NOTES:
1. EACH REPAIR PART BOLT AND ROLLER ASSY SHALL WITHSTAND THE FIRING OF ONE GOVERNMENT STANDARD HIGH PRESSURE TEST CARTRIDGE WITHOUT EVIDENCE OF FAILURE AS DETERMINED BY MAGNETIC PARTICLE INSPECTION FOR CRACKS, SEAMS AND OTHER INJURIOUS DEFECTS. USING A STANDARD 5 TURN MAGNETIZING COIL WITH A CURRENT OF 200 TO 250 AMPERES, APPLY MPI MARK TO ASSY MEETING THIS REQUIREMENT.

2. ROLLER SHALL BE ASSEMBLED TO THE BOLT BY GRADUAL APPLICATION OF FORCE WHILE RING IS COMPRESSED INTO THE GROOVE ON THE BOLT WITH A SUITABLE TOOL. CARE SHALL BE EXERCISED TO PRECLUDE DAMAGE TO THE RING DURING ASSEMBLY OPERATION.

3. AFTER ASSEMBLY, THE ROLLER SHALL ROTATE SMOOTHLY WITHOUT EVIDENCE OF BINDING OR DRAG.

4. MIL-W-48655 SHALL APPLY.

BEFORE ASSEMBLING RING AND ROLLER, PACK WITH GREASE CONFORMING TO SPEC MIL-G-10924. AFTER MPI, ROLLER SHALL BE REPACKED WITH GREASE CONFORMING TO SPEC MIL-G-10924.

LONGITUDINAL RESIDUAL MAGNETIZATION WITH WET FLUORESCENT SOLUTION (SEE NOTE 1)

SECTION VIEWS SHOWING ROLLER AND RING POSITION

APPLY MPI MARK "M" 1/8 HIGH ON UNDERSIDE

PRICK PUNCH AFTER PROOF FIRING (REPAIR PARTS ONLY)

BOLT - 7790185
ROLLER - 7267065
RING - 7267059

MT
MIL-I-6866

FOR LIST OF PARTS, SEE ENGINEERING PARTS LIST 7790186

C 7790186

BOLT AND ROLLER ASSEMBLY

SPEKERS IS AMYR