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

\( \varnothing 15.87 \pm 0.01 \) ZONE A

\( \varnothing 15.87 \) ZONE B

\( \varnothing 5.64 \pm 0.00 \) R 0.80

\( \varnothing 4.72 \pm 0.00 \) #1 CENTER DRILL PERMISSIBLE

BLEND SMOOTH

BETWEEN POINTS OF INTERFACE BETWEEN FILLET & CONICAL SURFACE

DETAIL N

SCALE 5 : 1

TRANSCRIBED FROM WBF DWG. NO. 9612-19-0210

1

PUNCH

1

STEEL M2 / 58-60 HrC (UNDERHARDEN)

QTY

DESCRIPTION

PART

NO

MATERIAL

HARDNESS

DRAWN

JD BAHULOT, BSIT

APR. 24, 2019

DESIGNED

Date:

CHECKED

ENGR SKY PEGUIG, ChE

April 24, 2019

Recommended Approval:

ENGR. DENNIS DS CHUA, ME

April 25, 2011

Approved by:

DANIEL R. CASABAR JR

DIRECTOR

Scale:

1 : 1

Dimension:

mm

TITLE:

1ST DRAW PUNCH

STATION #2

5.56mm M855 BULLET ASSEMBLY MACHINE

Republic Of The Philippines
Department of National Defense

GOVERNMENT ARSENAL

Camp General Antonio Luna
Lampao, Limay, Bataan

Dwg. No.

AM855T2-02a

Shl.No.

1

Of

1
TRANScribed FROM WBF DWG. NO. 9612-19-0251

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

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

Scale: 3:1
Dimension: mm
Dwg. No. AM855T2-02d
Sh. No. 1 Of 1
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TRANSCRIBED FROM WBF DWG. NO. 9612-19-0252

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Republic Of The Philippines
Department of National Defense

GOVERNMENT ARSENAL
Camp General Antonio Luna
Lamad, Limay, Bataan

Scale: 3:1
Dimension: mm

Dwg. No.: AM855T-02e
Sht.No.: 1

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

Recommend Approval:  
ENGR. DENNIS DS CHUA, ME

Checked:  
ENGR SW PAGUIO. ChE

Drawn:  
JD BAUVIZOT, BSIT

Designed:  

Approved by:  
DANIEL R CASABAR JR

Date: APR. 24, 2019
Date: April 24, 2019
Date: 04/25/19
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 BACOY, MT, BSIT

DESIGNED

CHECKED
ENGR SIXTO BUIO, ChE

Recommend Approval:
ENGR. DENNIS DS CHUA, ME

ACTG. SUPT., G85

Approved by:
DANIEL R. CASABAR JR

DIRECTOR

Date:
APR. 24, 2019

Date:
April 24, 2019

Date:
04/25/19

Scale: 3:1

Dimension: mm

Dwg. No.
AM855T2-03d

Sh. No.
1

Of
1

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

TITLE:
2ND DRAW DIE
STATION # 3
5.56mm M855 BULLET ASSEMBLY MACHINE
**DRILL AND TAP**

1/4-20 UNC \( \varphi \) 31.75

**SCALE 1:1**

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<td>April 24, 2019</td>
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**GOVERNMENT ARSENAL**

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

Scale: 1:1

Dimension: mm

TITLE:

1ST POINT PUNCH
STATION # 4
5.56mm M855 BULLET ASSEMBLY MACHINE

Dwg. No. AM855T2-04a
Sht.No. 1 Of 1
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| Ø 44.425 ±0.013 |
| Ø 19.05 |
| Ø 6.10 |

| R 0.5 ±0.03 |

| R 1.0 |

| R 47 |

| -0.013 |

| 0.00762 A |

| 0.76 X 45° |

| 20-0.10 |

| TRANScribed FROM WBF DWG NO. 9612-19-0751 |

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

| QTY | DESCRIPTION | PART NO | MATERIAL | HARDNESS |

| DRAWN | J C CABANILLA, BSIT |
| DESIGNED | |
| CHECKED | ENGR S K C PAGUIO, Che |
| Recommend Approval | ENGR DENNIS DD CHUA, ME |
| APPROVED BY | DANIEL R CASABAR JR, DIRECTOR |

