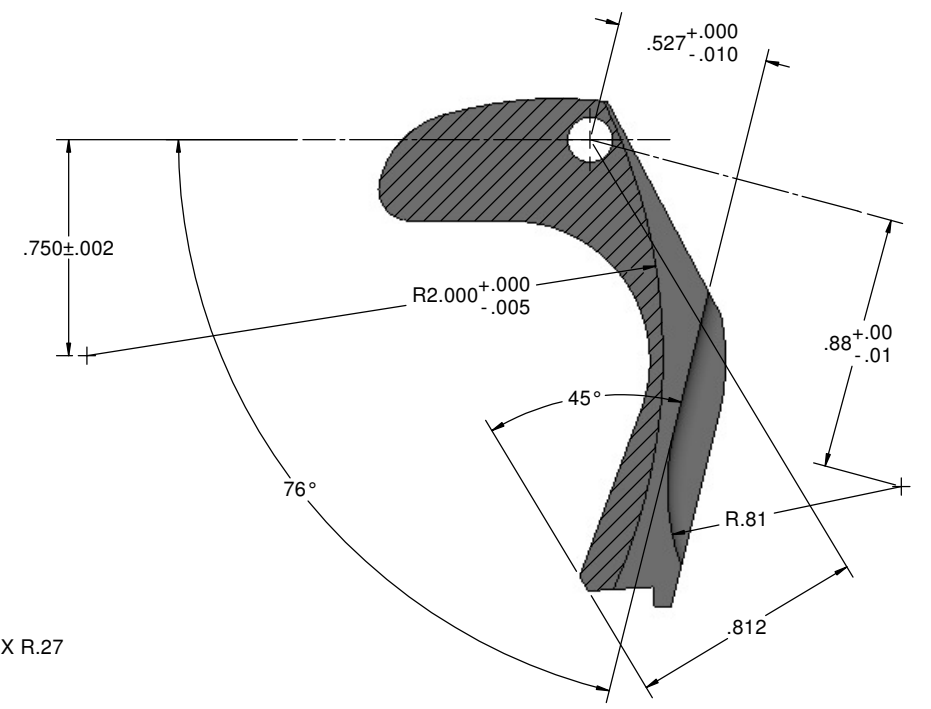
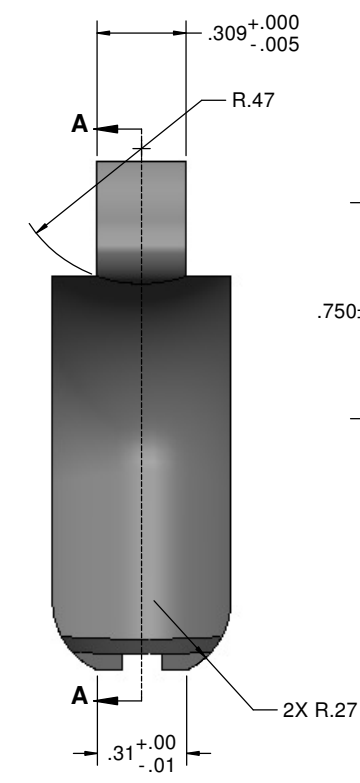
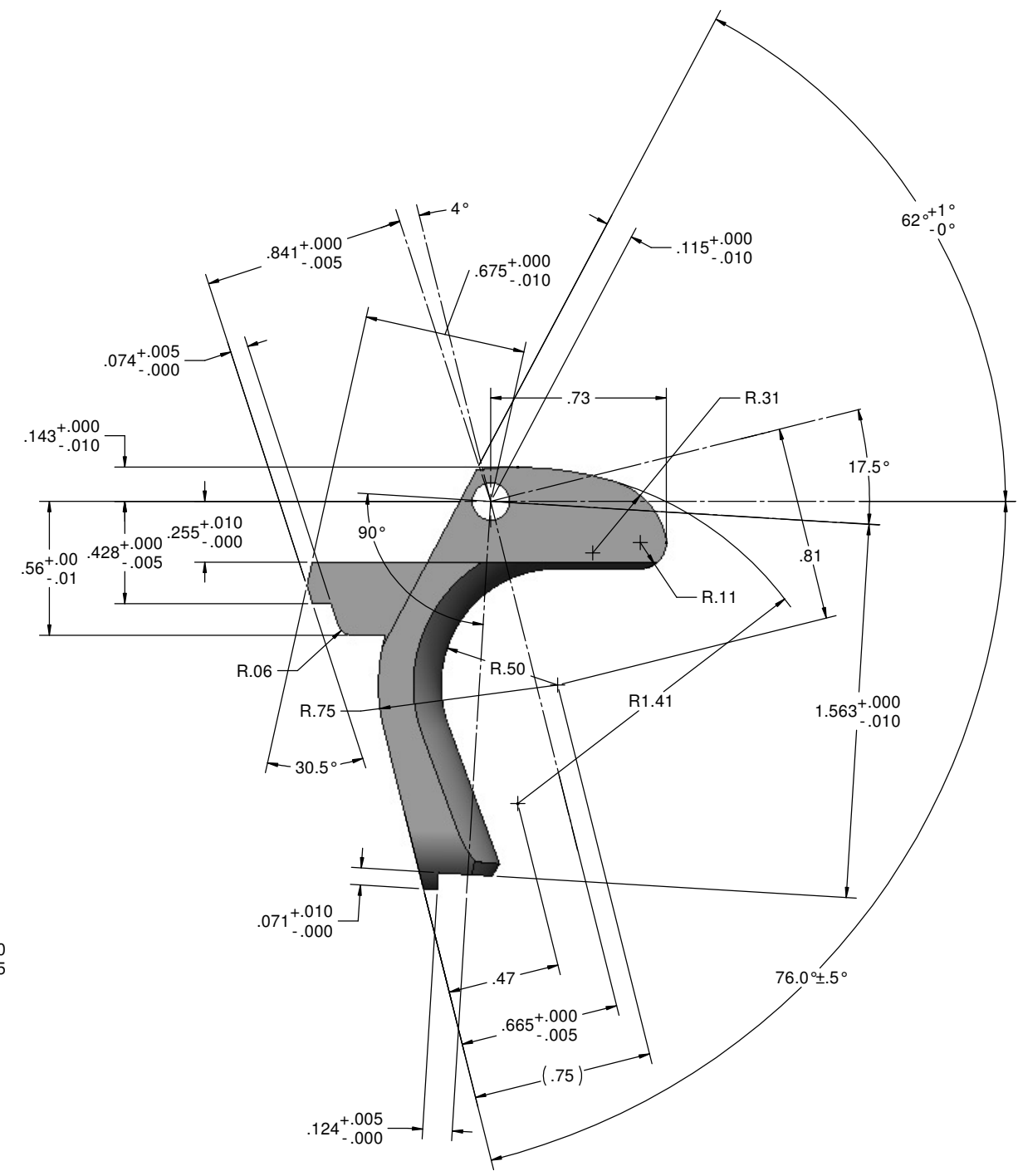
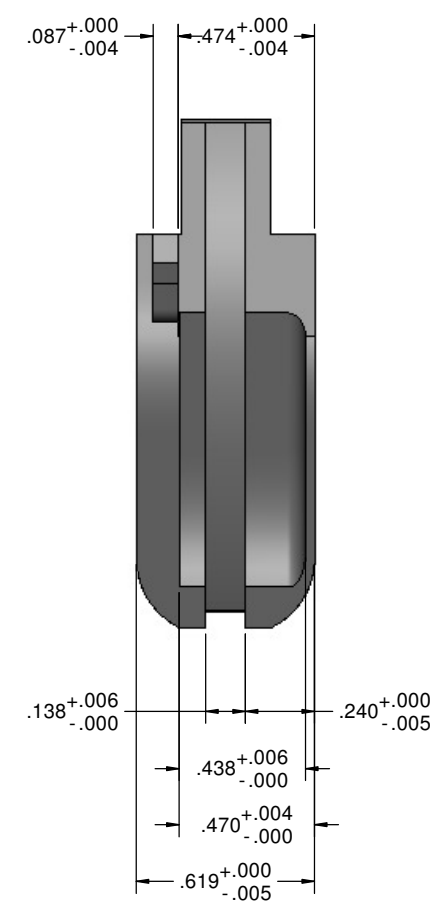


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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±.5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: PER CALLOUT	THIRD ANGLE	PROJ: M1911-A1 REDUX		SIZE: B	DWG/PART NO.: 6147780	REV:
	QTY REQD PER NEXT ASSY = 1		HEAT TREAT:	DRAWN BY: R Benson	DATE: 09/12/2010	SCALE: 2:1	WEIGHT: 0.00 LBS	SHEET 1 OF 1	
	DO NOT SCALE DRAWING		FINISH: SEE NOTE 1	APPROVED BY:					

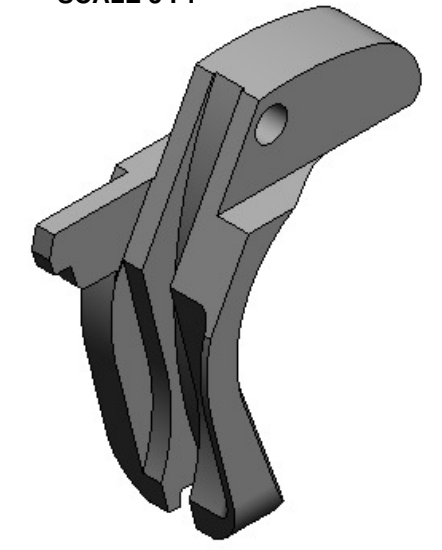
DATE PLOTTED: 5/25/2012

REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD

- NOTES:
- FABRICATED FINISH $\sqrt{63}$ EXCEPT AS NOTED.
 - MATERIAL:
WROUGHT: STEEL, 1117, ASTM A108.
CAST: STEEL, IC1117, ASTM A732.



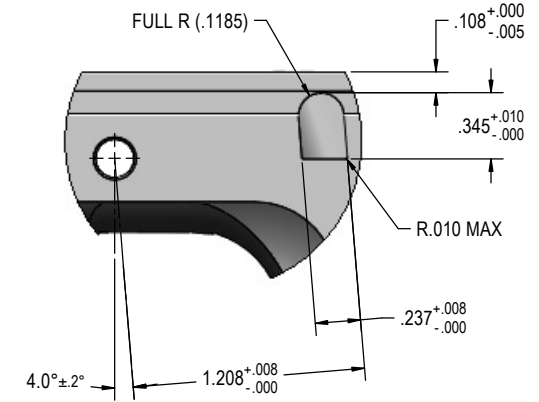
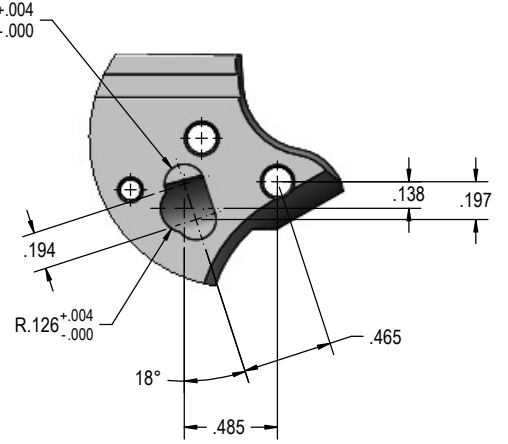
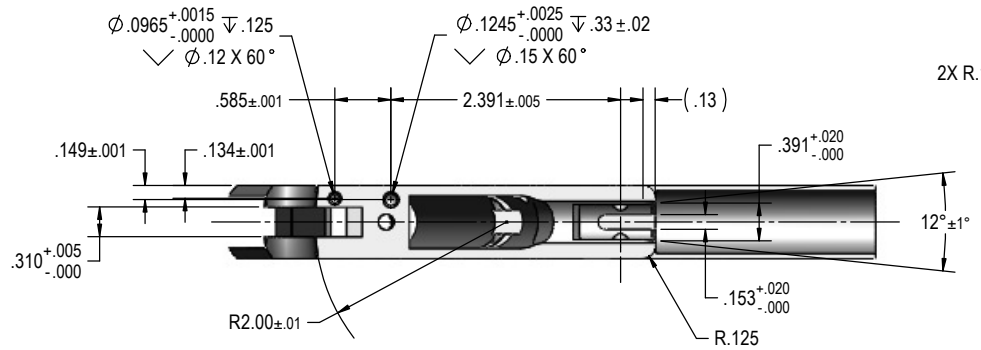
SECTION A-A
SCALE 3:1



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		<small>UNLESS OTHERWISE SPECIFIED (UOS): DIMENSIONS ARE IN INCHES TOLERANCES: PER DECIMAL PLACE X = ±.05, XX = ±.02, XXX = ±.015, XXXX = ±.005 ANGLES = ±5° MACHINED FINISH = ±3-125 μm REMOVE ALL BURRS AND SHARP EDGES. (D) MAX. INTERPRET DRAWING IAW ANSI Y14.5-1994.</small>	<small>MATERIAL: SEE NOTE 2 HEAT TREAT: CASE DP .003-.005 RH/C 48-52</small>	<small>THIRD ANGLE PROJECTION</small>
QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING	<small>1467 Georgetowne Drive Gastonia, North Carolina 28054 riobenson@clear.net</small>	PROJECT: M1911-A1 REDUX NAME: _____ DATE: _____ DRAWN BY: _____ APPROVED BY: _____	SIZE: D DWG/PART NO.: 6501828 SCALE: 3:1 WEIGHT: 0.07 LBS SHEET 1 OF 1	

