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TO: H. J. Hackman
FROM: M. H. Walker
SUBJECT: MODEL 40-X MANUFACTURE AND ASSEMBLY

The following is a list of the critical operations on the M/40-X as now visualized, per request of PE&C.

Barrel

Blank Straightening - .020 Max. indicator
Drilling - .050 Max. indicator on hole run out
Reaming - Finish at least equal to M/37
Rifling - good control on lubrication and size
Leading - finish and uniformity
Turning - control of concentricity and size
Chambering & cut-off & crown
Browning - prevention of pitting in bore from Browning acid

Receiver

Turning, boring, and threading - concentricity and alignment of
bolt hole and barrel threads with O.D.
Locking recess - squareness, finish, and location
Drilling and tapping of Guard Screw holes and Sight holes - location
and alignment

Stock

Inletting of Barrel & Receiver

Alignment of barrel and receiver grooves
Finish and size of receiver grooves
Alignment and location of Guard Screw holes
Location and alignment of recoil shoulder