| Republic Of The Philippines |
| Department Of National Defense |

| GOVERNMENT ARSENAL |
| Camp General Antonio Luna |
| Lamiao, Limay, Bataan |

| SCALE: 2 : 1 |
| DIMENSION: mm |
| DWG. NO. AM855T2-07d |
| SHELL NO. 1 |

| TITLE: 4TH POINT DIE |
| STATION #7 |
| 5.56mm M855 BULLET ASSEMBLY MACHINE |

Date: APRIL 23, 2019
Date: APRIL 24, 2019
Date: 04/25/19

<p>| Desktop - J Cabanilla / AI Drawings / Engr J T Lawing / Waterbury 5.56 mm (M855) / 4th Point Die |</p>
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**DRILL AND TAP**

1/4-20 UNCV 31.75

Ø15.87

R₁

45.14

R₁2.70

88.18

133.33

3

2.01

8

2.31

8.9

14.30

Detail R Scale 7:1

R₁

Ø5.65±0.025

Ø5.65

Ø5.55

Ø5.65

Ø4.85

Ø4.60

Ø1.71

R0.03

0.00762 A

---

**PUNCH**

1

**DESCRIPTION**

STEEL M2 / 58-60 HRC (UNDERHARDEN)

**MATERIAL / HARDNESS**

**DRAWN**

JD BALOYOT, BSIT

Date: APR. 24, 2019

**DESIGNED**

Date: APR. 24, 2019

**CHECKED**

ENGR. SK. BAGUIO, CHE

Date: April 24, 2019

**Recommend Approval:**

ENGR. DENNIS DS CHUA, ME

Date: 04/25/19

**Approved by:**

DANIEL R CASABAR JR

**TITLE:**

PINCH TRIM PUNCH

STATION # 8

5.56mm M855 BULLET ASSEMBLY MACHINE

**SCALE:**

1:1

**DIMENSION:**

mm

**DWG. No.:**

AM855T2-06a

**SHT. No.:**

1

**Of:**

1

Republic Of The Philippines
Department of National Defense

GOVERNMENT ARSENAL

Camp General Antonio Luna
Lamao, Limay, Bataan
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**APPLY GEN. TOLERANCE TO UNSPECIFIED TOLERANCES**

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### Detail Diagram

1. **DIE INSERT**
   - QTY: 2
   - DESCRIPTION: GC 320
   - MATERIAL: 85.1 ~ 86.6 HRA
2. **DIE CASE**
   - QTY: 1
   - DESCRIPTION: H-13 STEEL
   - MATERIAL: 46 ~ 48 HRC

### Technical Details

**DRAWN**
- J.C. CABANILLA, BSIT
- Date: APRIL 23, 2019

**DESIGNED**
- ENGR S.K.C. BAGUIO, ChE
- Date: APRIL 23, 2019

**CHECKED**
- ENGR DENNIS DS CHUA, ME
- ACTG. SUPERINTENDENT CIB
- Date: APRIL 23, 2019

**APPROVED BY**
- DANIEL R. CASABAR JR.
- DIRECTOR
- Date: APRIL 23, 2019

**GOVERNMENT ARSENAL**
- Republic Of The Philippines
- Department Of National Defense
- Camp General Antonio Luna
- Laoag, Ilocos Norte, Bataan

**SCALE**
- 2 : 1

**DIMENSION**
- mm

**Dwg. No.**
- AM855T2-08b

**Sh. No.**
- 1

**TITLE**
- PINCH TRIM DIE
- STATION #8
- 5.56mm M855 BULLET ASSEMBLY MACHINE
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**Diagram:**

- Ø44.42 ±0.01 ±0.00
- Ø38.07 ±0.00 ±0.05
- Ø19.05
- Ø5.80
- 8
- R0.50
- R1
- 8
- 4
- 4
- 4
- Ø5.66 ±0.01 ±0.00
- 0.51
- 1.27
- 5.56mm M855 BULLET ASSEMBLY MACHINE
- BLEND SMOOTH

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**Table: Transcribed From WBF DWG. No. 9612-19-1550**

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**Drawn:** JD BAGUET, BSIT
**Date:** APR. 24, 2019

