

M14 Rifle History and Development

Online Edition

Lee Emerson

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Sincere and strong love is greatly gratified and delighted in the prosperity of the beloved object; and if the love be perfect, the greater the prosperity of the beloved is, the more is the lover pleased and delighted; for the prosperity of the beloved is, as it were, the food of love, and therefore the greater that prosperity, the more richly is love feasted." – Jonathan Edwards, *Heaven, A World of Charity Or Love*, Northampton, England, 1738.

This book is dedicated to those who love and to those who love liberty.

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Foreword

I am always surprised to find writings on one of my favorite subjects that reflect a near obsession for historical fact and great detail. Lee Emerson is obviously obsessed with the M14 rifle! Lee's dedication to research on the subject has taken thousands of hours at no small expense. While most gun writers expound on the brief history of M14 development, already published information on maintenance, and accurizing procedures, Lee has delved into the almost secret world of manufacturing processes and metallurgy and the dark world of government specifications. This has exposed what a wonderfully complicated and highly engineered weapon system the M14 rifle truly is.

I have long felt that the M14 rifle is the finest military rifle ever fielded. Based on John C. Garand's M1 rifle, the rifle that won almost every battle in WWII and Korea, the M14 overcame all of the shortcomings attributed to the M1. True, it is a handful in full automatic fire, but it is none the least, a hard hitting long range rifle that gives credence to the proposition of "peace through superior fire power"!

Lee's *M14 Rifle History and Development* is the result of many hours of interviews with experts in the field as well as collecting almost everything available from government sources, commercial manufacturers, and several shady characters who hang out on the internet. It's been no small undertaking and constant additions have been made as new information turns up. It's truly a work in progress. Thanks Lee and thanks to your wife Adelfa, whose support of your obsession helped make it possible!

Ted Brown

Armorer

Preface To The Online Edition

This work is an honest and reasonable attempt at capturing the history and development of the M14 rifle. The reader is encouraged to check the facts for himself. The M14 rifle story is still very much in progress.

Thank you to members of the www.ambackforum.com, www.m-14forum.com, and www.warrifles.com Internet discussion boards for their support and helpful suggestions. Special thanks go to Sadlak Industries, Smith Enterprise, SparrowHawk Stocks, Troy Industries, Warbirds Custom Guns, and William J. Ricca Surplus for their generous assistance.

The author thanks those who have contributed to this work but wish to remain anonymous. Other Sources # 12, # 18 and # 27 made significant contributions to this volume. The copyediting chore for the First Edition was freely and graciously donated by Brent A. Blanchard, Attorney and Counselor at Law. Mr. Blanchard learned to shoot from his dad as a child. He shot smallbore rifle as a teenager and was a member of the

Brigham Young University Army ROTC Rifle Team. He competed in High Power competition matches in the 1980s while the M14 rifle was king of competition shooting. After he learned that careers in public relations, marketing, and financial planning were not to his liking, Mr. Blanchard went to law school. He was admitted to the bar in the State of Nevada after graduation and later accepted a position at a law firm in Las Vegas, NV.

William Cook Richards generously donated his time to the task of copyediting for the Second Edition. Additionally, his thoughtful suggestions regarding the use of publishing software have resulted in a much improved format over the First Edition.

There are no double quotes before and after specific alphanumeric characters used to identify equipment and rifle parts. The substantial number of rifle part identifying marks and dimensional measurements included in the narrow focus of this volume renders those conventions distracting. In this work, "Springfield Armory" refers to the U. S. government installation. The name "Springfield Armory, Inc." belongs to the commercial firearms manufacturer.

Due to the nature of the Internet, web site addresses listed in the Bibliography were active at the time research was conducted but may not work thereafter. Some rifle models, parts or accessories discussed in this work may not be available due to the limited number made or because the manufacturer is no longer in business.

Always handle all firearms in a safe manner. There are four basic rules of firearms safety: 1) **Treat every gun as if it was loaded** 2) **Never point the muzzle at anything you are not willing to destroy** 3) **Keep your finger off the trigger until the sights are on the target** and 4) **Always be sure of your target and what is behind and to the sides of it.** Metal targets present a ricochet hazard. Ricochets can come back to the firing line from which they originated. Wear proper attire, e.g., no tank tops, and personal protective equipment (ear muffs or plugs and shooting glasses) when shooting.

Always read and follow product safety warnings and instructions. This includes all firearms, ammunition, accessories, and gun care products. Use hand and portable tools safely and in the manner for which they are designed. Consult with law enforcement officials or an attorney if you are unsure of the law where you live.

Lee Emerson
October 2006
West Hartford, CT

Part 1

The Military M14

Introduction

The U.S. Rifle 7.62 mm M14 was adopted for military service by the United States on May 01, 1957. The rifle was officially designated M14 in the U. S. Army Ordnance Technical Committee document OTCM 36558 on June 05, 1957. The M14 rifle was developed to replace four military firearms, M1 Garand rifle, M1 Carbine, M1918 Browning Automatic Rifle and the M3A1 submachine gun. The M in M14 stands for Model. The M14 is a rotating bolt, gas operated, air cooled, magazine fed, shoulder fired weapon. The M14 is 44.28 " long with the hinged butt plate in the closed position and weighs 8.7 pounds. With a full magazine, cleaning kit and sling, it weighs approximately 11 ½ pounds. The maximum effective range is 460 meters (503 yards). The M14 has seen hostile service with the American military from the 1963 Cuban missile crisis to the Second Gulf War. The M14 rifle has been employed as a battle rifle, squad automatic weapon, competition match rifle, grenade launcher, sniper weapon system and ceremonial rifle.

Between 1958 and 1963, the U. S. government ordered 1,380,358 M14 rifles from four entities. These were the U. S. Army's Springfield Armory in Springfield, MA; Winchester (Olin Mathieson Chemical Corp.) in New Haven, CT; Harrington & Richardson Arms Company in Worcester, MA; and Thompson-Ramo-Wooldridge, Inc. in Cleveland, OH. A total of 1,376,031 M14 rifles were delivered between 1959 and 1964.

From 1945 to June 30, 1957, the U. S. government spent \$10,927,523 to research, develop, test and evaluate the M14. Total cumulative investment cost for the M14 project was \$207.017 million. The total cumulative operating, maintenance and ammunition costs up to July 01, 1968 was \$295.290 million. The average production cost was \$105.15 per rifle with TRW being the most affordable of the four manufacturers. The production learning curve slope was 92 percent. This means as production quantities doubled, the time to produce each rifle decreased by 8 percent. In 1968, the annual operating (parts, maintenance, and ammunition) cost for each rifle was \$50.52.

The cost of the M14 project production equipment was as follows: Olin Mathieson Chemical Corporation - \$7,593,460, Harrington & Richardson - \$6,330,726 and TRW - \$6,824,559. The cost of the production equipment at Springfield Armory was not available when researched for a U. S. Army Materiel Command report in October 1968.

The Mean Time To Overhaul (average time to overhaul a M14 rifle) was 1.5 hours. The Time Between Overhaul (TBO) for a M14 was 5 years. The Mean Time Between Failure (average time between any failure requiring repair) was 270 days and the Mean Time To Repair (MTTR) was 0.6 hours. As of November 1965, the average annual ammunition usage for each rifle was 810 cartridges (610 rounds ball, 50 rounds tracer and 150 rounds blank).

Some basic engineering background information is presented here to assist the reader later on. This will be helpful in understanding the manufacturing processes of M14 type rifle receivers and parts.

Engineering Material

There are three important factors which influence the quality of the M14 type rifle receiver and parts. These factors are material selection, heat treatment, and dimensional geometry. Selection of an engineering material is based upon the design, application and manufacturing feasibility of an object. With that in mind, if the proper material is not used, the specified (and desired) values for each mechanical property (hardness, strength, toughness, etc.) may not be achieved for a given part, regardless of whether heat treatment is performed well or done at all. If the incorrect material is used to make the part, the part may yield a shorter service life, or may even catastrophically fail with resulting personal injury or death. The same goes when heat treatment of parts is not performed according to design specifications and procedures. Whether a receiver is initially formed by forging, machining or casting, the finish machining operations are performed before carburizing, quenching and tempering. If dimensional geometry is incorrect, even a properly heat-treated part made of the correct material will either function poorly or it will not last as long as it should.

Engineering Definitions

The following terms are defined for this discussion:

A₁ temperature – This is the minimum threshold temperature to create austenite molecular structure in steel. The A₁ temperature is 1341 degrees Fahrenheit for steel with less than 6.67 % carbon content. All of the steel used in the M14 rifle contains less than 1.00 % carbon.

A₃ temperature – The temperature at which ferrite forms as the steel begins cooling. This is about 1528 degrees Fahrenheit for AISI 8620 steel.

Alloy steel – This is steel with trace percentages of other elements.

Annealing - This is a method of heat treatment performed by heating steel to a temperature that transforms all of the molecules to austenite structure, followed by slow furnace cooling. This method produces a coarse pearlite molecular structure in the steel. Annealing is done to produce lower strength and higher ductility steel—performance characteristics opposite of high strength and brittleness.

Austenite – Austenite is the Face Centered Cubic molecular structure of iron. The maximum solubility of carbon in austenite is 2.11 %.

Carburizing – Carburizing is a group of techniques for heat treating the surface of steel. It is used when the alloy steel has insufficient carbon to attain the desired surface properties through conventional heating methods. Carburizing alters the chemistry of the surface of the steel. The first part of the process is the diffusion of carbon into the part's surface at an elevated temperature. This creates a high carbon content at the surface which increases the hardness. When the part is then rapidly cooled and tempered the surface remains hard and strong while the core (or center) remains softer and tougher.

Case depth – The depth below the surface of a steel part to which hardening occurs by surface heat treatment techniques.

Cementite – This is a hard and brittle compound of three iron atoms and one carbon atom. It contains 6.67 % carbon. It is used to strengthen steel when it is dispersed evenly. The chemical formula is Fe_3C .

Ferrite – Ferrite is the Body Centered Cubic form of iron. The maximum solubility of carbon in (alpha) ferrite is 0.0218 %. Alpha ferrite is one structure of several that can form upon slow cooling from the molten phase.

Hardness – Hardness can be thought of as resistance to permanent indentation. Hardness is measured using various tests with their own number scales, such as Brinell, Knoop, Rockwell, and Vickers.

Heat treatment – Heat treatment is the controlled heating and cooling of metals for the purpose of changing their physical properties. It is one of many methods that can be used to change the mechanical properties of metals.

Hypoeutectoid steel – This is steel with less than 0.77 % carbon content. If hypoeutectoid alloy steel is heated above the A_1 temperature, 100 % austenite structure can be formed. This is desired for making hardened steel parts by heat treatment.

Magnetic particle inspection – Magnetic particle inspection is a method of non-destructive examination that detects surface and subsurface flaws in ferromagnetic metals (iron, steel, nickel and cobalt alloys).

Martensite - The Body Centered Tetragonal molecular structure of steel with 0.2 % or greater carbon content. It is the hardest, strongest and most brittle molecular structure of steel. It can be as hard as 65 HRC.

M_s – The temperature at which steel begins to form martensite molecules upon rapid cooling. This temperature differs for each alloy steel.

M_{90} – The temperature at which steel is composed of 90 % martensite upon rapid cooling. This temperature differs for each alloy steel.

Normalizing – This is a method of heat treatment that is performed by heating steel to a temperature that transforms all of the molecules to austenite structure followed by air cooling or oil quenching and tempering. This treatment produces a fine pearlite molecular structure in steel. Normalizing is done to control dispersion-strengthening of the steel.

Pearlite – A form of steel that contains two solid molecular structures of steel, ferrite and cementite. It is created when steel is slowly cooled.

Rockwell hardness test – This hardness tester uses a small diameter steel ball or diamond cone depending on the material to be sampled. The depth of penetration of the ball or cone is automatically measured and converted to a Rockwell hardness number, expressed with “HRC” or “HRD” after the number. HRC means the hardness value on the Rockwell C scale. HRD means the hardness value on the Rockwell D scale. The Rockwell C and D scales are used to measure the hardness of high strength steels. A diamond cone indenter is used for these hardness scales.

Stress – Applied force divided by the original material cross-section area.

Tempering – Tempering is the heating of martensite steel below the A_1 or eutectoid temperature. This heating redistributes the cementite within the martensite. Redistribution or dispersion of the cementite is called dispersion-strengthening. Tempering relieves residual stresses caused by the transformation of austenite into martensite upon rapid cooling. Tempering reduces the strength and hardness but increases the ductility and toughness of steel. However, the hardness is also dependent upon the carbon content of the steel. The higher the carbon content the higher the hardness of the martensite.

Tensile strength – The strength of a material can be determined by measuring the stress it takes to cause deformation. The yield strength is the stress needed to begin permanent deformation (elongation) of a material. The ultimate tensile strength is the maximum applied stress before the material breaks.

Toughness – Mathematically, it is often measured as the total area under the stress versus strain curve for a given material. In layman's terms, toughness is the resistance of a material to failure by impact.

AISI 4100 and 8600 Series Alloy Steels

In the United States, types of steel are commonly identified by the American Iron and Steel Institute (AISI) classification system. Carbon and alloy steels are given unique four digit numbers. The first digit of each number indicates the major alloying element or elements. The second digit represents a subgroup of the major alloy element or elements. The third and fourth digits denote the amount of carbon in the steel. For example, AISI 4140 is a molybdenum-chromium alloy steel with 0.40 % carbon content. AISI 4100 and 8600 series alloy and AISI 416 stainless steels are commonly used in the manufacture of M14 rifle parts. The following information is provided for the benefit of the reader.

Table 1: Elements of Alloy Steels

Element of Alloy Steel	Advantages and Disadvantages
carbon	increases hardness, strength and brittleness
chromium	increases hardenability and corrosion and wear resistance
iron	principal element of steel
manganese	increases hardenability by 1) lowering transformation points and causing those transformations to be sluggish 2) counteracts the brittleness effect from sulfur
molybdenum	prevents grain growth resulting in uniformity of hardness and high strength
nickel	increases toughness, ductility and corrosion resistance
phosphorous	Improves strength and machinability but has to be limited to prevent brittleness
silicon	improves hardness and corrosion resistance
sulfur	improves machinability but increases brittleness

vanadium	increases strength while retaining ductility
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Table 2: Composition of AISI 8620, AISI 4140 and AISI 416 Steels

Element of Composition	AISI 8620 Alloy Steel	AISI 4140 Alloy Steel	AISI 416 Stainless Steel
carbon	0.18 to 0.23 %	0.38 to 0.43 %	0.15 %
chromium	0.4 to 0.6 %	0.8 to 1.1 %	13 %
iron	major element	major element	major element
manganese	0.7 to 0.9 %	0.75 to 1.0 %	1.25 % maximum
molybdenum	0.15 to 0.25 %	0.15 to 0.25 %	0.6 % maximum
nickel	0.4 to 0.7 %		
phosphorous	0.035 % maximum	0.035 % maximum	0.06 % maximum
silicon	0.15 to 0.35 %	0.15 to 0.35 %	1.0 % maximum
sulfur	0.04 % maximum	0.04 %	0.15 % minimum

Table 3: Properties of AISI 8620, AISI 4140 and AISI 416 Steels

Property	AISI 8620 Alloy Steel	AISI 4140 Alloy Steel	AISI 416 Stainless Steel
density (lb/in ³)	0.283	0.28	0.28
specific gravity	7.8	7.83	7.7
specific heat (BTU/lb/degrees F)	0.1	0.114	0.11
melting point (degrees F)	2600	2580	2714
thermal conductivity (BTU-in/ft ² -h-degrees F)	180.3	159.5	172.6
mean coefficient of thermal expansion (x 10 ⁻⁶ in/in/degree F)	6.6	7	5.5
modulus of elasticity in tension (x 10 ⁶ psi)	31	33	29

M14 Rifle Preservation

Corrosion – In layman’s terms, corrosion is the wasting away of a material. This is not desirable but the M14 type rifle must be expected to perform in harsh environments. Thus, corrosion is an issue of concern in its design and application. Corrosion of metal parts can occur from contact from a plethora of sources such as chemicals, water immersion, humid air, human body sweat, salt water spray or microbes. Alloy aluminum, carbon steel and alloy steel surfaces will oxidize (rust) in moist air but at varying rates. Carbon and low alloy steels have similar poor corrosion resistance in aerated neutral pH water and sea water.

Stainless steels have good resistance in mild environments but are susceptible to localized chloride pitting corrosion from sources like salt water or body sweat. This susceptibility to chloride pitting corrosion is at its greatest when stainless steel is heated to a temperature around 195 degrees Fahrenheit, e.g., the M14 gas cylinder after firing. Martensitic stainless steels are used to manufacture some M14 type rifle parts (see USGI

Part Materials). Martensitic stainless steels have the least corrosion resistance of the five types of stainless steels (see General Information on AISI 416 Stainless Steel). In sea water or in water near neutral pH, AISI 416 stainless steel will suffer general surface corrosion at a faster rate than carbon steel or low alloy steel. Martensitic stainless steels are also susceptible to hydrogen embrittlement cracking corrosion but this is not an issue when in service as a M14 type rifle part.

Preservation – Carbon and alloy steels can be preserved with coating or plating. Most M14 type rifle parts are made from alloy steels. The parts are almost always coated with manganese phosphate or zinc phosphate coating for corrosion protection. Both methods of phosphate coating have been in use for decades.

Thomas Coslett developed and obtained a U. S. Patent, number 870,937, for iron phosphate coating in 1907. Six years later, the U. S. Patent for manganese phosphate coating was issued to Frank Richards (U. S. Patent 1,069,903). In 1915, Clark Parker obtained the rights to both patents and formed the Parker Rust-Proof Phosphating Company of America. Zinc phosphate coating was developed by the Parker Rust Proof Company as an inexpensive alternative to manganese phosphate coating. The U. S. Patent for the zinc phosphate coating method was issued to an employee of the Parker Rust Proof Company in 1942 (U. S. Patent 2,293,716).

Phosphate coatings can and do wear off of M14 rifle parts from normal use and handling. Many gunsmiths are equipped to refresh or replace the phosphate coating on parts with a worn finish. The color of phosphate coating on USGI M14 parts varies from light gray to green-gray to charcoal gray. Manganese phosphate produces darker shades of gray color finish. Zinc phosphate coats the parts with lighter shades of gray. M14 parts were phosphate coated in batches and by many companies for the U. S. government. Consequently, the M14 enthusiast should not expect new-in-wrap or used USGI M14 parts to match in color when assembling a M14 type rifle.

The USGI rack grade barrel bore, gas piston, spindle valve, gas cylinder plug, operating rod front end, gas cylinder bore and commercial stainless steel barrels are not phosphate coated. The bolt roller was not coated at the factory but left bare. Some bolt rollers on stripped bolts were phosphate coated during arsenal or depot inspection, recoating and rewrap. Some alloy steel barrels are blued, such as the commercial barrels and the early military barrels made by Gene Barnett (see USGI M14 National Match barrels). Gun bluing and phosphate coatings will not adhere to stainless steel. Consequently, USGI M14 gas cylinders, spindle valves and gas cylinder plugs were blackened with molten sodium dichromate oxide coating. Commercial reproduction gas cylinders are protected with paint that will adhere to stainless steel. Alternately, the gas cylinder, spindle valve, front band and gas cylinder plug exterior surfaces can be preserved with a ceramic coating as is done by Jeffrey Shapiro (NY) as part of his National Match modification.

The M14 rack grade barrel bore is chromium plated for corrosion protection among other benefits (see USGI M14 Rack Grade Barrels). Parts such as scope mounts and gas cylinder lock wrenches made from aluminum are typically anodized to prevent oxidation. All of these metal surface finishes serve to preserve M14 type rifle parts and accessories from the harmful effects of corrosion.

Raw and boiled linseed oil are traditional preservatives for wood stocks. The U. S. Army manual FM 23-8 cautions against getting linseed oil on the metal parts. Linseed oil, tung oil and a number of commercial wood finishes have been used with great success to bring out the natural beauty of M14 rifle stocks. Well-preserved wood M14 stocks command a collector premium.

Normal Climate Care – FM 23-8 requires a daily inspection of the M14 rifle to check for any corrosion when in use. It also requires a light film of lubricating oil to be applied on all metal parts except the inside of the gas cylinder, the gas piston and the gas cylinder plug. Note: The bore and chamber should be cleaned and dried before firing.

Cold Climate Care - For temperatures below freezing, all moisture and excess oil must be removed to keep the rifle working properly. It is best to keep the rifle outside in the cold air in such conditions. If the rifle is brought into a heated space, do not clean it until the rifle has reached room temperature.

Hot and Humid or Ocean Climate Care – Lightly coat metal surfaces with preservative oil. Frequently apply raw or boiled linseed oil to the wood stock to keep it from swelling.

Desert Climate Care – Clean the rifle daily or more often to keep sand and dust from accumulating in the bore and on the moving parts. Keep the rifle dry and the muzzle and receiver covered when dust or sand is in the air. It is better to keep the rifle dry of soft lubricants in sandy areas. This is because soft lubricants will collect dust and sand. The debris-laden lubricant then becomes abrasive when the rifle is employed. Apply raw or boiled linseed oil to keep the stock from drying out.

M14 Rifle Lubrication

Soft Lubricants – Oils, greases and sprays are used to lubricate moving parts within a firearm to facilitate proper function and minimize parts wear. Soft lubricants also provide modest protection against corrosion where applied. Aside from military specification grease, there are a number of commercially formulated greases that provide adequate lubrication for the M14 type rifle in all but the most severe service conditions. Most firearms lubricants today are petroleum based oils and greases. Soft lubricants often have additives for improving lubricity, corrosion resistance and viscosity. Soft lubricants do not perform well in cold weather and do break down after a period of time.

FM 23-8 specifies rifle grease should be applied at a number of contact points on the M14 as a part of normal maintenance: bolt locking recesses, the bolt camming lug on the hammer, operating rod camming surfaces, and the lip of the receiver that contacts the rear top edge of the bolt. As part of normal maintenance, M14 gunsmiths may also recommend a light film of rifle grease in: 1) the operating rod channel 2) the operating rod saddle that contacts the barrel 3) the bolt roller 4) the receiver bolt raceway 5) between the top of the lip of the front band and the bottom of the stock ferrule 6) the inside of the cylindrical portion of the operating rod 7) the inside diameter of the operating rod guide 8) the operating rod spring guide 9) the bottom of the rear sight base and 10) sides of the rear sight aperture. Grease should be removed and reapplied yearly to prevent solidification.

Troops lubricated M14 rifles with either Lubriplate or Plastilube grease. Lubriplate grease was developed for the M1 Garand rifle during World War II. It is pale yellow in color. Plastilube was developed in the 1950s for the M1 Garand rifle. Plastilube is dark brown in color and thicker in consistency than Lubriplate. U. S. Army armorers applied MIL-G-10924D specification grease to M14 NM rifles. The official name of this grease is "Grease, automotive and artillery" and is commonly referred to as "GAA."

Hard Lubricants – It may seem detrimental for very hard surfaces to be in bare sliding contact with each other but friction and wear can be significantly reduced with some hard surface finishes. In other words, a solid material can be a lubricant. In the M14 rifle, this is not only possible but has already been achieved. The benefit of applying a hard smooth finish to the M14 barrel bore was realized in 1956 (see M15). The all chromium plated firing pin has proven itself enduring and lubricious since the mid-1960s (see Miscellaneous Notes on USGI Parts). The XM25, M25, M14SE and Mk 14 SEI rifles employ gas pistons with very hard finishes in combat conditions. Some commercial M14 type receivers and parts have been nitrocarburized since 1985. As part of a custom rifle project, Century Arms International imported Norinco M14 Sporter receiver serial number C08610 has been dense chromium plated. Proper selection and application of hard, smooth finishes does enhance the service life of M14 rifle parts.

Ceramic coatings have been applied to metal cutting tools for decades. Titanium carbide coated cutting tools were introduced to the industry in 1969 and titanium nitride coated gear cutters were first used in 1980. Ceramic coatings are used on metal cutting tools because they are abrasion resistant, very hard, and chemically inert and have a low coefficient of friction. The benefits are longer tool life, higher cutting speed, higher feed rate and less machine tool down time. One such ceramic coating is titanium nitride. Titanium nitride is applied to clean metal parts by the physical vapor deposition method. Briefly, this process entails evaporating a very thin layer of titanium on to the part inside a nitrogen gas chamber. The titanium nitride layer is typically 0.0001 " to 0.0002 " thick. This process is done at a temperature low enough (400 to 900 degrees Fahrenheit) so that the metallurgy of the part being coated is not affected. Depending on the ingredient composition, the color of titanium nitride coatings can be any of several hues of brown or gold. The surface hardness can be made as high as 85 HRC.

Titanium nitride coated gas pistons became part of the build specification for XM25 rifles by 1988 (see XM25 and M25). The M14 SE Semi-automatic Sniper System is built with a dense chromium plated gas piston. The USGI M14 gas piston material specification is heat treated AISI 416 stainless steel. Typical USGI gas piston surface hardness ranges between 74.5 and 77 HRA (approximately 42 HRC). A gas piston coated with titanium nitride results in a surface hardness ranging from 70 to 80 HRC. Thin dense chromium plated gas pistons have a surface hardness of 80 HRC. The advantages of a hard and smooth finish gas piston are as follows:

- 1) Anti-galling and anti-seizing properties – Galling is the welding of two metals together as they slide against each other. Galling and seizing are not desirable in the M14 rifle gas system. Titanium nitride and dense chromium coatings are harder but have lower coefficients of friction than stainless steel. These characteristics result in a slicker surface

than the bare stainless steel gas piston. In effect, the hard finish is a solid lubricant in this application. Consequently, there is less gunpowder and primer residue buildup.

Gunpowder and primer residue buildup does cause a very minute amount of seizing between the gas cylinder and gas piston.

2) Corrosion protection – Titanium nitride and thin dense chromium finishes have better pitting corrosion resistance than martensitic stainless steel.

3) Thermal protection – Thin layers of titanium nitride and dense chromium give the substrate metal, AISI 416 stainless steel in this case, better resistance to the effects of heat. The higher resistance to heat extends the service life of the gas piston much like titanium nitride coated metal cutting tools last longer than those that are not coated.

4) Better compression – The hard finish extends the life of the piston grooves. A sharper groove edge will provide compression for a longer amount of time plus it removes more of the gunpowder and primer residue from the cylinder wall than a bare gas piston.

5) Easier cleaning – Cleaning the piston is made easier since the gunpowder and primer residue does not adhere as well as it would on bare gas pistons.

Nitrocarburizing is a thermochemical process that improves the surface properties of iron or steel parts. It increases surface hardness to 60 HRC, reduces the coefficient of friction, improves wear resistance and enhances corrosion resistance of the metal treated. M14 type receivers, gas cylinders, gas cylinder locks, gas cylinder plugs, front bands, hammers, triggers and scope mounts have received the benefits of nitrocarburizing treatment.

Nitrocarburizing produces two or three very thin layers of structurally altered steel by diffusing nitrogen and carbon into, not on, the surface of the steel part. Depending on the material composition and the treatment time, the depth of each layer will vary. Total depth of the nitrogen and carbon layers is normally 0.008 " to 0.040 ". The higher the alloy content of the part, the thinner the total depth of the nitrocarburizing layers for the same treatment time. A layer of epsilon iron nitride (6 to 9 % nitrogen and 1 % carbon) is created in the surface to a depth of less than 0.001 ". The epsilon iron nitride layer improves wear and corrosion resistance and lowers the coefficient of friction. A deeper layer of nitrogen under the epsilon iron nitride is produced among the steel molecules. This layer of nitrogen improves fatigue strength of the part. Depending on the treatment selected, a third very thin layer of passive Fe_3O_4 oxide is formed on the epsilon iron nitride layer for improved corrosion resistance. Application of this passive oxide layer is not suitable for stainless steel.

The static coefficients of friction for various materials obtained from several sources are listed for the benefit of the reader. Values for kinetic coefficients of friction are usually significantly lower. The lower the value for coefficient of friction the less resistance there is to sliding contact on the material.

Table 4: Coefficient of Static Friction for Select Materials

Material(s)	Coefficient of Static Friction
clean aluminum on aluminum	1.35
clean iron on iron	1
clean steel on steel	0.6 to 0.8
clean chromium on chromium	0.41
clean nitrocarburized steel	0.16 to 0.33
lubricated steel on steel	0.15 to 0.16
clean polytetrafluoroethylene	0.12 to 0.15
ice on ice	0.1
SAE 30 oil lubricated nitrocarburized steel	0.03 to 0.12
human shoulder, elbow, wrist and finger joints	0.01

The passive Fe_3O_4 oxide layer enhances the corrosion resistance of the substrate metal, which is AISI 8620 alloy steel for the M14 type receiver. Burlington Engineering, Inc. (Orange, CA) performed a salt spray test (DIN 50 021 SS procedure) to compare the corrosion resistance of various surface finishes. The base metal was a medium carbon steel, AISI 1045. The number of hours until the first spot of oxidation was observed was as follows: 1) untreated AISI 1045 steel – eight hours 2) hard chromium plating – 70 hours 3) double chromium plating – 100 hours 4) nickel plating – 120 hours 5) nitrocarburized AISI 1045 steel – 380 hours.

M14 Receiver Material

All military and commercial M14 type receivers are made of AISI 8620 or equivalent low carbon molybdenum-chromium alloy steel with the exception of a limited number of stainless steel receivers made by Armscorp of America, Inc. The M14 receiver (and bolt) should possess a hard and strong surface but ductile and tough core. The surface hardness and strength provides outstanding wear and fatigue resistance while the soft core gives excellent resistance to failure from impact. It is a hypoeutectoid steel. It is not age-hardenable. That is, it not will increase in strength below 500 degrees Fahrenheit over time. AISI 8620 alloy steel can be hardened and strengthened at the surface and made softer at the core by properly heat treating the surface. It is free machining steel which means it forms small chips when cut. AISI 8620 alloy steel is the choice of material for the M14 receiver and bolt.

Theory of AISI 8620 Steel Heat Treatment – The goal is to produce a part, e.g., M14 receiver, with a hard and strong surface and a ductile and tough core. This is a low carbon alloy steel. There is not sufficient carbon content to raise the surface hardness to what is desired (52 to 60 HRC) by simply heating the exterior. The part made from AISI 8620 steel can be made as hard and strong as AISI 4140 steel surface heating by carburizing. The part is placed in a carbon rich medium and then heated above the A_3 temperature. High carbon content (0.8 to 1.0 %) is created to a shallow depth from the surface by the diffusion of carbon into the austenite molecules present. The part is then quenched and tempered. The result is a hard, strong, and uniform depth martensite surface depth but the softer core is a mixture of martensite and free ferrite. The thickness

of the martensite layer, the case depth, is much less than a steel heat treated by surface heating such as is done with medium carbon alloy steels like AISI 4140. The result is that the softer core has a larger and consistent volume than it would have by surface heating. Thus, the carburized receiver has greater toughness. This is the chief advantage of AISI 8620 steel as the material of choice for the lightweight and reliable automatic M14 rifle receiver.

Chinese and U. S. commercial M14 receivers are not always heat treated to the same procedure as was done for USGI M14 receivers (see Receiver Heat Treatment). In 2005, a mid-1980s manufacture U. S. commercial receiver was tested and found to be 60 HRC at the surface and 45 HRC at the core. The core hardness was higher than allowed by the USGI M14 receiver drawing 7790189. The commercial receiver hardness was brought back into USGI specification by annealing the receiver. The surface hardness of a few Chinese receivers imported into the United States has tested substantially less than USGI drawing specification (see Chinese Receivers). Such receivers can be brought to suitable surface and core hardness through proper heat treatment.

AISI 8620 Alloy Steel

The following is presented as background information on AISI 8620 alloy steel. It is a low carbon nickel-chromium-molybdenum alloy steel. The description is as follows:

Typical Uses – AISI 8620 alloy steel is the most widely used carburizing alloy. It is used for gears, shafts and other applications where high wear resistance and a tough core are desirable.

Features – It is noted for a good combination of fatigue and wear resistance, hardness, strength and toughness when properly heat treated and carburized.

Shear Strength – Ultimate shear strength is about 70 % of ultimate tensile strength.

Machinability – The machinability rating is 68 % of AISI 1112 in the annealed condition. It is machined prior to carburizing so that the case depth is not reduced. It polishes well.

Average surface cutting speed is 110 feet per minute.

Forming – Forming is good in the annealed condition.

Normalizing – This alloy is typically heated to 1675 degrees F for sufficient time to ensure thorough heating then it is allowed to air cool.

Hardening – This alloy can be hardened by 1) normalizing by heating to 1500 F then water quenching then tempering or 2) annealing then cold working.

Carburizing – Carburizing is typically accomplished by heating to 1650 to 1700 degrees F in a carburizing medium then quenching the steel in oil.

Annealing – Anneal by heating to 1550 degrees F followed by furnace cooling at no more than 50 degrees F per hour down to 850 degrees F. Below 850 degrees F, it can be air cooled.