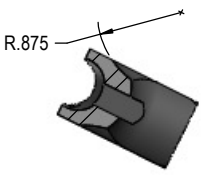
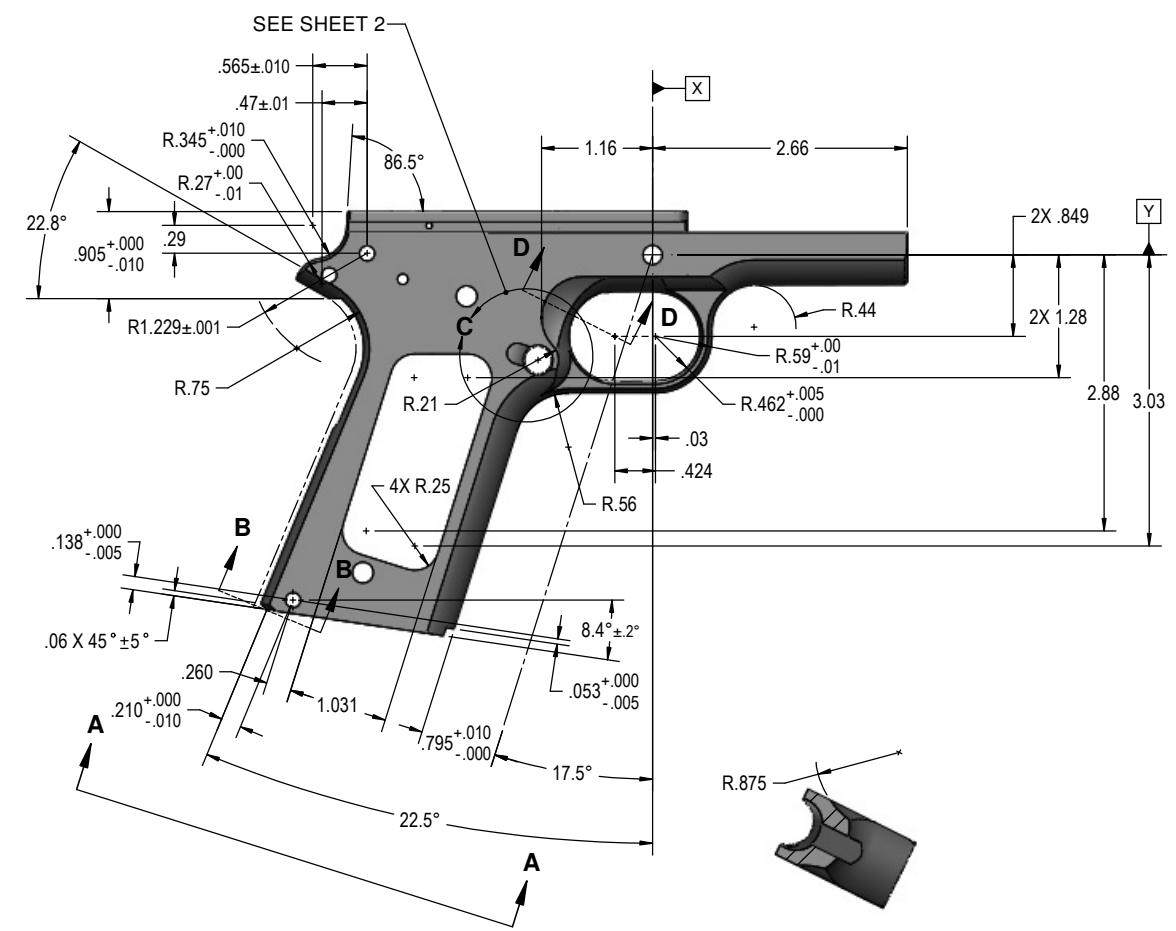
DATE PLOTTED: 5/25/2012

REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD

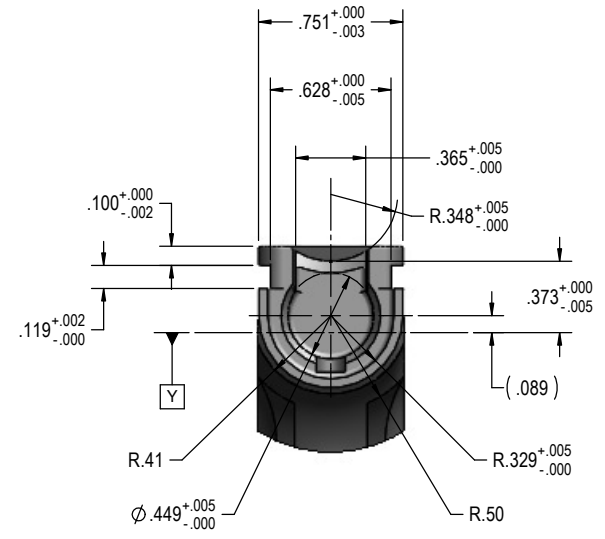


DETAIL H
SCALE 2 : 1

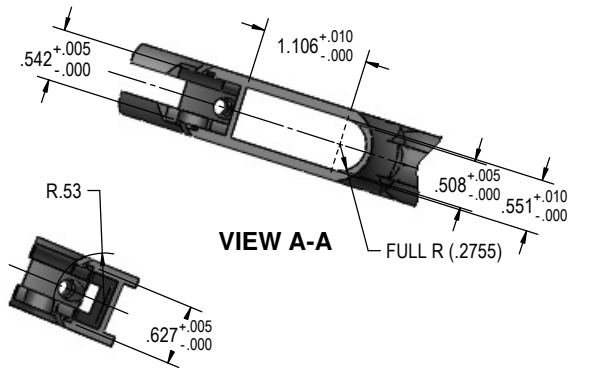
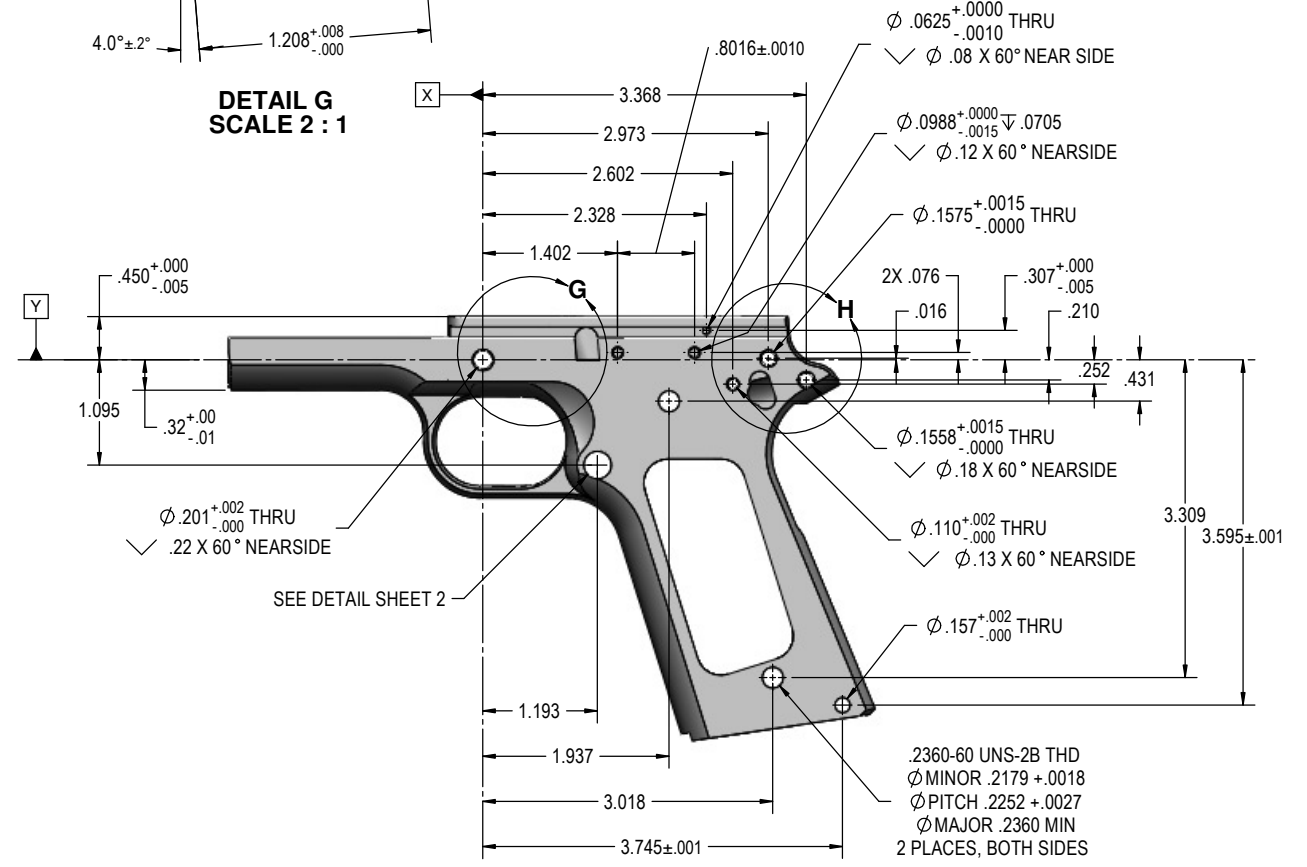
DETAIL G
SCALE 2 : 1



