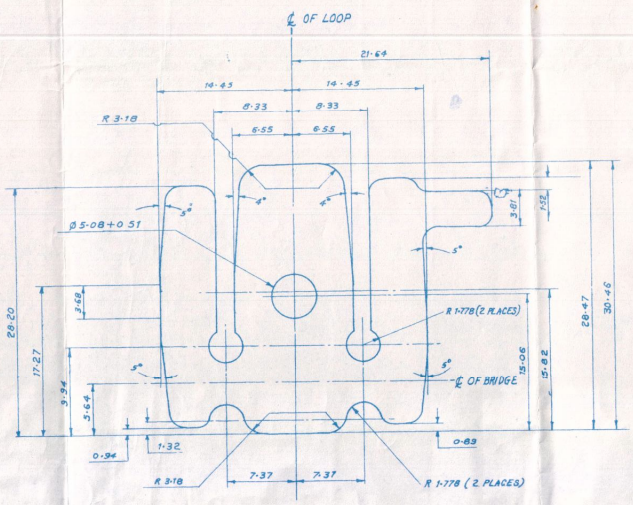
NOTES:-

1. MATERIAL FOR LINK IS COLD ROLLED, BRIGHT, ANNEALED STEEL STRIP TO SPEC IS 2507-1975 Gr. 65C6 OR 70 C6 COLD ROLLED BRIGHT ANNEALED STRIP. SHOULD BE OF 170 VPN MAX. & SHOULD HAVE AN AVERAGE GRAIN SIZE OF 5 OR FINER (ASTM STANDARD). MAX. PERMISSIBLE DEPTH OF TOTAL & PARTIAL DECARBORIZATION OF 0·025 OR 2% THE THICKNESS WHICHEVER IS GREATER THICKNESS OF STEEL STRIP = (22 B.G) 0·794 ± 0·038.
2. FINISH 3·2 mm EXCEPT 6·3 mm. ON SHEARED SURFACES.
3. EDGE BREAK SHALL NOT EXCEED 0·25.
4. ALL EDGES INDICATED BY PROTRUDING LINES IN ISOMETRIC VIEW SHALL BE BROKEN 0·05 + 0·20.
5. LINKS AFTER COMPLETION OF ALL MACHINING, FORMING & HEAT TREATMENT WILL BE PHOSPHATED IN ACCORDANCE WITH SPEC. SPEC ISS 0465-01-1988 CLASS 1 WITH COATING WT. 7540 Mg/SQ. METER MIN & SUPPLEMENTARY FINISH OF LANOLINE (70 SPEC. IND/6L/2B0Z) SOLUTION WITH WHITE SPIRIT (TO SPEC. IND/ME/57) AS STATED IN PARA 13(c)(ii) OF SPEC. 1A/1279. OR ALTERNATIVELY IN ADDITION TO THE MATERIALS INDICATED IN THE SPEC. 1A 1279, PARA 16 (d) (i), USE OF CASTROL RUSGUARD P-213 1B ALSO PERMITTED.
6. DIMENSIONS SHALL BE CONTROLLED TO MEET 12·55 MAX. REQUIREMENT.
7. LINKS AFTER FORMING SHOULD BE HARDENED BETWEEN 820° TO 840° C OIL QUENCHED & TEMPERED AT 285° TO 305° C. FOR 30 MINUTES TO AIM AT A HARDNESS OF 400-470 VPN.
8. LINKS SHALL BE FREE OF CRACKS, TEARS & MALFORMATION.

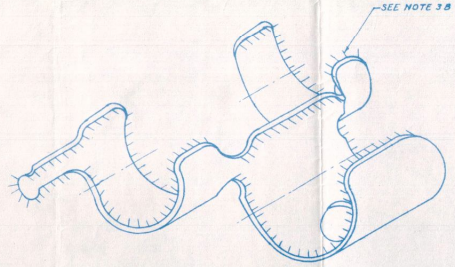


GRAIN

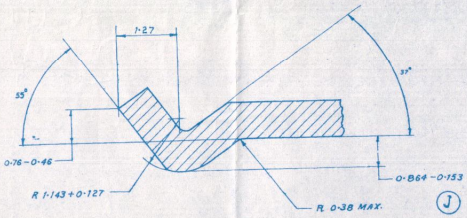
BLANK

BLANK DIAMENSIONS ARE FOR REFERENCE AND SHALL BE ADJUSTED TO PRODUCE THE COMPONENT WITHIN FINAL REQUIREMENTS RADII 1·6 UNLESS OTHERWISE SPECIFIED.