Forging – Forging is done from 2200 degrees to 1750 degrees F.

Tempering – The steel is heated at temperatures ranges from 400 to 1200 degrees F depending on the hardness wanted. The lower the tempering temperature the higher the hardness and tensile strength.

How was the U. S. Government Issue (USGI) M14 receiver made?

1. A slug of AISI 8620 steel is cut off from 1 3/4 " diameter bar stock.
2. The steel slug is heated to forging temperature using automatic instrumentation. The temperature range for forging AISI 8620 steel is 1750 to 2200 degrees Fahrenheit.
3. The steel slug is placed into the impression-die forging press and formed. The raw forging is created.
4. The hot receiver forging is removed by hand and held while trimmed by machine.
5. The raw forging is then heat treated. It is normalized by heating 130 to 140 degrees Fahrenheit above the A_1 temperature. This ensures the core exceeds the A_1 temperature. This causes the molecular structure of the steel to change from ferrite and cementite to 100 % austenite. The raw forging is then air cooled or oil quenched and tempered at not less than 450 degrees Fahrenheit. Normalizing produces a fine pearlite structure with a minimal amount of free ferrite. The raw forging is normalized instead of annealed because it is faster and extreme softness is not needed for the receiver. Normalizing also produces greater strength and toughness than annealing.
6. The receiver goes through broaching operations. Broaching is a simple and rapid means of removing metal. Typical tolerances that are obtained by broaching are + or - 0.0005 " to 0.0010 ". Broaching is usually more accurate and leaves a better finish than reaming or milling.
7. The receiver is machined to produce the final shape.
8. After all machining operations, the receiver is carburized, quenched and tempered. The receiver is placed in a carbon rich environment and heated to 1550 to 1600 degrees Fahrenheit. It is left in this condition long enough to obtain a case depth of 0.012 " to 0.018 ". The carbon surrounding the receiver diffuses into the austenite structure surface. After a specified time, the receiver is immediately quenched in oil. The receiver temperature is reduced to well below the M_{90} temperature, 650 degrees Fahrenheit, in less than two seconds. This produces a minimum of 90 % martensite structure throughout the receiver. However, martensite lacks the toughness and ductility desired for the M14 receiver. So, the receiver is tempered at 350 to 450 degrees Fahrenheit for at least one hour. The martensite in the core decomposes gradually to a softer mixture of ferrite and cementite as temperature and time are increased. This change in the core increases the ductility and toughness of the core. The procedure is controlled to limit the free ferrite to 10 % of the core composition. By specifying and adhering to the temper temperature range and time restrictions, the amount of free ferrite is controlled. The resulting hardness and strength is achieved within the desired values.
9. The receiver is air gauged for compliance to blueprint dimensional tolerances.
10. The receiver is inspected for defects by magnetic particle inspection.
11. The receiver is phosphate coated.
12. The receiver and other M14 parts are assembled together.

Receiver Heat Treatment

According to USGI M14 receiver (drawing number 7790189) blueprints, the treatment procedure is as follows:

1. Recommended Heat Treatment - Normalize before machining (oil quenching followed by tempering at not less than 450 degrees Fahrenheit may be used in lieu of air cooling). Carburize at 1550 to 1600 degrees Fahrenheit to specified case depth. Oil quench from 1550 to 1600 degrees Fahrenheit. Temper to hardness specified.
2. Mandatory Requirements:
 - a. Normalize before machining.
 - b. Carburize to case depth 0.012 " to 0.018 ".
 - c. Temper one hour minimum at 350 to 450 degrees Fahrenheit.
 - d. Core hardness 28 to 42 HRC. Surface hardness 61 to 71 HRD.
 - e. Microstructure of core shall not contain more than 10 % free ferrite after heat treatment.
 - f. The use of a straight cyanide bath or gas processes shall not be permitted.
3. Inspection after Heat Treatment - After heat treatment each receiver shall be free from cracks, seams and other injurious defects as determined by magnetic particle inspection using a standard five turn magnetizing coil with a current of 400 to 500 Amperes.

The USGI specification for M14 receiver surface hardness is 48 to 60 HRC (61 to 71 HRD) per drawing 7790189. A receiver core hardness of 35 HRC is the optimum value.

The terms, part number and drawing number, are used interchangeably when discussing USGI M14 (and other small arms) parts. For the most part, these two terms are synonymous. The exception to this rule was when a drawing was made for an assembly, e.g., drawing number 7790187 for the M14 bolt assembly.

Development of Magnetic Particle Inspection

According to an American Society of Nondestructive Testing Level III certified individual who audits U. S. DOD aerospace parts contractors for compliance with government specifications, the procedure for magnetic particle inspection has changed since the late 1950s. Regarding the M14 receiver blueprint, he states [minor spelling errors corrected]:

The listed procedure would only detect flaws oriented in the transverse direction of the receiver. On a forged or billet receiver, it would only detect flaws perpendicular to the grain flow of the metal. Most often, flaws will run in the direction of grain flow, not perpendicular to it. If the receiver was made from a casting, the procedure would, at best, only detect 50% of the possible flaws.

The amperage values listed are also below the requirements of MIL-STD-1949A and ASTM E 1444. The formula for determining coil shot requirements in the coil described is: $NI = 45000/(L/D)$, where I is the required amperage, N is the number of turns in the coil, L is the length of

the part, and D is the diameter (or major outside dimension). However, L/D (called the length to diameter ratio) can never exceed 15. If L/D exceeds 15, then 15 must be substituted for L/D. What this means is, when working the formula, the applied amperage through a five-turn coil should never be less than 600 Amps. The length to diameter ratio can never exceed 15, if it does, then 15 must be used. It is impossible to use the prescribed formula and come up with 400 to 500 Amps. By today's standards, the proper inspection might include a couple of coil shots (by shots I mean applications of electric current) plus a couple of direct contact shots and probably a central conductor shot. Any qualified magnetic particle inspector would most probably look at an M14 receiver and say at least two shots were required, and possibly as many as five. If I were inspecting it for myself, I would say five shots.

The magnetic particle inspection applied amperage requirement was changed to 800 to 1200 Amperes by no later than June 21, 1966 as shown on M14 Rifle drawing 7267000.

Disclaimer: The above information is for educational purposes. Machining, heat treat or inspection of any firearm receiver or frame should be performed by an experienced firearm manufacturing FFL / SOT. The author is not responsible for any consequence resulting from any attempt by anyone to manufacture, heat treat or inspect a firearm or parts thereof. Such activities should only be performed by businesses licensed and credentialed to do so.

USGI Receiver Geometry

Comparison of the T20E2, the T44 and the M14 – John C. Garand, father of the M1 Rifle, designed the T20E1 and T20E2 rifle select fire components between September 1944 and June 1945 while working at Springfield Armory. The select fire components of the M14 rifle are essentially copied from the T20E2 .30-06 caliber rifle. The M14 firing mechanism (trigger group) was borrowed from Garand's 1944 T20E1 design. The T20E2 and the M14 both fire from a closed bolt in semi-automatic and automatic. Nineteen T20E2 rifles were produced by Springfield Armory between May and August 1945 and a number of them remain in the inventory of the Springfield Armory National Historic Site. The T20E2 rifle did not go into production due to the end of hostilities in August 1945. The U. S. Army did produce an operator's manual for this rifle.

The significant differences between the T20E2 and M14 rifle select fire mechanisms are as follows: 1) the M14 rifle has an operating rod dismount notch in the center of the operating rod rail but the T20E2 rifle operating rod is removed through the notch at the rear top edge of the operating rod channel, similar to what is found on commercial manufacture M14 type rifles 2) the T20E2 rifle connector assembly has no operating rod rail "nub" 3) the T20E2 connector assembly is longer than the M14 connector assembly due to the greater length of the M2 receiver 4) there is no underside groove on the forward end of the T20E2 operating rod rail and 5) the forward end of the T20E2 connector assembly is anchored around the connector lock and not on top of it as is the case with the M14 late style connector. The original drawing for the late style M14 connector is dated April 01, 1959.

The T44 rifle was developed using the T20E2 receiver. Between August 1951 and March 1952 the T44 receiver got an operating rod dismount notch in the center of the operating rod rail and the corresponding "nub" was added to the T44 connector assembly. In January 1954, the United States and other North Atlantic Treaty Organization (NATO) nation members adopted the 7.62 x 51 mm cartridge as the standard for rifle ammunition. The new cartridge necessitated redesign of the T44 rifle. Colonel Rayle, Springfield Armory Head of Research and Development, sanctioned a contract with Mathewson Tool Company (New Haven, CT) to produce the drawings for and delivery of twelve shorter length receiver T44 rifles. The first such rifle was delivered to the U. S. Army in June 1954 on schedule. This rifle with the shorter length receiver was officially designated as the T44E4 by October 1954.

A January 1955 Springfield Armory photograph of a T44E4 rifle and associated select fire parts shows a shorter T44 style connector assembly in response to adoption of the 7.62 x 51 mm NATO cartridge. However, this means that the forward underside groove for the operating rod rail was not part of the 1954 T44E4 receiver design. The operating rod rail forward underside groove was part of the M14 receiver design by July 1958.

Comparison of Select Fire and Semi-Automatic Receivers - The functional differences between USGI and commercial M14 type semi-automatic receivers are slight but important. The USGI M14 receiver has a notch cut in the center of the receiver rail. This allows for dismounting of the operating rod during disassembly. The forward end of the USGI receiver rail has a groove cut into it on the underside to secure the connector assembly from drifting to the right and losing contact with the operating rod as it moves forward to initiate automatic firing sear release function. The USGI receiver is also manufactured with a selector lug on the rear right hand bottom side. The selector and connector assemblies are attached to the rifle by this selector lug.

The select fire M14 type receiver requires a USGI M14 design sear to allow automatic fire when the selector switch is placed in the automatic fire position. If a commercial reproduction M14 type sear or a M1 Garand sear is installed in the firing mechanism, the rifle will not fire in automatic mode even with all select fire components installed and the selector switch placed in the automatic position. This is because the commercial reproduction and M1 Garand sears are not wide enough to contact the sear release no matter the position of the selector switch. The USGI M14 sear is approximately 5/32 " wider than the M1 Garand and commercial reproduction sear designs.

The operating rod rail center dismount notch and forward end underside groove in and of themselves do not facilitate automatic fire but serve as convenient anchor points for reliable operation of the connector assembly. Nonetheless, law enforcement agencies have thought otherwise and enforced their interpretation of the law accordingly. The reader is strongly encouraged to stay out of trouble with law enforcement agencies and the judicial system. Warning: DO NOT alter any M14 type rifle operating rod rail and DO NOT purchase or possess a M14 type receiver in the United States with these two machining cuts or a selector lug unless it is listed in the National Firearms Act Registry.

USGI Receiver Common Traits – USGI receivers have a distinct machined flat surface with a longitudinal edge on the top of the barrel ring. Springfield Armory, Winchester,

Harrington & Richardson and TRW used the upper case letters MM to denote millimeter in their receiver heel stampings. An engraved circle or oval located to the left of the manufacturer stamping has been observed on USGI M14 receivers. This marking has been found on intact and demilitarized receivers. Preliminary research indicates this marking was not applied by Hahn Machine Company or the Israeli government (see The M14 Rifle in Overhaul).

Forming of Military Receivers

USGI M14 and Taiwanese Type 57 receivers are drop forged. The raw receivers were formed by the impression-die drop forging method. The flashing was removed and the finish machining completed on special broaching, milling and drilling machines. Storms Drop Forge (Springfield, MA) was the subcontractor that made the M1 Garand and M14 receiver and component forgings for Harrington & Richardson. The H&R, Springfield Armory and Winchester receivers would last 400,000 rounds and the TRW receivers were good for 450,000 rounds. ¹

Intervening Rifle Models: M2 through M13

Until the M1 Rifle was adopted, small arms were designated by date, e.g., M1903. By some time in the 1930s the U. S. Army changed to designating weapons by model number. The M1 Garand was the first rifle. The M1 Carbine was the first carbine. The M1 Thompson was the first submachine gun and so forth. Some of the intervening rifle models between the M1 and M14 are identified as follows:

M2: The M2 was a Springfield Armory .22LR caliber magazine fed bolt action rifle. It was 43.66 " long and weighed 8.87 pounds.

M4: The M4 (T38) was a magazine fed .22 Hornet caliber bolt action survival rifle. Harrington & Richardson made 29,344 M4 rifles in 1949. The M4 weighed 4 pounds and was 32 ½ " long with a 14 " barrel.

M5: The M5 was a combination .22 Hornet caliber rifle and .410 gauge shotgun. Harrington & Richardson produced fifty M5 rifles in 1950.

M6: The M6 was similar to the M5. It too was a combination .22 Hornet caliber rifle and .410 gauge shotgun. The M6 was developed by the U. S. Army Ordnance Command and produced by Ithaca around 1951. The M6 weighed 3 pounds 12 ounces. It had an overall length of 28 ¼ " and a folded length of 15 ". This model was reproduced by Springfield Armory, Inc. for a time.

M8 and M8C: These were spotting rifles for the 105 mm and 106 mm recoilless rifles, respectively.

M9: This may be a sub caliber device for the 106 mm recoilless rifle but this has not been confirmed.

M10: This model number was not used by the U. S. Army.

M11: This model number was not used by the U. S. Army.

M12: This model designation was assigned to two .22LR caliber training rifles, the

Winchester Model 52 Heavy Barrel and the Remington Model 40X-S1. Remington Model 40X-S1 M12 rifles were in the inventory of Marine Corps Junior ROTC units in the 1970s for smallbore rifle marksmanship training and competition.

M13: Likewise, this model number was given to two .22LR caliber training rifles, the Remington Model 513T Targetmaster and the Winchester Model 75 Target. Remington Model 513T Targetmaster M13 rifles were also in the inventory of Marine Corps Junior ROTC units in the 1970s.

The M14 rifle was designated as such in 1957 since that number was the next available model number for a rifle.

M14 Rifle Development Highlights

The M14 rifle incorporates a number of designs borrowed from developmental rifles dating between 1944 and 1954. Essentially, the M14 as known today is a slightly improved version of the T44E4 rifle design of 1954. The M14 rifle uses the M1 rear sight and trigger, the T20 breech and magazine catch, the T20E2 select fire components, the T25 gas system, the T31 magazine and the T44E4 receiver.

Much of the documentation of the development of the M14 rifle from 1952 until 1959 remains inaccessible for public inspection. This documentation is in classified material storage at the National Archives in Washington, DC. During the 1950s, the United States Department of Defense produced an immense quantity of classified documents related to the development of thermonuclear weapons. U. S. government documents related to M14 rifle development are stored along with the information on nuclear weapons. With the passage of time, the M14 project documents will become available for public inspection. Some highlights of the M14 rifle project are listed below:

July 01, 1957 to December 31, 1957 - Springfield Armory begins development on aluminum M14 magazines. Mathewson Tool Company produces the first experimental aluminum M14 magazines.

1958 - Initially, a ten round magazine stripper clip was experimented with for the M14. However, a modified five round Mauser stripper clip and magazine charger was eventually developed and adopted. General Tire & Rubber Company delivers fifty T44E6 and M14 reinforced fiberglass stocks under contract from Springfield Armory. Development work was done on the receiver scope mount and improvement of bolt roller durability.

March 18, 1958 – The U. S. Army Ordnance Command awards a contract to Springfield Armory for a pilot production lot of 15,000 M14 rifles.

July 01, 1958 to December 31, 1958 - The M14 Technical Data Package is completed.

October 1958 - The work needed to calibrate the rear sight elevation knob in meters is completed. Aberdeen Proving Ground and Springfield Armory participated in this project.

December 1958 – Springfield Armory begins making production M14 parts.

January 01, 1959 to June 30, 1959 - Several improvements were made to the M14 rifle including: 1) a longer connector lock pin for ease of disassembly 2) modification of the gas cylinder plug and gas piston to make assembly easier 3) modified barrel, gas cylinder and flash suppressor splines to prevent incorrect assembly 4) modification of the barrel

diameter to prevent cross-threading of the gas cylinder lock and 5) gas cylinder plug design improvement to prevent cross-threading and thread stripping. Development work continued on the reinforced fiberglass M14 stock.

February 21, 1959 - The Arctic Test Board recommends adoption of the Colley type winter trigger for the M14 rifle.

March 16, 1959 to March 23, 1959 - Two T44E4 bipod designs were tested at Fort Benning, GA for the M14 rifle. Both bipods attached to the bayonet lug. One version did not have any height adjustment. The second bipod model had three height adjustments, weighed 1.28 pounds and could be folded against the stock. Eventually, neither design was adopted. As part of the same test, the M14 rifles were fitted with aluminum butt plates and steel butt plate flappers. Additionally, three types of fiberglass hand guards were tested: Type A - solid, Type B - hand guard with thirty-eight round holes and Type C - hand guard with fourteen slotted holes.

April 10, 1959 - The U. S. Army Infantry Board published the Project Number 2839 report that recommended the adoption of the Type C hand guard and the hinged butt plate for the M14 rifle. The Army Infantry Board report also recommended the M14 rifle with the Type III bipod (referred to as the Type II bipod in other references) as a substitute for the M15 rifle.

July 01, 1959 to December 31, 1959 - Six T140 grenade launchers were made by Springfield Armory. Four T140 launchers were sent to the U. S. Marine Corps for testing. Springfield Armory also manufactured twenty-four M6 bayonets of which eighteen were sent to the U. S. Army Infantry Board and the U. S. Marine Corps for testing. A number of fiberglass reinforced M14 stocks were manufactured and sent to the U. S. Army in Alaska for testing. The U. S. Army Continental Army Command standardized the ventilated fiberglass reinforced plastic hand guard and hinged butt plate for the M14 rifle.

July 1959 – The first fifty Springfield Armory M14 rifles were assembled. The stocks and hand guards were made of black walnut.

August 1959 – Ten of the first fifty M14 rifles were shipped to Fort Benning, GA for testing. All shipment of production M14 rifles was suspended pending test results. The Type IV bipod (referred to as Type III in other references) was tested successfully at Fort Benning. It was later adopted and designated M2 Bipod.

September 1959 – M14 rifle testing is completed with satisfactory performance. The M14 hinged butt plate drawings are completed.

October 1959 – The first Springfield Armory production M14 rifle is presented to Master Sergeant George C. Ferguson by Secretary of the Army Wilbur C. Brucker at Aberdeen Proving Ground, MD.

July 01, 1960 to December 31, 1960 – Aberdeen Proving Ground (MD) successfully develops and tests the XM12 blank firing attachment and a breech shield for the M14. Engineering tests on the reinforced fiberglass stock and hand guard were completed at Aberdeen Proving Ground. The reinforced fiberglass plastic slotted hand guard was found to be superior to the wood hand guard in the testing. Additionally, it was slightly less expensive to manufacture than the walnut hand guard. The fiberglass stocks successfully passed testing as well but the grenade firing test resulted in further development work for improved durability.

October 1960 - Springfield Armory delivers the last rifles from its pilot production order of

M14 RIFLE HISTORY AND DEVELOPMENT

15,600 M14 rifles to the U. S. Army.

December 15, 1960 – Three Harrington & Richardson (H&R) M14 rifles (one receiver and two bolts) failed during range firing at Fort Benning, GA.

January 01, 1961 to June 30, 1961 – Springfield Armory makes the first production birch M14 stocks. Walnut became the alternate standard for the M14 stock. The blank firing attachment and breech shield are tested at Fort Benning, GA.

January 11, 1961 – Ordnance Weapons Command releases Engineering Order No. 164. This document provided additional quality assurance provisions for the bolt, receiver, barrel and rifle. This Engineering Order was the result of investigations conducted by Springfield Armory, Watertown Arsenal, Rock Island Arsenal, Frankford Arsenal and Aberdeen Proving Ground into the H&R M14 rifle failures of December 1960.

April 1961 – Plastic hand guards are produced at Springfield Armory.

September 21, 1961 – The M12 blank firing attachment and M3 breech shield were officially classified as Standard A.

July 01, 1961 to December 31, 1961 - U. S. Army soldiers in Europe reported difficulty in stowing and accessing butt stock cleaning kit. Springfield Armory determined the butt stock storage compartment holes were not correctly located. The affected stocks were repaired and the stock drawing was revised.

January 01, 1962 – June 30, 1962 – The preservation procedure for birch stocks was finally adopted. It required only one dip in tung oil whereas the walnut stocks had been dipped twice.

March 1962 - Springfield Armory received the final shipment of 200 aluminum M14 magazines from Mathewson Tool Company per Army Ordnance Command contract ORD-5115.

July 1962 - The aluminum M14 magazines were tested with favorable results.

January 21, 1963 – Secretary of Defense Robert S. McNamara announced the end of M14 rifle procurement with that fiscal year's contracts.

April 1963 - The U. S. Marine Corps had removed all defective Harrington & Richardson M14 bolts from its inventory.

July 01, 1963 to June 30, 1964 - A thorough revision was made of the M14 Technical Data Package. The wood M14 stock was redesigned to increase service life.

October 1963 – Springfield Armory fabricates and demonstrates five prototype M14E2 rifles. Springfield Armory delivers its last batch of M14 rifles to the U. S. Army.

November 1963 – Authority was given to Springfield Armory for 8,350 M14E2 conversions

June 30, 1964 – Official end of new M14 rifle production. TRW made its only run of M14 NM rifles in 1964.

July 1964 – Thompson-Ramo-Wooldridge, Inc. delivered the last 200 M14 rifles to the U. S. Army.

December 1964 – Springfield Armory completes delivery of the 8,350 M14E2 rifles.

July 01, 1965 – June 30, 1966 Springfield Armory converted 2,094 M14 rifles into M14 NM rifles. Springfield Armory conducted a study to evaluate different heat treatment processes and long term storage effects on M14 magazine springs. Work was begun at the Armory to fill spare parts orders for 64,000 bolts with rollers, 35,000 operating rods and 12,000 stocks.

The following decisions were made in M14 design or production:

1) These M14E2 design improvements were incorporated into the procurement system: M2 bipod, winter trigger assembly, muzzle stabilizer with positive locking mechanism, stock back plate, better hand grip, and improved bipod jaws.

2) Design improvements were completed on a synthetic rubber stock pad to smooth out automatic fire under all environmental conditions.

3) Springfield Armory produced 2,395 M14 NM rifles by rebuilding rack grade rifles.

December 1966 – Springfield Armory completed a rebuild program on 24,000 M14 rifles. Harrington & Richardson performed the targeting of these assembled rifles under contract from Springfield Armory. This is the last known involvement of Harrington & Richardson with the U. S. government M14 project.

December 1965 – The final revision drawings for the firing pin and synthetic M14 stock were issued.

July 01, 1966 to June 30, 1967 – Rock Island Arsenal rebuilt 2,462 rack grade rifles into M14 NM rifles.

1967 - Springfield Armory was given an order to deliver 52,780 M14 barrels. Delivery of the barrels was completed in the fall.

April 30, 1968 - Springfield Armory is closed. The M14 production equipment had been crated up and shipped to Rock Island Arsenal. The M14 manufacturing records, drawings and other documents were shipped to the U. S. Army Weapons Command at Rock Island Arsenal and to a federal records center in St. Louis, MO.

M14 Rifle Factory Inspection

The following describes the requirements each M14 rifle had to pass before it could be shipped to the military. The M14 rifle was tested by first firing a high pressure 67,500 psi proof round. The rifle and spent cartridge case were examined for any signs of broken parts and overpressure. If the test was successful, the proof P marks were immediately applied to the barrel (P), bolt (a punch mark), stock (P inside a circle) and receiver (punch mark).

The proof test was followed by function tests in semi-automatic, burst automatic, and sustained automatic fire. The rate of fire in automatic had to be within a specified range. This range is 650 to 780 rounds per minute according to Military Specification MIL-R-45012E. Each rifle was required to deliver its center of impact within a specified limited area around the point of aim at 100 yards with the rear sight set at eight clicks up from bottom and at zero windage. Every rifle had to group within 5.6 " at 100 yards with five rounds of M80 ball ammunition. Additionally, M14 rifles were tested for tightness of barrel draw, acceptable headspace, firing pin indentation and trigger pull force. The military specification for the amount of trigger pull force is 5.5 to 7.5 pounds for the M14 and 4.5 to 6 pounds for the M14 NM. If the rifle failed, it was tagged to record what the particular problems were. The manufacturer replaced the parts and sent it through the entire inspection process again. Most rifles passed the testing the second time around. The information noted on the tags was recorded and used to analyze the manufacturing process to determine what needed correction.

While a five shot group of 5.6 " at 100 yards may not seem terribly accurate, this includes

the inaccuracy of the M80 ball ammunition factored in. The Boston Ordnance District was responsible for final acceptance of M14 rifles manufactured by Harrington & Richardson and Winchester. By Fiscal Year 1962, it had conducted a study into the factory accuracy testing rejection rate of M14 rifles.² The Boston Ordnance District discovered that the M80 ball ammunition of itself had an average spread of 3.57 " at 100 yards within every ninety rounds fired. Ammunition inconsistency aside, a rack grade M14 type rifle is accurate for a battle rifle when properly assembled.

In addition to test firing, which every rifle went through, M14 rifles were pulled out at given intervals and subjected to endurance firing for 6000 rounds. One M14 rifle and twelve magazines were selected by a U. S. government representative out of each of the first five lots of 500 rifles at the factory. If each of the five selected rifles passed the endurance test, then the endurance test samples were selected at a rate of one for 2500 rifles produced. This endurance test sampling rate was performed for five lots of 2500 rifles. If these next five rifles all passed the 6000 round endurance test then the endurance sampling rate was upped to one test rifle every 5000 rifles produced.

The 6000 round endurance test was conducted as follows. The rifle was fired first in semi-automatic for 100 rounds followed by five round bursts for another 100 rounds. Then five full magazines were each emptied in automatic with one pull of the trigger for each magazine. The magazines were rotated for even use and the rate of fire was measured during one of the twenty round bursts. The barrel was allowed to cool to ambient after each 100 rounds. The rifle was cleaned and lubricated every 1000 rounds. No cleaning of the gas system was allowed. This procedure was repeated until 6000 rounds had been fired.

Only a small fraction of any kind of failure was allowed in the endurance test. The endurance test allowed no more than twelve malfunctions and no more than two unserviceable parts. The allowable malfunctions and associated instances were as follows: 1) bolt failed to lock into battery – three 2) bolt lock failed to hold the bolt open – one 3) cartridge case failed to eject – one 4) a cartridge that was visible failed to feed – four 5) a cartridge not visible failed to feed – three 5) failure to fire in semi-automatic – three 6) light primer strike – three and 7) punctured primer – one. If any one malfunction occurred more than the allowed number of times or if the total number of malfunctions was more than twelve, the rifle did not pass the endurance test.

No unserviceable parts were allowed in the first 3000 rounds. The allowable unserviceable parts and associated instances for the second 3000 rounds of testing were as follows: 1) ejector – one 2) ejector spring – one 3) extractor – one 4) extractor spring – one 5) firing pin – one. If any one part broke more than once or if there were more than two unserviceable parts, the rifle failed the endurance test. Some of the M14 rifles completed the 6000 round endurance with no malfunctions or unserviceable parts.

Ten M14 rifles selected by a U. S. government representative from each inspection lot were also tested for parts interchangeability. If more than one contractor was producing M14 rifles at the same time, each contractor submitted six specimens each month for parts interchangeability with parts made by the other contractor.

After completion of all firing tests, each bolt assembly was examined by magnetic particle inspection for cracks, seams and other injurious defects. If the bolt passed examination, the bolt was marked with the letter M. The bolt assembly was then cleaned, the roller repacked with grease and the rifle reassembled. Every rifle was given a final and thorough visual examination before preservation and packaging. Sample M14 rifles were tested for cleanliness before packing and the packaging tested for vacuum retention.

M14 Production at Springfield Armory

The Springfield Armory was built during the American Revolutionary War. The plot of land it was situated on had been used since the 1600s to train colonial militia units. The site was established as an ammunition depot in 1777 by General George Washington. President George Washington selected Springfield Armory in 1789 to be the first government arsenal. Springfield Armory was officially established in 1794 by an Act of Congress. From 1794 to 1968 the Springfield Armory was the center of military small arms development and production in the United States. The armory tested and manufactured several muskets in the eighteenth and nineteenth centuries for the U. S. Army. It also produced the Krag-Jorgenson, M1903 and M1 Garand rifles prior to the M14 project. The Department of the Army made plans to close Springfield Armory in 1964 and did so on April 30, 1968.

Springfield Technical Institute was established by the City of Springfield, Massachusetts in 1964. It operated under the jurisdiction of the City of Springfield, Massachusetts and the Commonwealth of Massachusetts Department of Health, Education and Welfare. Springfield Technical Institute later moved into three buildings inside the Springfield Armory during the summer of 1967 and began operating under the authority of the Commonwealth of Massachusetts Board of Community Colleges beginning in September 1967. The fifty-five acre site formerly known as the Springfield Armory was renamed Springfield Technical Community College in August 1968. The college continues to serve the people of the Commonwealth of Massachusetts to the present day.

The Springfield Armory National Historic Site was created by an Act of Congress in 1974 and opened in 1978 under the administration of the U. S. Department of Interior National Park Service. Twenty of the fifty-five acres of land were set aside for the National Historic Site. The Springfield Armory National Historic Site has two buildings, the Main Arsenal which is now the Museum, and the Commanding Officer's Quarters which are now National Park Service Administrative offices. The Main Arsenal was built in 1850 and the Commanding Officer's Quarters built from 1845 to 1846. The Springfield Armory National Historic Site houses the largest firearms collection in the United States and the second largest in the world.

Springfield Armory was the first of four M14 rifle manufacturers for the U. S. government. It was tasked with setting up a pilot production line in April 1958. Startup of parts production began in December 1958. The first five parts made were the receiver, the bolt, the gas cylinder, the operating rod handle and the trigger housing. Troublesome production issues included obtaining satisfactory precision castings for the flash suppressors, proper welding techniques for the operating rods, and achieving satisfactory heat treatment for the receivers. The USGI M14 operating rod drawing requires a weld

near the aft end of the cylindrical portion. Springfield Armory (and Winchester and Harrington & Richardson) made operating rods from two pieces of alloy steel.

Springfield Armory made the least number of USGI M14 rifles, 167,107. The first M14 rifles were delivered to the U. S. Army in August 1959 by Springfield Armory. It had 400 of 3100 employees involved with the M14 rifle in August 1961. M14 production orders followed in November 1959, March 1961, and Fiscal Year 1962. Springfield Armory also made M14 NM rifles (see M14 NM). During Fiscal Year 1964, Springfield Armory developed a dry fire device for the M14 rifle. It appears few, if any, of the rubber hammer bumpers were ever made.

Springfield Armory manufactured two M14 rifles for President Eisenhower in November 1959. Two rifles were made in case one was flawed. Both rifles were given a blued finish. As it turned out, close examination revealed M14 serial number D.D.E. 1 to be flawed but D.D.E. 2 was flawless. M14 serial number D.D.E. 2, with the selector lock, was presented to President Eisenhower. M14 serial number D.D.E. 1 was tested as an endurance test rifle then transferred to the Springfield Armory Museum on October 18, 1960 where it remains on public display.

Springfield Armory Machine Tools - In 1968, some M14 project equipment was auctioned off. The remainder was shipped to Rock Island Arsenal for storage. In 1994, Rock Island Arsenal auctioned off to the public a large quantity of M14 project equipment. The auction records were only kept for five years. Presumably, this equipment had been used at Springfield Armory. The following describes some of the machine tools in use by Springfield Armory in August 1961:

1. The barrel installation machine screwed the barrel and receiver together with the exact prescribed torque in seconds.
2. Broaching machines were used for high speed removal of metal from the receiver forging.
3. A grinder was used to grind the rear faces of the M14 bolt lugs.

M14 Production at Winchester

Oliver F. Winchester began his business venture into firearms in 1855. Eleven years later, he founded the Winchester Repeating Arms Company in New Haven, CT. He manufactured the first successful repeating rifle in the world in 1866. By 1872, Winchester begins making ammunition. In 1931, Olin Industries purchases Winchester Repeating Arms Company and combines it with the Western Cartridge Company to form Winchester-Western. During World War II, Winchester-Western manufactured M1 Garand rifles. In 1954, Olin Industries and Mathieson Chemical Corporation merged to form the Olin Mathieson Chemical Corporation. Its name was simplified to Olin Corporation in 1969.

In 1981, the shotgun and rifle manufacturing operation is sold to U. S. Repeating Arms Company, Inc. U. S. Repeating Arms, a subsidiary of Herstal Group, continued the tradition of manufacturing quality shotguns and bolt and lever action rifles under a licensing agreement from the Olin Corporation until 2006. On March 29, 2006 the manufacture of Winchester brand firearms in New Haven, CT came to a halt after 140

years of operation. The U. S. Repeating Arms facility had been manufacturing Winchester Model 94 and Model 70 rifles and the Model 1300 shotgun. The Winchester named operation remains a leading manufacturer of small arms ammunition. The ammunition is produced at facilities in East Alton, IL and Geelong, Australia.