SECTION D-D



DETAIL E
SCALE 2 : 1



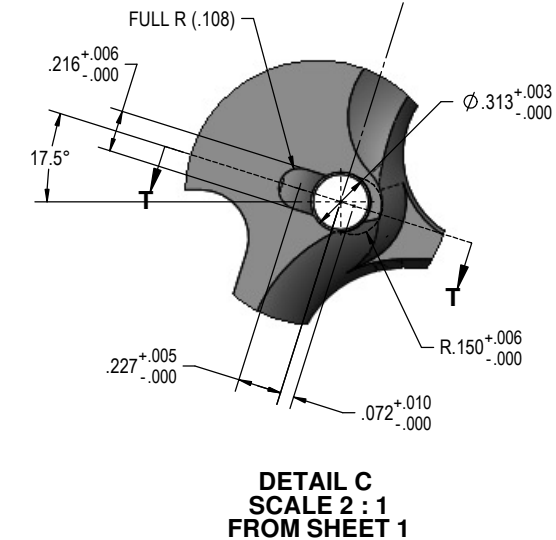
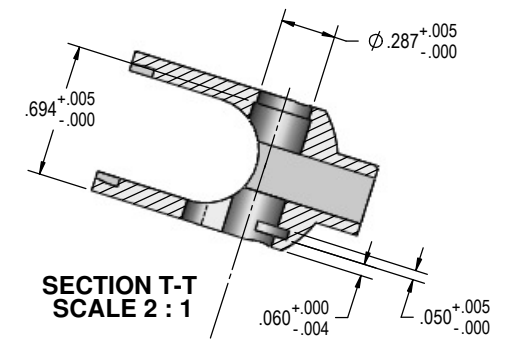
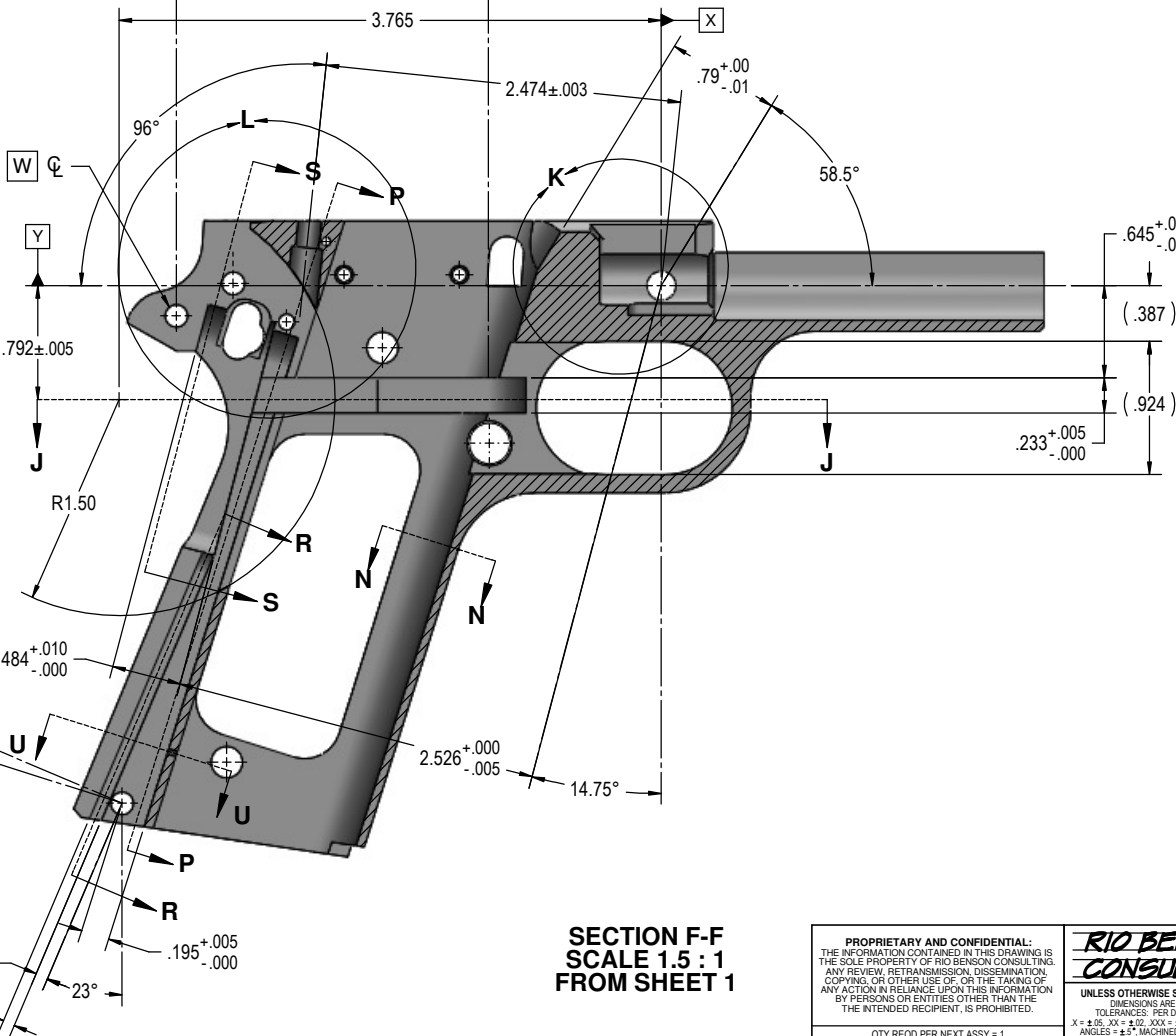
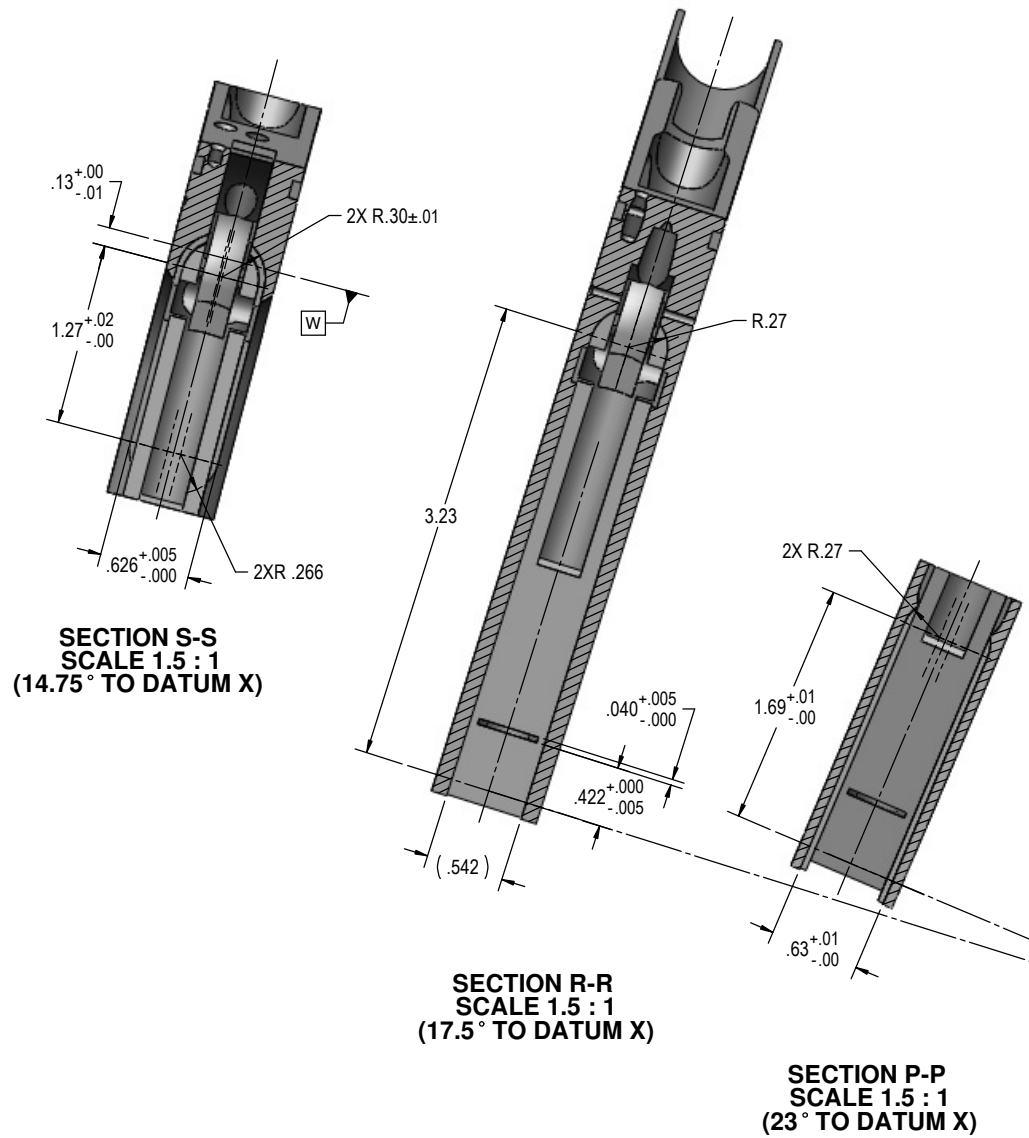
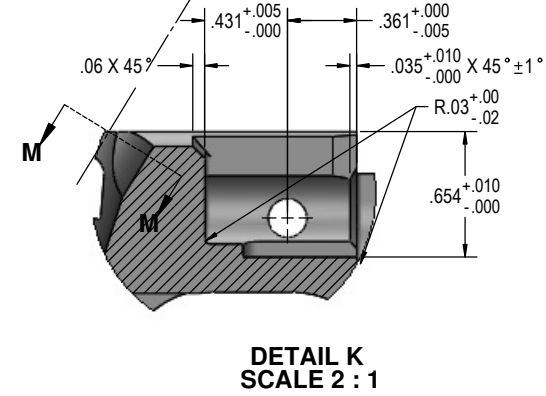
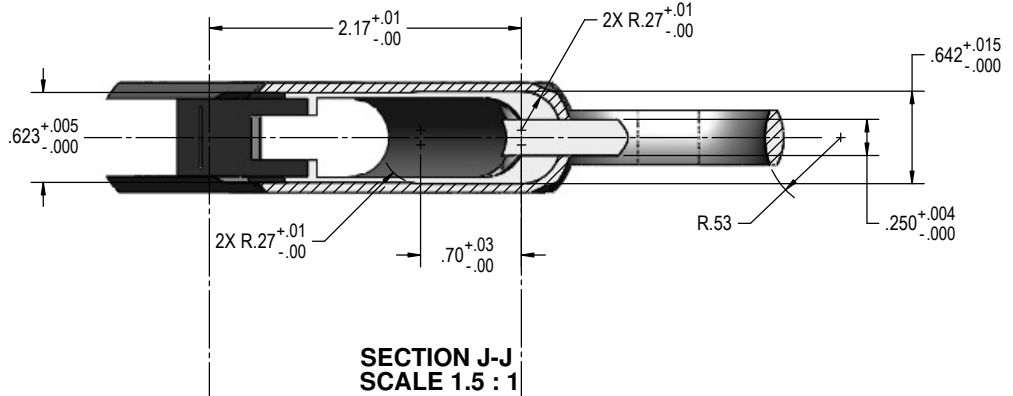
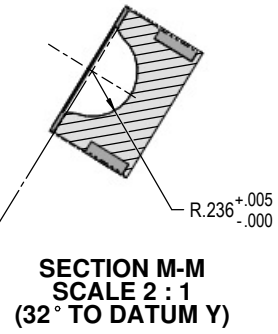
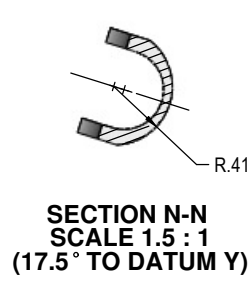
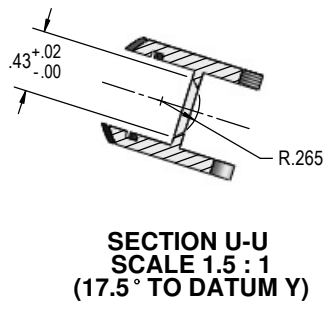
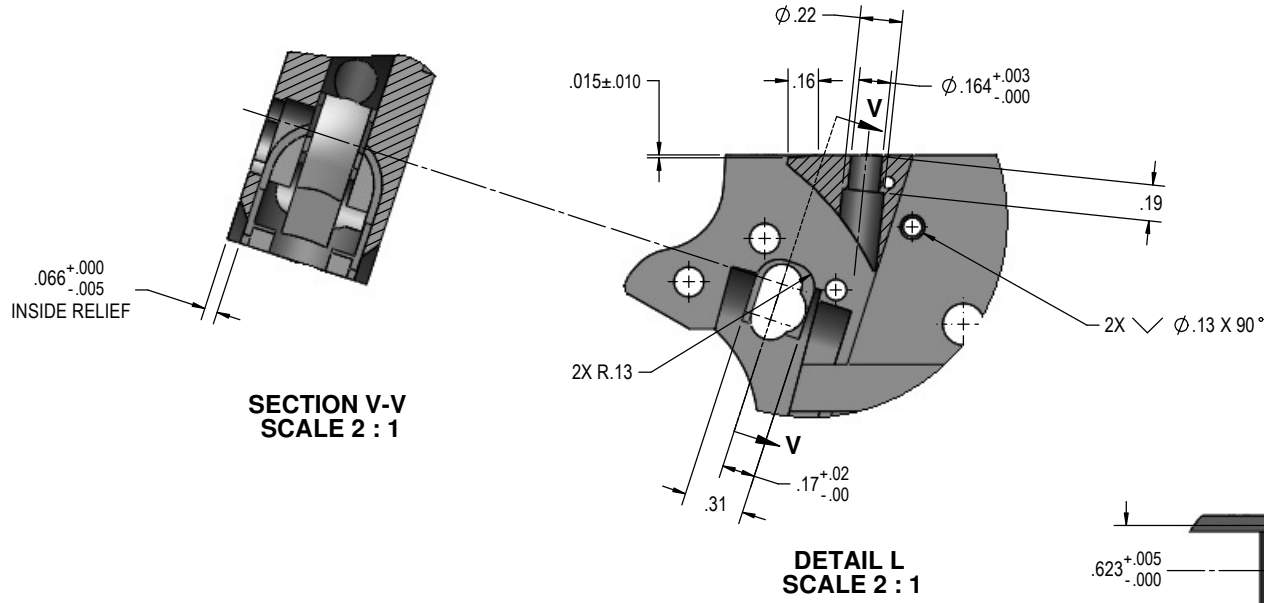
VIEW A-A

VIEW B-B



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<p>UNLESS OTHERWISE SPECIFIED (UOS): DIMENSIONS ARE IN INCHES TOLERANCES: PER DECIMAL PLACE X = ±.05, XX = ±.02, XXX = ±.01, XXXX = ±.005 ANGLES = ±5° MACHINED FINISH = ±.125 μm REMOVE ALL BURRS AND SHARP EDGES. (2) MAX. INTERPRET DRAWING IAW ANSI Y14.5-1994.</p>		<p>MATERIAL: STEEL 1035 ASTM A576 HEAT TREAT: FINISH: MIL-STD-171 PARA 5.3.1.2</p>		<p>THIRD ANGLE PROJECTION DRAWN BY: R Benson APPROVED BY:</p>	
<p>QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING</p>		<p>PROJECT: M1911-A1 REDUX NAME: R Benson DATE: 09/12/2010</p>		<p>SIZE: D DWG/PART NO.: 6535359 SCALE: 1:1 WEIGHT: 0.74 LBS SHEET 1 OF 2</p>	

DATE PLOTTED: 5/25/2012

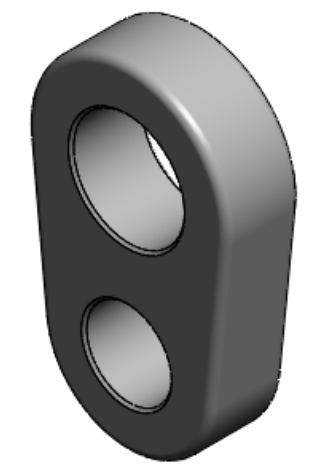
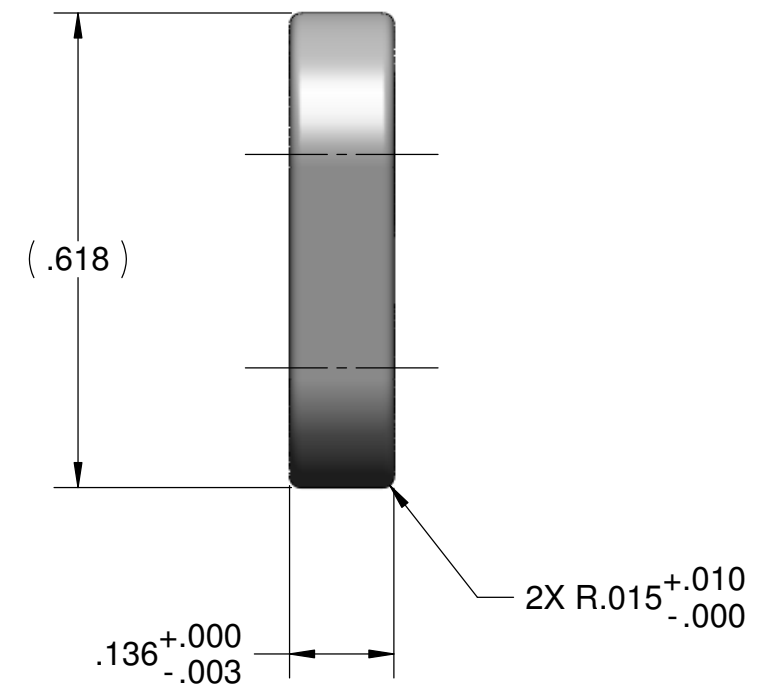
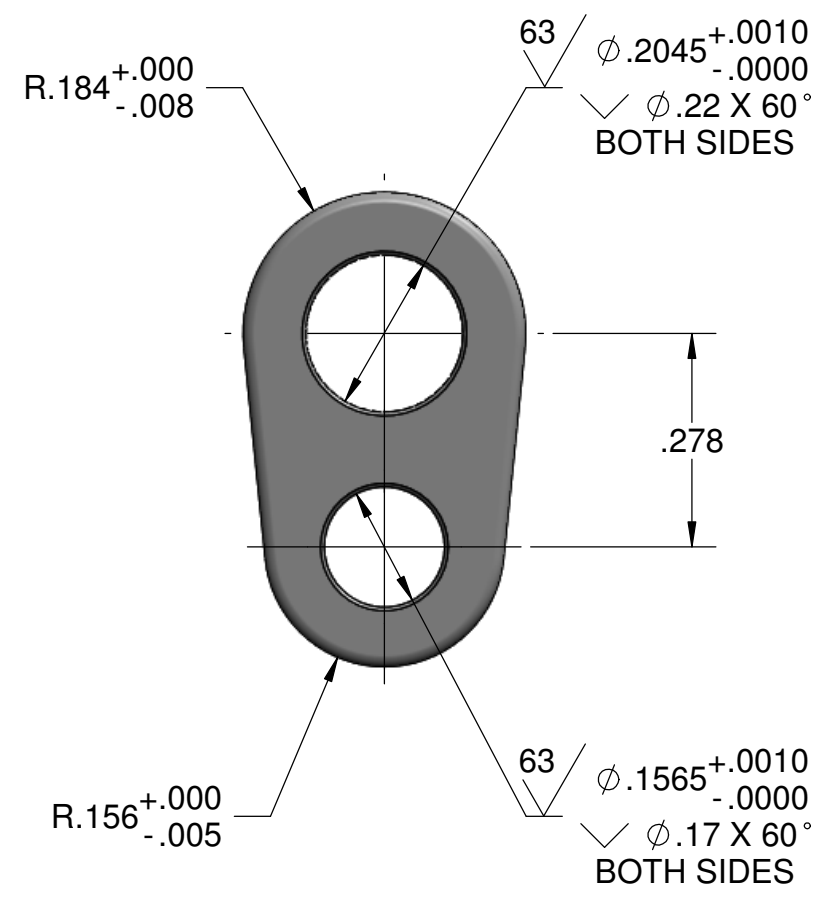


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DIMENSIONS ARE IN INCHES TOLERANCES: PER DECIMAL PLACE X = ±.05, XX = ±.02, XXX = ±.015, XXXX = ±.005 ANGLES: ±.5° MACHINED FINISH ±.125 μm REMOVE ALL BURRS AND SHARP EDGES (D) MAX. INTERPRET DRAWING IAW ANS Y14.5-1994.	MATERIAL: STEEL 1035 ASTM A576 HEAT TREAT:	PROJECT: M1911-A1 REDUX NAME: R Benson DATE: 09/12/2010 DRAWN BY: APPROVED BY:	SIZE: D DWG/PART NO.: 6535359 SCALE: 1:1 WEIGHT: 0.74 LBS SHEET 2 OF 2	QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING	DATE PLOTTED: 5/25/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD

NOTES:

- MATERIAL: STEEL, 1045, ASTM A576; AUSTENITIC GRAIN SIZE 7 OR FINER.