ACTUAL SIZE
SCALE : 1:1

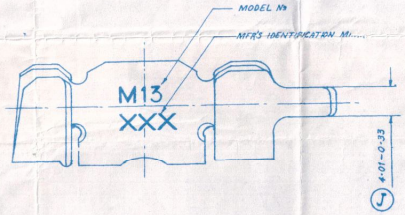


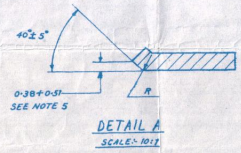
ISOMETRIC VIEW



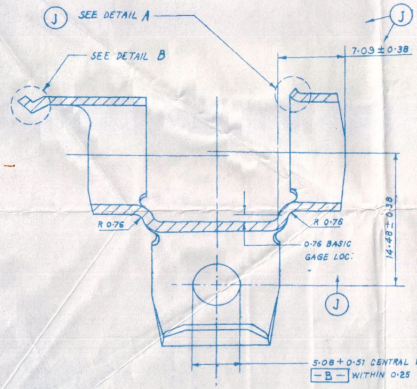
DETAIL B
SCALE :- 20:1

APPLY MODEL Nº: M 13 AND MFR'S IDENTIFICATION MARK 2·38 HIGH X 0·13 + 0·13 DEEP IN AREA DEPICTED.

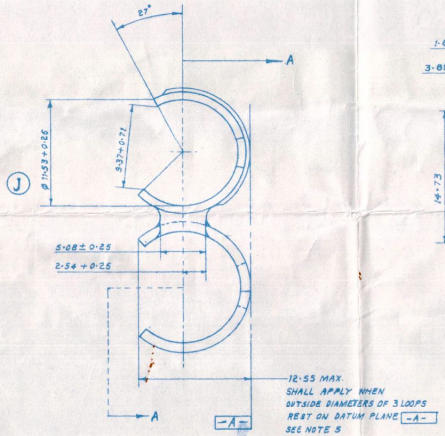


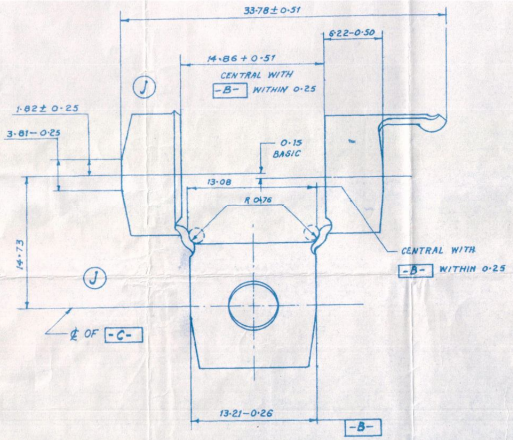


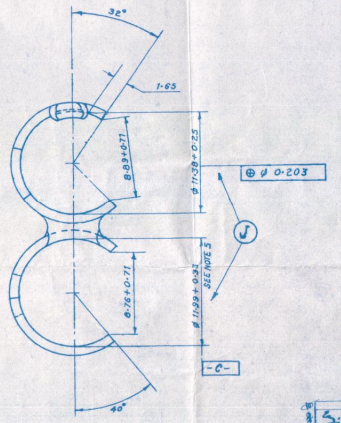
DETAIL A
SCALE :- 10:1



SECTION A-A







F 7268339

SYM	DESCRIPTION	DATE	APPROVAL
	SCANNED WITHOUT CHANGE	4·3·05	
	MATERIAL AMENDED	24·8·04	DC 36571-A
	IN NOTE Nº 6 PROTECTIVE FINISH AMENDED	6·7·91	DC 35132-A
	RETRACED WITHOUT CHANGE	21·5·88	
GH/-	PROJECTS 2-2301-4, 2730-4, 3248-4, 3004-4, 3010-4, 3053-4 & 3298-4		SH/-
JH	REF ED Nº 3A 2673L	26 SEP 82	SH/-
HE	REF ED Nº 3A 2830	1 MAR 82	-
G	REMARK AND REVISED	17 JAN 62	SH/-
F	REF. ED. Nº 3A 2572C	16 SEP 59	SH/-

(H) CODE IDENT Nº 00000

ORD PART Nº 7268389

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7268389

PHYSICAL PROPERTIES	
YP	
TS	
EL2	
RA	
BH	
RH	

SEE ENGRG RECORDS
NEXT ASSY | USED ON
APPLICATION
DO NOT | APPLY PART Nº

DIMENSIONS ARE IN mm.
TOL ON UNTOL DIMNS. ± 0·127
ANGLES ± 8°
MATERIAL
SEE NOTE 1
HEAT TREATMENT
SEE NOTE 6
FINAL PROTECTIVE FINISH
SEE NOTE 4

ORIGINAL DATE OF DRAWING 20 DEC 57
DRAUGHTSMAN SH/- | CHECKER SH/-
TRACER SH/- | CHECKER SH/-
ENGINEER SH/- | ENGINEER SH/-
SUBMITTED SH/-
ORD CORPS
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE SH/-
ORD CORPS

LINK, CARTRIDGE METALLIC BELT 7·62-MM, M13

SPRINGFIELD ARMORY
ORDNANCE CORPS
DEPARTMENT OF THE ARMY
SPRINGFIELD 1, MASS

DWG SIZE F | 7268389 | SHEET 1 OF 1

SCALE :- 4:1 | UNIT WT 0·01 LB.

TRACED AT CQA (A)	TRD	CHD	DATE
KIRKEE	C/S		31·5·88