On February 17, 1959, Winchester was the first of three commercial firms to be awarded a M14 rifle contract. Subsequent M14 contracts were awarded in April 1960, December 1961 and on September 28, 1962. As part of the second (April 1960) contract, the firm agreed to dedicate all of its manufacturing and assembly operations to manufacturing the M14. Apparently, Winchester held a ceremony on September 12, 1960 to celebrate the conversion of its New Haven factory to nothing but M14 rifle production. A commemorative 8 3/4 " wide ash tray was made by T. R. Mintz Sales Co. (then 286 Blake Street New Haven, CT) for the festivities. The first Winchester M14 rifles were delivered to the U. S. Army in April 1961. Mr. Hurley was a Winchester employee. In 1961, he was interviewed by *Ordnance* magazine regarding production of the M14 rifle for the U. S. Army.

Winchester designed special machinery to make the M14 receivers and wood stocks. Winchester was delayed several months getting the bugs worked out of the receiver making machine tools but was successful in meeting its required monthly production rate by August 1961. The automated high speed woodworking machinery was successful from the beginning of operation. Winchester produced the second largest number of USGI M14 rifles, 356,501.

Winchester Machine Tools – The following describes some of the machine tools used by Winchester in August 1961 to produce the M14 rifle:

1. The barrel drilling installation consisted of eight machines of six spindles each for drilling barrel bores.
2. The Gorton straight-line transfer machines performed thirty-two high precision machining operations on the receiver automatically.
3. The sixteen station stock inletting machine replaced sixteen single purpose woodworking machines in making wood stocks.

Receivers were machined using special milling machines. The other three rifle manufacturers formed their receivers by extensive broaching. Winchester had the most automated stock making machinery of the four manufacturers.

M14 Production at Harrington & Richardson

Harrington & Richardson Arms Company began manufacturing firearms in 1874 and produced double action revolvers as early as the 1880s. During World War I, the firm manufactured flare guns and sword scabbards for American troops fighting in Europe. Through the years Harrington & Richardson produced reliable and affordable rifles and revolvers. The company produced more than 400,000 M1 Garand rifles from 1952 to 1956 for the U. S. government. Harrington & Richardson M1 Garand rifles are sought after by collectors. The main plant for Harrington & Richardson was located at Park Avenue and Chandler Street Worcester, MA 06109. The company went out of business in 1986.

Harrington & Richardson received its first M14 contract in April 1959. Subsequent contracts were awarded in February 1960, September 1961, in Fiscal Year 1962, and then again in Fiscal Year 1964. The first Harrington & Richardson M14 rifles were delivered to the U. S. Army in December 1960. In August 1961 there were about 1,000 employees working on the M14 project at Harrington & Richardson. By 1963, there were over 1,500 employees involved with the M14 project company wide. Harrington & Richardson performed 243 operations to produce each M14 receiver. Harrington & Richardson produced the largest number of USGI M14 rifles, 537,625. The company returned the M14 rifle project documents and equipment to the U. S. government at some point before 1968.

H&R Machine Tools – The following describes some of the machine tools used by Harrington & Richardson in August 1961:

1. The Cincinnati special milling machine was a multi-station mill for finish machining operations on the receiver.
2. The crush grinder was used to grind gas cylinder threads on the M14 barrel.

Harrington & Richardson Parts Failures – Two H&R receivers, serial numbers 19478 and 19656, and one HRT bolt failed during range firing at Fort Benning, GA on December 15, 1960. Exactly one week later, receiver serial number 73293 fractured during proof firing at the Harrington & Richardson factory in Worcester, MA. Receiver serial numbers 19478 and 73293 were made of incorrect material, AISI 1330 steel, instead of AISI 8620 steel. Receiver serial number 19478 was stamped Winchester but it was one of 850 M14 receivers Winchester had purchased from Harrington & Richardson for initial production.

The use of the wrong material was an unintentional mishap on the part of Harrington & Richardson. When the receivers made of the incorrect steel were heat treated the result was unsafe. These AISI 1330 steel receivers were weak and brittle. The incorrect steel had been used for several days of production of receivers. The receivers made of the improper material were destroyed but Harrington & Richardson had to produce the contracted number of receivers. It is not known if the serial numbers from the defective receivers were reused or if new serial numbers were issued for the replacement receivers.

The bolt in receiver serial number 19543 had a completely sheared right lug and a severely cracked left lug. The failed bolt was made by Textile Machine Works, a subcontractor to Harrington & Richardson. A thorough metallurgical investigation of the M14 bolt was performed by government, Ipsen Furnace Company and Armour Research Foundation metallurgists between January and May 1961. The failed bolt was cut into sections and examined using microscope photography. The major fault was the failure to strictly adhere to the written heat treatment procedure even though the correct steel was used. The procedure requires the bolts to be heated to a narrow temperature range then immediately cooled by oil immersion. If the bolts are not brought up to the required temperature or if they are allowed to cool before oil quenching, an excessive amount of free ferrite is formed. Ferrite is soft and weak iron. Ferrite does not bond with carbon atoms so the freed up carbon atoms moved into the rest of the bolt. This condition in the HRT bolt created a very hard and brittle martensite molecular structure. Under repeated

impact loading, cracks formed and grew in the lugs, resulting in catastrophic bolt failure.

A task force of about forty Army Ordnance Command representatives met on December 28 and 29, 1960 to determine the causes of failure and to implement a plan of action to prevent any more such failures. After the meeting, a combined team from Springfield Armory and Boston Ordnance District visited the following contractors and subcontractors to review M14 component manufacturing procedures and obtain samples for evaluation: Winchester in New Haven, the Rochdale and Worcester H&R plants, Storms Drop Forge and Textile Machine Works. The following deficiencies were noted by the team:

- 1) M14 bolts at the Winchester plant were not quenched according to good engineering practice for 8620 steel. Additionally, there was no magnetic particle inspection of Winchester M14 bolts after proof firing.
- 2) Receivers that missed steps in the machining process were reworked by spot annealing and hand grinding at Harrington & Richardson.
- 3) Winchester was unable to meet the minimum core hardness limit for bolt heat treatment.
- 4) Textile Machine Works was unable to meet the maximum core hardness limit for bolt heat treatment.

Further, a Lackland Air Force Base report dated December 1960 revealed oversize chambers in H&R M14 barrels. The M14 barrel inspection gage measured chamber diameter at 0.5 " from the breech but the excessive diameter was located at 0.4 " from the breech. Thus, the oversized chamber in H&R M14 barrels had gone undetected. During testing of H&R M14 rifles with oversized barrel chambers in March 1961 at Aberdeen Proving Ground (MD), one early production Winchester bolt failed after 3,100 rounds in the cold room test due to excessive free ferrite.

Springfield Armory test rifle bolts which had gone thousands of rounds were examined for similarities and differences with the failed HRT bolt. The test rifle bolts demonstrated that minor cracks may start in the hardened surface but they do not grow through the bolt core if the heat treatment is correctly performed. Properly heat treated bolts were found generally to have less than 10 % free ferrite but the bolt from receiver serial number 19543 had as much as 50 % free ferrite. The end result was additional quality assurance provisions as required by Ordnance Weapons Command Engineering Order No. 164 released on January 11, 1961. This Engineering Order applied to the first and second Winchester contracts and the first Harrington & Richardson contract. These new requirements included a revised inspection procedure for the barrel, bolt and receiver, installation of new heat treatment equipment and a magnetic analyzer to check receiver material. The revised inspection procedure included two separate magnetic particle inspections of each receiver and bolt, before and after heat treatment. The magnetic analyzer was developed by Springfield Armory with assistance from Watertown Arsenal.

On April 23, 1961, Ordnance Weapons Command issued instructions to Raritan Arsenal to inspect, segregate and reassemble 35,000 Harrington & Richardson and 850 Winchester M14 rifles manufactured before the issuance of Engineering Order No. 164. The instructions required inspection of the barrels, bolts and receivers for compliance

with material, hardness and dimension specifications. Springfield Armory provided technical assistance, training and inspection equipment for this work at Raritan Arsenal. The relevant portion of the May 08, 1961 Springfield Armory report is reproduced here for benefit of the reader:

“Regarding cracks in bolt locking lugs, numerous firing tests at Springfield Armory have proved minute cracks in bolt lugs do not cause early failure if metallurgical structure of bolts is correct and bolts and receivers are dimensionally correct.

On 23 April 1961, instructions were issued from Hq. OWC on the inspection criteria to be observed at Raritan Arsenal for the inspection segregation and reassembly of M14 rifles. The instructions are as follows:

After careful evaluation of available tests and performance data, and with due consideration to the urgent requirements for M14 rifles, the following are effective immediately:

(a) M14 bolts manufactured prior to the implementation of OWC EO 164 except HRT lots A01 and A1980, and those 850 OMCC bolts in weapons at Raritan Arsenal returned from the field are acceptable for immediate assembly provided the following 100 % reinspection is conducted:

- (1) Check for compliance with surface hardness requirements.
- (2) Inspect for cracks at lug area using 600 amperage on Magnaglow inspection. No cracks are permissible
- (3) Inspect for compliance with the 0.028 minus .008 radius and toll marks in lug area in 4 locations.
- (4) These bolts will not be used for repair parts.
- (5) All bolts in the above category will be marked or etched below the part number or serial number with a small identifiable star or asterisk.

(b) Receivers meeting all other contract requirements are 100% acceptable provided inspection is conducted to insure:

- (1) Compliance with specified surface hardness requirements.
- (2) That proper steel was used in manufacture as determined by use of a magnetic analysis comparator. Receivers exceeding plus 40 reading shall be rejected. Receivers exceeding minus 40 may be accepted but will be marked or etched with a small identifiable star or asterisk.

(c) Dimensional requirements for both components remain unchanged.

(d) Boston Ordnance District was authorized to approve RDA's for bolts meeting the criteria previously stated.

(e) In addition, instructions have been established to accept oversized chambers in weapons at Raritan Arsenal up to .005["] maximum over the drawing tolerance.”

Random Sample USGI M14 bolts that had passed all required government inspection and testing measured 52 HRC (HRT marked bolt) and 54 HRC (TRW marked bolt) for surface hardness. Springfield Armory and Winchester carburized M14 bolts by the salt

bath method whereas Textile Machine Works used the ammoniated gas method for bolt carburizing. The USGI M14 bolt was manufactured to the following requirements:

- 1) Rockwell hardness readings shall be taken on the locking lugs and at the rear end of the bolt.
- 2) Bolt material: 8620H alloy steel except resulphurized content at 0.035 % to 0.50 % that is gun quality specification per ASTM A304, A322, or A331. Hardenability of steel shall be controlled as required to suit manufacturer's heat treatment process and to assure that the specified mandatory physical properties are met. Austenitic grain size is 5 to 8.
- 3) Heat treatment recommended process: normalize before machining (oil quenching followed by tempering at not more than 450 degrees Fahrenheit may be used in lieu of air cooling). Carburize at 1550 degrees Fahrenheit to 1600 degrees Fahrenheit to the specified case depth. Without reheating, quench in oil or neutral salt bath from 1500 degrees Fahrenheit to 1600 degrees Fahrenheit. If reheated, quench from 1550 degrees Fahrenheit to 1600 degrees Fahrenheit. Temper to the specified hardness.
- 4) Heat treating mandatory requirements:
 - A. Normalize before machining.
 - B. Carburize to a case depth of 0.012 " to 0.018 ".
 - C. Temper for one hour minimum at 350 degrees Fahrenheit to 450 degrees Fahrenheit.
 - D. Core hardness is 33 HRC to 42 HRC. Surface hardness is 66 HRD to 71 HRD (54 HRC to 60 HRC).
 - E. Microstructure of the core shall not contain more than 10 % free ferrite after heat treatment per AMS 2315.
 - F. The use of a straight cyanide bath or carbonitriding shall not be permitted.
 - G. When gas carburizing is used the carbon content shall not exceed 0.84 % at the surface of the bolt per AMS 2762.

M14 Production at TRW

Thompson-Ramo-Wooldridge, Inc. was the fourth and last of the USGI M14 rifle manufacturers. It is referred to as TRW throughout this work. The earliest origin of TRW was in the 1901 founding of the Cleveland Cap Screw Company. Eventually, this business was renamed Thompson Products. Thompson Products was a manufacturer of automobile and aircraft engine parts. In 1958, Thompson Products merged with Ramo-Wooldridge to form Thompson-Ramo-Wooldridge Corporation. Ramo-Wooldridge, Inc. had been created in Los Angeles, CA on September 16, 1953 by Dr. Simon Ramo and Dr. Dean Wooldridge. Ramo and Wooldridge were featured on the cover of the April 19, 1957 issue of *Time* magazine. Dr. Wooldridge retired in 1962 and went on to involve himself in the study of neurology. The five major business groups of TRW in 1962 were Automotive, Electro-Mechanical, Electronics, Space Technologies Laboratories and TRW International. The corporate name was changed to TRW, Inc. in 1965. Four years later, TRW sold off its Space Technology Laboratories group. This spin off enterprise was known as Bunker-Ramo. Simon Ramo was the President of Bunker-Ramo.

In 1999, TRW Automotive bought the British aerospace and automotive parts manufacturer LucasVarity. In 2002, TRW employed 100,000 workers. In December of the same year, its defense business was purchased by Northrop Grumman. The automotive portion of the business became a separate company for a short time but was then bought by The Blackstone Group. Goodrich Corporation took over the TRW aerospace business.

TRW received its first M14 contract in October 1961. The second M14 contract was let in October 1962 and a M14 NM contract in Fiscal Year 1964. In late 1961 and the first half of 1962, its Jet & Ordnance Division plant (23555 Euclid Avenue Cleveland, OH 44117) was remodeled and set up for M14 production. This plant was known as the Ordnance Works of the Electro-Mechanical Group within TRW. In October 1962, J. Wright was the Chairman of the Board at TRW and Stan C. Pace was the Vice President in charge of the Electro-Mechanical Group. TRW manufactured the third largest number of USGI M14 rifles, 314,789. The TRW M14 manufacturing operation is briefly described.

The principal stages of TRW M14 receiver manufacture were: 1) steel slug cut off from bar stock 2) drop forging after warm size 3) chain broaching and qualification broaching 4) machining through three dimensional mills 5) additional broaching and 6) phosphate coating.

The principal stages of TRW M14 bolt manufacture were: 1) cut off steel slug 2) extrusion 3) warm-coining 4) thirty machining operations on the Krueger lateral transfer machine 5) ten machining operations on two five station special milling machines and 6) phosphate coating.

The principal stages of TRW M14 operating rod manufacture - 1) cut off steel slug 2) bump up and roll 3) warm sizing 4) finish machining and 5) phosphate coating. Note that TRW made one piece operating rods.

TRW Machine Tools - The following describes some of the machine tools in use by TRW in November 1962:

1. The Allen multi-station drilling machine drilled all the small holes in the receiver.
2. The bolt assembly fixture completely assembled the bolt except for the roller.
3. The Colonial fifteen station pull-type broach cut the receiver magazine slot.
4. The Footburt 144 " chain broach was used for the first stage in receiver machining.
5. The Krueger lateral transfer machine performed thirty machining operations on two bolts at the same time including precision boring, reaming, gun drilling, hollow milling, and automatic gauging and inspection.
6. The Seneca Falls tracer lathe completed barrel exterior contour turning in two passes.

The TRW Mystique

TRW rifles and parts have a long-standing reputation as better made than those from the other three M14 manufacturers. This was obvious as early as late 1962, from objective facts described below. The first TRW rifles were delivered in October 1962, one month ahead of schedule. TRW's production record and the quality of its rifles brought enthusiastic praise from the Department of Defense and from the press. TRW was ahead

of Winchester and Harrington & Richardson in a number of ways. Because of its background, TRW had a broader and more sophisticated production experience. TRW considered itself to be highly skilled in the manufacturing techniques of precision forging and chain broaching. TRW made only eleven parts during its M14 rifle production. These eleven parts (rear sight base, receiver, trigger housing, hammer, bolt, operating rod, barrel, connector, gas piston, gas cylinder, and flash suppressor) amounted to a little less than 65 % of the cost to the government. TRW also made firing mechanism safeties. TRW M14 safeties are likely replacement parts made after rifle production.

The expertise of TRW is borne out by the 1962 *American Rifleman* interview of Stan C. Pace, Electro-Mechanical Group Vice President. Mr. Pace explained how TRW's personnel applied its jet engine manufacturing experience to the production of M14 rifles. TRW settled on making what parts it could make economically well (based on its expertise), and subcontracted out the remaining parts which were easily manufactured from conventional methods. TRW made single piece operating rods. Barrel interiors were formed by German design hammer forging. Barrel exterior contours were formed in two turning passes by using a Seneca Falls tracer lathe. The Seneca Falls tracer lathe replaced six conventional machine tools. The same barrel operation required four turning passes at Winchester. The TRW automatic barrel installation machine was similar to the other makers but it had some changes based on the experiences of the other manufacturers. As previously mentioned, TRW receivers gave about 6 % longer service life than others. TRW did assemble, test and ship all completed M14 rifles stamped with its logo on the receiver heel. Later on, TRW became the only commercial contractor to ever produce the USGI M14 NM rifle.

The M14 failure rate was 5 % to 12 % from all causes among Springfield Armory, Winchester and Harrington & Richardson as of August 1961. TRW had assembled and tested its first M14 rifle on August 23, 1962, three months ahead of the contract schedule. By November 1962 TRW M14 production was 100 per day and it had had no rejections to date. The largest five shot group of any TRW rifle up to November 1961 was 5.5 " out of a maximum allowable 6.1 " at 100 meters. The average five shot group size for TRW rifles until November 1962 was 2.5 " to 3.0 " in factory testing. The M14 NM contract was completed and the rifles delivered to the U. S. Army in time for the 1964 National Matches at Camp Perry.

With very few exceptions, e.g., chromium-molybdenum-vanadium alloy steel barrels in the second Winchester contract, all four manufacturers were required to use the same material and meet the same specifications in making M14 rifles. The TRW mystique is further strengthened by the growing pains suffered by Winchester and Harrington & Richardson in 1960 and 1961. Overall, it is fair to say that TRW had the most trouble-free production record of the four manufacturers. Sometimes it pays to be last but it always pays to plan well.

M14 bolts stamped 7790186 TRW ZJ and wrapped in packaging dated July or October 1969 or March 1970 demonstrate that TRW kept and used some of the M14 project machinery for some time after the M14 NM rifle contract was fulfilled. It is assumed that the replacement parts were made under contract by TRW, Inc. Replacement Parts

Division (CAGE Code 66614). The U. S. government budgeted \$4,000 to lay away twenty-one M14 rifle production machines at TRW (\$2,000 in Fiscal Year 69, \$1,000 in Fiscal Year 70 and \$1,000 in Fiscal Year 73). Twenty of the twenty-one production machines were to be laid up by the end of June 1970. The last M14 production machine at TRW was scheduled for lay up in February 1973.

Raritan Arsenal

Some changes in the design of the M14 rifle occurred after the earliest rifles had been shipped to the Army. This included adoption of a plastic ventilated hand guard and hinged steel butt plate and altering the upper butt plate screw in 1960. The earliest production M14 rifles were inspected and reworked as needed, and modified to incorporate the latest changes. These changes were published as Modification Work Orders issued by the U. S. Army Ordnance Command. This work was being done at Raritan Arsenal in Middlesex County, NJ as of August 1961. Raritan Arsenal also had the responsibility of managing the inventory of small arms training aids until it was decommissioned by the U. S. Army in 1963 (see The Issue M14 Rifle).

Experimental Items for the USGI M14 Rifle

Picatinny Arsenal (Morris County, NJ) designed a winter trigger with safety for the M14 in 1960. Another winter trigger without a safety known as the Colley type was made in 1961. That same year, the experimental breech loading X-1 40 mm grenade launcher was built for the M14. It attached to the gas cylinder and bayonet lug. Aiming was performed using a grenade launcher sight similar to but larger than the M15 sight. Examination of USGI M14 rifles at Watervliet Arsenal Museum revealed at least one other experimental design T44 series rifle stripper clip guide was made aside from the T44E6 aluminum stripper clip guide. In 1961, Springfield Armory produced an extended bolt lock (Springfield Armory part number 27907) for the M14 rifle but it was not approved for use by the U. S. Army.

Two hundred aluminum M14 magazines were produced by Mathewson Tool Company and tested by Springfield Armory in 1962. Whether or not they were made by Mathewson Tool Company, some aluminum M14 magazines did get issued in the 1960s. These aluminum magazines had an anodized finish. They varied from the steel production magazines in that the seam of the front side is reversed and there is only one weld "dimple" on the latch plate. An aluminum M14 magazine weighs approximately 4.25 ounces as compared to 8.25 to 9.00 ounces for the standard (carbon steel) twenty round M14 magazine.

Springfield Armory produced some mostly plastic twenty round M14 magazines that had a small "fence" of sheet metal at the top end to which the plastic body was molded. The plastic M14 magazines were made in an attempt to save money. Springfield Armory experimented with black, brown, gray, olive drab, tan and white colored stocks in the first half of the 1960s during development of the synthetic M14 stock. Rock Island Arsenal designed and manufactured an experimental two point scope mount for the XM21 in 1970.

The U. S. Army experimented in the second half of the 1960s and the early 1970s with twenty round plastic magazines for the M16 and M14 rifles in the Expendable Magazine Project. Two credible eyewitnesses, both U. S. Army veterans who carried the M14 rifle in the Republic of Viet Nam, report seeing or using USGI thirty round M14 magazines issued to them or other soldiers in their units while in the Republic of Viet Nam. One veteran was a member of the 2nd Battalion, 8th Cavalry Regiment, 1st Cavalry Division and the other was assigned to the 2nd Battalion, 94th Field Artillery, 108th Artillery Group. Some disposable plastic pre-filled thirty round M14 magazines were reportedly made and tested by Rock Island Arsenal in the early 1970s as part of this project but this has not been confirmed.

Harrington & Richardson, Inc. developed and produced the Simulator, M14, .22 Caliber Mark 1 select fire rifle in 1959. The M14 Simulator weighed 7.8 pounds and was 44 " long with a 22 " barrel. It was based on the Harrington & Richardson Reising Model 65 semi-automatic .22 LR rifle. Mr. E. G. Reising, an employee of Harrington & Richardson, invented many firearms including the Model 50 submachine gun. Harrington & Richardson took this project on because of a conversation in March 1959 with Dr. Frank Carten, then U. S. Army Chief of Ordnance.

The purpose of the M14 Simulator rifle was to provide an economical training rifle to complement the M14. Harrington & Richardson employee, Les Mulno, had finished building the M14 Simulator by May 1959. One of the M14 Simulator rifles was submitted to Springfield Armory in December 1959 for evaluation purposes. At least one model, serial number X-26, was semi-automatic operation only. The serial number for one of the select fire models was XX1. Harrington & Richardson kept a number of M14 Simulator rifles until 1986 when they were auctioned off due to going out of business (see U. S. Civilian Ownership of Select Fire M14 Type Rifles).

Using prototype sights supplied by the Infantry School at Fort Benning, Springfield Armory designed and fabricated in late 1959, two versions of weapon night sights. In 1960, these sights were tested on the M14 rifle in the field at Fort Benning and in Alaska. Barrel heat created from firing caused the luminescent material to loosen from the night sight posts during the testing at Fort Benning. The adhesive employed for attaching the luminescent material to the sight posts did not last at elevated temperature. Arctic testing of the night sights revealed cracks in the luminescent sight material after ten minutes of sustained firing.

Subsequent to this, Springfield Armory improved the design of the experimental M14 rifle night sight. The improved design resulted in use of an appropriate adhesive to secure the luminescent material to the night sight posts. The newer design also allowed the night sights to be zeroed at a distance of 100 to 150 yards by first zeroing the standard iron sights at the same distance. Springfield Armory referred to these weapon sights as multilite sights. The multilite sights consisted of two flip-up metal posts, one just aft of the front sight and one just forward of the rear sight. Each flip-up post was made integral to its standard iron sight counterpart.

The luminescent sight material used in the multilite sights was promethium-147. Promethium is number sixty-one on the periodic table of elements. It is classified as a

rare earth element and is produced from nuclear fission. It is radioactive. One isotope, promethium-147, can be made phosphorescent. Promethium-147 has a half-life of 2.64 years. It has been used in analog dial watches and in early M16A1 rifle sights. The promethium-147 was captured in ceramic microspheres and sealed with phosphor inside glass ampoules for the M16A1.

Harrington & Richardson built some prototype M14 rifles in 1962 known as "Guerilla guns." The Guerilla gun had a combination perforated conical flash suppressor and gas cylinder secured to the rifle by the flash suppressor nut and set screw. The Guerilla rifle had a USGI M14 chromium plated barrel shortened to 19.3 " but it extended halfway into the conical portion of the flash suppressor. These modifications shortened the M14 overall length by 4.5 ". The Guerilla guns had serial numbers beginning with the letter X. The M14 Guerilla rifle was never adopted by the U. S. Army. At least one M14 Guerilla rifle, X-45, was submitted to Springfield Armory in 1962 and subsequently transferred to the Springfield Armory Historical Museum on January 07, 1965. Springfield Armory tested this M14 Guerilla rifle for flash suppression in January 1963.

Harrington & Richardson kept a number of the M14 Guerilla rifles until auctioned off in 1986 at the close of operations (see U. S. Civilian Ownership of Select Fire M14 Type Rifles). One two digit X series serial number Harrington & Richardson Guerilla gun, X-35, was fitted with an under side folding stock. The folding stock appears to be an M14E1 Type III folding stock. The receiver of this rifle has no scope mount boss or threaded bolt hole.

Harrington & Richardson developed a 7.62 mm NATO caliber rifle that was a hybrid between the M14 rifle and a Reising submachine gun style receiver. It weighed 8.9 pounds and had an overall length of about 41 ". Only one copy is known to exist, serial number X26. It was fitted with a modified M14 slotted fiberglass hand guard. In the author's opinion, this rifle was created in the period from 1960 to 1962. The 7.62 mm NATO Reising uses the M14 gas cylinder, M14 magazine, M14 butt plate, a modified M14 flash suppressor, and a 20 " M14 modified barrel. However, the receiver, firing mechanism, select fire components and the operating rod were of totally different design from the M14.

The U. S. Army Marksmanship Training Unit (USAMTU) was created on March 01, 1956 by direction of President Eisenhower. The unit was formed to raise marksmanship proficiency in the U. S. Army. Sometime between 1966 and 1970, the U. S. Army Marksmanship Training Unit came up with the idea of adding a rear lug to the M14 receiver as part of their effort to improve the accuracy of the M14 rifle. A U-shaped piece of steel, known as a lug, was welded onto the receiver underneath the heel. The stock was inletted and drilled to accept the lug and screw. A hex head screw secured the lug to the stock through its underside when the rifle was assembled. The U. S. Army Weapons Command at Rock Island Arsenal did not accept this modification out of concern from the effects of welding the receiver. Nonetheless, M1 Garand rifles with welded rear receiver lugs appeared at Camp Perry as early as 1968 (see Camp Perry Military Reservation). M14 rifles with welded rear receiver lugs were shot competitively at Camp Perry shortly thereafter. The U. S. AMTU also experimented with gas cylinders, operating rod guides,

and operating rod spring guides. The experimental operating rod spring guides included prototypes with hollow shafts, conical shafts and even a pivoting magazine catch.

TRW altered at least two M14 flash suppressors into a design very similar to the T37 open prong flash hider used on M1 Garand rifles. These experimental tool room TRW M14 flash suppressors were available in the surplus market in November 1972. TRW also fabricated a mock up Special Purpose Individual Weapon (SPIW) that was built around a modified M14 receiver using SPIW cartridges. The TRW mock up SPIW included an integral 40 mm grenade launcher that held three grenades. The SPIW magazine and grenade launcher subassembly were made from wood. The butt stock had a telescoping pad. The rear end of the receiver was fitted with a folding leaf sight and there was a pronged flash suppressor. The TRW mock up was sold at a January 1974 Ohio gun show to a private individual from Michigan.

The Issue M14 Rifle

Factory Packaging - After final testing at the factory, each M14 rifle was disassembled, cleaned, dried, lubricated and assembled according to government packaging specifications. M14 rifles were lubricated by completely dipping in lubricating oil since that was the most economical means. Originally, a sling was not included with each rifle. At some point before 1980, the packaging requirements were changed to include placing a small arms sling inside a heat-sealed bag for each of the two rifles inside the shipping box. Each rifle had a vapor corrosion inhibitor tube placed in the bore with the front of the tube bent around the muzzle to hook it into place. White polyethylene protectors for the front sight and muzzle, rear sight, and operating rod handle were placed on each rifle. A white plastic indicator placed in the chamber signified the rifle was empty of ammunition. Each M14 was then placed in a vapor corrosion inhibitor treated bag, the excess air squeezed out and the open end of the bag heat-sealed. The end of the bag was folded over the butt end of the rifle. Additionally, every shipping box contained ten in-the-wrap twenty round M14 magazines and two Basic Initial Issue (BII) kits. The BII kit contained the following items: four M3 cleaning rod sections, cleaning rod carrying case, lubricant case, patch tip, bore brush, chamber brush and combination tool. At some point before 1980, the packaging instructions were revised to remove the BII kits. The packaging instructions specified thirty shipping boxes per shipping container. Each shipping container was required to have a packing list that contained the serial numbers of the rifles contained inside.

There was an exception to the standard M14 BII list of items. BII kits made up at Letterkenny Army Depot (PA) in 1968 included the selector switch and selector spring. These special M14A1 BII kits, along with some M14, M1 Garand, and M16 BII kits, were placed into M79 grenade launcher accessory pouches. These BII kits were to be shipped to the Army of the Republic of Viet Nam. About 2400 of these kits were never shipped but released as surplus to the public in 1979. Letterkenny Army Depot packaged numerous small lots of small ordnance parts during the Viet Nam War due to its well-deserved performance in such projects.

Receiving the M14 - When the new-in-box M14 rifles were received by the Army and Marine Corps, oil was present in the gas cylinders because of the factory lubrication.

Thus, the U. S. Marine Corps issued Technical Instruction TI-02648A-15/6 to deal with the problem. This Technical Instruction references U. S. Army TM 9-1005-223-12 which requires that each M14 rifle to be field stripped, cleaned, and lubricated prior to firing. The first time the rifle is cleaned the gas cylinder, gas piston and gas cylinder plug should be thoroughly cleaned and dried.

In the U. S. military, the selector shaft lock was installed on most M14 rifles so that only semi-automatic fire could be employed. However, the Table of Organization for the U. S. Marine Corps required three automatic riflemen per rifle squad when the M14 was the issue rifle. In Viet Nam, U. S. Marine Corps units such as the 1st Marine Division 1st Reconnaissance Battalion and the Combined Action Platoons (CAP) were equipped with selector switches on their M14 rifles in Viet Nam. Automatic fire was used in ambush situations and by the patrol point man when making enemy contact.

Reliability - The following description serves to demonstrate the ruggedness and reliability of the M14 rifle. The M14 rifle was tested for sustained fire at Fort Benning, GA. In particular, one M14 rifle was fired continuously at a rate of sixty rounds per minute for 3080 rounds. The test ended when the chambered rounds started pre-igniting because of the hot barrel. The barrel never failed to stabilize the exiting bullets. The front end of the stock and the hand guard eventually burst into flames but the rifle continued to fire. At Fort Benning, the M14 rifle was found capable of firing 600 rounds in heavy rainfall without any malfunctions.

Storage Racks - When not in use, the M14 rifle was securely stowed in a small arms storage rack. There were two types of locked storage racks for the M14 rifle, floor mounted and wall mounted. Two floor mounted rack models were available, the M1A1 (FSN 1095-776-0043) and the M3A1 (FSN 1095-776-0044). Both models were constructed of wood and could store twenty M14 or M1 Garand rifles. Floor mounted storage racks were installed in barracks. The wall mounted storage rack, M11 (FSN 1095-897-8755), was made of 6061 T6 alloy aluminum, painted green and held twenty M14 rifles.

Weapons Cards - Troops issued M14 rifles were given a wallet-sized "weapons card." The card was known as a Weapon Custody Receipt (Form 4430) in the U. S. Navy and U. S. Marine Corps. Form 4430 was created in June 1961 and later revised in March 1976. The original Form 4430 contained the following information: organization, person to whom the weapon was issued to and his Service Number, signature and grade of the Commanding Officer, weapon description, weapon serial number and the storage rack number. The March 1976 revision replaced the Service Number with the serviceman's Social Security Number and added a Privacy Act Statement on one side. Accordingly, "THIS FORM IS USED TO DETERMINE WHO HAS CUSTODY OF WEAPON AND TO ESTABLISH RESPONSIBILITY FOR CONTROL, CARE AND SAFEKEEPING."

When a serviceman went to retrieve his M14 rifle he gave the Weapon Custody Receipt or "weapons card" to the armorer. The armorer issued the rifle to the serviceman and placed his "weapons card" in the bottom of the rack where the individual's rifle was stored.