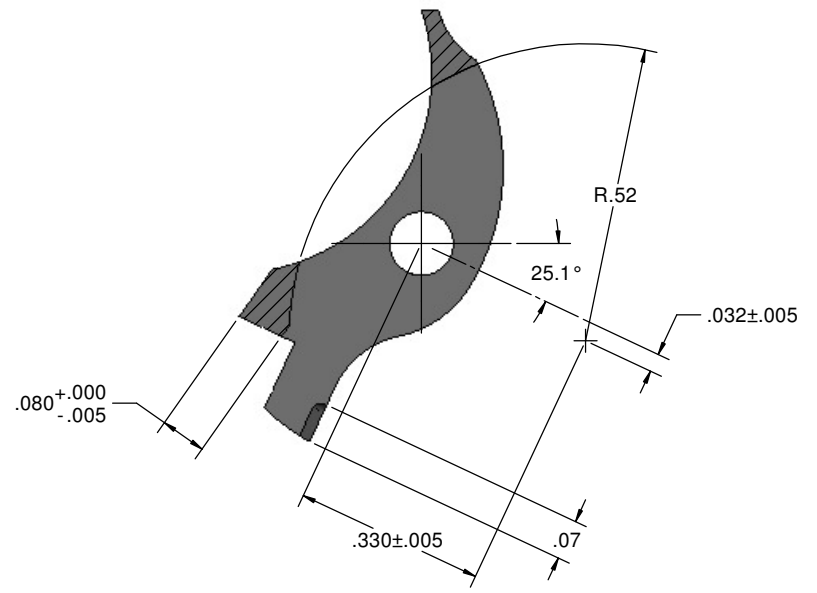
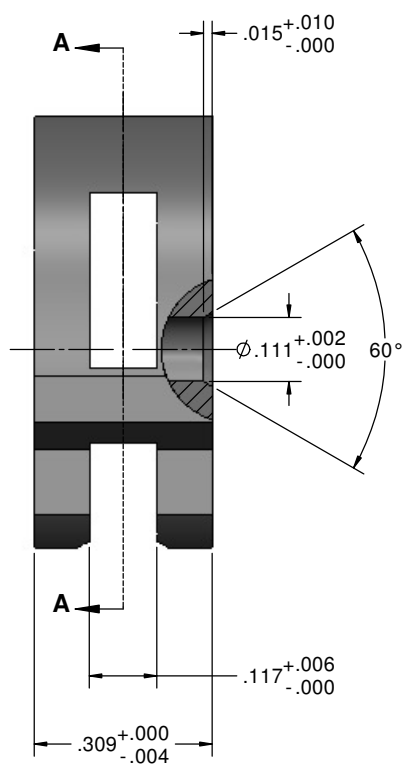
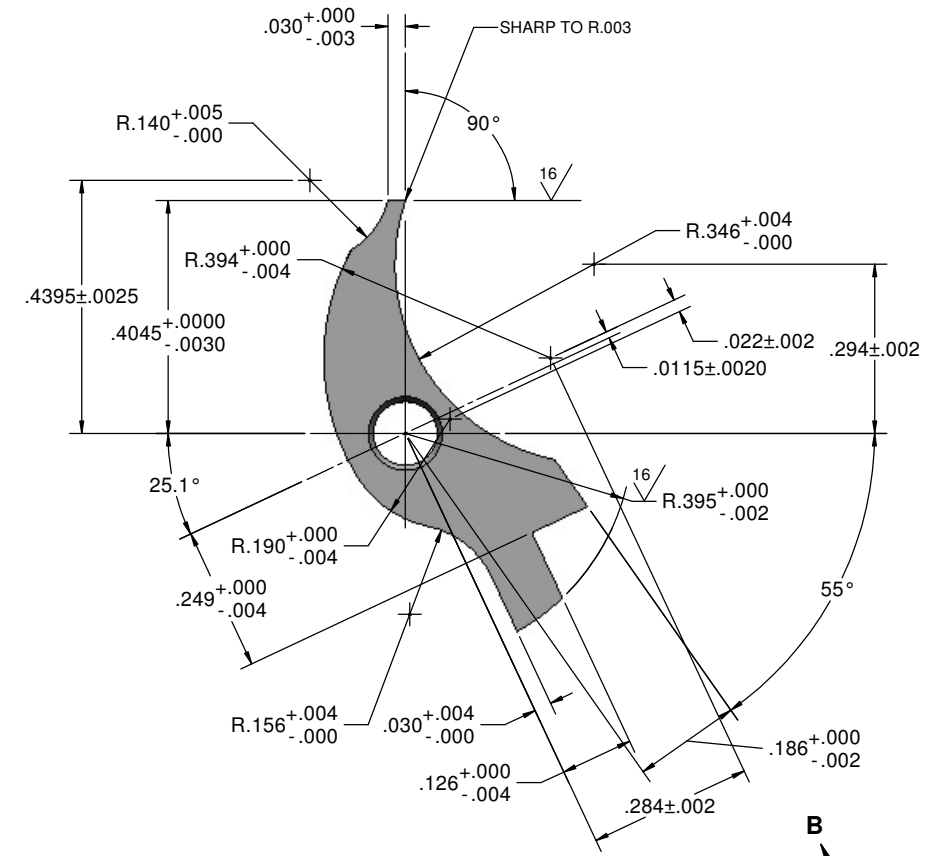


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	UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, XX = ±.02, XXX = ±.005, XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994		MATERIAL: SEE NOTE 1	THIRD ANGLE	PROJ: M1911-A1 REDUX		SIZE: B	DWG/PART NO.: 7267771	REV:
	QTY REQD PER NEXT ASSY = 1		HEAT TREAT: AUSTEMPER RH C 40-47	DRAWN BY: R Benson	DATE: 09/15/2010	SCALE: 4:1		WEIGHT: 0.01 LBS	SHEET 1 OF 1
	DO NOT SCALE DRAWING		FINISH: MIL-STD-171 PARA 5.3.1.2	APPROVED BY:					

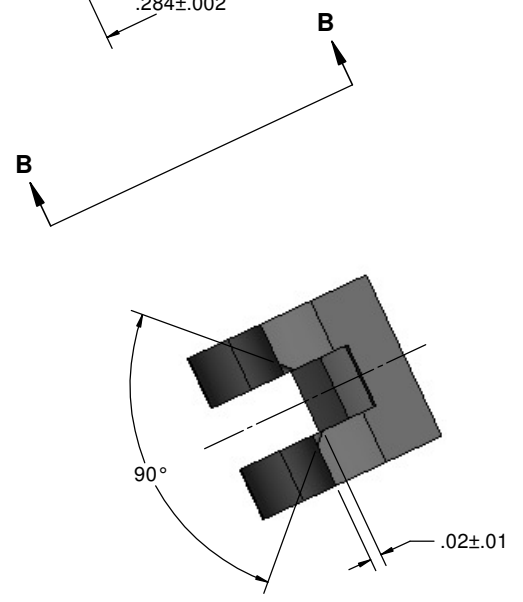
DATE PLOTTED: 5/25/2012

REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD

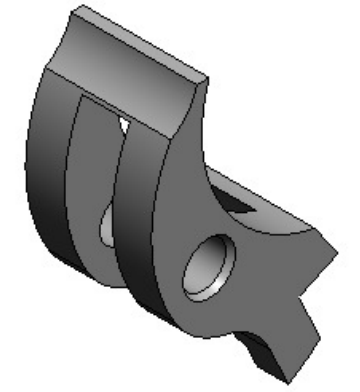
NOTES:
 1. MATERIAL:
 WROUGHT: STEEL, 4150, ASTM A576;
 AUSTENITIC GRAIN SIZE 6 OR FINER.
 CAST: STEEL, IC4150, ASTM A732.



SECTION A-A
 SCALE 6 : 1



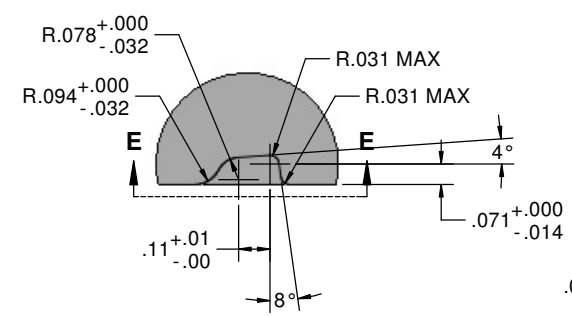
VIEW B-B



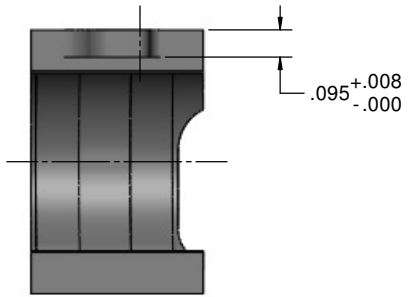
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		MATERIAL: SEE NOTE 1 HEAT TREAT: RH C 43.5-50 FINISH: MIL-STD-171 PARA 5.3.1.2	PROJECT: M1911-A1 REDUX NAME: R Benson DATE: 09/15/2010
QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING	UNLESS OTHERWISE SPECIFIED (UOS): DIMENSIONS ARE IN INCHES TOLERANCES: PER DECIMAL PLACE X = ±.05, XX = ±.02, XXX = ±.015, XXXX = ±.005 ANGLES = ±5° MACHINED FINISH = 63-125 μIN REMOVE ALL BURRS AND SHARP EDGES (D) MAX. INTERPRET DRAWING IAW ANSI Y14.5-1994.	THIRD ANGLE PROJECTION	SIZE: D DWG/PART NO: 7268068 SCALE: 6:1 WEIGHT: 0.01 LBS
		APPROVED BY:	SHEET 1 OF 1

DATE PLOTTED: 5/25/2012

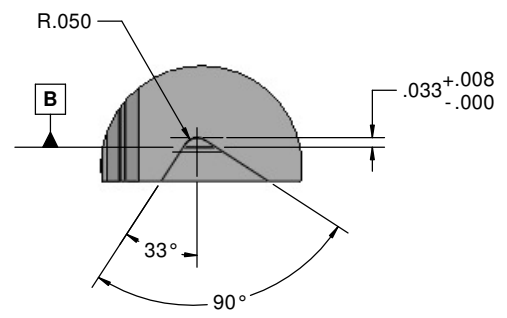
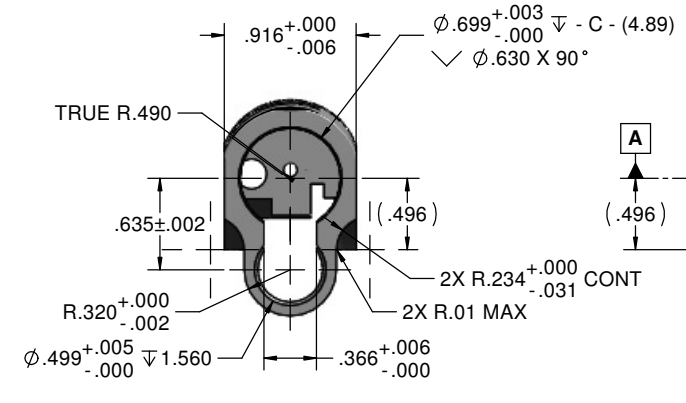
ZONE	REV	DESCRIPTION	DATE	APPRVD
D6 SH1	A	ADDED 220-.004 & (.238) DIMS. 436+.004 WAS SYMMETRICAL IN ERROR	4/05/2011	R BENSON
C6 SH2	C	ADDED MISSING 117-.005 & 128+.005 DIMS AND SECTION M-M. FEATURE MODELED, DIMS. MISSING.	4/13/2011	R BENSON
A3-4 SH2	C	ADDED MISSING VIEW PLANE N-N AT END VIEW, SH1, AND SECTION P-P, BOTH SHOWN ON SH2	5/22/2011	R BENSON