**Designed:**
**Date:**

**Checked:** ENGR. SK. PAGUIO, CHe
**Date:**

**Recommend Approval:** ENGR. DENNIS DS CHUA, ME
**Date:** April 24, 2019

**Approved by:** DANIEL R. CASABAR JR
**Date:**

**Republic Of The Philippines**
**Department of National Defense**

**GOVERNMENT ARSENAL**
Camp General Antonio Luna
Lamao, Limay, Bataan

**Title:**
1ST SIZING DIE GUIDE
STATION # 15

**Scale:**
4:1

**Dimension:**
mm

**Dwg. No.:** AM855T2-15b

**Sh. No.:** 1

**Of:** 1
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**PUNCH**

**STEEL, M2 / 58-60 HRC [UNDERHARDEN]**

**DRAWN**: JD BAUJO, DT, BSIT  
**DESIGNED**:  
**CHECKED**: ENGR. SKP AQUINO, ChE

Recommend Approval: ENGR. DENNIS DE CHUA, ME  
Approved by: DANIEL R CASABAR JR, DIRECTOR

**DATE**: APR. 24, 2019  
**DATE**:  
**DATE**: April 24, 2019  
**DATE**:  
**DATE**: 04/25/19

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

**Scale**: 1:1  
**Dimension**: mm

**TITLE**: BOAT TAIL PUNCH  
**STATION # 14**  
5.56mm M855 BULLET ASSEMBLY MACHINE

**Dwg. No.**: AM855T2-14a  
**Sht.No.**: 1

---

**TRANSCRIBED FROM WBF DWG. NO. 9612-19-1411**

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TRANSCRIBED FROM WBF DWG. NO. 9612-19-1413

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**DRAWN**
JD BALUYOT BSIT
Date: APR. 24, 2019

**DESIGNED**

**CHECKED**
ENGR SK PAGUIO, Che
Date: April 24, 2019

Recommend Approval:
ENGR. DENNIS DS CHUA, ME

Approved by:
DANIEL R. CASABAR Jr.

Scale: 1:1
Dimension: mm

**TITLE:**
BOAT TAIL PUNCH CHUCK BODY
STATION # 14
5.56mm M855 BULLET ASSEMBLY MACHINE

GOVERNMENT ARSENAL
Camp General Antonio Luna
Lamia, Limay, Bataan
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**REMARKS**

**DRAWN**  
JD BALLETT, BSIT

**DESIGNED**

**CHECKED**
ENGR. SK. PABUGO, ChE

Recommend Approval:
ENGR. DENNIS DE CHUA, ME

Approved by:  
DANIEL R. CASABAR, JR., DIRECTOR

**GOVERNMENT ARSENAL**  
Republic Of The Philippines  
Department of National Defense

**CAMP GENERAL ANTONIO LUNA**  
Lamao, Limay, Bataan

**SCALE**: 3:1

**DIMENSION**: mm

**TITLE**:  
2ND SIZING DIE GUIDE  
STATION # 17  
5.56mm M855 BULLET ASSEMBLY MACHINE

**Dwg. No.**: AM855T2-17b

**Sh. No.**: 1

**Of**: 1

Date: APR. 24, 2018

Date: APR. 24, 2019

Date: 09/25/19
TRANSCRIBED FROM WBF DWG. NO. 9612-19-1751

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**DRAWN**
JD BAJUYOT, BSIT
Date: APR. 24, 2019

**DESIGNED**

**CHECKED**
ENGR SK PAQUIO, ChE
Date: April 24, 2019

Recommend Approval:
ENGR. DENNIS DS CHUA, ME
Date: 04/25/19

**Approved by:**
DANIEL R CASABAR JR

**GOVERNMENT ARSENAL**
Camp General Antonio Luna
Lamao, Limay, Bataan

**SCALE:**
3:1

**DIMENSION:**
mm

**DWG. NO.:**
AM855T2-17c

**SH. NO.:**
1

**TITLE:**
2ND SIZING LOWER DIE
STATION # 17
5.56mm M855 BULLET ASSEMBLY MACHINE
### TRANSCRIBED FROM WBF DWG. NO. 9612-19-1710

**GOVERNMENT ARSENAL**

Camp General Antonio Luna
Lamao, Limay, Bataan

**Republic Of The Philippines**
Department of National Defense

**TITLE:**

2ND SIZING PUNCH
STATION #17
5.56mm M855 BULLET ASSEMBLY MACHINE

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<th>MATERIAL / HARDNESS</th>
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<td>STEEL M2 / 58-60 HRC [UNDERHARDEN]</td>
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