Training Aids – As with other small arms, the U. S. Army and U. S. Marine Corps used training aids to instruct servicemen in the operation and maintenance of the M14 rifle. These training aids were used in U. S. Marine Corps recruit and U. S. Army basic and advanced training. After Raritan Arsenal was closed, training aids were stored, issued and maintained by regional facilities such as Fort Jackson (SC) and Fort Benning.

The U. S. Army produced training film T.F. 9 2970 in 1960 on the operation and cycle of functioning of the M14 Rifle. The twenty-seven minute black and white film was titled *U. S. RIFLE, CAL. 7.62 MM M-14*. The M14 and M14A1 were featured in *Weapons of the Infantry*, a twenty minute training film in color produced in 1967 by the U. S. Army. This film consisted of live fire demonstrations of the infantry weapons of time, including the M14 and M14A1. The narrator states the capabilities for each weapon throughout the film. The U. S. Marine Corps produced a thirty minute color training film, *The Rifle Basic Marksmanship Series*, for classroom instruction of recruits. It was filmed in 1970 at MCRD Parris Island (SC). The film covered the principles of marksmanship, shooting positions and zeroing of the M14 rifle. It also featured short clips of combat footage of the M14 in use in the Republic of Viet Nam at the beginning of the film.

Cardboard M15 sighting devices were used in classroom instruction to teach soldiers and Marines proper M14 rifle sight alignment and sight picture. The U. S. Army had a chart (GTA 21-2-10 dated June 1971) to instruct soldiers on how lay out the individual combat equipment, including the M14 or M16 rifle, for inspection in the field.

Cloth and heavy paper training mats with the outlines of M14 parts printed with contrasting color were used as well to teach field stripping and assembly. The U. S. Marine Corps used a cloth training mat that had a green color background and yellow print outlines of M14 parts in recruit classrooms at MCRD San Diego in 1971. Fort Benning produced a M14 parts disassembly chart in July 1963.

In 1962, American Research and Manufacturing Corporation produced a pair of animated transparencies that demonstrated the gas system, bolt and firing mechanism operation of the M14 rifle. The Federal Stock Numbers for these two devices were 6910-708-2379 for the Gas System transparency and 6910-708-9720 for the Operating Group transparency. These transparencies were used by the U. S. Marine Corps. A double size training mock up of the M14 was produced by two different contractors with some slight differences between the two models. The mock M14 rifle was oversized and exterior areas cut away in places to illustrate the function of the moving parts. One mock double size M14 rifle is on display at the Stone Bay Ranges Armory inside Marine Corps Base Camp Lejeune (NC). The November 24, 1972 issue of *Life* magazine ran a story on Marine Corps boot camp at Parris Island, SC. In the story, are photographs of Marine recruits training with skeletal metal castings shaped in the form of M14 rifles. The *Life* article refers to these training aids as mock weapons.

The M14 Rifle in Overhaul

As deemed by appropriate authority, the U. S. Army overhauled rack grade M14 rifles at depot facilities, e.g., Anniston Army Depot in October and December 1983. If a USGI M14 rifle has been through overhaul, the depot performing the work and the month and

date it was done will be identified on the right side of the receiver under the operating rod rail, e.g., ANAD 12-83. Possibly, the engraved circle or letter O found on some M14 receiver heels means that rifles so marked went through overhaul. U. S. Marine Corps armorers did mark overhauled M1 Garand rifles on the flat surface behind the rear sight with O-65, O-66, etc. By similarly marking the M14 receiver heel with the letter O, the rifle would not require disassembly to identify it as an overhauled unit. The purpose of the letter O marking has not been confirmed.

Some of the testing for overhauled M14 rifles is briefly described as follows:

Functioning – With a full twenty round magazine, each rifle was fired with five rounds in semi-automatic then one burst of three to five rounds and finished by emptying the magazine with one last pull of the trigger. During the last pull of the trigger, the cyclic rate of the rifle was measured. The cyclic rate requirement was within the range of 650 to 780 rounds per minute. After 100 consecutive rifles passed the cyclic rate of fire test, then every tenth rifle was tested to determine the cyclic rate.

Targeting and Accuracy – Sample M14 rifles were placed into a test stand, loaded with M59 or M80 ball ammunition and five shots were fired at targets at a distance of 1000 inches (27.78 yards). The five shots had to group within a 1.8 " diameter circle.

Endurance – One of every 500 rifles was subjected to a 1000 round endurance test. The first series of 100 rounds was shot in semi-automatic. The second series was fired in five rounds bursts in automatic. The third series was a full magazine dump. The barrel was allowed to cool to ambient after each series of 100 rounds. This set of series was repeated three times then the last 100 rounds were fired by emptying each of five fully loaded magazines with one pull of the trigger for each magazine. No cleaning of the gas system was allowed during the endurance test. No more than four malfunctions total were allowed for passing the endurance test. Also, there were limits on the number of specific types of malfunction: 1) failure to feed – two 2) bolt failed to lock – one 3) failure to fire – one 4) pierced primer – zero 5) failure to extract – two 6) failure to eject – three 7) failure to fire semi-automatic – zero 8) selector operation caused firing – zero and 9) firing not in accordance with the selector switch setting – zero.

Additional Testing – All parts were examined for proper fit, function, condition, and finish. The minimum headspace was 1.6355 " and the maximum, 1.6415 ". However, the overhaul procedure specified that every effort be made to keep the maximum headspace to no more than 1.6375 " to maximize barrel life (with 7.62 x 51 mm NATO ammunition). The trigger pull had to be free from creep and greater than 4 ½ pounds but no more than 7 ½ pounds. The following parts were replaced without regard to condition: ejector, ejector spring, extractor spring and plunger, magazine latch spring, operating rod spring, hammer spring and bolt lock spring. Wood or slotted fiberglass hand guards were replaced with solid fiberglass hand guards. Non-plated firing pins were replaced with chromium plated firing pins. Early style extractors were replaced with late (1963 design) style extractors. Any part marked with N M was removed and replaced. Both styles of operating rod spring guides and gas cylinders were acceptable for service (see Miscellaneous Notes on USGI Parts). Barrels with throat erosion readings greater than 5

required replacement. The gas cylinder plug on the overhauled rack grade M14 rifle was torqued to 13 to 17 foot-pounds force. Failure to fall within specified limits resulted in rejection and subsequent rework of the rifle.

M14 in Service with the U. S. Army and U. S. Marine Corps

The M14 in the 1960s - In the U. S. Army infantry squad of the early 1960s, the M14 rifle was standard issue. Each infantry squad had two automatic riflemen, two grenadiers and six riflemen. The 101st Airborne Division was the first Army division to be equipped with the M14 rifle. Delivery of the M14 rifle to this unit began in January 1960. There were U. S. Army infantry units that used the M14 rifle in the Republic of Viet Nam. For instance, the U. S. Army 1st Infantry Division deployed to the Republic of Viet Nam in July 1965 with its soldiers bearing the M14. The 1st Infantry Division was equipped with M14 rifles on November 19, 1965 during combat operations at Lai Khe in Binh Duong province.

The soldier of the 1960s period carried his M14 magazines using M1956 Lightweight Load Carrying Equipment (LCE). This equipment was introduced in 1956 except the small arms ammunition case came out a year later. The M1956 LCE replaced the M1910 wire hook fasteners with slide clip fasteners and metal canteen with a polyethylene model. The standard components consisted of canvas material equipment belt, load bearing suspenders, butt pack, ammunition cases, one quart canteen with cover, shovel carrier, sleeping bag carrier, and small pouches for first aid items and compass.

Development of night vision rifle scopes for military purposes was underway by 1960. Raytheon produced the T-1 infrared rifle scope that year. The Varo AN/PAS-4 infrared scope was mounted on a M14 rifle in 1964 and 1965 for orientation of U. S. Army recruits in basic training at Fort Dix (NJ) and Fort Jackson (SC). The AN/PAS-4 equipped M14 rifle also saw service in the Republic of Viet Nam with U. S. and South Vietnamese troops but primarily in a training role. It had an effective range of 300 yards. The AN/PAS-4 weighed about 6 pounds and the belt carried battery for it weighed about 7 pounds.

Ammunition cases are commonly referred to as magazine pouches. The M1956 LCE had at least four variations of the small arm ammunition case (FSN 8465-647-0852). A 1960 vintage example of the first three variants was marked as follows inside the flap, top to bottom: first line - POUCH, SMALL ARMS, AMMUNITION, UNIVERSAL second line FSN 8465-647-0852 third line DA 36 243 QM (CTM) 5558-E-61 fourth line AUG 1960.

Another M14 magazine pouch made after 1960 was marked as follows inside the flap: top line - CASE, SMALL ARMS, AMMUNITION middle line - DSA-1-8682 bottom line - 8465-647-0852.

The M1956 small arms ammunition cases made before 1968 could hold two M14 twenty round magazines or four M1 Carbine thirty round magazines or six M1 Rifle enbloc clips. The 1968 production M1956 ammunition cases were designed to hold M16 twenty round magazines. The cases were secured with a canvas tab and metal loop arrangement.

The U. S. Army upgraded the LCE system in 1967 to better resist the effects of jungle warfare. The LCE components were made from nylon. The equipment belt and magazine pouches were given quick release plastic buckles. The M1967 all-metal

construction shovel folded into three parts and was stowed inside a plastic case. The M1967 magazine pouches were designed for the M16 rifle. However, in 1970, some M1967 nylon M14 magazine pouches with quick release plastic buckles were produced. These magazine pouches also held two M14 twenty round magazines. Individual load carrying equipment was further modernized in 1974 with the introduction of All Purpose Lightweight Individual Carrying Equipment (ALICE).

The M16 type rifle was introduced into service as the standard arm of the U. S. Armed Forces in the mid-1960s. Consequently, the M14 rifle was phased out among Army and Marine Corps infantry units. For example, the M14 rifle was replaced by June 1966 in the 22nd Infantry Regiment 4th Infantry Division of the U. S. Army. Yet, U. S. Army Military Police on the streets of Saigon, Republic of Viet Nam during the November 01, 1966 National Day Parade carried M14 rifles. The M16A1 officially replaced the M14 as the Standard A rifle in the U. S. Army on February 28, 1967. The U. S. Army was still using the M14 rifle in combat as late as January 1968 in the Republic of Viet Nam. Soldiers of the Army 40th Signal Battalion stationed around Phu Tai, Binh Dinh defended themselves with the M14 rifle when attacked by the Viet Cong during the Tet Offensive, which began the night of January 30-31, 1968. The soldiers of the U. S. Army 2nd Battalion 94th Field Artillery 108th Artillery Group at Camp J. J. Carroll, near Cam Lo, Quang Tri Province, did not exchange their M14 rifles for the M16 until May 1968. M14 rifles were mixed in with M16A1 rifles among troops of the U. S. Army 1st Cavalry Division in the Republic of Viet Nam as late as August 1970.

On October 03, 1993, U. S. military forces executed Operation Gothic Serpent in Mogadishu, Somalia. During the mission, U. S. Army Special Forces Delta operators Master Sergeant Gary Gordon and Sergeant First Class Randall Shughart volunteered to leave the relative safety of the helicopter they were aboard to provide security for the crew of the second downed Black Hawk UH-60 helicopter, *Super Six-Four*, of Task Force Ranger. Gordon and Shughart fended off the hostile Somalis until all small arms ammunition had been expended and they were fatally wounded. Their selfless actions saved the life of the pilot, Chief Warrant Officer Four Michael J. Durant. Both men were awarded the Medal Of Honor posthumously.

Sergeant First Class Shughart routinely carried the M14 in Somalia. On October 03, 1993, his M14 rifle was equipped with a leather sling and a dot sight. The stock was painted with a desert camouflage pattern. Before landing on the ground to assist *Super Six-Four*, Sergeant First Class Shughart had provided fire from his M14 rifle on the target building and at both helicopter crash sites. The mission plan called for the two Delta operators to remain airborne. Consequently, Gordon and Shughart, did not bring extra quantities of ammunition. Shughart boarded the helicopter that afternoon with only seven twenty round M14 magazines for the M14 and a Colt M1911 as a secondary weapon. When Gordon and Shughart touched the ground at the second crash site, there was less than 140 rounds left for the M14 rifle. Nonetheless, Sergeant First Class Shughart put the M14 and the other weapons on the scene to good use. The weapons of both heroes were never recovered.

The M14 rifle was issued to the first Marine Corps units in 1961. In the 1960s, the U. S. Marine Corps infantry rifle squad consisted of a squad leader and three four man fire teams. Each fire team assigned one M14 with a selector switch to the Automatic Rifleman. The U. S. Marine Corps developed its own Load Carrying Equipment in 1961.

The M1961 LCE had an equipment belt with metal snap "button" fasteners for securing ammunition pouches. The markings on one M1961 web belt read as follows: top line is the item description - BELT, INDIVIDUAL EQUIPMENT middle line is the contract number - DSA100-67-C-1041 bottom line is the Federal Stock Number 8465-823-6937. To the right of this information is the letter M signifying Medium Size. Under the letter M is the marking -2-.

The ammunition pouches were slid on to the belt then secured by snapping the "male" half of the fastener on the pouch to the "female" half of the fastener on the belt. Each M1961 magazine pouch carried one M14 twenty round magazine. The thought behind the M1961 LCE was that it allowed for a lower prone position. U. S. Army and U. S. Marine Corps infantry Riflemen were issued five M14 magazines and Automatic Riflemen were given eight M14 magazines. Marines carried additional ammunition in sixty round bandoleers. The M1961 LCE also had a butt pack. M1956 canteen covers and shovel carriers were used by the Marines.

The U. S. Marine Corps experimented with two M14 magazine pouches known as M14H and M14-V, H for horizontal carry and V for vertical carry. These olive drab nylon pouches attached by ALICE clips held two magazines. The M14-V pouch was manufactured at some point before 1973. It was marked U.S.M.C. on the flap on the outside and POUCH M14-V on the inside. The magazines were accessed by undoing the flap and pulling vertically out of the pouch. Likewise, a single magazine was removed from the M14H pouch by pulling up on the pouch flap. The M14H pouch was marked U.S.M.C. on the outside of the pouch flap. These magazine pouches were not issued.

While the number of combat operations in the Republic of Viet Nam are too numerous to list, one frightful night in 1966 will serve as witness to the value of the M14. Led by Gunnery Sergeant Jimmie E. Howard, sixteen Marines and two Navy corpsmen (medics) from First Platoon, C Company, 1st Battalion, 5th Marines, 1st Marine Division formed up as a reconnaissance patrol on June 13, 1966. They were delivered by helicopter to Hill 488 in the Que Son Valley of Quang Tin Province, Republic of Viet Nam that evening. The Marines and sailors set up an observation post at the top of the hill. During the next two days, the unit called in artillery strikes and aerial bombing runs on Viet Cong units in Que Son Valley. The Marines were equipped with select fire capable M14 rifles, one M79 40 mm grenade launcher and a total load of about 3,000 rounds of 7.62x51 mm NATO ammunition. The two Navy corpsmen carried .45 ACP pistols. Each man also carried a minimum of four fragmentation hand grenades.

By the third evening, June 15, 1966, the enemy had figured out where the source of their trouble was located and had determined to do something about it. A battalion sized force of 450 North Vietnamese Army and Viet Cong soldiers began the attack of Hill 488 at about 11:00 PM in an all-out attempt to annihilate the eighteen Americans. When hostilities had ended at about 9:30 AM the next morning, this small unit of Marines and

sailors had become the most highly decorated military unit in American history. The unit had expended all hand grenades and 40 mm projectiles and had less than an estimated 200 rounds of M14 rifle ammunition left by 4:00 AM on June 16. Six of the eighteen were killed in action that night with another later dying of wounds sustained in the battle.

Another five Marines were killed the morning of June 16 as part of the reaction force. The following medals were awarded to the members of Gunnery Sergeant Howard's unit as a result of the bravery shown and wounds received that night: one Medal of Honor, four Navy Crosses, thirteen Silver Stars, and eighteen Purple Hearts.

Apparently, not all M14 rifles had been turned in by infantry units of the U. S. Marine Corps as late as 1968. U. S. Marine Corps film footage of the battle for Hue, Thua Thien, Republic of Viet Nam reveals Marines engaging the enemy with M14 rifles between the beginning of the Tet Offensive and the liberation of Hue four weeks later on February 26, 1968. Some U. S. Marines relied on the M14 rifle during one of the most infamous battles of the second half of the twentieth century at Khe Sanh, Quang Tri, Republic of Viet Nam. The 26th Marine Regiment 4th Marine Division at Khe Sanh was laid siege to from January 21 to April 14, 1968 by as many as 20,000 North Vietnamese Army soldiers. The 1st Battalion, 3rd Marines, 3rd Marine Division used M14 rifles against a North Vietnamese Army Ranger Battalion north of Dong Ha, Quang Tri, Republic of Viet Nam during Operation Thor in July 1968 in a fierce five day battle leaving over 1000 enemy dead and only five taken prisoner.

Marines assigned to Air Wing helicopter squadrons in Viet Nam as well as the Army National Guard still carried the M14 in 1968. On April 04, 1968, Rev. Dr. Martin Luther King, Jr. was murdered. Following this tragic event, there were many protests, marches, rallies and riots during the spring and summer of 1968. For example, the downtown areas of several major U. S. cities sustained major damage in August 1968 from fires set by rioters protesting the death of Dr. King. U. S. Army National Guard troops armed with M14 rifles were called into control the riots in these cities. U. S. Army Signal Corps soldiers carried M14 rifles in the Republic of Viet Nam near Hue until at least May 1970 while constructing radio relay sites. The soldiers constructing the hill top sites were subject to frequent North Vietnamese Army and Viet Cong sniper fire and so needed a magazine fed rifle with sufficient range to counter the threat.

The decision to replace the M14 rifle in Marine Corps units in the western Pacific was made in March 1966. In Viet Nam, the M16 for the most part replaced the M14 in U. S. Marine infantry units during March, April and May 1967. The Marine 3rd Reconnaissance Battalion had exchanged its M14 rifles for the M16 by November 1967.

The M14 in Training and Garrison - After the war in Viet Nam, the M14 remained in use for training and barracks duty. The U. S. Army issued the M14 to new recruits until December 1969 although the phase out in Basic Training began as early as August 1968, e.g., Fort Dix in New Jersey. The U. S. Marine Corps issued the M14 rifle to recruits at Marine Corps Recruit Depot (MCRD) Parris Island (SC) until at least June 1973 and at MCRD San Diego (CA) until at least September 1973.

Beginning with recruit training, U. S. Marines qualified with the M14 Rifle each year as

late as 1974, e.g., Marine Corps Base Camp Pendleton (CA) and Marine Barracks Roosevelt Roads (PR). The U. S. Marine Corps M14 Rifle qualification test consisted of the following: 1) ten rounds fired at 200 yards in slow fire in the standing position 2) ten rounds fired in sustained fire at 200 yards from the sitting position 3) ten rounds fired in slow fire at 300 yards with half shot from the sitting position and the other rounds fired in the kneeling position 4) ten rounds fired at 300 yards in sustained fire from the prone and 5) ten rounds at 500 yards in slow fire from the prone position. A total of fifty rounds were shot for a maximum possible 250 points. The minimum points necessary to earn U. S. Marine Corps rifle marksmanship badges were as follows: Rifle Marksman – 190, Rifle Sharpshooter – 210 and Rifle Expert – 225.

The 2nd Brigade 112th Armor 49th Armored Division of the Army National Guard during the second half of 1972 exchanged its M14 rifles for M16A1 rifles. Marine Corps Office Candidate School classes trained with the M14 as late as June 1974. The M14 rifle was issue equipment for Marines assigned to the 32nd Street Naval Station in San Diego, California until the first half of 1978. As of August 2002, the M14 rifle was still in use by aggressor forces at the U. S. Army Ranger School.

Close Order Drill and The M14 - In the 1700s, armies developed instructions for troops to handle and load weapons while in formation in the field or on the parade ground. These instructions were known as manuals of arms. Some examples are the 1764 British Army manual and the Von Steuben manual adopted by the Continental Army in 1777. Until the American Civil War, soldiers were organized in close-knit formations on the battlefield. Hence, the organized movement of troops with or without weapons came to be known as close order drill. Today, close order drill is rarely used for purposes other than or ceremonies and parade functions. However, the manual of arms command, "Fix Bayonets!", was used on occasion by American forces in combat in the twentieth century.

In 1907, the U. S. Navy published the Landing-Force and Small Arms Instructions manual for sailors and Marines. This set of instructions covered amphibious landing operations as well as close order drill movements, use of the sword and guidon, color guard movements, and parade formations. This manual was revised in 1927 as the Landing Force Manual and yet again in November 1960 as the Landing Party Manual OPNAV P34-03. The 1960 Landing Party Manual had extensive photographs in Chapter 2 Drill and Chapter 3 Ceremonies to illustrate proper execution of close order drill movements with the M14 rifle. On May 26, 1981, the Department of the Navy issued SECNAVINST 5060.22. That instruction replaced the 1960 Landing Party Manual with the Marine Corps Drill and Ceremonies Manual NAVMC 2691 for close order drill purposes. NAVMC 2691 gives instruction on close order drill using the M16 rifle instead of the M14. The M14 Manual of Arms can be found in Appendix C of the July 2003 edition of the Department of the Army field manual FM 3-21.5.

The M14 after 2000 - The U. S. Army and Marine Corps have put the M14 rifle to combat use in Afghanistan, Kuwait and Iraq in support of the War on Terrorism. In March 2003, the Fox television network news department showed video footage of a U. S. Army soldier shooting a M14 rifle using automatic fire into the window of a building during the opening days of Operation Iraqi Freedom. Select members of the following units used

the M14 rifle in those countries: U. S. Army 1st Cavalry Division, 1st Infantry Division, 2nd Infantry Division, 10th Mountain Division, 25th Infantry Division, 42nd Infantry Division, 82nd Airborne Division, 101st Airborne Division and the 5th and 7th Special Forces Groups, and the U. S. Marine Corps 1st Marine Division. For example, the 1st Battalion 26th Infantry Regiment 1st Infantry Division used the M14 rifle during Operation Baton Rouge in Samarra, Iraq from September 30 to October 2, 2004. The M14 rifle offers greater range and punch than M16 variant rifles and carbines. A carbine is normally defined as a long gun with a rifled barrel that is less than 20 " long.

Some 82nd Airborne soldiers in 2002 had Trijicon, Inc. TA01-NSN 4x32 scopes mounted to their M14 rifles while on combat patrol in Afghanistan. U. S. Army and Army National Guard soldiers in Iraq with M14 rifles have purchased and installed a variety of optics at their individual discretion. Optics from Aimpoint, Inc., EOTech, Inc., Leupold & Stevens, Inc., Schmidt and Bender, Inc. and Trijicon, Inc. are in use by U. S. soldiers in Iraq. Likewise, Smith Enterprise, Inc. and Springfield Armory, Inc. scope mounts have been purchased and installed on issued M14 rifles by individual soldiers.

Additionally, U. S. Army and Army National Guard battalion and company sized units being deployed to Iraq have purchased M14 accessories such as scopes, scope rings, and scope mounts with unit MPAC credit cards. For example, C Company 3rd Battalion 112th Armor Regiment, 56th Brigade Combat Team, 36th Infantry Division purchased and installed scope rings, Springfield Armory, Inc. scope mounts and Tasco rifle scopes on its two M14 rifles before deployment to Iraq in 2005.

In February 2004, the U. S. Army established a new school called Squad Designated Marksman School at Camp Bullis (San Antonio, TX). The U.S. Army issued orders to a group of civilian shooters to serve as the faculty for this school for a period of two weeks.

Designated as Volunteer Military Instructors, these civilians were all distinguished competition shooters and members of the Texas State Rifle Association. Two groups of forty soldiers from the U. S. Army First Cavalry Division (Fort Hood, TX) were put through a one week course on operating and maintaining the M14 rifle as the Squad Designated Marksman. The Squad Designated Marksman School at Camp Bullis was such a success that it was hosted by the 5th Army Small Arms Readiness Group in December 2004 at Fort Hood for soldiers of the 3rd Infantry Division.

In 2003, the U. S. Army added the M14 rifle to the weapons inventory of the Stryker brigades. The Designated Marksman (DM) for each squad is outfitted with a scoped M14 rifle. The choice of optics is a Leupold & Stevens, Inc. tactical rifle scope. This gives each squad the ability to cover a larger field of fire.

During the late summer and early fall of 2004, two U. S. Army armorers rebuilt and upgraded a batch of M14 rifles into Squad Designated Marksman rifles for the U. S. Army 10th Mountain Division. This accurizing work included unitizing the gas systems, reaming the flash suppressors, tuning the triggers, bedding the stocks and fitting the receivers with Tasco (Overland Park, KS) 10 X 40 mm scopes.

The U. S. Army National Guard 1st Battalion 69th Infantry Regiment, based in New York, teamed up with the Army National Guard 1st Battalion 156th Infantry Regiment from Louisiana to form the 256th Brigade Combat Team (BCT). The 256th BCT was deployed in Baghdad, Iraq from October 2004 to September 2005. During this deployment, the 1st Battalion 69th Infantry Regiment equipped one soldier from each ten man squad with a M14 rifle fitted with a Springfield Armory, Inc. Third Generation scope mount and Tasco rifle scope but no bayonet or USGI cleaning kit. Towards the end of its deployment, the 1st Battalion 69th Infantry Regiment was receiving new production Check-Mate Industries twenty round magazines for its M14 rifles. Staff Sergeant John Chalker of the 1st Battalion 69th Infantry Regiment used his USGI Winchester M14 rifle with iron sights to engage the enemy while serving as the turret gunner aboard a Humvee providing security for Airport Road. Airport Road in Baghdad was dubbed the most dangerous road in the world because of the heavy number of improvised explosive devices planted and detonated by the enemy on this road. Staff Sergeant Chalker preferred to use his M14 rifle in lieu of the turret mounted M240 belt fed machine gun because he could respond faster to ambushes.

In November 2005, A Company, 1st Battalion, 22nd Infantry Regiment of the U. S. Army 4th Infantry Division left Fort Hood, TX for deployment to Iraq. Sergeant Cody Hofer of A Company was issued a M14 rifle in a wood stock along with his M16 style carbine for duty in Iraq.

In the fall of 2004, the U. S. Army National Guard 42nd Division upgraded its 108 M14 rifles in preparation for deployment to Iraq. The M14 rifles were upgraded with Sadlak Industries (Coventry, CT) steel scope mounts, Tasco 10 X 40 mm scopes, Badger Ordnance (North Kansas City, MO) scope rings, Harris bipods, Butler Creek scope covers, and BlackHawk Products Group (Norfolk, VA) cheek pads. Sadlak Industries provided instruction to the 42nd Division soldiers on installing the scope mounts. The 42nd Division, along with its M14 rifles, deployed to Iraq in early 2005. The M14 rifles are used in the 42nd Division's Long Range Surveillance detachment. The M14 rifle is still very much a useful tool on the modern battlefield and is far from obsolescence.

The M14 in the U. S. Navy

U. S. Navy ships inventory the M14 rifle for several purposes. M14 rifles are maintained by Gunner's Mates on surface ships and Missile Technicians or Fire Control Technicians on submarines. The M14 rifle is used to shoot a line (rope for landlubbers) from one ship to another during underway replenishment, to arm the Shark Watch during swim call, to repel boarders, and to arm the security detail during loading and off loading of nuclear weapons on submarines. Navy SEAL Team 1 operating out of the Rung Sat Special Zone in the Republic of Viet Nam was equipped with the M14 rifle until November 1967. Today, the Navy SEAL Teams equip themselves with M14 and M25 rifles when the needs of the mission dictate.

There are times when use of the M14 rifle is totally unexpected but very useful. One such instance occurred while the ballistic missile submarine *USS Nathan Hale* SSBN 623 was

on deterrent patrol in 1985. As a Lafayette Class SSBN, the *USS Nathan Hale* was equipped with a device known as the "towed array." The towed array was a black steel box about the size of an automobile. It contained an assortment of radio and sonar equipment. The towed array was attached to a steel cable that could be reeled in or out from its compartment within the steel decking just aft of the missile tube hatches. With the towed array deployed, the submarine was limited to the speed, depth and dive angle it could do to prevent breaking the cable and losing the towed array. The benefit was that the submarine could remain submerged but continuously receive radio messages. While on deterrent patrol one day somewhere in the Atlantic Ocean, the Officer of the Deck forgot that the towed array was reeled out. He ordered a bell (order to change speed) too fast for the steel cable attached to the towed array. The towed array detached from the boat (submariner term for submarine) and was quickly floating on the ocean surface. Considering the tactical situation and the sensitive nature of the equipment lost, the Captain ordered the boat to surface. After the ship had ventilated, the ship's Captain, Commander J. W. Hamburg, and Missile Technician Second Class MacPherson armed with a M14 rifle laid (hurried quickly) to the bridge. The Captain ordered the Missile Technician to sink the towed array. After cycling 134 times, the M14 rifle had put enough holes in the towed array casing to make it sink to the bottom of the Atlantic Ocean. The boat quickly dove (submariner term for submerged) immediately thereafter and carried on its deterrent patrol without further incident.

The M14 in Other Service

The M14 rifle remains in use today with U. S. Air Force pararescue jumpers, at West Point Military (NY) and Annapolis Naval Academies (MD), Virginia Military Institute (VA), The Citadel (SC), Norwich University (VT), and university ROTC and Marine Corps Junior ROTC units nationwide. The firing pins are removed from M14 rifles at the service academies and ROTC units. M14 rifles in the inventory of JROTC units have been demilitarized. The barrels are plugged and welded to the receiver, the firing pins removed and the bolt firing pin front hole welded over. As an aside, Brookfield Precision Tool rebuilt a batch of M14 rifles at Fort Devens, MA for the U. S. Air Force within days prior to the start of Desert Storm.

In August 2004, the U. S. Army Tank Automotive Command at Rock Island Arsenal published a notice of intent to purchase 350 M14 chromium plated parade rifles with accessories from Springfield Armory, Inc. under a sole source contract. The M14 rifle is frequently used as a ceremonial rifle by drill teams and color guards and at Arlington National Cemetery.

Arlington National Cemetery became a military burial ground in May 1864 for the Union Army during the Civil War. The land had been previously owned by Confederate Army General Robert E. Lee but it was illegally seized by the Federal government in 1862. In 1882, the U. S. Supreme Court declared the government guilty of trespassing and ordered the return of the land to the Lee family. With more than 10,000 soldiers buried on the property, George Washington Custis Lee, oldest son of Robert E. and Mary Lee, sold the land to the U. S. government for \$150,000.00. Arlington National Cemetery is one of two cemeteries administered by the U. S. Army. The Tombs of the Unknown at Arlington

National Cemetery contain the bodies of three unknown soldiers, one each from World Wars I and II and the Korean War. The Tombs of the Unknown are guarded around the clock by U. S. Army soldiers in E Company of the 3rd Infantry Regiment, also known as The Old Guard. The Old Guard has guarded the Tombs of the Unknown since April 06, 1948 without interruption. The M14 rifle has been in service with the 3rd Infantry Regiment continuously since the early 1960s. The Tomb Guard uses M14 rifles with wood stocks modified to streamline the grip area.

Some federal, state and local law enforcement agencies in the United States also have M14 rifles in inventory on loan from the U. S. Army through the Section 1033 program. The authority for this federal program is found in Section 1033 of the National Defense Authorization Act for Fiscal Year 1997. It is codified at Title 10 United States Code Part IV Chapter 153 Section 2576 (a). The Secretary of Defense may transfer excess personal property to law enforcement agencies with officers empowered to arrest and apprehend. The Section 1033 program is administered by the Defense Logistics Agency Law Enforcement Support Office. Since 1995, the Law Enforcement Support Office has transferred excess DOD equipment such as aircraft, vehicles, cameras, computers, electric generators, military clothing, boots, night vision goggles and weapons to law enforcement agencies. Before October 01, 1996, this program was known as the Section 1208 program. A few police departments have replaced the selector locks with selector switches in M14 rifles obtained through the 1033 program. As of June 2005, no more M14 rifles were available to law enforcement agencies through the 1033 program pending outcome of the XM110 rifle trials.

In December 2005, Georgia Arms Precision rebuilt fifty M14 rifles for an undisclosed U. S. government agency. Each of these M14 rifles were assembled with the following: heavyweight 1:10 twist match grade barrel, bedded McMillan M3A stock, unitized gas system, match conditioned firing mechanism, National Match grade operating rod spring guide, Smith Enterprise, Inc. 7 " rail scope mount, Badger Ordnance scope rings, Leupold & Stevens, Inc. 3.5-10X rifle scope and complete surface coating in tan color.

The M14 in the Arts and Entertainment

While not related to military service or law enforcement the M14 type rifle has been used dramatically in entertainment media such as films, fine art, photography, television shows and video games over the years.