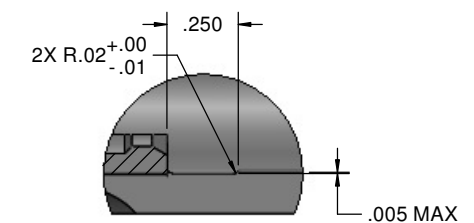
DETAIL C
SCALE 3 : 1



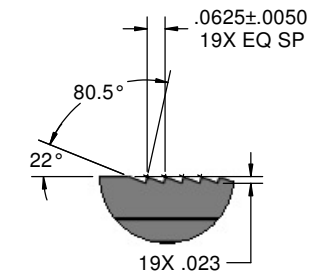
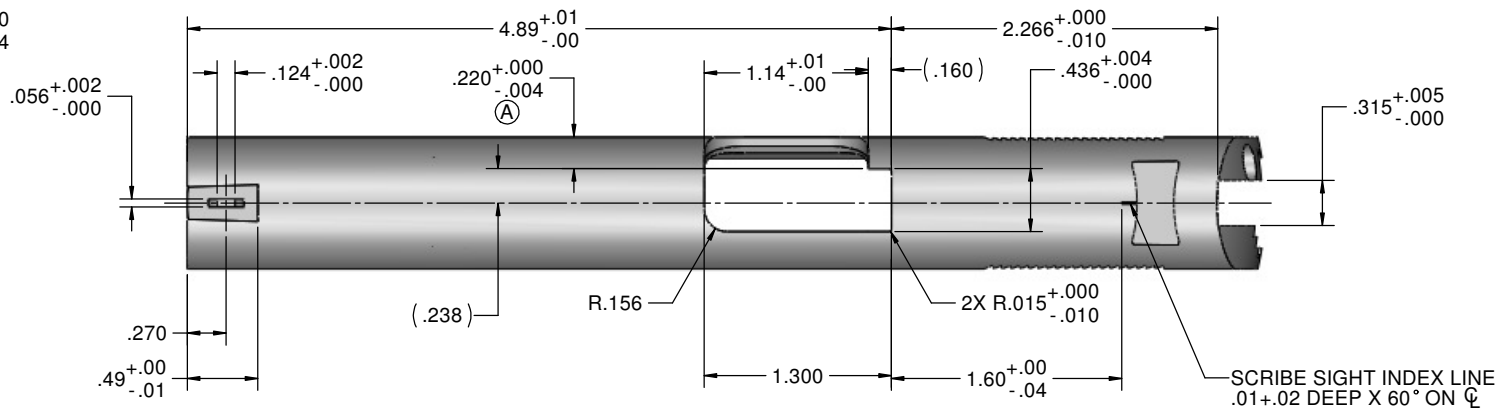
SECTION E-E
SCALE 3 : 1



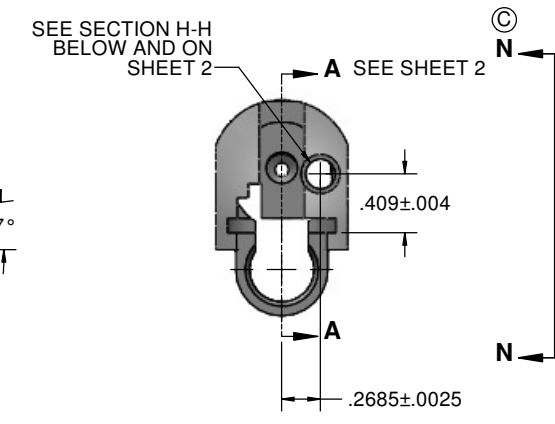
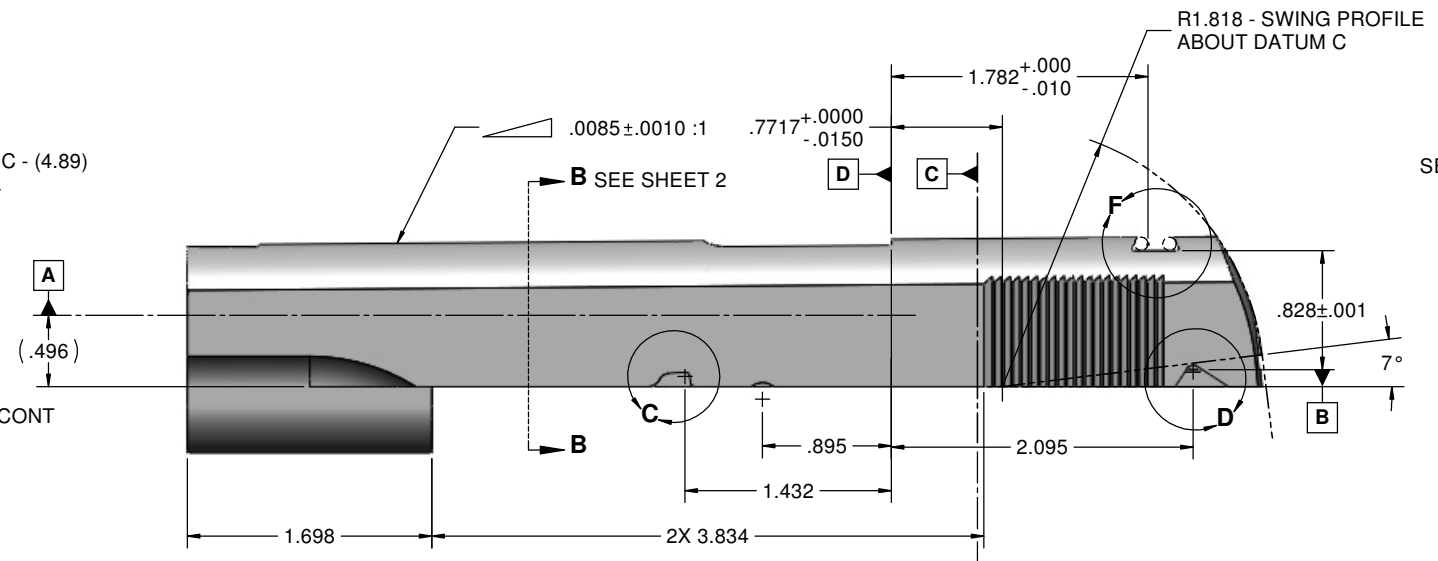
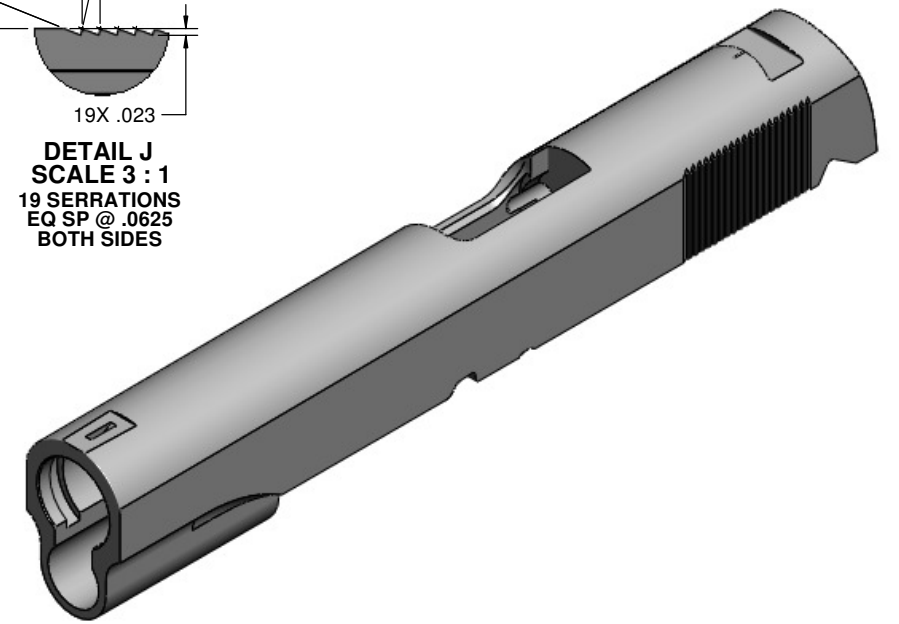
DETAIL D
SCALE 3 : 1



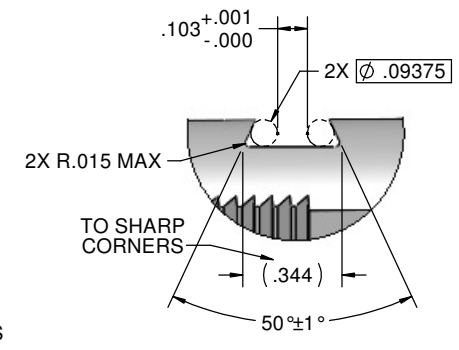
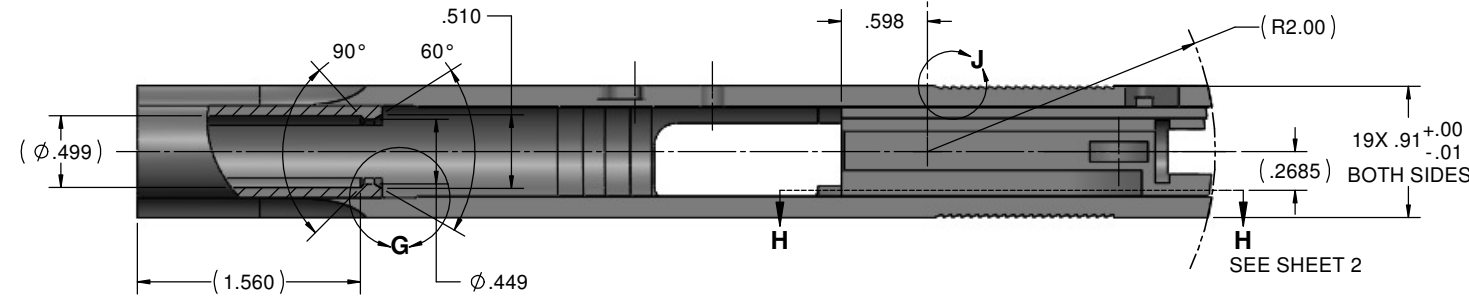
DETAIL G
SCALE 3 : 1
BOTH SIDES



DETAIL J
SCALE 3 : 1
19 SERRATIONS
EQ SP @ .0625
BOTH SIDES



NOTES:
1. MATERIAL: STEEL, 4140, ASTM A108;
AUSTENITE GRAIN SIZE 5 OR FINER.

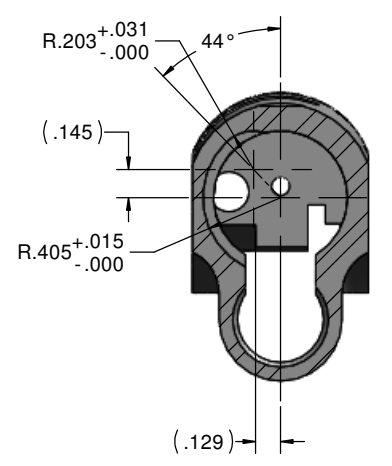


DETAIL F
SCALE 3 : 1

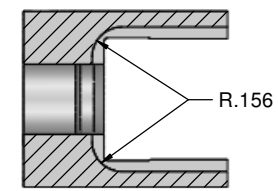
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<p>QTY REQD PER NEXT ASSY = 1</p> <p>DO NOT SCALE DRAWING</p>		<p>SCALE: 3:2</p> <p>WEIGHT: 0.78 LBS</p>		<p>SIZE: DWG/PART NO. D 7790314</p> <p>REV: C</p> <p>SHEET 1 OF 2</p>	

DATE PLOTTED: 5/25/2012

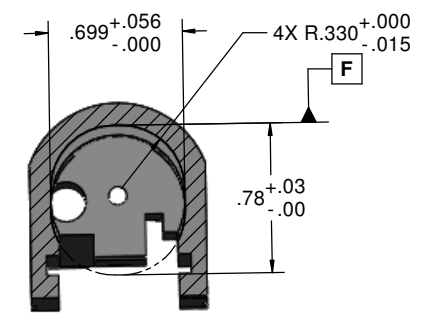
REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
-	-	See Sheet1	-	-



