1/4-20 UNC \( \varphi \) 31.75
DRILL & TAP

\[ \varnothing 15.87 \pm 0.01 \pm 0.00 \]
ZONE A

5209°

\[ \varnothing 5.64 \pm 0.00 \pm 0.03 \]

7453°

\[ \varnothing 4.72 \pm 0.00 \pm 0.03 \]

R 0.80

#1 CENTER DRILL PERMISSIBLE

BETWEEN POINTS OF INTERFACE
BETWEEN FILLET & CONICAL SURFACE

DETAIL N
SCALE 5 : 1

DRAWN
JD BALUDOT, BSIT

DESIGNED

CHECKED
ENGR SVF BAGUIO, ChE

Recommend Approval:
ENGR. DENNIS DS CHUA, ME

Approved by
DANIEL R CASABAR JR, DIRECTOR

1 PUNCH

1 STEEL M2 / 58-60 HRc (UNDERHARDEN)

MATERIAL / HARDNESS

GOVERNMENT ARSENAL
Camp General Antonio Luna
Lamao, Limay, Bataan

Republic Of The Philippines
Department of National Defense

Scale:
1 : 1

Dimension:
mm

Dwg. No.
AM855T2-02a

Shl.No.
1

TITLE:
1ST DRAW PUNCH
STATION #2
5.56mm M855 BULLET ASSEMBLY MACHINE

Date:
APR. 24, 2019

Date:
April 24, 2019

Date:
04/25/11

Date:
TRANSCRIBED FROM WBF DWG. NO. 9612-19-0251

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<td>DIE CAGE</td>
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<td>H-13 STEEL / 46-48 HRC</td>
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Republic Of The Philippines
Department of National Defense
Camp General Antonio Luna
Lamao, Limay, Bataan

GOVERNMENT ARSENAL

TITLE:
1ST DRAW LOWER DIE
STATION # 2
5.56mm M855 BULLET ASSEMBLY MACHINE

DRAWN: JD BALUYOT, GSIT
DATE: APR. 24, 2019

DESIGNED: 
DATE: 

CHECKED: ENGR. SK RAGUIO, CHE
DATE: April 24, 2019

Recommend Approval: 
DATE: 04/25/19

Approved by: DANIEL R CASABAR JR, DIRECTOR
DATE: 

Scale: 3:1
Dimension: mm
Dwg. No. AM855T2-02d
Sht. No. 1

APPROVED

SMOOTH THE ANGLE
C.076 X 45.0°

Ø44.425 _0.013 +0.000
Ø19.05

Ø6.70 _0.02 +0.00
0.00762 A

APPLY GEN. TOLERANCE TO UNSPECIFIED TOLERANCES
> 0 TO 6  > 6 TO 30  > 30 TO 120  > 120 TO 315  > 315 TO 1000
±0.1 ±0.2 ±0.3 ±0.5 ±0.8
TRANSCRIBED FROM WBF DWG. NO. 9612-19-0351

1  DIE INSERT  2  GC 209 / 90.5 - 92 HRA
1  DIE CASE  1  H-13 STEEL / 46-48 HRC

QTY  DESCRIPTION  PART NO  MATERIAL / HARDNESS

DRAWN  JD BACUZO, BSIT  Date: APR. 24, 2019
DESIGNED  Date:
CHECKED  Date: April 24, 2019
Recommend Approval: ENGR. DENNIS CHUA, ME
Approved by: DANILO R. CASABAR, JR.

TITLE: 2ND DRAW DIE
STATION # 3
5.56mm M855 BULLET ASSEMBLY MACHINE

Republic Of The Philippines
Department of National Defense
GOVERNMENT ARSENAL
Camp General Antonio Luna
Lanang, Limay, Bataan

Scale: 3 : 1
Dimension: mm
Dwg. No. AM655T2-03d
Sht.No. 1 Of 1
TRANSCRIBED FROM WBF DWG NO. 9612-19-0451

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DIE INSERT 2 GC320 85.1 ~ 86.6 HRA
DIE CASE 1 H-13 STEEL 46 ~ 48 HRC

DRAWN J C CABANILLA, BSIT
DESIGNED
CHECKED ENGR S K HAGUO, Che

Republic Of The Philippines
Department of National Defense
GOVERNMENT ARSENAL
Camp General Antonio Luna
Lamao, Lemy, Bataan

Scale: 2 : 1
Dimension: mm
Dwg. No. AM855T2-04d
Shtr. No. 1 of 1
DRILL & TAP
1/4-20 UNC \( \varphi \) 31.75

\[ \varnothing 15.87 \pm 0.005 \mp 0.000 \]

\[ \varnothing 4.62 \mp 0.01 \mp 0.00 \]

\[ R1.02 \]

\[ \varnothing 4.52 \]

\[ 53.37 \]

\[ 1.43 \]

\[ 10.72 \]

\[ 16.95 \]

\[ 5.99 \]

\[ 0.00 \]

\[ 2.3 - 0.02 \]

\[ T.S \]

DETAIL R
SCALE 7:1

TRANScribed FROM WBF DWG. NO. 9612-19-0510

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1 STEEL M2 / 58-60 HRC (UNDERHARDEN)

Republic of the Philippines
Department of National Defense

GOVERNMENT ARSENAL
Camp General Antonio Luna
Lamao, Limay, Bataan

1:1 Scale:

mm Dimension:

AM855T2-05a Dwg. No.

1/1 Sht. No.

2ND POINT PUNCH
STATION # 5
5.56mm M855 BULLET ASSEMBLY MACHINE

DRAWN

APR. 24, 2019

Date:

Designed:

RESIGNED

Date:

CHECKED

ENGR SK DAAGUIO, CHE

Date:

Recommend Approval:

DATE:

APPROVED:

DATE:

DANIEL L CASABAR JR
DIRECTOR
TRANSCRIBED FROM WBF DWG NO. 9612-19-0551

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DIE INSERT 2 GC 320 85.1 ~ 86.6 HRA
DIE CASE 1 H-13 STEEL 46 ~ 48 HRC

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Scale: 2 : 1
Dimension: mm
Dwg. No. AM855T2-05c
Sh. No. 1

Republic Of The Philippines
Department of National Defense
Camp General Antonio Luna
Lamao, Limay, Bataan

2ND POINT DIE
STATION #5
5.56mm M855 BULLET ASSEMBLY MACHINE

TRANScribed from WBF DWG NO. 9612-19-0551

J C CABANILLA, BSIT

ENGR S K C BAGUIO, Che

ENGR DENNIS DS CHUA, ME
ACTG. SUPERINTENDENT, C&B

DANIEL R CASABAR JR
DIRECTOR