Films - A list of big screen and television films with the M14 type rifle includes *Goldfinger* (1964), *Follow Me, Boys* (1966), *The Green Berets* (1968), *Tribes* (1970), *Billy Jack Goes To Washington* (1977), *Black Sunday* (1977), *A Rumor of War* (1980), *Uncommon Valor* (1983), *Missing In Action* (1984), *Purple Hearts* (1984), *Crocodile Dundee 2* (1986), *Raw Deal* (1986), *The Manhattan Project* (1986), *Full Metal Jacket* (1987), *Gardens of Stone* (1987), the director's cut edition of *Lethal Weapon* (1987), *Distant Thunder* (1988), *The Siege of Firebase Gloria* (1988), *84 Charlie Mopic* (1989), *Counterforce* (1989), *Born On The Fourth Of July* (1989), *NAVY SEALS* (1990), *Highlander II: The Quickening* (1991), *Hot Shots!* (1991), *A Perfect World* (1993), *Demolition Man* (1993), *Hot Shots! Part Deux* (1993), *Clear and Present Danger* (1994), *Forrest Gump* (1994), *On Deadly Ground*

(1994), *The Shawshank Redemption* (1994), *Congo* (1995), *Star Hunter* (1995), *Mars Attacks!* (1996), *Tremors 2* (1996), *The Postman* (1997), *A Bright Shining Lie* (1998), *Rogue Force* (1998), *The Negotiator* (1998), *Dogma* (1999), *The Boondock Saints* (1999), *The General's Daughter* (1999), *Thirteen Days* (2000), *Black Hawk Down* (2001), *Spy Game* (2001), *Tears Of The Sun* (2003), *The Fog of War* (2003), *The Rundown* (2003), *Mr. & Mrs. Smith* (2005), *Munich* (2005), *State of the Union* (2005), *Stealth* (2005), *The Island* (2005), *XXX Part II* (2005) and *US vs John Lennon* (2006).

The original 1980 three hour twenty minute unedited version of *A Rumor of War* and *Born On The Fourth Of July* are the only two full-length entertainment films known to contain a scene of the M14 type rifle in automatic fire. In 1987, *A Rumor of War* was re-released as a three part mini-series without the scene of the M14E2 in action. *Forrest Gump* is the only commercial film known to show the disassembly of the M14 rifle. Two Rock SOPMOD M14 rifles were built for and used in the film *Mr. & Mrs. Smith*.

Fine Art – Max D. Crace was stationed in the Republic of Viet Nam in 1971 while serving in the U. S. Air Force. As an artist, he has captured the life of the serviceman in Viet Nam in his illustrations. His drawings are known for their accurate detail of the uniforms and equipment worn and carried in the war.

Mr. Crace's color drawing, "One Shot One Kill" depicts a U. S. Army sniper team poised to take on the enemy with an XM21 rifle. A black and white illustration from Mr. Crace depicts a Marine readying to fire his M14 with commercial telescope and improvised mount from a kneeling position. Another of his drawings, "BOOM BOOM ROCK", depicts an American soldier with a M14 rifle leaning against a large boulder at a lookout point on Monkey Mountain. This spot on the mountain provided a panoramic view of the water and white sands of China Beach. The boulder was marked BOOM-BOOM ROCK MONKEY MOUNTAIN VIETNAM by no later than 1968. Son Tra Mountain, or Monkey Mountain, was an American military base at the north end of China Beach. Bac My An Beach, or China Beach, was located about four miles southeast of Da Nang, Quang Nam Province, Republic of Viet Nam. It was home to a U. S. Army medical hospital and a Rest and Recreation facility during the war. Presumably, the large boulder was so named because it was a popular location for romantic interludes.

Mr. Crace later drew an illustration of a U. S. Navy SEAL employing a M25 rifle in Kuwait in February 1991 during the First Gulf War. As he did with his Viet Nam era illustrations, this drawing was accurate down to the last detail including the rubber pads on the Harris bipod legs.

The M14 rifle itself has become a work of art in the true sense of the word by burning combat images into wood M14 stocks.

Photography – Still photographs of the M14 rifle and its end users can be divided into three forms, media news journalism snapshots, combat photographs, and photographic art. It is the author's contention that examples of all three forms of photography exist of the M14 rifle. With more than two dozen photographs of the M14 rifle in the hands of Marines and soldiers, *Nam A Photographic History* (see Bibliography) has some splendid examples of each.

There is one photograph including the M14 rifle that stands out as a combination of all three forms of photography. While not central to the subject, the photo does record the M14 as the rifle carried by those affected by the tragic event. Dickey Chapelle was a war correspondent who traveled with U. S. Marines in combat during World War II. She filed stories with and submitted photographs to publications such as *National Geographic*, *Life*, and *Reader's Digest*. After the war, she photographed combat from the vantage point of rebel groups in Algeria, Cuba and Hungary. Later, she was the first female member of the press to parachute jump with American troops into combat while on assignment in the Republic of Viet Nam and in her forties at that. Working for the *National Observer*, she returned to the Republic of Vietnam in the fall of 1965 to photograph and write again of the true story of the U. S. Marine Corps in action. She was so well respected by the U. S. Marine Corps that the Commandant, General Wallace M. Greene, Jr., in 1965 presented her with the Marine Corps eagle, globe and anchor device from his own uniform.

On the fateful morning of November 04, 1965, Dickey Chapelle went on patrol near Chu Lai, Quang Tin with a platoon of U. S. Marines. She was walking second in the column behind the platoon leader, Lieutenant Mauriski. The platoon had just left camp when the platoon leader tripped on a wire. This mishap set off a booby trapped mine. The resulting explosion injured four U. S. Marines and threw Dickey Chapelle twenty feet while a piece of shrapnel punctured her carotid artery. She passed away minutes later on the way to the hospital inside a helicopter. In her last minutes, U. S. Marine Corps Chaplain John Monamara prayed over her and administered last rites as the blood flowed from her neck. Behind the Chaplain, three U. S. Marines watched intently, each armed with a M14 rifle.

This tragedy was captured on black and white film by *Associated Press* photographer Henri Huet. Dickey Chapelle was the first American journalist to be killed during the war in Viet Nam. She once informed a General, "When my time comes, I want it to be on a patrol with the Marines." ³ Henri Huet and three other combat photographers were killed on February 10, 1971 when the helicopter transporting them was shot down by the enemy over Laos.

Philip Jones Griffith spent three years in the Republic of Viet Nam, 1968 through 1970, photographing all aspects of the war. Griffith captured the human suffering in war as well as anyone in the 1971 volume, *Vietnam Inc.* The majority of the photographs of this book should be considered photographic art while others are worthy of a headline story or a magazine cover. Included in this collection of war time black and white still photos are three which contain the M14 rifle: *Limits of Friendship*, *Wounded VC Suspect* and *Forced Urbanization*. In each of the three photographs, the M14 rifle is carried by an American soldier or Marine as he deals with the Vietnamese people. These three photographs speak clearly about the human condition at the artistic level.

Larry Burrows was another combat photographer that captured historical events and gut wrenching scenes on film, both black and white and in color. He photographed the first American troops, the 3rd Battalion, 9th Marines, carrying M14 rifles, to come ashore on March 08, 1965 in the Republic of Viet Nam at Red Beach 2, ten miles north of Da Nang,

Quang Nam. His photographs of the war in Viet Nam were showcased in a number of issues of *Life* magazine in 1963, 1965 and 1966. Larry Burrows was known to consistently put himself at the front of the action. The day before he was killed, he pulled an Army of the Republic of Viet Nam (ARVN) soldier from a burning armored personnel carrier. The next day, he was aboard the fatal helicopter flight with Henri Huet over Laos.

Perhaps the most artistic combat photograph ever taken of the M14 rifle was one by Larry Burrows on October 05, 1966, or very shortly thereafter, during Operation Prairie atop Hill 484 in Quang Tri Province, Republic of Viet Nam. In that action, 1,397 North Vietnamese Army soldiers were killed and twenty-seven were taken prisoner while 239 Americans were killed and 1,214 wounded in action. The color photograph is a hill top view overlooking a valley and distant mountain range with cloudy skies in the background. In the fore ground is a fallen and defoliated tree trunk lying next to a Marine helmet and a M14 rifle with inserted magazine pointed away from the camera. This photograph graces the front cover of *Requiem*, a book about combat photographers who were killed during the war in Viet Nam (see Bibliography).

Broadcast Network Television - The M14 rifle made its entertainment debut on the NBC broadcast television drama series *The Lieutenant* starring Gary Lockwood and Robert Vaughn. The series depicted a U. S. Marine infantry unit stationed at Camp Pendleton (CA). The series received strong support from the U. S. Marine Corps. There were twenty-nine hour long episodes which aired during the 1963-64 season. The M14 was next featured on the hit CBS broadcast television situation comedy *Gomer Pyle, USMC* starring Jim Nabors and Frank Sutton. It aired from September 25, 1964 to September 19, 1969.

The M14 rifle was first animated for entertainment on October 23, 1964 during the "Treasure of the Temple" episode in the ABC network series *Jonny Quest*. In the teleplay by Walter Black, Race Bannon (voice by Mike Road) carries an M14 rifle. *Jonny Quest* aired in prime time for one season of twenty-six episodes from September 18, 1964 until September 09, 1965. This animated series enjoyed brief revivals in 1986 and 1996.

The CBS broadcast television weekly series *Tour of Duty* first aired on September 24, 1987. It ran for three seasons with a total of fifty-eight episodes. The show was a fictional account of the struggles of a U. S. Army infantry platoon in the Republic of Viet Nam between October 1967 and January 1969. The firearms, including the M14 rifles, and military vehicles used in taping *Tour of Duty* were as historically accurate as possible. The third season had two episodes depicting use of the M14 rifle. In one episode, a Central Intelligence Agency (CIA) employee is attached to an Army squad of soldiers. The CIA employee successfully engages a Viet Cong Lieutenant with the M14 rifle he is carrying. The result is a firefight that involves the infantry squad. The CIA employee uses the M14 rifle during the firefight. The other episode from the last season involves a helicopter pilot that tires of a persistent sniper outside the Special Forces "A" Camp. Armed with a scoped M14 rifle, he takes it upon himself to hunt down the sniper. He is able to finally silence the sniper who turns out to be a woman.

The M14 type rifle was seen in scenes of fictional 1960s Viet Nam combat on the NBC broadcast television drama *American Dreams*. This series began September 29, 2002

and ran for three seasons. The last of sixty-one episodes aired on March 30, 2005. M14 type rifles have also been seen in network television dramas such as the January 1983 pilot for *The A-Team* (NBC 1983 to 1987) and *In the Heat of the Night* (NBC 1988 to 1995) as well as a December 2005 episode of *CSI* (CBS 2000 to 2006), a May 2005 episode of *Las Vegas* (NBC 2003 to 2006) and the May 16, 2006 episode "Three Minutes" of *Lost* (ABC 2004 onward).

Cable Television - The M14 rifle was shown in the "Flashpoint Vietnam" episode in the fourth season of the Fox News Channel cable television weekly documentary *War Stories* hosted by Oliver North. *War Stories* first aired in May 2001 and ran for sixty-four sixty minute episodes through four seasons. Footage of the M14 rifle has appeared in the following Military Channel programs: *Battlefield Vietnam: Showdown in the Iron Triangle*, *Coat Guard at War*, *Kiowa Down*, *Navy Bomb Squad*, *Snipers: One Shot, One Kill Taks Force Devil*, and *The U.S. Army Rangers*.

The M14 type rifle has also been featured at least once, Episode # 30, on the History Channel cable television weekly program *Mail Call* hosted by former U. S. Marine, Viet Nam veteran, actor and M14 fan R. Lee Ermey. *Mail Call* premiered on August 04, 2002. By March 07 2006, *Mail Call* ended its seventh season with ninety-three episodes aired. The History Channel has also featured the M14 rifle in "The M16" and "Bullets" episodes of *Modern Marvels*.

Music Video - The M14 rifle is carried by American troops in back drop film footage of three country music videos, *Whiskey Lullaby* by Brad Paisley (2004 Arista Nashville), *8th of November* by Big & Rich (2005 Warner Bros.) and *Arlington* by Trace Adkins (2005 EMI).

Video Games – The M14 and M21 are equipment options for game players in the video games *Battlefield Vietnam*, *Delta Force: Black Hawk Down*, *Men of Valor*, *Operation: Flashpoint*, *Rainbow 6 III*, *SOCOM III* and *Vietcong: Purple Haze*.

Springfield Armory Historical Museum

A number of Springfield Armory and Harrington & Richardson M14 rifles were transferred from the U. S. Army to the Springfield Armory Historical Museum (Springfield, MA). For the most part, these transfers occurred between September 14, 1959 and May 9, 1967. M14 rifle receiver serial number 2085 was transferred to the Museum on January 22, 1986 from Rock Island Arsenal. Some of the M14 rifles at the Springfield Armory Museum were transferred back to the U. S. Army (Rock Island Arsenal (IL), Watervliet Arsenal (NY), and Fort Lee (NJ)) between April 26, 1966 and May 18, 1972. The Museum is operated by the U. S. Department of Interior National Park Service. It houses the second largest collection of firearms in the world. The Museum has the following M14 rifles amongst its inventory:

Table 5: Sample List of Springfield Armory National Historic Site M14 Rifles

Serial Number	Comment
D.D.E. 1	one of two presentation M14 rifles made for President Eisenhower and used as an endurance test piece
X-45	Harrington & Richardson M14 Guerilla Rifle
2000	first production M14 rifle
10117	M14E2 rifle
106436	M14 rifle with the experimental X-1 40 MM grenade launcher
539712	M14E1 Type V rifle
540833	M14 rifle used as an endurance test piece for 6000 rounds
545480	M14 rifle used as an endurance test piece for 30,000 rounds

Israel Defense Forces

The Israel Defense Forces (IDF) used the M14 as a sniper weapon system (SWS) from 1973 to 1997 when it was replaced by M24 SWS. Israeli Military Industries built 10,000 sniper weapon systems out of the 35,000 rifles given to them by the United States in 1973 as a result of the Yom Kippur War. The remaining M14 rifles were disassembled for spare parts. The Israeli Defense Forces used M14 sniper rifles for fire support during the 1982 invasion of Lebanon. Optics on the Israeli M14 rifles was either the EI-Op Nimrod 6X40 mm daylight scope or the Litton AN/PVS-2 night vision scope. In 1994, the EI-Op Nimrod day scope was replaced with the Swarovski Futonic 6X42 mm scope. As of 2005, the M14 was still in use by the IDF Reserve. Sardius produced fifty M36 bullpup rifles from M14 rifles. These were purchased by the IDF from Sardius in the late 1980s. In the early 1990s, some M14 rifles were converted to bullpup M89 rifles by TCI in Israel (see M36 and M89). The M89 rifle has been used by Israeli Special Forces and exported for sale to other Special Forces units.

Other Foreign Hostile Action

Latin America - The Argentine Army used M14 rifles in the Falklands War with the United Kingdom. Argentine soldiers of C Company, Regimiento (Especial) de Infanteria 25 made very effective use of M14 NM rifles equipped with AN/PVS-2 night optics against British forces in the battles for San Carlos and Goose Green in May 1982. The Colombian Army has used the M14 and M14K rifles in action in the 1980s against drug traffickers known as FARC. M14 rifles were turned in by rebels to the government of Honduras at La Ceiba during the summer of 2003.

Philippines - The Philippine Army, Marines, CAFGU (regional militia) and the rebel New People's Army (NPA) have used American and Chinese M14 rifles against each other in hostile action. For example, on September 24, 2005, the NPA conducted a raid on a platoon of Philippine Army soldiers at rest in Barangay San Carlos, Isabela. In this action, five Philippine Army soldiers were killed and one M60 machine gun and one M14 rifle were captured by the NPA. The Philippine Womens Army Corps conducts close order drill with M14 rifles.

The Philippine Marines Reserve Marksmanship and Sniper Unit established its scout sniper school in 1969. The first Commanding Officer of the school was Lieutenant Commander Adolfo S. Feliciano. The school was in operation until 1994. The Philippine Marines scout snipers used M1D Garand rifles with M84 scopes and iron-sighted M14 rifles until 1996. The Philippine Marines scout snipers converted to an accurized M16A1 weapons system in 1996 and re-established the scout sniper school in July 2001. One squad of scout snipers is allotted per Marine Battalion Landing Team (MBLT).

The Philippine Marines continued to use the M14 rifle until at least February 2003. Philippine MBLT 8 was deployed to central Mindanao to join with the 602nd Brigade of the Philippine Army 6th Infantry Division in the February 11, 2003 attack on the Moro Islamic Liberation Front (MILF) Central Command headquarters in the 494 acre Buliok Complex at Pikit, North Cotabato. The Buliok Complex encompasses several towns in the North Cotabato and Maguindanao provinces. After five days of continuously strong resistance by the MILF, the Armed Forces of Philippines succeeded in taking the headquarters complex on February 16, 2003. As part of this operation, Philippine Marines from MBLT 8 were sent to the Liguasan Marsh in rubber rafts to search out and destroy the MILF resistance. The Buliok complex is adjacent to the Liguasan Marsh. During this combat action in the Liguasan Marsh, at least two M14 rifles can be seen in video along with M16 type rifles carried by the Philippine Marines.

Other Areas - Lebanese Forces (Christian militia) used M14 rifles as they were acquired defending villages in the 1980s against the Syrian Army and the Lebanese Druze Progressive Socialist Party militia. M14 rifles were in use by both Haitian government forces and insurgents during the February 2004 uprising. In November 2004, at least one M14 rifle was in the hands of the rebel Sudanese People's Liberation Army. Later, in May 2006, Fur tribesmen of the Sudanese People's Liberation Army in Darfur, Darfur Province were seen on *ABC World News Tonight* equipped with M14 rifles shortly after the Sudanese government had offered a peace agreement.

Taiwan

A Memorandum of Understanding between Taiwan and the United States from the Viet Nam War era grants license to the Government of Taiwan to produce M14 rifles known as the Type 57. The January 23, 1967 memorandum states that Taiwan will purchase tools, components, material, documentation, technical assistance and assemblies from Fiscal Year 1967 through Fiscal Year 1969. As agreed to in the Memorandum of Understanding, the U. S. government sold some of the M14 rifle production machinery used by Harrington & Richardson to Taiwan in 1968. The Memorandum of Understanding also required that the Taiwanese M14 items produced would be interchangeable logistically with USGI M14 items. The Republic of China (Taiwan) made approximately 1,000,000 Type 57 rifles from 1969 until at least 1980. Some, if not all, Type 57 rifles were made at the 60th Arsenal in Kaoshiung, Taiwan.

There are two models of Type 57 rifles. Both the first and second model receiver heels are marked in Chinese with the exception that the serial numbers use Arabic numerals. First model Type 57 rifles were assembled with many USGI parts including stocks, flash

suppressors and magazines. The Taiwanese government did not receive the tooling to make flash suppressors and magazines when it received the H&R production machinery. Thus, the Taiwanese government had to make the tooling to manufacture these parts to continue production. The first models had serial numbers 000001 to 048655. The second model began with serial number 048666. The Taiwanese developed a simplified rear sight for the second model Type 57 rifle and the receiver heel information was rearranged. The flat surface immediately behind the rear sight on Type 57 receivers is very distinct in comparison to a USGI M14 receiver. There has not been any collaboration whatsoever of any kind between the People's Republic of China and Taiwan on M14 type rifle design or manufacture.

Destruction and Export of USGI M14 Rifles

M14 rifles have been given or sold to foreign governments under U. S. military aid programs since the early 1970s. As of June 30, 1973, the U. S. Army had over 940,000 M14 rifles remaining in its inventory. In late 1973, U. S. Army Director of Material Acquisition, Major General Peter G. Olenchuk, testified before a House of Representatives subcommittee that the Army planned to remove the M14 rifle from its inventory "except for war contingency purposes." Major General Olenchuk retired from active duty in 1975 and passed away on October 06, 2000.

As of 1996, at least 450,000 M14 rifles had been transferred to foreign armies while another 750,000 were destroyed by the United States. The Naval Surface Warfare Center (Crane, IN) and Anniston Army Depot (Anniston, AL) were two facilities used to demilitarize M14 rifles in the 1990s. The machine used to demilitarize M14 rifles was not very discriminate. After the stock and hand guard were removed, the M14 was fed into the machine for destruction. This machine was referred to as Captain Crunch. Captain Crunch sheared the rifle about every four to six inches along its length. Typically, Captain Crunch took "bites" at the middle of the receiver, at the front end of the barrel chamber, near the operating rod guide, through the gas cylinder, and through the flash suppressor. Some parts were retrieved and sold on the open market by surplus parts dealers. These parts were typically the rear sight assembly, bolt lock, extractor, operating rod guide and pin, gas cylinder lock, gas cylinder plug, flash suppressor nut and set screw, front sight, and front sight screw. After each rifle was destroyed, a certificate recording the receiver serial number was signed, dated and kept indefinitely. Destroyed M14 receiver halves have been sold to collectors and to those who work on M14 stocks and make M14 type rifle accessories.

A partial list of foreign governments that have received M14 rifles from the United States includes Argentina, Belize, Chad, Chile, Colombia, Dominican Republic, Estonia, Greece, Haiti, Israel, Jordan, Latvia, Lithuania, Niger, Philippines, South Korea, Taiwan, Tunisia, Turkey and Zaire. The M14 rifles transferred to Greece were used for guard duty at Greek Navy bases. The Philippine Marines, Naval Infantry and Army Airborne soldiers had M14 rifles in their weapons inventories before Mount Pinatubo erupted in June 1991. Some examples of U. S. government transfers of M14 rifles are as follows:

Table 6: Sample List of U. S. Government Sales of M14 Rifles to Foreign Nations

Nation	Amount	Year(s)	Transfer Method	Cost If Available
Belize	15	1995	EDA	\$828.00
Chile	12	1995	EDA	\$662.00
Colombia	10,000	1990-92	FMS	
Estonia	40,500	1998	EDA	Free
Israel	35,000	1973		Free
Israel	Not available	1978	FMS	
Latvia	10,000	1996	EDA	Free
Lithuania	40,000	1998	EDA	Free
Philippines	3,638	1994	EDA	\$200,817.60
Taiwan	30,450	1995	EDA	\$1,680,840.00
Turkey	200	1995	EDA	Free

EDA = Excess Defense Articles program FMS = Foreign Military Sales program MAP = Military Assistance Program

124,815 M14 rifles were exported under the EDA program between 1995 and 1998. Some were given at no cost under the EDA and MAP programs while other M14 rifles were sold under the FMS program. The Excess Defense Articles program is authorized under the Federal Assistance Act of 1961. Other M14 rifles were transferred to foreign nations under Military Assistance Programs. Some M14 rifles were given to the Nicaraguan Contras in the 1980s and Eritrean rebels in Ethiopia. In July 2005, fifty M14 rifles from the government of Jordan were sent to Georgia Precision Shooter's Supply (Forsyth, GA) for accurizing.

A Total Army Assets database query performed during the first half of 2001 found a total U. S. Army inventory of 120,021 M14 rifles. This included M14 rifles in each classification of readiness condition. This query did not account for M14A1, M14M (Modified) and M14 NM (National Match) rifles in the possession of the U. S. Army or any M14 rifles in the inventory of the U. S. Navy, Marine Corps or Air Force. As of mid-2003, the U. S. Army inventory was approximately 96,000 M14 rifles in Condition A readiness. In May 2006, the U. S. Navy held a total of 4,354 M14 rifles aboard its ships.

The reader may be puzzled regarding why M14 rifles (and other small arms) should be destroyed or exported by the United States. The discussion below provides some interesting background.

The destruction of M14 rifles began as early as 1970. Rock Island Arsenal personnel replaced the 250 M14 rifles in inventory at the Loyola University (Chicago, IL) Army ROTC program with 250 M16 rifles. The M16 rifles were fitted with devices to inhibit automatic fire. Prior to leaving the university campus, Rock Island Arsenal personnel disassembled and destroyed all 250 M14 rifles. These 250 M14 rifles were cut through the barrels and the receiver barrel rings and the parts discarded as trash.

During the Cold War, the United States military inventoried a huge stockpile of weapons

that would enable it to fight two wars simultaneously. From World War II to the late 1980s, this roughly equated to 2.3 small arms for each member of the Armed Forces. The shift during the 1990s towards flexible, high-tech rapid-reaction forces meant that a large reserve of small arms was thought to be no longer required.

Initially, the U. S. Department of Defense destroyed large quantities of these newly surplus weapons, including 479,367 M14 rifles in 1993 and 1994 and roughly 350,000 M16A1 rifles in 1996. But under increasing pressure from gun advocates in Congress, an amendment was passed to the Defense Authorization Act in 1996 to prohibit the Army from destroying further collectable guns. The amendment has been passed every year since. This has created a growing stockpile of surplus weapons that gun advocates hoped would be made available for sale at a later date.

In a change of policy in 1995, the Army began to transfer its surplus stocks to foreign governments. Between 1995 and early 1998, 321,905 surplus small arms were exported to foreign militaries under the Excess Defense Articles program. The main recipients were Estonia, Latvia and Lithuania, Israel, Philippines and Taiwan.

From the perspective of the U. S. government, this policy of exporting surplus stocks to friendly governments has the twin benefit of strengthening vulnerable allies while simultaneously reducing the surplus stockpile. The blanket prohibition on the re-transfer of U. S. military equipment without prior approval from the U. S. government is also said to prevent the weapons from being diverted to third countries.

Foreign Sales of USGI M14 Rifles

Israel has exported USGI M14 rifles to Canada, Germany and New Zealand for commercial sale and to Italy for government use. In 1987, a number of USGI M14 rifles were imported into Canada from Israel. These rifles had the selector lug cut off in order to comply with Canadian law (see Canada Firearms Laws). New Zealand allows private possession of a USGI M14 rifle if the owner has a C Category firearms license but it cannot be fired.

During 1988 and 1989, two licensed gun dealers in Germany imported USGI M14 rifles into that country from Israel. The two dealers imported the rifles one at a time per customer request. Initially, there was not much interest in these rifles. Then the German firearms magazine, *Deutsches Waffen Journal*, printed a story on the Springfield Armory, Inc. M1A and Norinco M305 rifles in its July 1988 issue. The article generated some interest in the M14 type rifles among the gun buying public. In the May 1989 issue of *Deutsches Waffen Journal*, one of the gun dealers, Stefan Harlacher, advertised the USGI M14 rifle for a price range of 1,585 Deutsche Marks to 1,685 Deutsche Marks. Subsequently, a large firearms importer, Interimport, and a large firearms distributor, Frankonia, sensed a business opportunity. Frankonia placed an advertisement in the June 1989 issue of *Deutsches Waffen Journal* for USGI M14 rifles at the substantially lower price of 1,099 Deutsche Marks. These rifles were sold without the selector lug and no select fire components. Shortly after the Frankonia sale began, the Bundeskriminalamt (the German equivalent of the U. S. Federal Bureau of Investigation) declared the imported M14 to be a military small arm. All further importation was halted. The USGI

M14 rifles that had been imported were allowed to remain in private hands but had to be permitted by the Bundeskriminalamt. All transfers, sales and repairs regarding the USGI M14 rifles had to be documented. There were a total of about eighty USGI M14 rifles imported and sold in Germany. With a new firearms law effective April 2003, these M14 rifles can be transferred without restriction in Germany among those with gun permits.

A www.BattleRifles.com member and resident of Isle of Jersey, United Kingdom has been the owner of a USGI Winchester M14 rifle since about 1989. A gentleman living in Barbados legally owns a Harrington & Richardson USGI M14 rifle. A small number of M14 rifles remain in the Socialist Republic of Viet Nam. At least one M14 and one M14A1 are on display at the War Remnants Museum 28 Vo Van Tan District 3 Ho Chi Minh City (formerly known as Saigon). Some M14 rifles have been exported from Viet Nam to the Netherlands, Finland, Luxembourg, and Norway. M14 rifles are available for sale to private individuals in those countries. For example, Mr. van Veen of Amsterdam imported M14 (and M1 Garand and Carbine) rifles into the Netherlands during the 1980s.

Private individuals in Queensland, Australia with a valid state license owned USGI and Chinese M14 rifles from at least 1991 until 1996. In 1996, the Australian government banned private ownership of semi-automatic firearms except for a few private individuals possessing pest control licenses. The 1996 legislation included a buy back program for semi-automatic firearms including M14 rifles.

In 2006, the Queensland Department of Fisheries and Wildlife had approximately USGI M14 rifles in its equipment inventory. This agency has at times employed a sharpshooter equipped with the M14 rifle to kill wild pigs, wild horses and buffalo from a helicopter. The selective hunting is conducted as part of the government's wildlife conservation program. Firearms and firearms parts imported for the use by state law enforcement agencies in Australia must be approved by the Attorney General of Australia.

Countries that allow the commercial importation of USGI M14 rifles generally do not allow owners to have automatic fire capability so the rifles and / or parts are regulated to prohibit select fire. For example, M14 rifles are legal for civilians to own in Germany but the selector lug is milled off and the USGI flash suppressor is replaced with a faux suppressor. In the Netherlands, it is illegal for all of the select fire parts to be installed on civilian owned M14 rifles.

M14E1

Between September 1961 and January 1963, Springfield Armory developed five versions of a folding stock designated as the M14E1. This was done at the request of the U. S. Army. Such a rifle was to be carried by paratroopers, tank crews and vehicle drivers. The designs included both under-folding and side-folding stocks for the M14 rifle as follows:

Table 7: M14E1 Rifle Types

Model	Description
M14E1Type I	no information available, tool room folding style model
M14E1Type II	under folding style with left side mounted front and rear sling swivels
M14E1Type III	under folding Soviet AKM style with left side mounted front and rear sling swivels
M14E1Type IV	under folding style with folding front and rear pistol grips and hinged butt plate
M14E1Type V	left side folding style with folding front and rear pistol grips and hinged butt plate

The M14E1 Type IV was outfitted with a clip on muzzle stabilizer that was also capable of mounting a bayonet. One M14E1 Type V rifle was made in January 1963. The Type V stock had an aluminum bar stock arm, aluminum butt plate and swivel bracket. However, the difficulties encountered in producing forged aluminum stock arms were not resolved due to a lack of funding. The M14E1 Type V was shown to the Army and Marines at Fort Belvoir, Fort Knox, Fort Campbell, Fort Benning and Marine Corps Base Quantico by representatives of Springfield Armory during the first six months of 1963. Fort Benning recommended that the Type V stock be changed to a right side folder and that the front pistol grip fold to the rear instead of to the front. The Marines Test Center recommended acceptance of the M14E1 but it was not meant to be.

M14E2 and M14A1

The M14E2, later M14A1, rifle assigned to the automatic rifleman had an M14E2 stock and sling, stabilizer assembly and M2 bipod with sling swivel. His rifle would have a selector switch and selector shaft spring installed in place of the selector lock. Initially though, the automatic rifleman was equipped with a M2 bipod attached to his M14 rifle with or without the sling swivel. This configuration was known as the M14 (Modified) rifle, not to be confused with the M14 M with welded select fire components (see M14 M).

The M14 (Modified) suffered from excessive bullet dispersion, heavy recoil and severe muzzle rise. In 1961, the U. S. Army Infantry Board at Fort Benning, GA was given the task of improving the performance of the M14 (Modified) rifle. Captain Durward Dean Gosney, a native of Phoenix, AZ and an Army Infantry Board test officer, developed three major changes to the M14 (Modified) rifle. Captain Gosney was recognized as the creator of the design officially classified in late 1963 as the M14E2.

The M14E2 design differed significantly from the M14 (Modified) in three ways: 1) attachment of a muzzle stabilizer over the flash suppressor 2) a straight-line stock with a rubber butt pad and 3) dual hand grips. The muzzle stabilizer was found to reduce lateral bullet dispersion. It also reduced recoil by 25 %. Unfortunately, the muzzle stabilizer did not suppress the flash signature. The straight-line stock with rubber butt pad reduced muzzle rise and further reduced recoil. The fore and rear hand grips, in tandem with the M14E2 sling, increased the downward force acting on the M2 bipod legs from 7 pounds with the M14 (Modified) to 31 pounds. Final testing on the M14E2 rifle was completed at Fort Jackson, SC in early 1964. Much tighter shot group sizes were obtained with the

M14E2 over the M14 (Modified), i.e., 4 " versus 12 " at 25 meters. With a modest amount of practice, the author has obtained 7 " groups at 100 yards with a NFA Registered Springfield Armory, Inc. M1A in automatic fire.

Between July and December 1964, 8,350 M14 rifles were converted to M14E2 rifles and delivered to the military. Originally, TRW and Winchester were tasked with the M14E2 conversions but the supplier was late in delivering the rubber coated metal fore grips. When the fore grips were finally delivered, Springfield Armory did the conversions in order to speed delivery of the M14E2 to military units. By April 1966, the M14E2 had been designated as the M14A1. The classification M14E2 means the second experimental design for the Model 14 rifle. M14A1 stands for the first alternate configuration for the Model M14 rifle. Among collectors, the terms M14E2 and M14A1 are interchangeable.