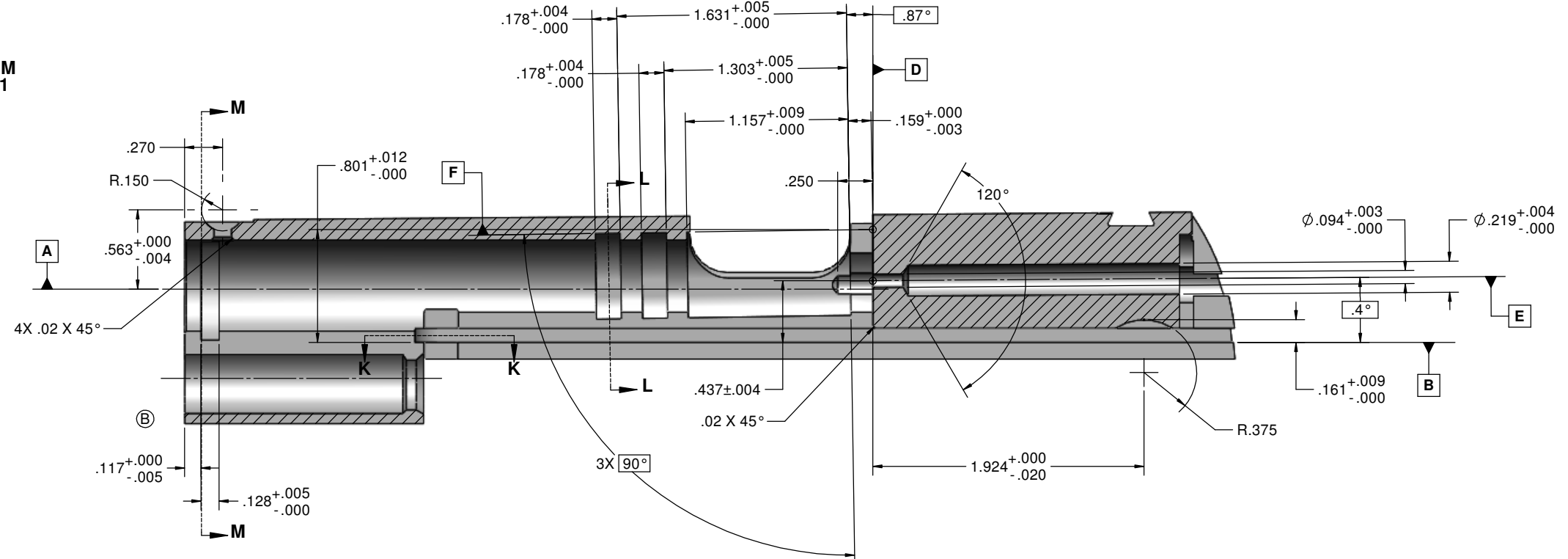
**SECTION M-M
SCALE 2 : 1**
B



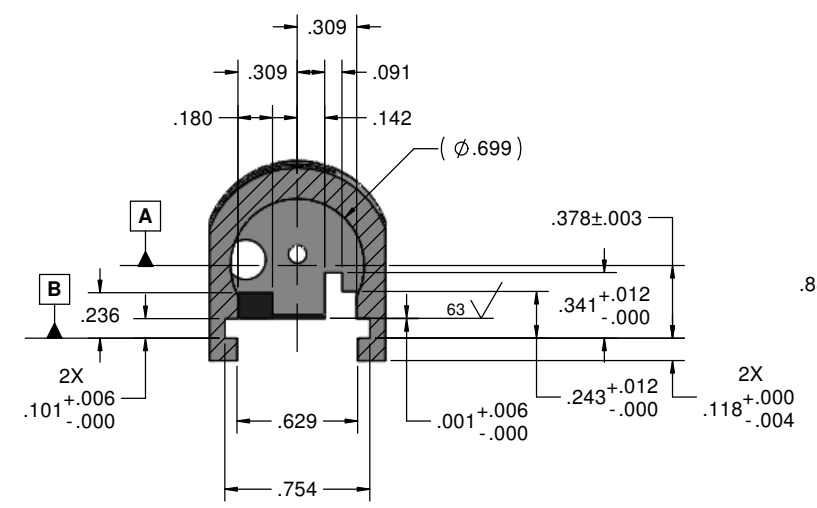
**SECTION K-K
SCALE 2 : 1**



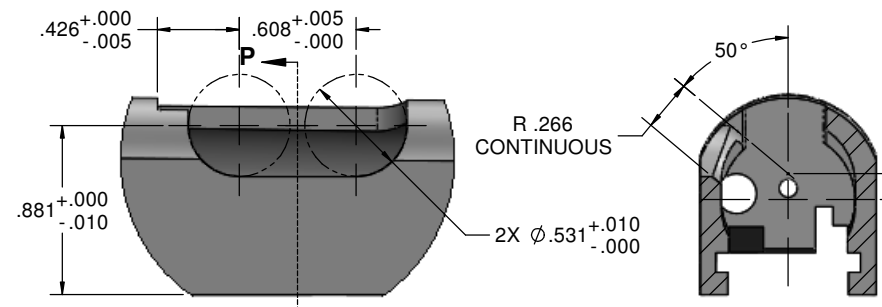
**SECTION L-L
SCALE 2 : 1
BREECH LOCK PROFILE
3 PLACES ALONG DATUM F**



**SECTION A-A
SCALE 2 : 1
FROM SHEET 1**

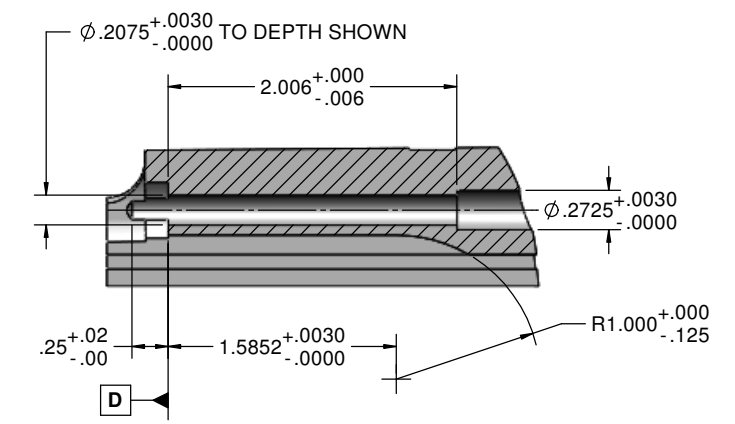


**SECTION B-B
SCALE 2 : 1
FROM SHEET 1**



**VIEW N-N ©
SCALE 2 : 1
FROM SHEET 1**

**SECTION P-P ©
SCALE 2 : 1**



**SECTION H-H
FROM SHEET 1**

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		<p>MATERIAL: SEE NOTE 1</p>	<p>PROJECT: M1911-A1 REDUX</p>	<p>SIZE: D</p>	<p>DWG/PART NO: 7790314</p>
		<p>HEAT TREAT: RH C 48-52</p>	<p>NAME: R Benson</p>	<p>DATE: 07/31/2010</p>	<p>REV: C</p>

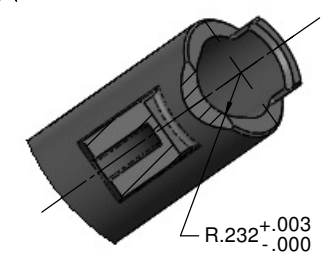
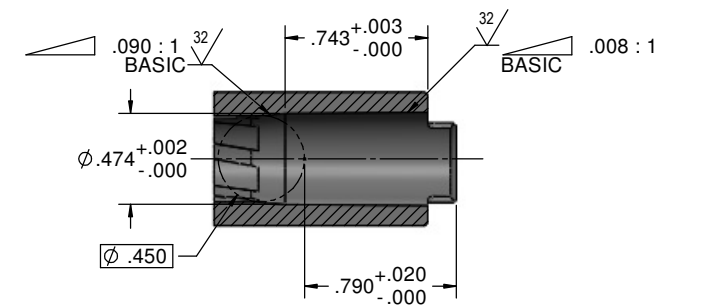
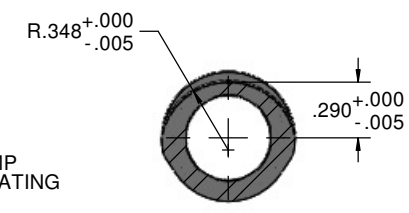
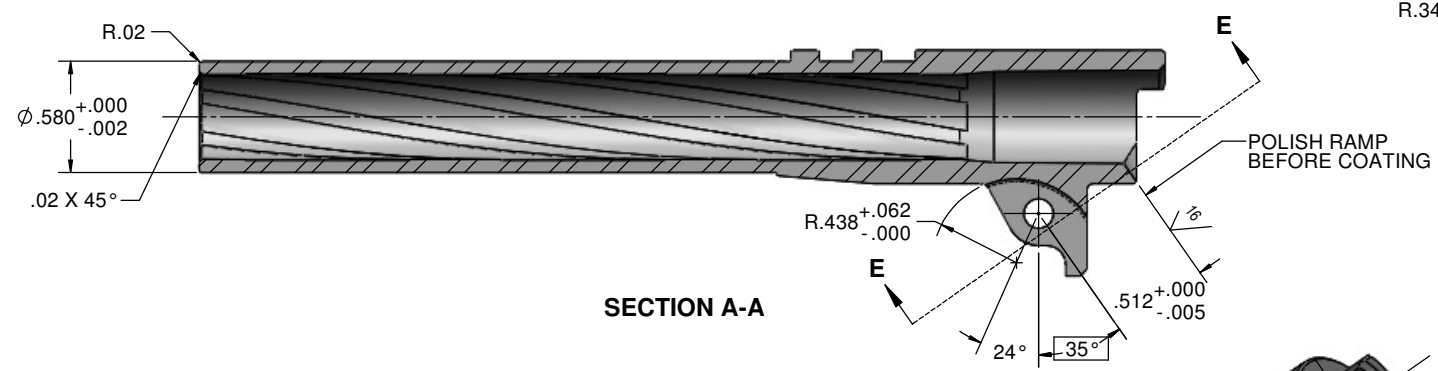
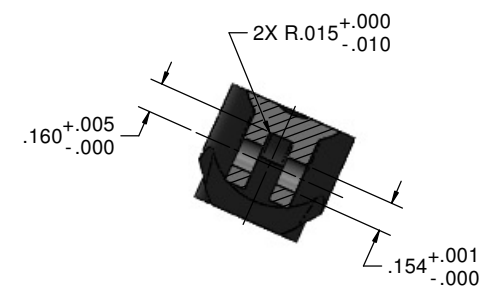
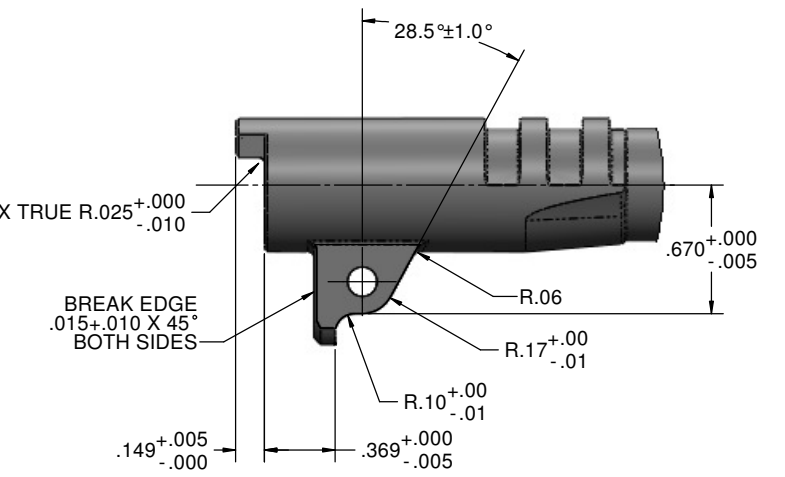
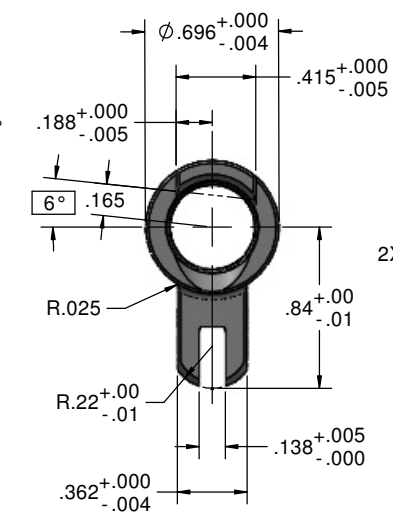
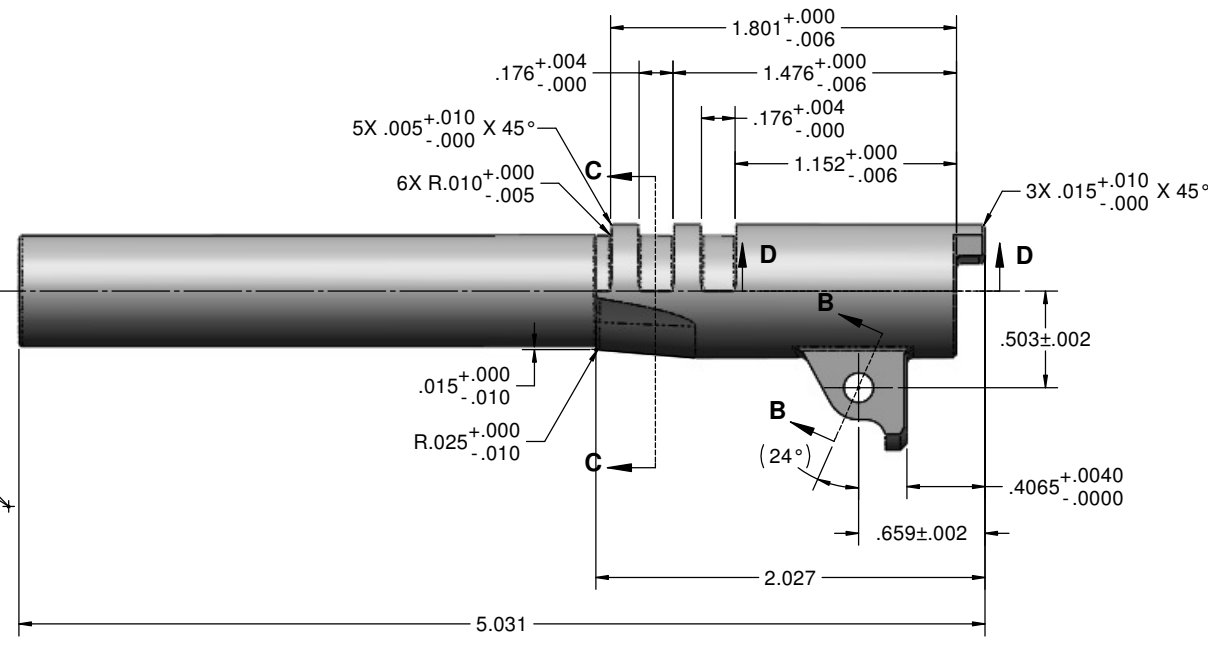
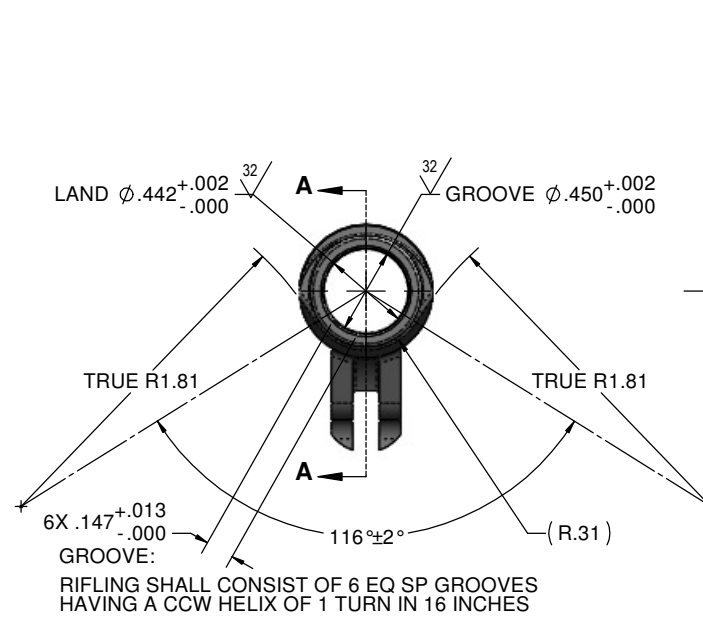
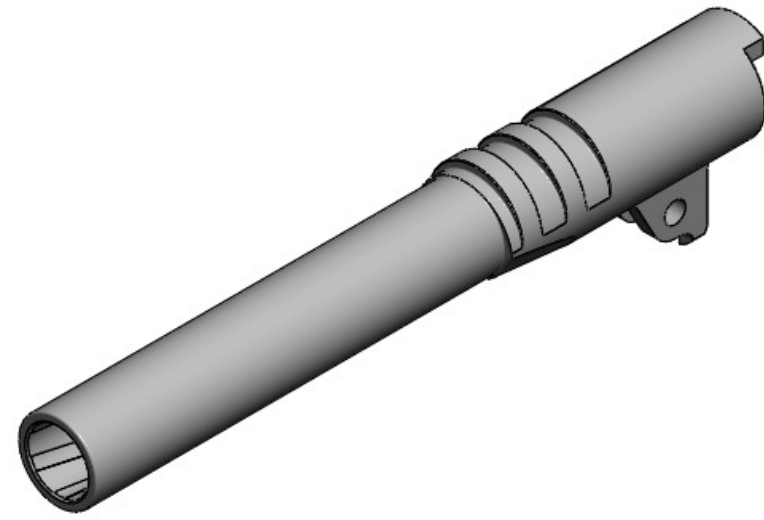
SCALE: 3:2 WEIGHT: 0.78 LBS SHEET 2 OF 2

DATE PLOTTED: 5/25/2012

REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD

NOTES:

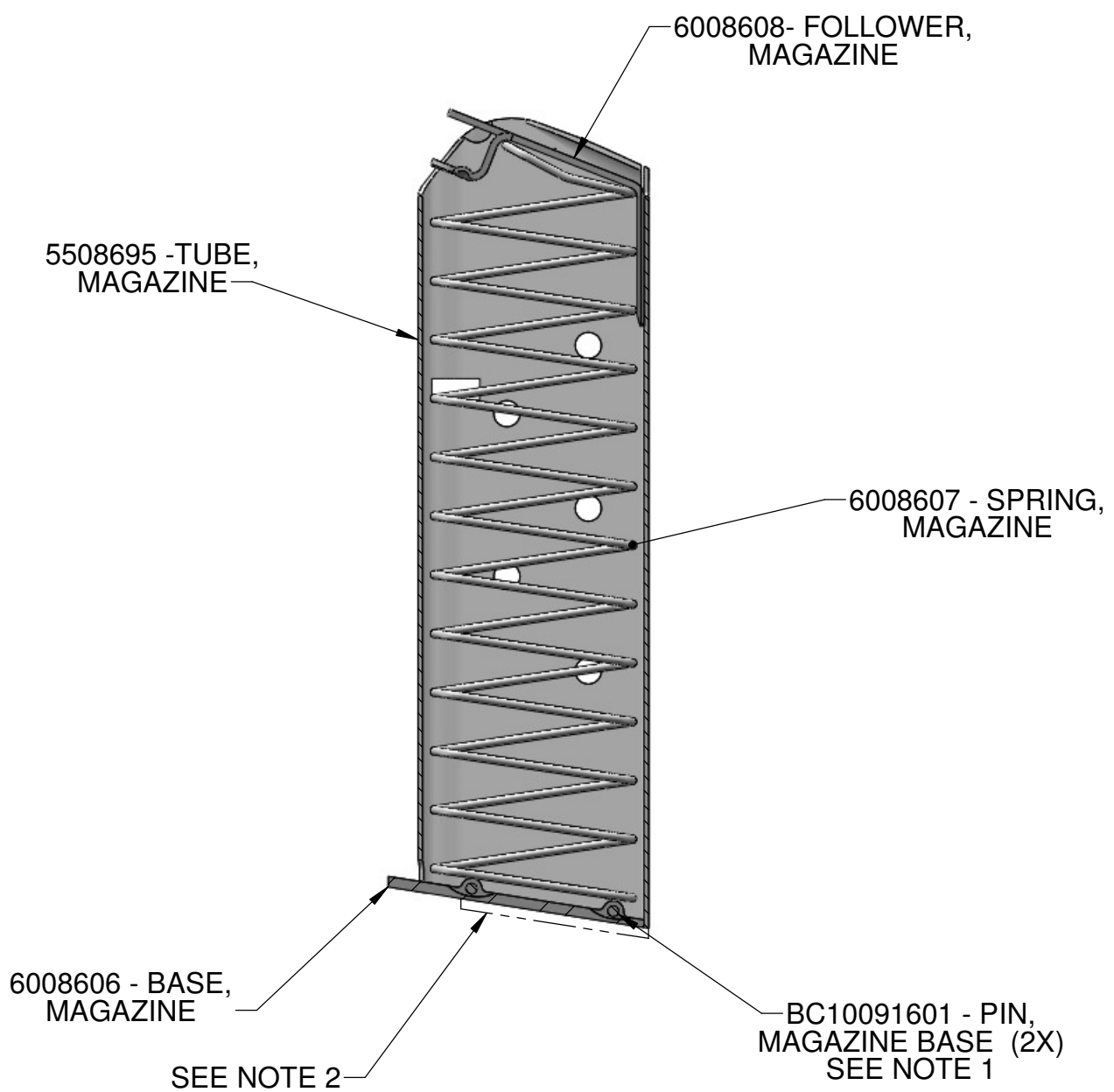
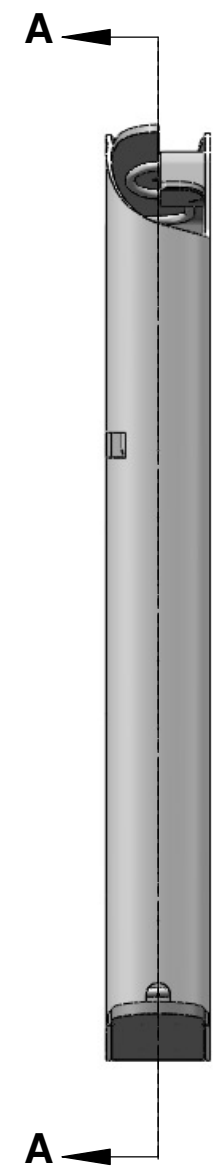
- MACHINED FINISH $\sqrt{63}$ EXCEPT AS NOTED.
- DIAMETERS AT MUZZLE SHALL NOT BE GREATER THAN THOSE AT BREECH.
- MATERIAL: STEEL, 4150, ASTM A-108; AUSTENITIC GRAIN SIZE 5 OR FINER.
- HEAT TREATMENT: AUSTEMPER TO RH C 53 TO 56.5. ALL DIMENSIONS APPLY AFTER HEAT TREATMENT.
- FINISH: THIN DENSE CHROME COATING (ARMOLOY TDC) IAW SAE AMS2438, AFTER SURFACE POLISHING.



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<p>UNLESS OTHERWISE SPECIFIED (UOS): DIMENSIONS ARE IN INCHES TOLERANCES: PER DECIMAL PLACE X = ±.05, XX = ±.02, XXX = ±.015, XXXX = ±.005 ANGLES: ±.5° MACHINED FINISH ±.125 μIN REMOVE ALL BURRS AND SHARP EDGES. (D) MAX. INTERPRET DRAWING IAW ANSI Y14.5-1994.</p>		<p>MATERIAL: SEE NOTE 3 HEAT TREAT: SEE NOTE 4 FINISH: SEE NOTE 5</p>		<p>THIRD ANGLE PROJECTION</p>		<p>PROJECT: M1911-A1 REDUX NAME: R Benson DATE: 09/15/2010</p>	
<p>QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING</p>		<p>SCALE: 2:1</p>		<p>SIZE: DWG/PART NO. D 7791193</p>		<p>WEIGHT: 0.21 LBS SHEET 1 OF 1</p>	

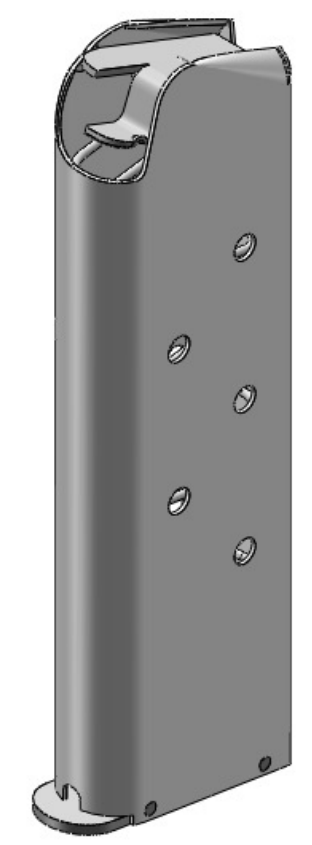
DATE PLOTTED: 5/25/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



NOTES:

1. PEIN OVER PIN END TO FILL HOLE CSK, BOTH SIDES, TO FIRMLY RIVET TUBE TO BASE. GRIND SMOOTH, FLUSH WITH TUBE. 2 PLACES.
2. GRIND PROTRUDING TUBE FLUSH WITH BASE ON 3 SIDES.

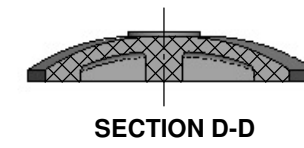
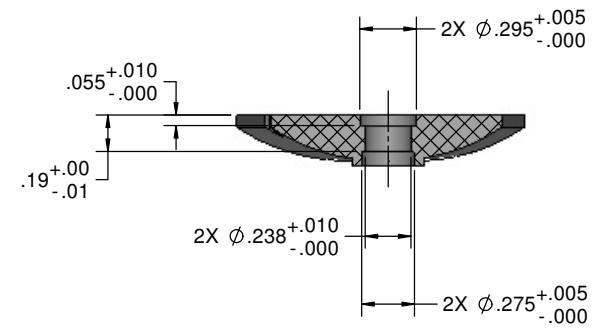
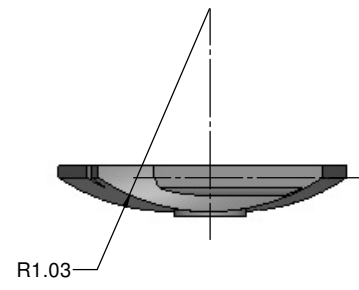


SECTION A-A

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	<p>QTY REQD PER NEXT ASSY = 1</p>		<p>MATERIAL: DRAWING CALLOUTS</p>		<p>THIRD ANGLE</p>		<p>PROJ: M1911-A1 REDUX</p>	
	<p>DO NOT SCALE DRAWING</p>		<p>HEAT TREAT:</p>		<p>DRAWN BY: R Benson</p>		<p>DATE: 09/16/2010</p>	
			<p>FINISH:</p>		<p>APPROVED BY:</p>		<p>SIZE: B DWG/PART NO. BC10091603 REV</p>	
						<p>SCALE: 1:1 WEIGHT: 0.14 LBS SHEET 1 OF 1</p>		

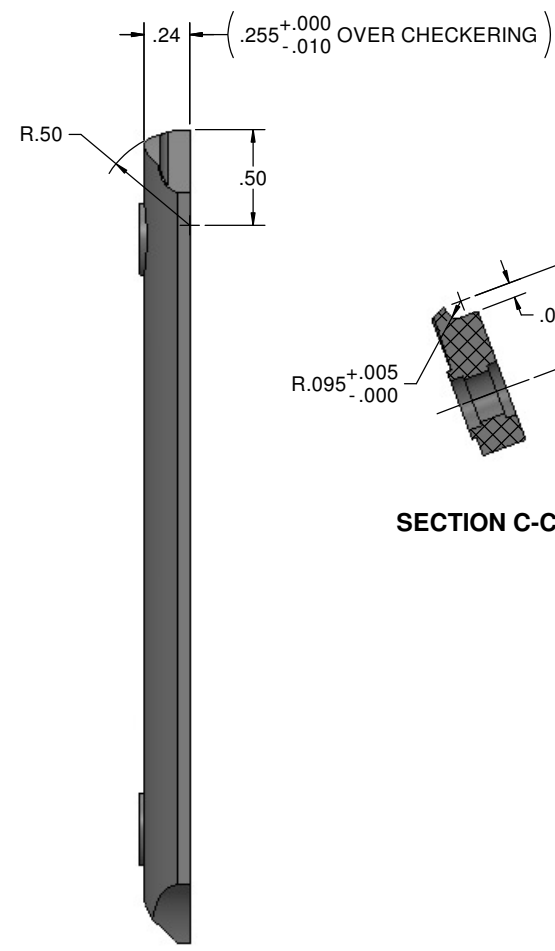
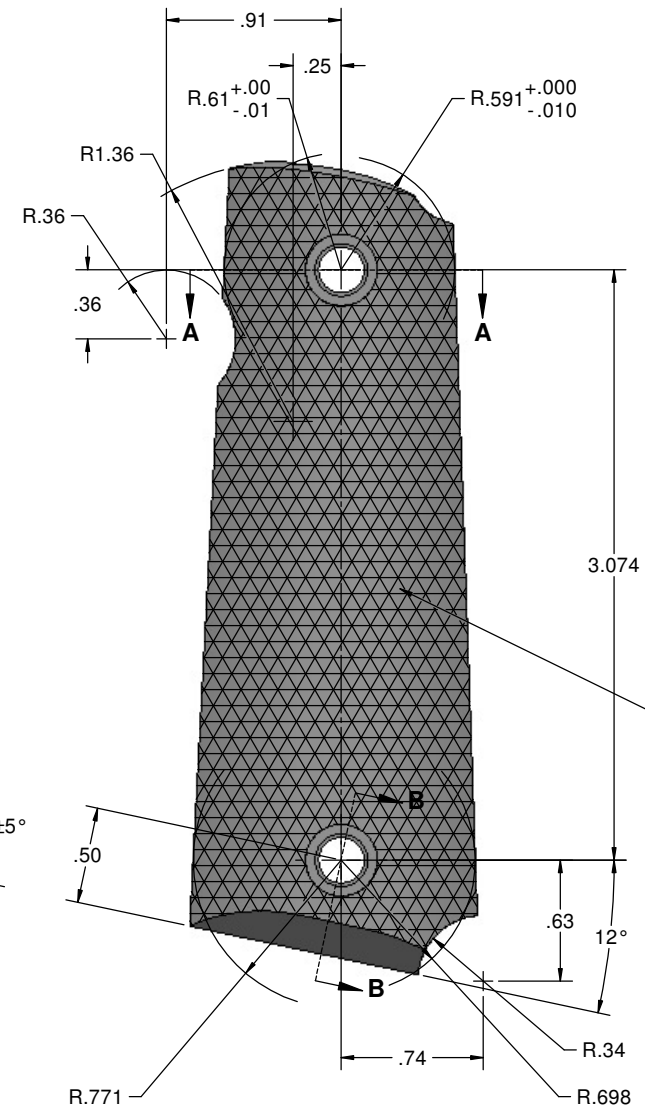
DATE PLOTTED: 5/25/2012

REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPRVD

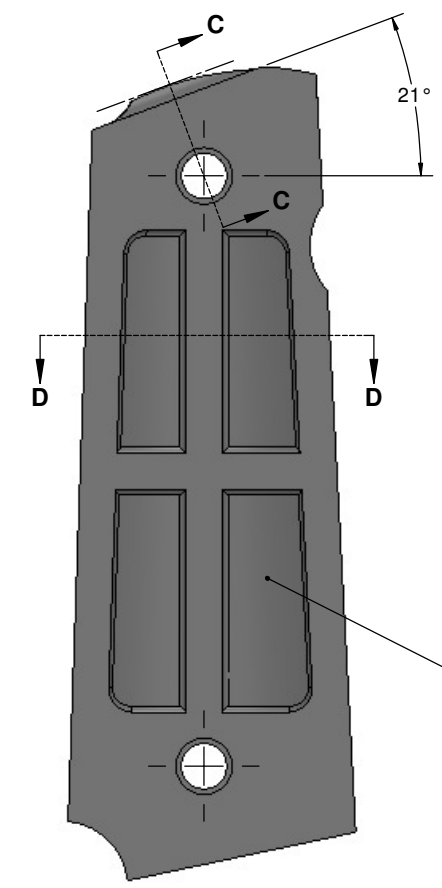


SECTION A-A

- NOTES: (UNLESS OTHERWISE SPECIFIED)
- RECESSES SHOWN ARE NONFUNCTIONAL, AND ARE PERMITTED WITHIN REASONABLE LIMITS FOR STABILITY OF THE MOLDED PRODUCT.
 - MATERIAL: MOLDING PLASTIC IAW MIL-M-14, PHENOLIC, TYPE CFI-20. COLOR: NO. 20045, 20059 OR 20062 OF TABLE ii, FED STD NO. 595; SEMI-GLOSS BROWN.
 - CHECKERING IS 20° DIAGONAL DIAMOND, 90° GROOVES, .06 CENTER TO CENTER ON THE DIAGONAL.