The M14A1 as a Sniper Rifle - Less than 100 M14 rifles were fitted with walnut M14E2 stocks for use as sniper rifles. These rifles could also fire M198 duplex ball ammunition in automatic if need be. This work was performed at Anniston Army Depot and Rock Island Arsenal. An example of these M14A1 sniper rifles is discussed in the article entitled "Snipers in Vietnam Also Need Firepower" by Army Lieutenant Louis A. Garavaglia in the January 1968 *American Rifleman*. Prior to 1968, a sniper detachment was created within the Long Range Reconnaissance Patrol (LRRP) Company of the U. S. Army 4th Division in Viet Nam.

The LRRP Company sniper detachment tested the following rifles for use as a sniper weapon: Winchester Model 70, Remington Model 700, M14, M16A1, and three versions of the AK47. The M14 was chosen because it was reliable, capable of long distance shots and could deliver volume of fire if needed. These M14A1 sniping rifles were used in the Central Highlands of the Republic of Viet Nam and configured as follows: 1) all Harrington & Richardson models 2) equipped with M14E2 stocks 3) equipped with M84 2.2 X scopes 4) lighter M16A1 bipods mounted on the gas cylinders just forward of the spindle valves and 5) the selector switches were installed. The M14A1 proved sufficiently accurate for sniping use. It was found that experienced shooters could easily hit Army E type silhouette targets at 700 meters from the prone position. This was equivalent to shooting a man that was kneeling at 700 meters. Snipers equipped with these scoped M14A1 rifles took nine magazines of ammunition with them. The nine magazines were loaded to eighteen rounds each. Two magazines contained M118 match grade cartridges and the other seven magazines held M198 duplex ball rounds. Should the three man sniper team get into a firefight, snipers would remove the match ammunition, insert a magazine of duplex rounds and switch to automatic for suppressive fire.

At the end of 1970 or early 1971, a custom built M14A1 rifle was issued to Chuck Karwan, an officer of the U. S. Army 1st Cavalry Division, while in the Republic of Viet Nam. This rifle was bedded and equipped with a Griffin & Howe, Inc. design scope mount, M84 scope and M14 butt plate and the vertical fore grip removed.

M14 Grenadier

The M14 Grenadier's rifle was equipped with the M15 grenade launcher sight and the M76 grenade launcher. The grenadier prepared the M14 rifle by turning the spindle

valve, loading a grenade blank into the magazine and placing a grenade on the M76 grenade launcher. The grenadier could propel a one and one-half pound grenade out to a distance of 250 meters depending on the angle at which he held the rifle and the launcher position to which the grenade was placed. Rifle grenade types included smoke, signaling, M31 high explosive anti-tank, M19A1 white phosphorous and M11A4, M29 and M31 inert training.

The M79 40 mm grenade launcher was adopted by the U. S. Army in October 1960. It had largely replaced the M14 rifle for the purpose of launching grenades by 1965. However, M14 rifles equipped as such did see combat service as late as June 1966 with the U. S. Marine Corps. C Company, 1st Battalion, 5th Marine Regiment, 1st Marine Division launched grenades against the Viet Cong with the M14 rifle during Operation Kansas in the Que Son Valley of Quang Tin Province, Republic of Viet Nam on June 16, 1966.

Besides launching grenades, the spindle valve on the M14 rifle is turned to the closed position (slot in the horizontal position) when shooting a line (rope) from ship-to-ship or when the shooter does not desire the cartridge case to be ejected. The spindle valve may also be closed during routine barrel cleaning to prevent the introduction of bore cleaner into the gas cylinder. If so, remember to open the spindle valve when finished cleaning. At some point between the spring of 1958 and the fall of 1959, the spindle valve was redesigned to have the slot cut across the entire diameter of the spindle valve head.

M14 M

A very few M14 rifles were permanently rendered semi-automatic. This was accomplished by welding the selector shaft lock, selector lock pin, selector shaft, sear release and the receiver. The welding of the select fire parts was accomplished by the Gas Tungsten Arc Welding method. This prevented removal of the selector lock and installation of the selector switch. Otherwise, the M14 M rifle was a rack grade M14. This modification was officially announced in the Director of Civilian Marksmanship's 1963 Rifle National Matches bulletin. The Army also announced it in Army Regulation 920-25 dated 8 February 1965. The U. S. Army intended to issue M14 M rifles to civilian shooting clubs and to sell them to the public through the Director of Civilian Marksmanship (DCM) program but this failed to occur. The Gun Control Act was signed by President Lyndon B. Johnson on October 22, 1968 and it went into effect on December 16, 1968. This law, among other things, prevented distribution of the M14 rifle to the public. The M14 M rifle was identified by stamping the letter M to the right of M14 on the receiver heel. Springfield Armory had converted 1009 M14 rifles to M14 M models by June 30, 1963.

M14 NM

A development program to turn the M14 into a competition match rifle was begun at Springfield Armory in 1959. This effort originated with Colonel Joe Smith, U. S. Army. Colonel Smith was the Director of Civilian Marksmanship from 1958 until 1971. Colonel Smith was the driving force in convincing the U. S. Army to spend the funds to develop

and produce the M14 NM. He promoted the use of the M14 rifle in competition shooting to the National Rifle Association. As part of the Springfield Armory National Match Engineering Program, the first accurized M14 rifles were tested in early 1961.

The competition match M14 rifle was designated M14 NM. Springfield Armory and TRW made M14 NM rifles from scratch. Additionally, Springfield Armory and Rock Island Arsenal converted some M14 rifles to M14 NM models. M14 NM rifles received the same welding operation as the M14 M rifles. The last complete set of drawings for the M14 NM was made in January 1986. The drawing number 7790189 R N has been observed on TRW M14 NM serial number 1473XXX. U. S. Army and National Guard match armorers had to pass the M14 NM armorer school at Rock Island Arsenal before they were allowed to work on match grade M14 rifles. By the 1980s, the National Guard MTU established an annual M14 NM armorer school at Camp Robinson (North Little Rock, AR). At least one M14 NM, a TRW model, was issued in 2004 to a U. S. Army soldier on active duty in Iraq as a rack grade rifle.

M14 NM Distinctive Features - The receiver heels were stamped M14 NM. The NM stamping appeared just to the right of M14 or on the flat surface behind the rear sight. The major differences between the M14 NM and the M14 were: 1) NM barrel was held to half the tolerances of the rack grade barrel and was not chromium plated 2) NM rifle receiver was glass bedded to the stock 3) specific parts were hand fitted and assembled 4) NM rear sight was adjustable in ½ MOA increments through finer threads in the sight base and windage knob, and through half-turn rotation of a hooded eccentric rear sight aperture and 5) select fire parts were welded to prevent operation. The M14 NM rear sight was the same as what was used on National Match modified M1 Garand rifles. Both walnut and birch stocks have been used to build M14 NM rifles. M14 NM rifles were required to group no more than 3.5 " on average at 100 yards after three ten shot groups using M118 match ammunition. The maximum group size allowed for any single round of ten shots was 5.0 ".

M14 NM Production – The best accounting to date figures the sum of 18,466 for M14 NM rifle production from 1962 to 1967. Springfield Armory was tasked to deliver 3,000 new M14 National Match rifles by August 01, 1962 and it delivered 3,641 new National Match rifles the following year. TRW manufactured 4,874 new M14 NM rifles in 1964. Springfield Armory rebuilt 2,094 rifles in 1965 and 2,395 rifles in 1966. Rock Island Arsenal rebuilt a batch of 2,462 rifles in 1967.

M14 NM and M21 Gas Piston - The gas piston for the M14 NM and M21 had a groove cut on the top of cylindrical portion, according to drawing number 9352724. The groove was made part of the M14 NM and M21 specifications as a result of the efforts of Picatinny Arsenal. Civilian draftsmen and engineers from Picatinny Arsenal interviewed National Guard Marksmanship Unit shooters and armorers to develop standardized build specifications for the M14 NM and M21. From this development effort, the M14 NM and M21 rifles were given the gas piston groove and medium weight match grade barrels.

The gas piston groove equalizes the gas pressure inside the cylinder resulting in gentler stroking of the operating rod. The groove also aids in breaking vacuum so that the competition shooter can determine if the gas piston is free to move inside the cylinder by

tilting the rifle up and down with the bolt held open. Members of the National Guard Marksmanship Unit, as well as some competition shooters, thought the piston groove also reduced the force impacting the operating rod. The perceived result was a smoother and more consistent cycling of the operating rod. Match armorers also polished the gas piston in M14 NM and M21 rifles with crocus cloth to reduce the friction between the gas cylinder and the gas piston. Some competition shooters had the groove cut on the bottom of the gas piston. Two very credible sources interviewed for this work favored the piston groove on the bottom for the match grade M14 type rifle. By no later than 1984, the U. S. Marine Corps Shooting Team had access to match conditioning documents that specified two grooves to be machined in the gas piston for match use.

M14 NM Operating Rod Spring Guide – The standard USGI operating rod spring guide performs its function of guiding the operating rod spring but not without noticeable binding and twisting due to its thin cross-section (see Miscellaneous Notes on USGI Parts). This is acceptable for a rack grade M14 rifle. However, the U. S. Army MTU realized the operating rod spring guide could be improved upon as an aid to M14 NM accuracy. By no later than mid-1967, the AMTU had created the National Match operating rod spring guide. It was made of two pieces, a section of un-heat treated drill rod welded to a cutoff magazine catch portion of a USGI operating rod spring guide. The drill rod section was tapered at the forward end like the issue operating rod spring guide. The benefits were a straight operating rod spring and smoother operation of the gas system. Unfortunately, the National Match operating rod spring guide was not hardened by heat treatment after the welding procedure. Consequently, the magazine catch portion of the NM operating rod spring guide wore out much quicker than the issue spring guide.

In the 1980s and 1990s, the National Guard Marksmanship Training Unit attached the magazine catch portion to the slotted drill rod by silver soldering. This method of attachment kept the magazine catch from softening. Often, a hole was drilled through the rod and a pin inserted to secure the magazine catch as well.

M14 NM Issue – Shooters were introduced to the M14 NM rifle at the 1963 National Rifle Matches. M14 NM rifles were a regular issue item at the 1964 and 1965 Matches. The M14 type rifle was popular in competition shooting until the early 1990s. The M14 was used by the U. S. Marine Corps at Camp Perry as late as 1996. However, U. S. DCM shooting clubs, such as the Alabama State Service Rifle Team and the Connecticut State Rifle and Pistol Association, still inventoried M14 NM rifles in 2004 and 2005, respectively.

Civilian Ownership of the M14 NM - The 1980 court case, *U. S. v. One U. S. (TRW) 7.62mm M-14 National Match Rifle, Serial No. 1453711*, is worthy of mention. This federal court case was not appealed, and is not “controlling legal authority” for other situations, even within the Southern District of Ohio. Though this case applies only to this particular M14 NM rifle, it does establish that one court has determined that the M14 NM rifle as manufactured by TRW and Springfield Armory is not capable of and is not designed for automatic fire. The rifle in question was originally manufactured as a M14 National Match model, in contrast to rack grade M14 rifles converted into M14 NM configuration.

Robert Sauerman purchased the TRW M14 NM rifle serial number 1453711 in 1973 or 1974. It was not registered as a National Firearms Act machine gun. In order to set the question of the rifle's legal status to rest, Mr. Sauerman informed the Bureau of Alcohol, Tobacco and Firearms (BATF) that he was in possession of the TRW M14 NM. This TRW M14 NM was confiscated from the owner, Robert Sauerman, by the BATF on September 27, 1977 at his gun shop near Dayton, Ohio. The trial court made findings of fact that included a ruling that this TRW M14 NM was not a machine gun under the National Firearms Act, and ordered to be returned to Mr. Sauerman. The TRW M14 NM serial number 1453711 was sold by Mr. Sauerman around 1986 or 1987 to a private individual. In 2006, this TRW M14 was sold again to a collector in Ohio. After 1987, Robert Sauerman met an untimely death when a drunk driver crossed lanes and hit him head on at a stoplight. The 1987 to 2006 owner of TRW M14 NM serial number 1453711 also possessed the court case documents and a Springfield Armory M14 NM.

M15

From 1955 to 1959, the M15 (T44E5) rifle was developed as a heavier version of the M14 (T44E4). The M15 (T44E5) weighed 14.8 pounds with sling, bipod and a full magazine of twenty rounds. The cyclic rate of fire was 750 rounds per minute. The overall length of the M15 was 45.5 ". The heavy non-plated barrel was 22 " long and weighed 3.5 pounds.

Mathewson Tool Company produced three samples of the T44E5. An unknown number of T44E4 rifles in the serial number range 1001 to 1500 were built into T44E5 models by Springfield Armory. These Springfield Armory developmental rifles were stamped T44E5 on the receiver. However, one M15 rifle had no receiver markings whatsoever.

The M15 (T44E5) had the following parts that differed from the M14: flash suppressor, barrel, gas cylinder, gas cylinder lock, front band, heavier wood stock with a different liner, heavier and triangular front sling swivel base, bipod, and a M1 Garand butt plate with a BAR hinge carefully inletted and secured with welds. Like the T44E4, the M15 hand guard was made of wood. The M15 flash suppressor had a machined surface just forward of the front sight for attaching the bipod. The bipod had eight height positions and the legs were similar to the M2 bipod. Some experimental M15 parts included a chamfered front end flash suppressor akin to the T44E4, a stock with notches and latching clips for securing the bipod feet, and a grenade launcher fitted to the muzzle coupled with an experimental bipod.

In 1956, the decision was made to chromium plate standard contour M14 barrels. The T44E5 was tested by the U. S. Army and the U. S. Marine Corps in 1958. During U. S. Marine Corps testing of the T44E5, a hinged butt plate and bipod were fitted and tested on a T44E4 rifle. Combined with the chromium plated barrel and ventilated hand guard, the T44E4 performed satisfactorily. As a result, the U. S. Marine Corps requested a hinged butt plate and bipod for the M14. These features were adopted for the M14 the following year. Consequently, the M15 was declared obsolete in December 1959 without any USGI rifles ever stamped M15.

One commercial M15 rifle was made. Prior to May 1986, a physician in Ohio custom ordered a select fire M1A receiver from Springfield Armory, Inc. The doctor had

Springfield Armory, Inc. stamp the receiver M15 instead of M1A. To this receiver he added M14 and T44E5 parts he had accumulated to create the only known M15 rifle ever built.

U. S. Army Snipers and the XM21 and M21

Before 1985, U. S. Army sniper schools were operated at the division or base command level. From 1956 until 1985, the USAMTU either sent out Mobile Training Teams to combat theaters to train instructors or trained them at Fort Benning, GA to staff up the sniper schools as needed. As the involvement of the Army wound down in a given conflict, the sniper schools were dissolved until the next time they were needed. After 1985, the USAMTU no longer taught sniper school instructors. Now known as the Army Marksmanship Unit (AMU), it is involved with competition shooting and small arms development. The U. S. Army sniper school at Fort Benning, GA was established about 1985 and is a separate command from the AMU. The U. S. Army five week sniper course average student failure rate was 32 % from 2000 through 2004.

The instructors trained at Fort Benning in the 1960s by the USAMTU were sent to the Republic of Viet Nam to run division sniper schools. For example, the 9th Infantry Division sniper school was established at Dong Tam, Dinh Tuong, the 23rd Infantry Division sniper school was based at Chu Lai, Quang Tin and the 25th Infantry Division sniper school was located at Cu Chi, Tay Ninh.

On a side note, one of the 1960s AMTU staff members is particularly noteworthy in M14 rifle history. Sergeant First Class Gerald "Hook" Boutin, U. S. Army (Retired) built XM21 rifles and was a sniper instructor during the American involvement in the Republic of Viet Nam. SFC Boutin was also a service rifle competition shooter. He built accurized semi-automatic M14 type rifles for civilian shooters for decades after the American military pull out from the Republic of Viet Nam. SFC Boutin was recognized for his service to the U. S. Army and the American people by his induction into the AMU Hall of Fame on October 23, 2004. His custom built M14 type rifles leave no tell tale signature of his gifted touch other than black color bedding material if the particular stock was bedded by him.

Essentially, the XM21 and M21 rifles are M14 NM rifles equipped with optics. The XM21 weighed 11 pounds by itself and 14 pounds 5 1/3 ounces with equipment. The M14 rifle was used for sniping duty as early as 1965. The U. S. Army 11th Air Assault Division had M14 rifles equipped with M84 scopes on aluminum mounts made by the USAMTU.

In 1966, the Army Weapons Command at Rock Island Arsenal developed a scope mount for the M84 scope to be used on the M14 NM rifle. This scope mount was a two piece affair. The machined base had an integral rail and vertical and horizontal keys to mate to the receiver grooves. The base was attached to the receiver by a hex head screw or a screw with a knurled knob. The M84 scope was held by a Griffin & Howe, Inc. hinged mount borrowed from the M1C sniper rifle. The scope and mount assembly was secured to the base rail by throw levers. The base had a clearance undercut at the top of the vertical exterior surface to allow free movement of the Griffin & Howe, Inc. mount levers. The scope was centered over the receiver when in use. To use the iron sights, the hinged Griffin & Howe, Inc. mount was rotated counterclockwise to move the scope

outboard of the receiver.

In March 1967, the Army Weapons Command shipped the first 125 M84 scoped M14 NM rifles to the Republic of Viet Nam for use by Army snipers. M14 NM rifles equipped with M84 scopes were in use in Viet Nam even after the XM21 with the ART scope was fielded.

U. S. Army armorers in the Republic of Viet Nam manufactured two M14 scope mounts. Both versions used steel angle iron with a machined rail secured to the top by three flat head screws. Each scope mount had a hole drilled through the vertical portion to bolt into the M14 receiver. Neither version had a vertical key to fit the receiver vertical groove. One version had a horizontal weld bead on the vertical inside surface. The weld bead was filed down to neatly fit the receiver horizontal groove. The other version had two tapped holes 1 3/4 " apart in the vertical portion of the mount. Two 3/16 " screws were threaded into the holes then filed down to rest in the receiver horizontal groove. The two screws were secured with lock pins.

At the request of Army Major General Julian Ewell, commander of the 9th Infantry Division, fifty-four auto-ranging variable power scoped M14 MTU-NM rifles were delivered to the division's sniper school in the Republic of Viet Nam on October 03, 1968. The Army Weapons Command provided an additional seventy-four M14 NM rifles equipped with the M84 2.2 X scope to the same sniper school.

The auto-ranging variable power scoped M14 MTU-NM was designated the XM21 by the U. S. Army Weapons Command at Rock Island Arsenal on September 18, 1969. This designation remained until 1972 when it became the M2. The XM21 and M21 were both equipped with an auto-ranging variable power telescope (ART) and National Match iron sights. By no later than May 1967, M14 NM rifles were being rebuilt by Rock Island Arsenal for sniping duty. XM21 rifles are either stamped or etched XM21 on the flat surface just behind the rear sight. The selector shaft is not welded on the XM21. Conversion to XM21 configuration included accurizing and installation of a standard contour National Match barrel and marking the scope mount with the last four digits of the receiver serial number by use of a Hermes engraving machine. These gunsmithing procedures were codified by Colonel Conway when he wrote the original late 1968 edition of the USAMTU Accurized National Match M14 Rifle "M14 (MTU-NM)." This manual became the build manual for the XM21. Colonel Conway was the Ordnance Officer for the USAMTU at Fort Benning, GA from 1966 to 1970. The USAMTU performed final acceptance tests on the XM21 rifles. The XM21 rifles that had passed testing were sent to Anniston Army Depot for packing and shipment to Army units in the Republic of Viet Nam. A few of the XM21 rifle stocks were camouflaged after arrival in Viet Nam. At least a few of the XM21 rifles shipped to the Republic of Viet Nam were assembled with USGI synthetic stocks. By April 1970 more than 1300 XM21 rifles were in Viet Nam.

Scoped M14 NM and XM21 rifles were used by snipers from the 1st Cavalry Division, 1st Infantry Division, 9th Infantry Division, 23rd Infantry Division, 25th Infantry Division, 101st Airborne Division, and the Military Assistance Command Vietnam/Studies and Operations Group (MACV/SOG) in Viet Nam and Cambodia. The scoped M14 NM and XM21 rifles

were supplied with 172 grain M118 match grade ammunition.

At the request of the U. S. Navy, the Army MTU built and shipped forty accurized and scoped M14 rifles to the Republic of Viet Nam in 1969 for use by sailors on river patrol boats. However, these forty M14 rifles were furnished with conventional fixed magnification scopes and not the ART scopes.

The variable 3X to 9X scope system used on the XM21 rifles was conceived by Army Lieutenant (later Captain) James M. Leatherwood in 1965 and developed by the Army Limited Warfare Laboratory. The Limited Warfare Laboratory at Fort Benning, GA modified Redfield Gunsight Company Accu-Range scopes for the first and second versions. The third version of the original ART scope was wholly manufactured by Redfield and with the mount made by Frankford Arsenal. The third version became known as the ART TEL or ART I. The ART I scopes were manufactured some time between March and October 1969. Frankford Arsenal completed manufacture of the ART I scope mounts in October 1969.

James Leatherwood's design improvement consisted of using a cam connected to the scope's variable power ring to adjust the elevation, as the user increased or decreased magnification until vertical stadia bracketed a known distance. This created an automatic bullet drop compensator. Leatherwood's adjustable trajectory rifle scope ideas were patented in 1967, 1969 and 1970 (U. S. Patent numbers 3,340,614, 3,431,652 and 3,492,733). The Viet Nam era Leatherwood scopes were camed for the M80 and M118 cartridges. Early scope mounts used a single mounting screw developed by the USAMTU and the Limited Warfare Laboratory at the Aberdeen Proving Ground.

The 9th Infantry Division sniper school students were each issued a starlight scope with their XM21 rifles. The AN/PVS-1 and AN/PVS-2 models used mounting brackets that situated the scopes over the receiver but to the left of the bore centerline. The AN/PVS-1 and AN/PVS-2 scopes were first generation technology night vision devices. The Night Vision Laboratory, which was attached to the U. S. Army Electronics Command (ECOM) in 1965, began development of the AN/PVS-2 starlight scope in 1961. In 1965, ECOM was based at Fort Monmouth (NJ) and was then a subordinate command of the U. S. Army Materiel Command. The AN/PVS-1 scope had been fully developed and a U. S. Army Training Circular written for it by November 1966. It weighed 5 pounds 14.75 ounces. The AN/PVS-2 went into production under contract in September 1964 with Electro-Optical Systems, Inc. The AN/PVS-2 starlight scope replaced the AN/PVS-1 for night shooting by 1969 among U. S. Army snipers in the Republic of Viet Nam. The AN/PVS-2 was more rugged than its predecessor but weighed one pound more and was about an inch longer. The smaller AN/PVS-3 was used as early as May 1968 in the Republic of Viet Nam by American snipers as a hand-held night vision monocular for spotting enemy activity. The AN/PVS-3 weighed 3 pounds. These three night scope models were 4X magnification.

After 1970, USGI National Match barrels were no longer available for several years. Consequently, the U. S. Army Weapons Command purchased match grade barrels for the XM21 and M21 from commercial barrel manufacturers such as Douglas, Shilen and Hart. XM21 and early M21 rifles had a bedded and epoxy impregnated wood stock.

XM21 rifles did not have receiver lugs. Some M21 rifles in the late 1980s were built with a rear lug under and extending behind the receiver heel. Later M21 rifles were issued with a fiberglass stock and a medium weight match grade barrel. M21 rifles have the marking M14 lightly ground out and the marking M21 is engraved on the receiver heel.

Although the M24 was officially adopted in 1988 (see XM25 and M25), the M21 remained in service with the U. S. Army until at least March 1991. In June 1990, the 101st Airborne Division was in the process of issuing M24 sniper weapon systems at the company level to replace the M21 rifles. The M24 systems were to be issued throughout the division before any of its M21 rifles were turned in. With the pending deployment to Saudi Arabia, the decision was taken by a number of company commanders, A Company 1st Battalion 327th Infantry Regiment and others, to deploy with the M21 rifles. According to one such company commander, now Lieutenant Colonel John Russell, the M21 rifles "held up to the desert environment great and maintenance was not a problem." In 1990, each rifle company in the 101st Airborne Division typically had three M21 rifles assigned to each platoon for a total of nine. On March 08, 1991, the first American troops returned home from Operation Desert Storm (First Gulf War).

In 1972, Realist (FL) was producing ART I scopes for the U. S. government. The major difference between the Redfield and Realist models was the reticle design. In the first half of 1974, James Leatherwood bought the remaining inventory of Realist ART I scopes, ballistic cams and scope mounts. Leatherwood Bros. was established in Stephenville, TX. The company modified the ART I design to increase service life and reliability. The Leatherwood Bros. ART II scope was developed by 1978. Various cams were available for the ART II scope according to the ammunition in use. Mounts for the ART II scope had a second mounting screw. Leatherwood Bros. produced a rear mounting block for the ART II scope mount that replaced the stripper clip guide. For reasons unknown to the author, U. S. Army M21 rifles did not use this rear mounting block. Instead the issue stripper clip guide was drilled and tapped to accept the second mounting screw. The ART I scopes were mostly replaced in 1981 and later by Leatherwood Bros. ART II scopes. Rock Island Arsenal has rebuilt ART scopes as needed. Apparently, a few ART I and ART II scopes were still in the inventory of the U. S. Army in 2004. U. S. Army Special Forces at Fort Bragg, NC in November 2004 shipped ART I and ART II scopes to U. S. soldiers in Iraq.

M14 Product Improved Rifle

Beginning in 1970, the U. S. Army Materiel Command funded a project at Rodman Laboratories, Rock Island Arsenal to further improve the M14 rifle. A civilian employee, Robert E. Snodgrass, headed the project. Three prototype rifles were produced and weighed approximately 10 ½ pounds with sling and empty magazine. These 43 " long rifles had 24 " heavyweight stainless steel barrels, two bedding lugs, improved gas systems, laminated walnut stocks, no hand guard, hooded target grade front sight, and no select fire components including removal of the selector lug. The bedding lugs on the first prototype model were located at the front and rear ends of the receiver. The bedding lugs for the second and third prototype rifles were placed at the front of the receiver lug

and the operating rod guide. The barrel on the first prototype rifle was broach cut (see The Barrel Making Process). Remaining barrels for the M14 Product Improved Rifle project were to be made by the hammer forging method. These rifles grouped less than two minutes of angle at 100 yards with M118 ammunition. This was about a 100 % improvement over the acceptance standard of the M14 NM rifle specifications in 1975. By 1975 the funding for this project was stopped.

XM25 and M25

The M25 rifle is an improved version of the M21. In 1986, the 10th Special Forces Group at Fort Devens, MA had its own machine shop and ammunition reloading shop to support the unit's sniper weapon systems. While the ART II scope and side two point scope mount design were great improvements for the M21 over the original XM21 configuration, these optical systems were still prone to loss of zero when knocked around in the field. The condition of the bedding compound in the XM21 and M21 rifles deteriorated with removal of the receiver and barrel for cleaning and maintenance. The bedding compound in use at the time was also susceptible to chemical attack from various oils. Loss of the bedding material further worsened accuracy by causing the receiver to shift around in the stock.

To alleviate these problems, 10th Special Forces Group armorer Sergeant First Class (later Master Sergeant) Tom Kapp, now deceased, sought to improve the M21 rifle. So, he and Master Sergeant Amelung, worked with Mitchell E. Mateiko, owner of Brookfield Precision Tool (BPT), to develop the XM25 rifle between 1986 and 1988. Master Sergeant Amelung was the Non-Commissioned Officer-In-Charge of the 10th Special Forces Special Operations Target Interdiction Course. Mitch Mateiko had served in the Army National Guard and worked as a tool and die maker for the M14 project at one of the four government funded manufacturers. Brookfield Precision Tool was located at 126-A Quaboag Street Brookfield, MA 01506. After 1996, he went on to become a law enforcement officer in Massachusetts.

Meanwhile, higher authority within the U. S. Army sought Congressional funding to change its sniper rifle from the M21 to the M24 bolt action rifle. This effort was successful with the M24 officially replacing the M21 as the sniper rifle for the U. S. Army in 1988. U. S. Army General Guest, in Congressional testimony seeking funding for the M24 rifle, was of the opinion that the M21 rifle was at the end of its usefulness as a sniper weapon system. Consequently, the development of the XM25 rifle continued quietly. The rifle produced by the 10th Special Forces Group and Brookfield Precision Tool was classified as the XM25 since the M21 was no longer considered viable by higher authority. The 10th Special Forces Group intended for the XM25 rifle to be carried by the sniper team observer in urban operations with an effective range of 600 meters. The XM25 was found to be as accurate as the M24 in the late 1980s when both rifles used M118 Special Ball ammunition. In 1991, the U. S. Army designated the XM25 as the M25. The XM25 / M25 saw combat service in Panama in 1989, the 1990-1991 Gulf War, and in Afghanistan in 2002. The M25 still serves admirably as the spotter's rifle in Special Operations sniper teams.

Initially, the XM25 rifle did not mount a bipod and it was fitted with a 10th Special Forces Group made scope mount. But as adopted, the XM25 design specification required the rifle to have a synthetic material stock, a medium weight match grade barrel, a Harris bipod and the following Brookfield Precision Tool parts: steel stock liner, operating rod spring guide, scope mount, and titanium nitride coated gas piston. Various Harris bipod models were employed by Special Forces operators but over time the notched-leg swiveling bench rest height model was the typical bipod found on U. S. Army issue M25 rifles. A bipod was not always used in the field with the M25 rifle. Often, the M25 rifle was steadied with a ruck sack or a sock containing a plastic bag filled with cooked popcorn for making the shot.

The Brookfield Precision Tool operating rod spring guide was machined with four flat sides on the shaft to reduce friction with the operating rod spring and as an allowance for debris. After all, the XM25 was expected to be used in combat operations. Otherwise, the operating rod spring guide was made by the traditional means of welding a machined vice stamped magazine catch to the slotted end of the shaft. The Brookfield Precision Tool operating rod spring guide was hardened by heat treatment after welding. Consequently, these spring guides did not suffer from premature wear at the magazine catch like the AMTU models. It has the tapered forward end similar to the AMTU operating rod spring guide. A small number, one or two production batches, were not marked with the Brookfield Precision Tool name. The side three point scope mount, modified operating rod spring guide, and gas piston titanium nitride coating employed in the XM25 were innovative developments. Brookfield Precision Tool parts were not assigned National Stock Numbers.

Two side three point scope mount designs were tested by the U. S. Army for the XM25 rifle (see Side Three Point Scope Mounts). The Atlantic Research Marketing Systems, Inc. (West Bridgewater, MA) scope mount was tested by the 82nd Airborne Division and by the 10th Special Forces Group during development of the XM25. The 10th Special Forces Group also tested a scope mount made by Brookfield Precision Tool (BPT). The U. S. Army settled on the BPT model by 1988 for the XM25 rifle specification.

Optics on the M25 varies according to unit preferences. The U. S. Army XM25 rifles were first outfitted with Leupold & Stevens, Inc. M1 Ultra and Bausch & Lomb Tactical scopes followed by Leupold & Stevens, Inc. M3 Ultra models. Army Special Forces M25 rifles today typically sport the Leupold & Stevens, Inc. M3A 10X scope while the Navy SEALs prefer the Bausch & Lomb Tactical 10X scope on its M25 rifles. Brookfield Precision Tool also produced an adapter for its scope mount to accommodate the AN/PVS-4 night scope. The AN/PVS-4 second generation technology night scope was manufactured for the U. S. Army in 1980 and 1981. It saw service in 1991 during the First Gulf War. Generation III image intensifier tubes were available for the AN/PVS-4 by 1999.

The Brookfield Precision Tool gas piston was coated with titanium nitride on the larger cylindrical diameter but not on the smaller diameter portion. Brookfield Precision Tool made two different titanium nitride coated gas pistons. Both used drawing number 7267047. The Revision 1 gas piston has the standard diameter gas inlet. The Revision 2 has a smaller diameter gas inlet. Only a relatively few 7267047 Revision 2 gas pistons

were made. The Revision 2 gas pistons were designed for use in sound suppressed M14 type rifles. The U. S. Navy purchased 7267047 Revision 2 gas pistons but the U. S. Army and U. S. Marine Corps did not. For sound suppressed M25 rifles the U. S. Army welded and drilled the gas piston gas inlet to a smaller diameter and also drilled an approximate 0.030 " diameter hole in the center of the gas cylinder plug in order to keep the chamber pressure and the force acting on the operating rod to acceptable values.

The XM25 rifle had a steel liner placed inside the stock to allow removal of the stock without loss of scope zero. The steel stock liner was designed by Master Sergeant Tom Kapp. The design was successful because it allowed the sniper to remove the barrel and receiver from the stock, clean the weapon and reassemble the rifle without a loss of scope zero. However, the stock liner was time consuming to produce. Consequently, the stock liner was not kept as part of the specification for the M25 rifle. The M25 rifle, as used by the U. S. Army, typically sports either a McMillan M1A or M2A bedded stock without the steel liner and a heavyweight match grade Krieger barrel. The M25 rifle does not have a rear receiver lug. The select fire components are not welded on the M25 rifle. The selector lock is installed but can be replaced with a selector switch if desired.