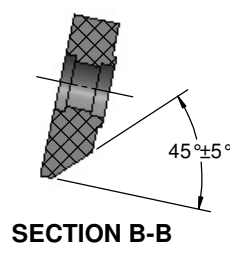


SECTION C-C

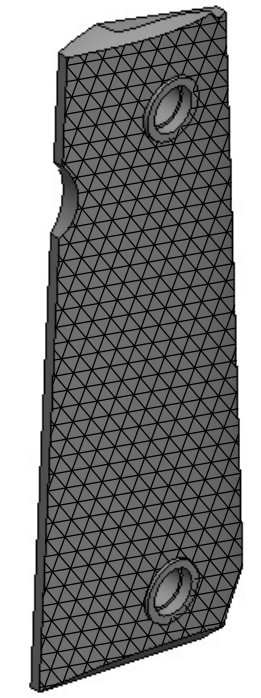
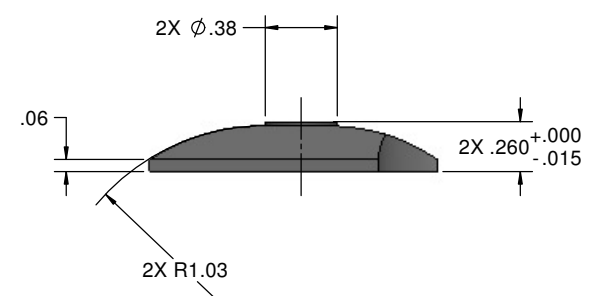


SEE NOTE 1

SEE NOTE 3



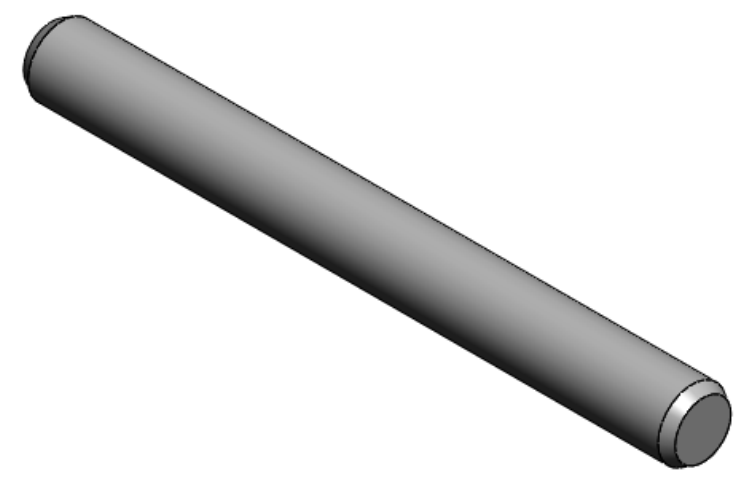
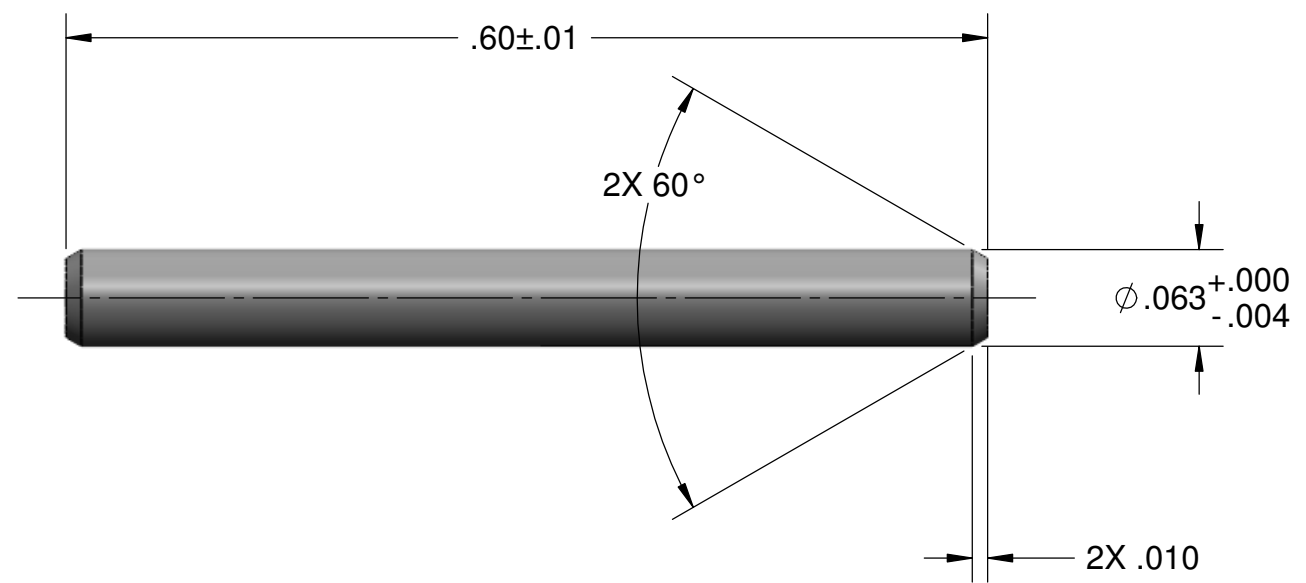
SECTION B-B



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		MATERIAL: SEE NOTE 2 HEAT TREAT:	PROJECT: M1911-A1 REDUX NAME: R Benson DATE: 09/06/2010
QTY REQD PER NEXT ASSY = 1 DO NOT SCALE DRAWING	UNLESS OTHERWISE SPECIFIED (UOS): DIMENSIONS ARE IN INCHES TOLERANCES: PER DECIMAL PLACE X = ±.05, XX = ±.02, XXX = ±.015, XXXX = ±.005 ANGLES = ±5° MACHINED FINISH = ±3-12 μIN REMOVE ALL BURRS AND SHARP EDGES. (D) MAX. INTERPRET DRAWING IAW ANS Y14.5-1994.	FINISH: APPROVED BY:	SIZE: D DWG/PART NO: BC10090501 SCALE: 2:1 WEIGHT: 0.02 LBS SHEET 1 OF 1

DATE PLOTTED: 5/25/2012

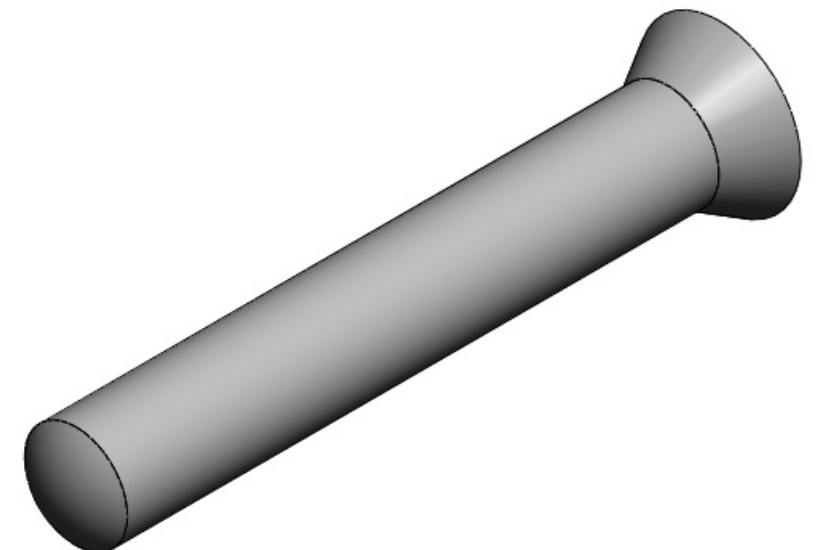
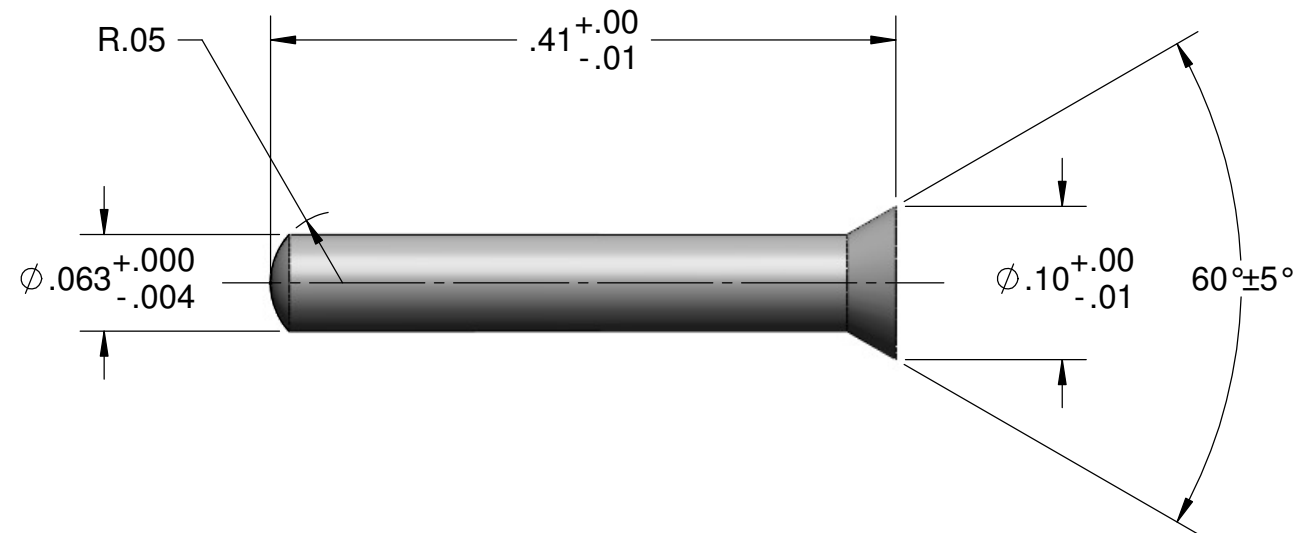
REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



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	<p>UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, XX = ±.02, XXX = ±.005, XXXX = ±.0005 ANGLES = ±5°, MACHINED FINISH = 63-125 μIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994</p>		<p>MATERIAL: STEEL 1018 ASTM A108</p>		<p>THIRD ANGLE</p>		<p>PROJ: M1911-A1 REDUX</p>		<p>SIZE</p>	<p>DWG/PART NO.</p>		<p>REV</p>
	<p>HEAT TREAT:</p>		<p>FINISH: MIL-STD-171 PARA 5.3.1.2</p>		<p>DRAWN BY: R Benson</p>		<p>DATE: 09/16/2010</p>		<p>B</p>	<p>BC10091601</p>		
	<p>QTY REQD PER NEXT ASSY = 2</p>				<p>APPROVED BY:</p>							
<p>DO NOT SCALE DRAWING</p>												

DATE PLOTTED: 5/25/2012

REVISION HISTORY			
REV	DESCRIPTION	DATE	APPRVD



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	<p>UNLESS OTHERWISE SPECIFIED [UOS]: DIMENSIONS ARE IN INCHES. TOLERANCES PER DECIMAL PLACE: X = ±.05, .XX = ±.02, .XXX = ±.005, .XXXX = ±.0005 ANGLES = ±.5°, MACHINED FINISH = 63-125 µIN. REMOVE ALL BURRS AND SHARP EDGES .02 MAX INTERPRET DRAWING IAW ANSI Y14.5M -1994</p>		<p>MATERIAL: DRILL ROD, O2 ASTM A681 HEAT TREAT: RH C 34.5-41</p>		<p>THIRD ANGLE </p>		<p>PROJ: M1911-A1 REDUX</p>		<p>SIZE</p>	<p>DWG/PART NO.</p>		<p>REV</p>
	<p>QTY REQD PER NEXT ASSY = 1</p>		<p>FINISH: ASTM A171 PARA 5.3.1.2</p>		<p>DRAWN BY: R Benson</p>		<p>DATE: 09/16/2010</p>		<p>B</p>	<p>BC10091602</p>		<p>SHEET 1 OF 1</p>

DO NOT SCALE DRAWING

SCALE: 12:1 WEIGHT: 0.00 LBS SHEET 1 OF 1

DATE PLOTTED: 5/25/2012

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