M14 SMUD

U. S. Air Force Explosive Ordnance Disposal (EOD) units were equipped with the M14 SMUD rifle. SMUD is a military acronym for Standoff Munitions Disruption. The M14 SMUD rifles in the inventory of the U. S. Air Force EOD unit in the Republic of Korea in 1990 had wood stocks and commercial manufacture Redfield variable 3x9 magnification rifle scopes. The M14 SMUD was assigned a separate National Stock Number from other M14 variants. It was eventually displaced by the M82A1 .50 BMG semi-automatic rifle in U. S. Air Force EOD units by 1996 or 1997. Reportedly, the M14 SMUD was also in use by U. S. Navy EOD units in 1990s.

M14 DMR

The U. S. Marine Corps adopted a Designated Marksman Rifle and established a Designated Marksman School (Mare Island, CA) by no later than 1992. Initially, the Pacific Fleet Marine Corps Security Force Battalion was equipped with Galil rifles and Nimrod scopes to serve as the Designated Marksman Rifle. The Galil rifles did not provide satisfactory service for the Fleet Antiterror Security Team (FAST) Company according to a Marine in the Weapons Platoon during this period. By 1993 or earlier, the U. S. Marine Corps chose the M14 rifle to become its Designated Marksman Rifle (DMR). The M14 DMR is classified as a precision grade, semi-automatic 7.62 mm NATO caliber rifle. It weighs 13 pounds with its issue equipment. The DMR enables the shooter to deliver accurate semi-automatic fire against multiple targets at greater distances and with greater lethality than with the M16A2. U. S. Marines selected to become a Designated Marksman attend a four week course given at a number of Marine Corps installations such as Marine Corps Base (MCB) Quantico (VA) and Camp Lejeune (NC).

In August 1998 the U. S. Marine Corps Systems Command negotiated three sole source commercial item contracts for scope mounts and rings, barrels and stocks. McMillan Fiberglass Stocks (Phoenix, AZ) supplied 253 M2A stocks for the M14 DMR. To each

M14 DMR stock, a Harris bipod was mounted under the forearm. GG&G (Tucson, AZ) provided 253 M1A1 scope mounts and 253 pairs of Sniper Grade Medium 30 mm scope rings. More recently, Badger Ordnance has supplied 30 mm scope rings for the M14 DMR. In 2003, the Precision Weapons Shop at MCB Quantico had designed and was capable of producing a scope mount for the M14 DMR.

Cooper Precision Manufacturing (Oak Ridge, TN) was owned by Accuracy International (United Kingdom). Cooper Precision Manufacturing sold 278 barrels for the M14 DMR in 1998 to the U. S. government. Reportedly, the Cooper Precision Manufacturing barrels were found to not meet the external dimensional specifications so they were not used. Cooper Precision Manufacturing struggled financially and was finally closed down by the parent company. The remaining material stock was sold to two individuals who now produce quality match grade barrels. Mike Rock, in late 1996 and 1997, and Krieger Barrels, Inc. have supplied match grade barrels to the U. S. Marine Corps for M14 DMR rifles.

M14 DMR rifles are built at the Precision Weapons Shop, Weapons Training Battalion, Training and Education Command. The Training and Education Command is a subordinate command under the Combat Development Command at MCB Quantico. U. S. Marines trained as armorers at the Precision Weapons Shop are assigned to build and maintain accurized sniper and marksman rifles including the M14 DMR. This is all done with a modern array of Computer Numerical Control (CNC) machine tools. The Weapons Training Battalion is tasked with training scout-sniper, designated marksman, officer candidate and small arms instructor students.

The M14 DMR has sported Unertl and Leupold & Stevens, Inc. variable 3.5-10X and fixed 10X daylight scopes and the AN/PVS-4, AN/PVS-10 and AN/PVS-17 night vision scopes. The initial ammunition issued for these rifles was the M118 round but that was later replaced with the 175 grain M118LR cartridge. The M118LR round makes the M14 DMR effective to a greater distance. Some M14 DMR rifles have been equipped with OPS, Inc. combination sound suppressor and muzzle brake attachments. The M14 DMR typically is built with a Krieger Barrels, Inc. 22 " match grade medium weight barrel, McMillan M2A stock with adjustable cheek rest, stock mounted bipod, side three point scope mount and armorer fitted parts. The M14 DMR is built with a standard M14 rear sight assembly and a M14 NM front sight.

Every M14 DMR is required to be proof fired with one pressure test round and thirty M118 rounds of ammunition. The accuracy test for every M14 DMR consists of a check list of items which includes grouping no more than a 3 " by 3 " square at 300 meters. The successful proof firing is indicated on the exterior of the barrel right hand rear end. The barrel is stamped with 1/16 " size letters in the following manner: PWS – P on the top line and the month and year below that. PWS denotes Precision Weapons Section and P means the barrel was proof fired.

The M14 DMR has seen combat service with the 26th Marine Expeditionary Unit from November 2001 to February 2002 while engaged in Operations Enduring Freedom and Swift Freedom to seize Camp Rhino and the Kandahar Airport in Afghanistan. In Afghanistan, the U. S. Marines had OPS, Inc. sound suppressor and muzzle brake

attachments available to them for the M14 DMR rifles. The Marines used AN/PVS-10 day/night scopes on the M14 DMR rifles and shot with M118LR ammunition. Less than two weeks before the November 07, 2004 attack on Fallujah, U. S. Marines of the Regimental Combat Team 7 were test firing the M14 DMR on a small arms range at Al Asad, Iraq.

Currently, the M14 DMR is assigned to Fleet Antiterror Security Teams of the Security Force Battalion within the 4th Marine Expeditionary Brigade (Anti-Terrorism). The 4th Marine Expeditionary Brigade (AT) was formed on October 29, 2001 in response to the terrorist attacks against the United States of America on September 11, 2001. Beginning in December 2001 until at least November 2003, a detachment from the 4th Marine Expeditionary Brigade (AT) provided additional security for the U. S. Embassy in Kabul, Afghanistan. The Marines occupied the roof top of the embassy round the clock in two man teams with M14 DMR rifles fitted with Leupold & Stevens, Inc. variable 3.5-10X day scopes and supporting equipment as part of the additional security provided to embassy personnel. The M14 DMR is also used by USMC Explosive Ordnance Disposal and Military Police units.

U. S. Marine Corps Scout-Snipers and the M14 Rifle

For the official record, the U. S. Marine Corps has never adopted the M14 rifle or any variant as its primary sniper rifle. Initially, Marine Corps scout-sniper schools were conducted in-theatre during the war in the Republic of Viet Nam. As an example, the 4th Marine Regiment established a three week scout-sniper school in March 1966 at Phu Bai, Thua Thien Province. Marine scout-snipers in the Republic of Viet Nam were issued the pre-1964 Winchester Model 70 .30-06 caliber bolt action rifle or the M1D semi-automatic rifle. Marine snipers carried the Winchester Model 70 until December 1967. The Remington Model 700 7.62 x 51 mm bolt action rifle was first issued in April 1966. By December 1967, the Marine scout-snipers had turned in their Winchester Model 70 rifles for the Remington rifles. Since the 1970s, the Marine Corps has refined the Remington Model 700 into the M40A1 and M40A3 models.

Like the M14 DMR, the M40 series rifles were built by the Precision Weapons Shop at MCB Quantico. The present day USMC Scout-Sniper School was established in 1977. Gunnery Sergeant Carlos N. Hathcock, II was the first Non-Commissioned Officer-In-Charge. While serving as a U. S. Marine Corps sniper in the Republic of Viet Nam, Gunnery Sergeant Hathcock used a pre-1964 Winchester Model 70 bolt action rifle. The scout-sniper nine week basic course failure rate was approximately 50 % in 2003 even though all who attend are qualified Rifle Expert.

Nonetheless, the M14 rifle was no strange bedfellow to Marine Corps scout-snipers in the Republic of Viet Nam. 4th Marine Regiment scout-sniper teams of two to five carried and used select fire capable M14 rifles along with the issue bolt action sniper rifles during operations from November 1966 until at least January 1968 in Quang Tri and Thua Thien Provinces. Likewise, 5th Marine Regiment scout-sniper team observers put the M14 rifle to good use against the Viet Cong R20 Main Force Battalion in the Song Thu Bon valley of Quang Tri province while in support of Marine rifle companies during Operation

Tuscaloosa in late January and early February 1967. The M14 rifles provided the necessary firepower to break contact with the enemy at close range.

The American military presence in the Philippines ceased shortly after the June 1991 eruption of Mount Pinatubo. During the two years prior to this event, the Marine Corps Barracks at Subic Bay Naval Base was authorized one billet for a scout-sniper and one M40A1 rifle. There were a number of scout-sniper school graduates on the roster of the Marine Barracks during this period. As part of their training routine, the Marine Barracks at Subic Bay conducted jungle patrols in the Philippines. In order to make use of the scout-sniper trained Marines during such operations, these particular Marines were equipped with M14 NM rifles sporting ART II scopes. These rifles worked well enough in the Philippine jungle.

M14 Enhanced Battle Rifle

Mike Rock started Mike Rock Rifle Barrels, Inc. in 1978. He made National Match and DMR barrels for the U. S. Marine Corps in the 1990s. After some financial struggles and losing his business, Malcolm Cooper hired Mike Rock to make barrels. Mr. Cooper passed away later on. Subsequently, engineers Jim Ribordy and Mike Rock teamed up as RD Systems (South Beloit, IL). In 2000, Rock Creek Barrels (Albany, WI) was formed. Rock Creek Barrels, Inc. is owned and operated by Mike Rock and Kim Theiler. Mike Rock produces single point cut rifle barrels. Kim Theiler manufactures pull button rifle barrels. To date, Mike Rock has personally fired over 1,000,000 rounds through firearms. He holds a Master's degree in Mechanical Engineering and an honorary Doctorate in Metallurgical Engineering.

About 2001, Mike Rock was asked by U. S. Army Lieutenant Colonel Gus Taylor at Naval Surface Warfare Center Crane, IN to participate in the SOPMOD Conference at Fort Benning, GA. SOPMOD is a military acronym for Special Operations Peculiar Modification. This term is used to denote that a weapon system has been modified for use by the U. S. Special Operations Command. Mike Rock was the sole barrel maker invited to this conference. Colonel Taylor asked Mike Rock to design a shortened M14 rifle. A contract was signed with NSWC Crane and the project began. As part of the project, Mike Rock was given ten M14 rifles to be used to develop the SOPMOD M14. Mr. Rock thought about the M14 design and how to improve upon it. He came up with the idea to reorient the gas system so that it was in line with the bolt roller. He made a wood mock up at first. It showed to be very promising so further development work was done. Malcolm Cooper and Mike Rock sketched out a "V" block two half stock for an Accuracy International bolt action rifle. This is where the concept of the two half synthetic stock originated. Mike Rock then measured and machined a prototype two half stock that had a wooden fore end with an aluminum channel. After this, Colonel Taylor informed Mike Rock that a collapsing stock was desired for the SOPMOD M14.

Mike Rock then created an aluminum stock body with steel telescoping rails. It allowed the barrel and gas system to float freely. The redesigned SOPMOD M14 gas system pushed directly in line with the bolt roller and reduced barrel whip. This gas system has been patented by Mike Rock under RD Systems. The original USGI M14 barrel was replaced with a 1:11.27 twist five radial groove heavy pull button barrel. Barrel twist rate

is defined as how far the bullet must travel down the barrel before it has spun one revolution, e.g., 1:10 means a bullet will turn one revolution for every 10 " of barrel length. A faster twist rate is generally used to stabilize heavier and longer bullets in flight.

It was found through testing that acceptable accuracy could be maintained with as short a barrel as 11 " with this design but the noise level was excessive. All of this work was done by Mike Rock and Jim Ribordy working together at RD Systems. Jim Ribordy hand delivered the prototype SOPMOD M14 to Colonel Taylor at NSWC Crane, IN. Mike Rock's SOPMOD M14 was tested at Fort Campbell, KY by a U. S. Army 5th Special Forces Group soldier. It was also test fired by Colonel Taylor. The results were impressive. Initially, OPS, Inc. designed sound suppressors were used in concert with the SOPMOD M14. These SOPMOD M14 sound suppressors were manufactured by RD Systems. For whatever reasons, this design was not adopted for military use by NSWC Crane but it is available in the commercial market.

By no later than August 2003, NSWC Crane had decided on a design specification for the M14 EBR. In 2003, Smith Enterprise first built its prototype M14 Enhanced Battle Rifle (EBR) for consideration by the U. S. Navy. It was favorably received.

The M14 EBR is built on a USGI M14 receiver with enhancements including, but not limited to, a fully adjustable stock, a 18 " standard contour molybdenum-chromium alloy barrel and Smith Enterprise combination gas cylinder lock front sight, direct connect flash hider (SEI part number 2000V) and extended bolt lock (SEI part number 2003). The extended bolt lock allows the bolt to be released the same way as on M16 type rifles.

Springfield Armory, Inc. was awarded a contract to supply the machined and finished Mk 14 Mod 0 barrels to NSWC Crane. Wilson Arms supplied the barrel blanks to Springfield Armory, Inc. These standard contour 1:11 twist 18 " barrels were not chromium plated. The barrel gas port was drilled using a # 45 bit and the gas cylinder shoulder boss was moved forward about 0.62 " because of the lack of a gas system front band on the Mk 14 Mod 0. The M14 EBR weighed 11 pounds 10 ounces with a 22 " barrel but no optics or fore grip when evaluated by *Armed Forces Journal* at its February 2004 Shoot-out. The M14 EBR tested by *Armed Forces Journal* was equipped with the black color steel wire telescoping version of the Sage International M14 EBR stock.

In February 2005, the U. S. Navy's proposed funding for the M14 EBR (Mk 14 Mod 0 and Mk 14 Mod 1) purchases was as follows: FY 2008 - \$1,772,000 for 886 rifles, FY 2009 - \$1,782,000 for 886 rifles, FY 2010 - \$1,772,000 for 886 rifles and FY 2011 - \$1,772,000 for 886 rifles. The following year, the acquisition was scaled back dramatically. In February 2006, the U. S. Navy budgeted \$536,000 for 233 rifles in FY 2006 and \$553,000 for 233 rifles in FY 2007 for the newer variant, Mk 14 Mod 1. In 2005, Smith Enterprise, Inc. developed a barrel (SEI part number 2027) for evaluation by NSWC Crane for the M14 EBR project. This AISI 4140 alloy steel chromium plated standard contour barrel was 18 " in length, had a 1:10 twist and was chambered for the M118LR cartridge and was headspaced for USGI M14 receivers. Due to budgetary constraints, the SEI barrel was not adopted for the Mk 14 Mod 1. Smith Enterprise, Inc. is supplying parts to NSWC Crane, IN as requested in support of the M14 EBR project.

The M14 EBR built for the U. S. Navy SEALs was classified as the Mk 14 Mod 0. The U. S. Navy SEALs were able to field the Mk 14 Mod 0 by no later than the first half of 2005. The Mk M14 Mod 0 rifle is dressed in the lightweight gray color version of the Sage International EBR stock (see Folding and Telescoping Commercial Stocks). The U. S. Coast Guard requirement for the Mk 14 Mod 0 differs from the Navy version in that the direct connect flash hider is replaced with a Smith Enterprise, Inc. muzzle brake (SEI part 2001). The U. S. Coast Guard is more concerned with minimizing muzzle rise from use on a rolling deck than eliminating muzzle flash. The U. S. Coast Guard muzzle brake is marked U.S.C.G. SMITH ENT. As of July 2005, the U. S. Coast Guard was slated to receive 1000 or more Coast Guard versions of the Mk14 Mod 0. Sage International, Ltd. (Oscoda, MI) produces the fully adjustable black color steel wire telescoping M14 EBR stock for the U. S. military and civilian sales (see Folding and Telescoping Commercial Stocks).

M14SE, Mk14 SEI and M80 SDM

M14SE - The M14 rifle as a sniper weapon system has been successful but it has had its minor shortcomings. The M14 rifle is a sound and proven weapon but glass bedding, steel inserts, and gas system unitizing requires armorer support. The flash suppressor nut and setscrew arrangement affect barrel performance. Installing a sound suppressor to the USGI front sight housing is not the most rugged means of attachment. The USGI bolt lock can be difficult to manipulate with thick gloves. Ron Smith of Smith Enterprise, Inc. has examined the barrel-to-receiver interface, the optics, the barrel itself, the gas system, the flash suppressor and sound suppression of the M14. He has developed simple and reliable solutions to these nagging deficiencies while taking advantage of current technology. The result is the M14SE semi-automatic rifle system. This development work had been completed before 2004. Until mid-2006, the weapon was known as the M14SE Semi-Automatic Sniper System. At that point, the rifle system was billed as the M14SE Squad Designated Marksman (SDM) rifle without any component changes. Per U. S. Army doctrine, a 7.62x51 mm sniper rifle is capable of engaging targets out to 900 meters and a squad designated marksman rifle is intended for use against the enemy at distances to 600 meters.

In May 2004, the U. S. Army 2nd Infantry Division 2nd Brigade Combat Team was preparing to deploy from South Korea to Iraq. The U. S. Army had noted that many soldiers were making individual purchases of Smith Enterprise, Inc. scope mounts and scope rings for their issued M14 rifles. Major Kim Zimmerman from the 2nd Infantry Division approached Leupold & Stevens, Inc. to acquire some scopes, mounts and rings for twenty of the division's 110 M14 NM rifles in anticipation of pending deployment to Iraq. Leupold & Stevens, Inc. assisted Major Zimmerman in acquiring the requested parts but also made him aware of Smith Enterprise, Inc. and its capabilities.

Over the course of the following month, Major Zimmerman was in constant communication with Smith Enterprise, Inc. They discussed at length the needs of the 2nd Brigade Combat Team of the 2nd Infantry Division and what could be done with its M14 NM rifles to meet those needs. In general terms, the 2nd Brigade Combat Team was in

need of accurate, rapid fire, heavy fire power sniper rifles for engaging enemy targets at medium and long range distances. Major Zimmerman briefed the 2nd Infantry Division Commanding General, Major General George A. Higgins, on what Smith Enterprise, Inc. was able to do. Major General Higgins immediately saw the merit in converting the M14 NM rifles and gave quick approval. Major Zimmerman wrote the sole source contract and Major General Higgins awarded it to Smith Enterprise, Inc. in July 2004 without either officer having seen a M14SE rifle. Major General Higgins was able to award the contract because the M14SE is a proprietary shooting system and the M14 NM rifles are owned by, not on loan to, the 2nd Infantry Division. This is the first time that an entire U. S. Army unit has adopted a sound suppressed sniper weapon system.

At about the same time in May 2004, the U. S. Army was getting ready to release the requirements for the XM110 sniping system. The XM110 is a gas operated semi-automatic 7.62 x 51 mm caliber sniper rifle. Smith Enterprise, Inc. briefed the U. S. Army Director of Combat Development (Fort Benning, GA) on the M14SE. The Director of Combat Development was convinced that the XM110 requirements could be met by the M14SE and save the taxpayer money by converting an existing weapon. Rock Island Arsenal was also briefed and convinced of the merits of the M14SE. The Director of Combat Development and Rock Island Arsenal were both well aware of the 2nd Infantry Division's pursuit of the M14SE during all of this. In 2005, additional U. S. Army units had ordered conversion of M14 rifles to the M14SE configuration.

Smith Enterprise, Inc. received 110 M14 NM and XM21 rifles from the 2nd Infantry Division in late September 2004 by U. S. Air Force transport direct to Luke AFB from South Korea. These M14 NM rifles were in poor condition. The operating rods were coated in rust and dirt filled the rear sight pocket under the rear sight assemblies. There were broken elevation pinions, cracked wood stocks, and flash suppressor nut setscrews and gas cylinder plugs all chewed up. One wood stock broken in half was held together by a tent stake and tape. Nonetheless, the conversion project was completed per the contract. The M14SE rifles were picked up by the U. S. Air Force at Luke AFB and flown directly to Baghdad, Iraq. Optics for the 2nd Infantry Division M14SE rifles are Leupold & Stevens, Inc. variable 3.5-10X40 mm illuminated reticle or 1.5-5X20 mm illuminated reticle scopes. The combination gas cylinder lock front sights installed on the 2nd Infantry Division M14SE rifles are marked 2 I. D. on the top line and O. I. F. on the bottom line.

To convert the M14 into the M14SE the heart of the weapon (receiver, bolt and operating rod) is kept but everything else is changed out. Highlights of the M14SE configuration include the following modifications: 1) synthetic USGI stock without lugs or bedding 2) 22 " medium weight molybdenum-chromium alloy 1:10 twist four groove barrel chambered for M118LR ammunition 3) the receiver, new barrel and bolt are cryogenically treated 4) the gas cylinder, gas cylinder plug, and front band are nitrocarburized 5) gas system is unitized 6) gas piston is high density hard chromium plated 7) SEI MIL-STD-1913 scope mount and SEI 30 mm heavy duty tactical tall ring set 8) choice of Leupold & Stevens, Inc. rifle scope models 9) waterproof strap-on nylon cheek rest with polyvinyl chloride inserts 10) SEI M14DC direct connect flash hider 11) SEI dovetail or hooded

style nitrocarburized combination gas cylinder lock front sight 12) SEI extended bolt lock 13) tuned 4.5 pound pull firing mechanism 14) SEI wire electro-discharge machined from bar stock rear sight assemblies and 15) manganese phosphate coating to military specification. The selector shaft on the M14SE rifle is inoperable rendering it semi-automatic fire only.

Each M14SE is carefully assembled and lubricated with MD Labs XF7 weapons lubricant. Optional accessories include: 1) 18 " M14SE medium weight barrel 2) adjustable firing mechanism 3) M1907 leather or synthetic sling 4) quick detaching sound suppressor 5) angle cosine indicator and mount 6) model GLFS-T combination gas cylinder lock dovetail style front sight with tritium insert 7) magazine pouch 8) nylon suppressor and tool pouch and 9) AN/PVS-22 scope mount.

The tactical tall heavy duty rings are used to keep the combination gas cylinder lock front sight from obscuring the shooter's view through the scope. The barrel for the M14SE was started with the June 1981 U. S. Army Armament Research Development and Engineering Center (Dover, NJ) drawing 9345206. This is the blueprint for the medium weight contour M14 National Match barrel. However, Smith Enterprise, Inc. has improved upon this barrel by giving it a 1:10 twist instead of 1:12 and chambering it for the M118LR cartridge. M80, M852 and M118LR ammunition all shoots well from this barrel.

The first batch of M14SE barrels were stamped WA 9345206 9/04. Beginning in May 2005, the 18" long M14SE medium weight barrel became available. On September 28, 2005, Smith Enterprise, Inc. successfully concluded its M14SE system contract with the U. S. Army 2nd Infantry Division.

M14SE Phase II – Several enhancements to the M14SE and Mk 14 SEI systems were implemented in the spring of 2005. USGI contract trigger and hammer pins made in the 1960s were heat treated to a hardness in the low 40s HRC. With extended use, these pins will wear into an oblong shape causing noticeably inconsistent hammer and trigger operation. Consequently, all M14SE and Mk 14 SEI rifles are now fitted with Smith Enterprise, Inc. proprietary S-7 alloy steel trigger and hammer pins hardened to 52 to 55 HRC. The result is a lifetime of use and consistent firing mechanism performance. The M14SE barrel gas ports were slightly enlarged as further assurance that all types of 7.62x51 mm ammunition will work with the direct connect sound suppressor under all weather conditions. The USGI M14 connector lock was replaced with a Smith Enterprise, Inc. proprietary design unit made from a special tool steel. The USGI operating rod and hammer springs are replaced with SEI designed chromium silicon springs. The operating rod guides are sized perfectly to the M14SE and Mk 14 SEI barrels. The Smith Enterprise, Inc. 7 " long scope mount (see Side Three Point Scope Mounts), steel bipod (SEI part number 2033) and optical upgrades were offered as well.

In June 2006, Smith Enterprise began work on another M14SE contract. Twenty-six worn out USGI M14 rifles were rejuvenated and sent back the following month as M14SE SDM models to the U. S. Army 502nd Infantry Regiment 101st Airborne Division in Iraq. Each 101st Airborne Division M14SE rifles was assembled with a Krieger M14 DMR

medium weight stainless steel match grade barrel, SEI Tri Rail MIL-STD-1913 scope mount, Leupold & Stevens, Inc. Mark 4 3.5-10X40 mm illuminated reticle scopes, SEI quick detaching MIL-STD-1913 bipod, and an advanced version M14DC sound suppressor. The Krieger M14 DMR barrels were used because the M14SE medium weight molybdenum-chromium alloy steel barrels were temporarily unavailable during the short turnaround time requirement of this build project.

In September 2006, the SEI AN/PVS-22 scope mount was made available for law enforcement, foreign military and U. S. government sales (part number 2002). The AN/PVS-22 scope is a third generation night vision sight designed for ease of use in the field. It was designed and developed by Optical Systems Technology, Inc. in 1996. The SEI AN/PVS-22 scope mount is unique in that it is of a cantilever design. It attaches at one point at the front of a MIL-STD-1913 Picatinny rail side three point scope mount. The SEI AN/PVS-22 scope mount is manufactured by the wire EDM method from AISI 4140 molybdenum-chromium alloy steel. It is nitrocarburized to 60 HRC. The advantage of this design is keeping the scope mount for a night vision optic from touching the barrel.

M14 SEI - In 2004, Smith Enterprise, Inc. converted a number of M14 rifles into the M14SE system for U. S. Air Force pararescue teams. The modified M14SE rifles made for the U. S. Air Force pararescue teams were assembled with the Sage International, Ltd. M14 EBR stock in lieu of the USGI M14 synthetic stock. The top rail of the Sage International, Ltd. M14 EBR stock had to be modified for installation of the Smith Enterprise, Inc. scope mount as part of the work to build the Mk 14 SEI rifles. The U. S. Air Force rifles were fitted with 18 " medium weight M14SE barrels chambered for the M118LR cartridge. The selector switch was left operable. This M14 derivative is known as the Mk 14 SEI.

The chromium plated 18 " barrel mentioned above is an option for the Mk 14 SEI system (see USGI M14 Rack Grade Barrels). The U. S. Air Force pararescue teams reported successful engagement of targets out to 900 yards with Mk 14 SEI systems fitted with Leupold & Stevens, Inc. 3.5-10x40 mm illuminated reticle scopes. In the summer of 2005, the U. S. Air Force contracted with Smith Enterprise, Inc. to convert 100 M14 rifles into Mk 14 SEI systems. Like the M14SE, the Mk 14 SEI was designed to fill the U. S. Army requirement for the XM110 semi-automatic sniper system.

Smith Enterprise, Inc. (SEI) converted two U. S. Army 10th Special Forces Group Chinese select fire M14 rifles converted during the fall of 2004 to Mk 14 SEI rifles. The Chinese M14 chu wood stocks with selector cutouts were replaced with Sage International, Ltd. M14 EBR stocks. These two Chinese select fire M14 rifles are not registered under the National Firearms Act since that law does not apply to military property. The only marking, M14, was stamped on the heel of each Chinese select fire receiver. The selector switch was left operable on these two Chinese M14 rifles when returned to the U. S. Army 10th Special Forces Group.

M80 SDM - Smith Enterprise, Inc. developed the M80 SDM in 2006 for the U. S. Army. This was a M14SE rifle outfitted with a slightly shorter barrel, a shorter length-of-pull stock and a Leupold & Stevens, Inc. moderate variable power scope.

Semi-automatic Only USGI M14 Rifles

Three semi-automatic only M14 receivers were manufactured at the Springfield Armory in 1962. Two of the receivers were assembled into complete rifles. These semi-automatic only rifles differed from the standard M14 in the following manner: 1) no selector lug or operating rod rail cuts for the connector 2) M1 Garand design operating rod dismount notch 3) no stock selector cutout 4) M1 Garand butt plate on the stock 5) no spindle valve in the gas cylinder 6) no connector-tripping notch in the operating rod 6) M1 Garand sear installed in the firing mechanism 7) ten round magazine in lieu of a twenty round magazine. These semi-automatic M14 receivers were numbered X500, X501 and X502. X500 remained at Springfield Armory as a bare receiver for the time being. Receivers X501 and X502 were assembled into complete rifles. These two rifles were examined by the Chief of Army Field Forces, the Director of Civilian Marksmanship and the Department of Treasury. The Department of Treasury concluded that these rifles were suitable for sales to civilians. Major General Nelson M. Lynde, Chief of Army Field Forces, decided that these modifications deviated too far from the original design. These semi-automatic M14 rifles could not be converted back to the issue rifle in the event of a national emergency. Thus, the project was abandoned. Disposition of these three receivers is unknown though M14 serial number X502 was observed at Camp Perry in the 1960s.

Hahn Machine Company and Pearl Manufacturing

In the 1990s Hahn Machine Company (St. Charles, MO) legally manufactured semi-automatic only M14 rifles by cutting and welding pieces from scrapped USGI M14 receivers. This was done according to a letter of approval signed by then BATF Chief, Firearms Technology Branch, Edward M. Owen, Jr. dated June 8, 1994. The letter was addressed to Mr. Lloyd Hahn of the Hahn Machine Company in St. Charles, MO. It was the BATF response to Mr. Hahn's May 11, 1994 submission of a modified USGI TRW M14 receiver for a BATF ruling on the assembly of a semi-automatic only USGI M14 receiver. The approval letter granted permission to manufacture semi-automatic only M14 receivers from "properly destroyed" USGI M14 receivers. The destruction procedure first required a specific torch cut procedure on the receiver followed by removal of the selector lug and weld fill in of the operating rod rail cuts. After these steps were completed, the pieces of receiver scrap could be welded into one piece. The letter also required Hahn Machine Company to permanently engrave the company name, city and state on the receiver. A second letter from the BATF dated March 22, 1995 and signed by Technical Section ATF Specialist Naomi L. Rubarts was the cover document for an approved Application for Registration for Tax-Free Transactions as a manufacturer.

The following is presented strictly for providing the reader with a historical perspective regarding civilian ownership of M14 type rifles in the United States. The June 8, 1994 BATF letter to Lloyd Hahn was consistent with a previous letter mailed to Martin Pearl of Grants, New Mexico dated August 21, 1980. In the letter to Mr. Pearl, Edward M. Owen, Jr. stated that the "manufacturing of firearms from properly destroyed (demilitarized) firearm receivers is an acceptable practice" as long as "the first stage of your manufacturing process be the removal of the selector pivot housing" and this

“modification will remove the new receivers from the provision of the National Firearms Act.” As an aside, Martin Pearl (SOT/FFL Pearl Manufacturing) went on to register and convert thirty-two Maadi AKM and two Valmet M78 rifles to select fire capability. He did these conversions for the 1984 film classic, *Red Dawn*.

Warning: Since the mid-to-late 1990s, the Bureau of Alcohol, Tobacco, Firearms (and Explosives) has not interpreted 26 U. S. Code 5845 (b) to allow welding of USGI M14 receiver halves back together even if all select fire features are removed. The BATFE considers such activity as manufacturing of a machine gun. The reader is strongly encouraged to NOT attempt any restoration of demilitarized USGI M14 receivers. Machine gun manufacture by a private individual in the United States is a felony and the offender is subject to severe criminal penalties.

The receivers were heat treated after all welding operations had been completed. The quality of the welding on Hahn Machine receivers is reputed to be very good. The number of Hahn Machine welded semi-automatic M14 receivers is unknown but is thought to be in the hundreds. Among the number of M14 rifles reconstructed by Hahn Machine Company are some of the receivers destroyed by Rock Island Arsenal in 1970 at Loyola University. A very few of these receivers had been marked by the military as XM21 and at least one was a T44 receiver.

U. S. Civilian Ownership of Select Fire USGI and Chinese M14 Rifles

There are several hundred National Firearms Act (NFA) registered USGI select fire M14 rifles (including legally welded USGI receivers) in the United States according to an ATF Agent who conducted an audit of the NFA Registry. The Agent conducted the audit with the specific purpose of determining the number of USGI M14 rifles in the Registry. Most of the NFA Registered select fire M14 receivers have been welded back together. Welded USGI M14 receivers were registered under the National Firearms Act by approved ATF Form.

There were likely a few uncut USGI M14 rifles among the tens of thousands of machine guns registered when the National Firearms Act was revised in 1968. The NFA amnesty period ran from November 02, 1968 to December 01, 1968. It may have been one of these amnesty registered M14 rifles that was advertised in the August 01, 1975 issue of *Shotgun News*. The ad was placed by a William M. Douglas. The ad stated that he had an original Harrington & Richardson Arms M14 rifle for trade.

In late 1985 or early 1986, Harrington & Richardson registered a group of twenty-five to thirty, possibly more, Harrington & Richardson M14 rifles and a handful of the Harrington & Richardson .22 LR caliber M14 Simulator rifles with the BATF. These M14 rifles had never left the factory and were registered in time to become legal for civilian possession before the 1986 McClure-Volkmer Firearms Owner Protection Act ended any further legal registration of automatic capable firearms for civilian purchase. They were auctioned off when Harrington & Richardson went out of business.

One of the soon-to-be auctioned M14 rifles, serial number 87156, was transferred by Harrington & Richardson Arms Co. to Qualified Manufacturing (Broken Arrow, OK) on November 02, 1985 by approved ATF Form 2. Qualified Manufacturing was a Class 2

FFL/SOT firearms manufacturing business reportedly owned by Richard Parker. Qualified Manufacturing submitted an ATF Form 2 to return M14 serial number 87156 to Harrington & Richardson on November 14, 1985. The BATF approved the Form 2 on December 05, 1985. Based on this sequence of events, the Harrington & Richardson Arms Co. auction likely occurred soon after December 05, 1985. Robert J. Perry purchased these H&R M14 and M14 Simulator rifles in April 1990 from the anonymous winning bidder of the Harrington & Richardson auction. Subsequent to the passing of Mr. Perry, these have been sold to other individuals.

Most of the Harrington & Richardson M14 rifles were test models, experimental Guerilla Gun M14 models or machined receivers that had never been heat treated. Some had no scope mount boss and threaded bolt hole on the left hand side while others were barreled actions or only partially assembled. A few were standard issue M14 rifles with production serial numbers such as 87156 and 1545579. Most of the rifles had hand stamped experimental or test model numbers, e.g., R14. A number of these M14 rifles were assembled with T44E6 parts and some had the rear sight pocket knob holes milled off while others lacked the U S RIFLE M14 marking on the heel. The Harrington & Richardson M14 rifles that required it were heat treated at FPM Heat Treating (Chicago, IL). This collection of Harrington & Richardson M14 rifles was then phosphate coated and assembled into new M14 rifles with standard USGI M14 parts. Parts were cannibalized from all of the .22 LR caliber select fire rifles to create three complete .22 LR caliber M14 Simulator models. The phosphate coating and rebuilding of the Harrington & Richardson rifles was done under the supervision of Robert J. Perry and an associate who wishes to remain anonymous.

The U. S. Department of Energy obtained some USGI M14 rifles prior to May 1986. These USGI M14 rifles were released for sale in the mid to late 1990s to the public by the U. S. Department of Energy (DOE). These USGI M14 rifles were obtained and subsequently sold by Class 3 SOT / FFL businessman F. Charles Logan (Warrendale, PA) (see Firearms Laws in The United States). The number of DOE M14 rifles released for sale has been reported as fifteen by a very credible source. Many of these DOE M14 rifles have the symbol # and a number etched on the left side of the receiver above the stock line. These are DOE assigned numbers. A second very credible source has observed one DOE M14 rifle etched with # 29. Another five of these DOE M14 rifles are etched with the following: # 8, # 10, # 19, # 21 and # 34. At least one of these DOE M14 rifles is not etched with a number on the receiver.

The following FFL/SOT businesses legally welded pieces of scrap to create USGI M14 receivers and registered them in time to remain transferable: Bill Fleming (Collinsville, OK), H&R Gun Co. (Holland, OH), John Norrell Arms, Inc. (Little Rock, AR), Neal Smith (Smith Firearms in Mentor, OH), Specialty Arms (Springfield, OH) and the late Bruce Swalwell (Metro Tech, Ltd. of McHenry, IL).

One M14 receiver legally welded together by Bruce Swalwell was engraved M Tech McHenry ILL. Mr. Swalwell also worked for Neal Smith before 1986. Reportedly, Bill Fleming registered about fifty welded USGI select fire M14 receivers. H&R Gun Co. M14 type rifle serial number 0556 is a select fire USGI M14 receiver rifle. It was originally

registered with the BATF by an approved NFA Form before the May 1986 ban. On March 31, 2003 this rifle sported a USGI birch stock, USGI M2 bipod, 18 " barrel and lugless flash suppressor. It was quickly sold by Elite Firearms (Boaz, KY).

Post-'86 dealer samples - A small number of Chinese Norinco select fire M14 rifles were imported between 1990 and 1992 into the United States as post-'86 dealer samples for sale to law enforcement agencies. Serial numbers for three NFA registered post-'86 ban dealer sample Norinco select fire M14 rifles are as follows: 620035XX, 620401XX and 640026XX. Additionally, at least one USGI M14 has been imported back into the United States legally after May 1986 as a dealer sample. Dennys Guns (North Kansas City, MO) imported Harrington & Richardson Arms Co. M14 serial number 9970XX.

Ignore the Petition to Sell the M14!

Ignore any petition regarding public sales of M14 rifles. Orest Michaels, Chief Operating Officer for the U. S. Civilian Marksmanship Program (CMP), stated in a June 17, 2003 e-mail message to a member of the Internet discussion board www.battlerifles.com: that 1) the U. S. Army has no surplus M14 rifles to sell 2) no M14 rifles are being destroyed and none have been destroyed for almost ten years 3) CMP may not want to or may not be allowed to get involved if such a program existed anyway because the M14 is considered a machine gun. A petition to this effect occasionally surfaces in various e-mail messages and Internet discussion groups, but is filled with outdated information.

The 1996 Fiscal Year National Defense Authorization Act changed the legal status of the Civilian Marksmanship Program and the Office of Director of Civilian Marksmanship. On October 01, 1996, these entities were given non-profit corporate status by statute, and ceased to be a part of the U. S. government. Until then, the CMP was a part of the U. S. Department of the Army.

Select Fire M14 Rifle Rate of Fire Modification

John C. Garand designed a rate reducer for the T20E2 rifle between 1948 and 1950. He modified the T20E2 rate reducer in 1953 for the T44E1 rifle. The T44E1 rate reducer slowed the automatic rate of fire from 735 rpm to 550 rpm. This device was inside the trigger housing. It acted to slow the speed of the hammer. An electronic rate of fire controller made by the Pinderton Company was used on the T20E2 and T44 rifles in 1951. A rate reducer for the M15 rifle was also tested but eliminated. Tests showed comparable accuracy at both rates of fire in automatic.

During the Viet Nam War, American soldiers experimented with different means of changing the rate of fire of a M14 rifle in automatic. Soldiers in Viet Nam developed modifications which could make the M14 fire at either rate of 550 or 1100 rounds per minute. By milling a 0.060 " wide and deep channel along the top of the cylindrical portion of the gas piston the rate of fire was slowed to 550 rounds per minute. The rate of fire in a select fire M14 can be further reduced to about 500 rounds per minute by drilling a hole in the center of the gas cylinder. The drill bit size used for this is 0.0400 ". With use, this hole will enlarge due to gas erosion.

Part 1 Notes

1. Culver Shooting Page Lane's Tips www.jouster.com/lanestips Gus Fisher's FAQ discussion of USGI M14 receivers and parts. Gus Fisher, a former, USMC shooting team armorer for two years, states he was told by a very trustworthy source that TRW receivers were good for 450,000 rounds whereas the other USGI receivers lasted about 400,000 rounds.
2. Stevens, R. Blake. "*U. S. Rifle M14 From John Garand to the M21.*" p. 225.
3. Photobetty. "Before You – Dickey Chapelle."
4. Poyer, Joe. *The M-14 Type Rifle A Sporter's and Collector's Guide.* North Cape Publications: Tustin, CA, 1997. p. 10.
5. Duff, Scott A. and CWO John M. Miller. p. 12 and Iannamico, Frank. *The Last Steel Warrior U.S. M14 Rifle.* Moose Lake Publishing: Henderson, NV, 2005. p. 193.
6. Harrison, E. H. "The M14 National Match Rifle." *American Rifleman* May 1966. p. 48.
7. Poyer, Joe. p. 10. and Stevens, R. Blake. p. 337.
8. Stevens, R. Blake. p. 337.
9. Poyer, Joe. p. 10.

Part 2

The Commercial M14

U. S. Commercial Production of the M14 Type Rifle

Commercial production of the M14 type rifle began by 1971 and continues to the present day. The following list is not complete but based on observation of serial numbers, U. S. commercial manufacturers have produced at least this many M14 type receivers as listed in the table below. Note that some manufacturers (Armscorp of America, Maunz Match Rifle, Smith Enterprise, Inc., and Springfield Armory, Inc.) have issued custom serial numbers to receivers. Custom serial numbers are not accounted for in this table.

Table 8: Production of Commercial M14 Rifles

U. S. Company Name on the Finished Receiver	City and State	Receiver Model Marking	Highest Serial Number Observed and Comments
A. R. Sales Co.	South El Monte, CA	Mark IV	225 receivers were produced (200 in the serial number range 1 to 225 and 25 in the range 226 to 250)
Armscorp of America, Inc. and Armscorp USA, Inc.	Silver Spring, MD Baltimore, MD	M14, M14 NM, M21, XM25	17,396 (some serial numbers are preceded by A or S) + 25 (WTA series prefix made for West Texas Armory)
Entreprise Arms	Irwindale, CA	M14A2	1119 (serial numbers are preceded by E, EA or ABNI)
Federal Ordnance	El Monte, CA	M14, M14A, M14SA, CM14SA	60,308 + 581 (C series prefix serial numbers made for Century Arms International)
Fulton Armory	Savage, MD	M14, M14 NM, M21, XM25	550 (serial numbers began at FA00000) + 50 (WR serial numbers start at 000)
Hesse	CT?		2
H&R Gun Co. (Smith Manufacturing)	Holland, OH	Semi-Auto 7.62MM- M14	1128
LRB Arms (LRB of Long Island, Inc.)	Bellerose, NY and Floral Park, NY	M14SA, M25	71 (M14SA serial numbers less than 01201) + 524 (M14SA serial numbers 01201 and higher) + 3 (M25 serial numbers 10001 and higher)
Maunz Match Rifle (Smith Manufacturing)	Holland, OH	MODEL 77, MODEL 87	41 (MODEL 77 serial numbers are four digits) + 50 (ASU serial numbers are five digits starting at 00010)

Maunz Manufacturing, Inc.	Toledo, OH	U. S. RIFLE	1011 + 10 (EX series have one or two digit serial numbers)
National Ordnance, Inc.	South El Monte, CA	?	2
Sarco, Inc.	Stirling, NJ	M21	2
Smith Enterprise, Inc.	Mesa, AZ Tempe, AZ	M-14, M-14 NM, M-21	more than 176 (select fire pre-'86 FA series) + 2,580 (pre-'94 ban) + 80 to 85 (post-'94 ban serial numbers starting at 5000) + 1 (M-21)
Smith, Ltd. (Smith Manufacturing)	Holland, OH	M-14	237 (serial numbers are four digits) + 5 (EX series have one digit serial numbers)
Springfield Armory, Inc.	San Antonio, TX Devine, TX Geneseo, IL	M1A, M-1A	186793 (serial numbers are six digits, see Appendix A for comment on 2300XX) + 200 (SM series) + 227 (IDF series) + 304 (WF series) + 500 (VME series)

A batch of fifty to 100 investment cast AISI 8620 alloy steel 80 % semi-automatic receivers were made between 1972 and 1975 but had not been finish machined as of November 2004. These receivers are marked as follows on the receiver heel

M W G ASSAULT-1 BARBERTON OH.

The serial number is on the left side of the receiver at the rear. The letters M W G are located on the flat surface just behind the rear sight. The letters M W G were cast into the receiver.

Characteristics of Commercial Receivers

Cast receivers - A. R. Sales Co., some Armscorp of America, Armscorp USA, Federal Ordnance, Hesse, H&R Gun Co., Maunz Match Rifle, Maunz Mfg., some Smith Enterprise, Smith, Ltd. and Springfield Armory, Inc. receivers are made by the investment casting method. Investment casting has existed in China for centuries. However, it did not gain industrial significance until after World War II with the demand for aircraft and aerospace parts. Investment casting allows complex shapes and thin sections to be formed with very close dimensional tolerances. It is common practice for the rifle manufacturer to design and own the casting die for the receiver. Any repairs or modifications to the receiver die are normally the responsibility of the owner.

Billet machined and forged receivers - Enterprise Arms and some Armscorp of America and Smith Enterprise receivers are machined from raw billet. Information on how Sarco M21 receivers were manufactured has not been available to date. Chinese and LRB Arms receivers are drop forged. The rifle manufacturer, typically, owns the receiver forging dies and is responsible for any maintenance on the dies.

Receiver Barrel Ring - Chinese, LRB Arms, Fulton Armory and some Springfield Armory, Inc. receivers have a distinct machined flat surface with a longitudinal edge on the top of

the barrel ring. At some point after the first 3000 Springfield Armory, Inc. M1A receivers, the presence of this flat surface on the top of the barrel ring is found sporadically until a serial number just above 030000. The flat surface on the barrel ring is present on serial numbers 0062XX, 00623X, 00724X and 01899X but is not on 015XXX, 020XXX, 0210XX and 0301XX.

Caliber Marking - Springfield Armory, Inc. used upper case letters MM as part of the 7.62-MM caliber receiver marking until at least serial number 000326. At some point between serial numbers 000326 and 000527, Springfield Armory, Inc. changed the abbreviation for millimeter to a lower case mm on its receivers. Springfield Armory, Inc. used to include the stamping 7.62-mm or 7.62mm as part of the receiver marking. The 7.62-mm marking is the more common of the two. Additionally, where the caliber is indicated as 7.62mm (no hyphen) the model number is stamped as M-1A (with hyphen) instead of the usual M1A model number. Receiver serial numbers are 616XX and 66857 are stamped with 7.62mm (no hyphen) and M-1A (with hyphen).

The 7.62 millimeter caliber markings began with serial number 000001 and remained as part of the heel stamping until at least serial number 0630XX. By serial number 063112 the caliber marking no longer appears on M1A receivers. Thus, in March 1991 the 7.62-mm and 7.62mm markings were dropped because Springfield Armory, Inc. was producing the M1A in different calibers, e.g., 7mm-08 (see Other Calibers).

Millimeter is stamped with an upper case MM on Armscorp of America, Armscorp USA, Enterprise Arms, Fulton Armory, LRB Arms, Smith, Ltd., Smith Enterprise, and some imported Poly Technologies receivers. On most Chinese M14 type rifles imported into the United States the caliber is typically denoted .308 but will be indicated on the barrel if not on the receiver. A Poly Technologies M14/S rifle, serial number 0653, has been observed with the receiver heel caliber stamping 7.62 NATO.

Receiver Scope Mount Horizontal Groove and Bolt Hole - Some commercial receivers have horizontal grooves too shallow and narrow to accommodate military specification side three point scope mounts, e.g., Brookfield Precision Tool and Sadlak Industries. The USGI drawing specification for the horizontal groove is 0.149 " wide at the top of the groove with a sixty degree angle from the bottom of the groove. Commercial receiver horizontal grooves can measure as narrow as 0.120 " at the top of the groove. Early production Smith Enterprise, Inc. receiver scope mount bolt holes were made with a pitch of twenty-four threads per inch. This is the only known exception for M14 type receivers which otherwise accept a Number 12 - 32 NEF thread screw.

Commercial Receiver Geometry

The commercial semi-automatic M14 type receivers have no selector lug, no operating rod rail center dismount notch, and no groove on the front underside of the operating rod rail. The dismount notch for the operating rod is located at the rear end of the operating rod rail on all U. S. and semi-automatic Chinese commercial receivers. Springfield Armory, Inc. and Smith Enterprise, Inc. select fire receivers have both the rear and center operating rod dismount notches as well as the cut on the under side of the forward end of the operating rod rail. If a receiver is USGI manufacture or Chinese made select fire

capable, it will not have this rear dismount notch.

Many of the U. S. commercial receivers (Springfield Armory, Inc., Armscorp USA, Fulton Armory, etc.) have operating rod rails wider than the USGI specification. Operating rod rail width has been measured on Armscorp receivers as follows: 1) serial number 10451 manufactured in April 1993 – 0.232 " 2) serial number 15906 manufactured in January 2000 – 0.258 " 3) serial numbers 17011 and 17013 both manufactured in July 2003 – 0.316 ". The Armscorp USA receiver operating rod rail is also machined differently from USGI specification to prevent the bolt roller from slamming back. Current production Armscorp USA receiver operating rod rail channels are deliberately undersized to accept operating rods with worn tabs, because new USGI operating rods ones are scarce.

The Fulton Armory receiver operating rod rail measures about 0.140 " wider than the USGI receiver operating rod rail specification (0.130 " – 0.01 "). Canadian import Norinco receiver operating rod rails are approximately 2 mm wider than the USGI drawing specification. The select fire Springfield Armory, Inc. receiver operating rod rail is 1/8 " wide while its semi-automatic receivers are made with one 3/16 " or 13/64 " wide. Melvin Smith increased the M1A operating rod rail width by 0.066 " to achieve the same strength as the USGI M14 receiver. Additionally, the wider operating rod rail provides more bedding surface and complicates conversion to select fire.

Semi-automatic M14 type receivers will not have the selector lug and operating rod rail machining cuts. Springfield Armory, Inc. M25 and some Norinco M305 receivers do not have the scope mount boss on the left side. Armscorp USA, Smith Enterprise, Springfield Armory, Inc. and Enterprise Arms also make rear lugged and double lugged receivers for competition shooting. The receiver lug or lugs are welded on to the receiver. Fulton Armory offers rear lugged receivers. Springfield Armory, Inc. has offered a rear lugged receiver since 1989 and LRB Arms has done so since 2003. Smith Enterprise has added lugs to receivers upon customer request since at least 1991. Receiver lugs are welded on with two known exceptions. About 1985 or 1986, Smith Manufacturing produced rear lugged receivers from castings for Armscorp of America. Karl Maunz designed and marketed a bolted receiver front lug in 1986 (see Karl Maunz).

Manufacturing Difficulty and Forgiveness – Even though the M14 receiver is essentially an updated 1936 design, it is not easily machined into final form. As of 2005, a five axis CNC machining center was still not capable of performing all of the cuts necessary to bring the receiver to final form. Some cuts still require manual manipulation of a cutting tool to complete the form to blueprint specification. However, it is a very forgiving design in that many of the machining cuts are purely cosmetic. For example, the top edge contour from the rear sight pocket to the barrel ring, the relief cut above the bolt lock, the barrel ring top center and left hand corner, and the heel corner symmetry on commercial receivers are often not identical to USGI receivers but accuracy and function are not affected in the least.

Comparison of USGI and Springfield Armory, Inc. Select Fire Receivers - There are six minor differences between the commercial Springfield Armory, Inc. select fire receiver and a USGI receiver: 1) the commercial receiver has a rear dismount notch 2) receiver heel stampings reflect either USGI contractor or the commercial Springfield Armory, Inc.

manufacture 3) the USGI receiver has a drawing number, 7790189, stamped underneath the operating rod rail forward of the center dismount notch 4) the USGI receiver has a machining fixture alignment hole in the right receiver leg 5) the commercial receiver selector lug is neatly welded on and 6) some, if not all, factory Springfield Armory, Inc. receivers have a small hemisphere machined on the outboard side of the receiver rear sight pocket right ear. Otherwise, they look the same. An examination of both select fire receivers under the heel, rear sight base and stripper clip guide show almost identical underside machining cuts.

Presently, only Armscorp USA, Inc., Enterprise Arms, LRB of Long Island, Inc. and Springfield Armory, Inc. are producing M14 type receivers in the United States. Smith Enterprise, Inc. has definite plans to manufacture M14 type receivers in the future.

U. S. Commercial Manufacture Select Fire M14 Type Rifles

Civilians may own select fire M14 type rifles in the United States of America as long as federal, state and local laws are complied with. However, the May 19, 1986 McClure-Volkmer Firearms Owners Protection Act ceased new production of select fire M14 type rifles allowed for civilian possession under the registration provisions of the 1934 National Firearms Act. Converted and new commercial manufacture receivers were registered under the National Firearms Act by approved ATF Form.

Since 1971, U. S. commercial manufacturers have produced more than 273,000 M14 type rifles but less than one percent of them are select fire capable. Springfield Armory, Inc. (Geneseo, IL) produced 125 select fire M1A rifles (catalog number MA9801) between the late 1970s and May 1986. The highest serial numbers observed for Springfield Armory, Inc. National Firearms Act registered select fire M1A rifles are 038503, 038767 and 038770. These rifles were built at the Geneseo, IL factory in 1986. A few more than 176 Smith Enterprise select fire M-14 rifles were produced before May 19, 1986.

A number of Springfield Armory, Inc. M1A rifles made by the Texas company have been identified as NFA registered select fire conversion models. M1A rifle serial numbers 000908 and 001691 are NFA Registered. As early as May 1974, Class 2 FFL/SOT Fred L. Rexer, Jr. (Houston, TX) was converting M1A rifles to select fire capability. He offered his conversions in a standard M14 wood stock for \$365.00 or dressed in a M14E2 stock for \$415.00. The Rexer conversions are denoted by the letters FAKTS on the left side of the receiver. At least one Texas M1A was converted by Federal Firearms Licensee Stan Andrews. In early 1975, Class 2 FFL/SOT Rich Davis (Salem, VA) sold select fire conversions of the Springfield Armory, Inc. M1A for \$550.00.

A number of Illinois M1A rifles were converted to select fire after they left the factory and registered under the National Firearms Act. Rock Island Armory (Geneseo, IL), the late J. D. Farmer of Hard Times Armory (GA), and Federal Firearms Licensees Charles Erb, Martin Pearl and Neal Smith were businesses who legally performed such work. For example, Hard Times Armory was the manufacturer who converted M1A serial number 014748 to select fire. Rock Island Armory converted thirty-five M1A rifles to select fire capability before May 1986.

Camp Perry Military Reservation

Camp Perry Military Reservation is a 640 acre Ohio National Guard marksmanship training center. It is the largest small arms firing range in the world. Camp Perry is located on the shore of Lake Erie about eighty miles west of Cleveland, OH. Since 1907, military and civilian shooters have participated in the National Rifle Association and National Board for the Promotion of Rifle Practice / Civilian Marksmanship Program (CMP) national matches conducted each summer. Collectively, these are known as the "National Matches." The M14 M and M14 NM were first shot at Camp Perry at the 1963 National Rifle Matches. The M14 NM was first used in competition at Camp Perry during the National Matches held August 16th to August 30th, 1964. The M14 NM rifle used in the National Matches by the U. S. Marine Corps as late as 1996. Since then, it has been replaced by the M16 style rifle for competition at Camp Perry.

John C. Garand retired in April 1953 from Springfield Armory. He did some consulting work for Mathewson Tool Company in 1954 on the T44E4 rifle, test version of the M14. He visited the National Matches at Camp Perry every summer with 1961 being his last trip there. As part of his annual visit to Camp Perry, Mr. Garand visited the TRW test facilities in the summer of 1961 at the adjacent Erie Ordnance Depot while developmental work was being done on the M14 NM. TRW occupied four brick buildings at the Erie Ordnance Depot. The U. S. Coast Guard had office spaces in one of these buildings in February 2005. In the early 1960s, Erie Ordnance Depot warehoused hundreds of thousands of M1 Garand and M14 rifles.

As an aside, at the Camp Perry National Matches, TRW assembled and exhibited a display board 4 feet by 8 feet in size displaying all of the M14 rifle parts with many of them in various stages of manufacture. The raw forgings of the eleven TRW manufactured M14 parts were displayed on the board. This included a semi-finished receiver. The rear sight knob components were shown individually and in assembled condition. The display board also had two TRW M14 barrels of which one barrel had been cut in two places along the length to show the chamber and bore rifling. This TRW display board was sold at a gun show in March 1972.

From 1960 until at least 1968, men such as Elmer Ballance, Karl Maunz, and Richard Smith participated in the shooting competition at Camp Perry. Melvin Smith was at Camp Perry each year during this period selling welded M1 Garand receivers and parts to civilian competition shooters. From the early 1960s until 1974, civilian competitors used the M1 Garand rifle and military shooters were equipped with the M14 rifle. Before 1960 until some time in the mid-1970s as many as 3,500 civilians competing at Camp Perry each summer were housed in hundreds of four man wood huts. The wood huts had originally been built to house Prisoners-of-War during World War II. In the 1960s, they were labeled with automobile license plates to assist the residents in locating their assigned huts. Most of these wood huts were torn down a long time ago but a few dozen still remain in February 2005. These wood huts were approximately 16 feet square. In the 1960s, each hut had four single military bunk beds and a wall-mounted rifle rack for the occupants.

From about 1970 until 1986, civilian competitors traded M14 rifle parts amongst

themselves from these wood huts and from their automobiles. This practice was known as “tailgating.” Karl Maunz started an informal association of competition shooters in 1984 in Atlanta, GA known as the American Shooters Union. The American Shooters Union had set up a place to buy, sell, and trade M14 parts in 1985 amongst the Commercial Row at Camp Perry. Camp Perry officials put a halt to tailgating as of 1986. In response, Karl Maunz and other members of the American Shooters Union opened a firearm parts and accessories store known as Uncle Sam’s. The store was located at 4484 W. Lakeshore Port Clinton, OH, directly across the highway from the entrance to Camp Perry. In the summer of 1986, Uncle Sam’s sold used M14 parts and other firearms related items. From their 1986 catalog, some of the M14 parts prices are as follows: complete bolt \$35.00, stripped bolt \$25.00, barrel \$75.00, flash suppressor \$15.00, gas cylinder \$15.00, operating rod \$30.00, fiberglass stock \$10.00, complete rear sight assembly \$15.00, complete USGI M14 parts kit \$239.95, Accuracy Lug \$39.95, and Maunz Mfg. receivers for \$239.95.

Springfield Armory, Inc.

Springfield Armory, Inc. is the oldest and largest commercial manufacturer of M14 type rifles. In 1994, it was renamed Springfield, Inc. for a time. Springfield Armory, Inc. has been located in Geneseo, Illinois since 1974 when Robert (Bob) R. Reese became the owner. While at Camp Perry in August 1973, Bob Reese took a photograph of Karl Maunz with a U. S. Marine utility cover (hat) on his head and a M1A rifle in his hands posing in the offhand position. Mr. Maunz borrowed the utility cover for the photograph from a friend present at the time. This photograph was drawn as an illustration and became the company’s logo by no later than 1979. At the suggestion of Colonel Joe Smith, head of the DCM, in August 1973 at Camp Perry, Karl Maunz encouraged Mr. Reese to shoot the M1A rifle in a DCM match and he did so.

Texas Production

The Springfield Armory, Inc. story begins with U. S. Air Force veteran Mr. Elmer Ballance of Devine, Texas. His last name is correctly spelled with two lower case letters “L.” He started his business, L. H. Gun Co., in 1960 while stationed at Lackland Air Force Base in San Antonio, Texas. The base had a housing subdivision named Lackland Heights. To save time writing, he named his company, L. H. Gun Co. “L. H.” is an abbreviation for Lackland Heights. While serving in the Air Force, Mr. Ballance shot the M14 rifle in competition on the All Air Force High Power Team. Staff Sergeant Ballance earned U. S. Air Force Distinguished Rifleman Badge (# 42) before completing his military service in 1964. After that, he built match grade M1 Garand rifles for competition shooters.

The U. S. Army Springfield Armory had closed down in April 1968. During the NRA National Matches at Camp Perry in the summer of 1968, the closure of Springfield Armory was a topic of discussion among the attendees including Elmer Ballance, Karl Maunz and Melvin Smith. These three men and an unnamed fourth person, held two or three meetings during August 1968 in one of the wood huts used to house civilian competitors. During one of these meetings, there was a Buckeye beer case full of Melvin Smith welded M1 Garand receivers wrapped in newspaper in the middle of the hut. It was in this meeting that Karl Maunz voiced his suggestion to name the business venture

that would produce commercial M14 type rifles, "Springfield." This was agreed to by the four men present. That particular wood hut still stood in February 2005.

Subsequent to this, Mr. Ballance began the process to acquire the name "Springfield Armory" for production of his commercial version of the M14 rifle. In late 1969, Mr. Ballance commenced work on making the dream of civilian M14 type rifles become reality. Though banks refused to fund his dream, this did not deter him. Mr. Ballance raised the funds himself. He and Melvin Smith of Valley Ordnance Co. worked together to get the equipment set up for production of the civilian receiver and complete rifles at their respective facilities in Texas and Pennsylvania. Some of the machinery and parts which Mr. Ballance purchased for the project came from the Harrington & Richardson M14 production facility.

During this time, Mr. Ballance also modified less than fifty Springfield Armory and Winchester M1 Garand receivers to accept the M14 barrel and gas system, to function with M14 magazines, and to fit in M14 stocks. This was completed prior to September 1971. These are the first commercial production M14 type rifles ever made. In 1971, these M1/M14 receivers and complete rifles sold for \$100.00 and \$250.00, respectively. One of these modified M1 Garand receiver semi-automatic M14 rifles was sold by Collector Firearms in Houston, Texas in 2004 for \$2500.00. The workmanship on these modified M1 Garand receivers is excellent.

The Bureau of Alcohol, Tobacco and Firearms held the position in 1971 that the M14 rifle was a machine gun as defined by the 1968 Gun Control Act. The Valley Ordnance Co. design receiver was only designed for and capable of semi-automatic fire. Thus, the BATF was of the opinion at the time that it had to be named something other than M14. The January 1975 edition of the BATF publication P5300.1 text on the M14 rifle on page 5 is reproduced here:

M-14 Machine Gun

[photograph of M14 rifle inserted here]

CLASSIFICATION: Machine Gun

DISTINCTIVE CHARACTERISTICS: This is the M-14 Rifle. It generally can be distinguished from the M-1 by shoulder plate, magazine and flash hider. The forestock is also different from that found on the M-1. The Selector Switch on the M-14 Machine Gun is located on the right rear side of the receiver, just above the trigger. All M-14's which are so marked are Machine Guns whether or not equipped with a Selector Switch.

SPECIAL NOTE: The Model M-1A rifle manufactured by the Springfield Armory, San Antonio, Texas is identical in appearance to the M-14, but is NOT a machine gun. The M-1A is Title I weapon.

RATE OF TRANSFER TAX: \$200.00

Apparently, at some point between 1975 and 1985, the BATF changed its stance on the model names M14 and M-14. The model number appears to have lost any relevance to functionality with Class 2 FFL/SOT licensees legally converting M1A rifles to select fire capability as early as May 1974. From 1985 onward, the following firearms

manufacturers produced semi-automatic M14 type rifles stamped M14 on the receiver heel: Armscorp of America, Federal Ordnance, Fulton Armory and H&R Gun Co. Likewise, Smith Enterprise, Inc. and Smith, Ltd. (a different manufacturer entirely) produced semi-automatic rifles marked M-14.

Mr. Ballance began marketing the M1A rifle in September 1971. The M1A rifle was first advertised in *Shotgun News* in the November 01, 1971 issue. In October 1971, his Federal Firearms License was in the name of his business, L. H. Gun Company at 3426 Weir Avenue San Antonio, TX 78226. About this time, BATF Agents informed Mr. Ballance that he could not market the M1A rifle because the receiver markings did not bear the name and address of the manufacturer or the distributor. Mr. Ballance promptly applied for a new Federal Firearms License in the name of Springfield Armory, Inc. He agreed to indicate the address on the barrel. Thus, L. H. Gun Company became Springfield Armory, Inc. The name of the closed government arsenal, Springfield Armory, was well known by the public and especially by competition shooters. It turned out to be a successful marketing strategy.

Production of newly manufactured investment cast M1A receivers began by the end of 1971. For example, M1A receiver serial number 000065 was received by the retail buyer on December 24, 1971. These M1A rifles were assembled from USGI and National Match M14 parts except for the receiver and select fire parts. The Texas business warranted M1A rifles for one year. The first recorded gun show (and public) appearance of the commercial M14 type rifle occurred on January 15 and 16, 1972 at the Ohio Gun Collectors Association show in Canton, OH. Though the temperature dipped to minus 15 degrees Fahrenheit that weekend in Canton, Melvin Smith promoted, but did not sell, the M1A rifle at this and all other gun shows. At this show, Mr. Smith displayed M1A rifles 000003 (in match grade configuration) and 000011 and M1A receiver 000012. In the same row of tables, an OGCA member displayed M1A serial number 000070 dressed in a M14A1 stock, M2 bipod, M14E2 muzzle stabilizer and M14E2 sling. In January 1972, Mr. Ballance sold a stripped M1A receiver for \$110.00 and a barreled M1A receiver for \$125.00. Mr. Smith continued to display and promote the M1A rifle at Ohio gun shows until at least July 13, 1975.

In January 1972 Valley Ordnance Co. (Wilkes-Barre, PA) was prepared to manufacture all major M1A components. Melvin Smith and Elmer Ballance agreed that Valley Ordnance would be responsible for the manufacture of the components parts and for maintaining an adequate supply of spare parts. Valley Ordnance would handle all quality control on receivers and any barrels that it might make. L. H. Gun Company would supervise all quality control during assembly and final testing and would have the sole right to sell M1A rifles. A large stack of customer orders had been building up. The San Antonio plant was not able to meet the demand. So, the L. H. Gun Company was forced to move to a new facility in Devine, TX. Beginning on February 03, 1972, Springfield Armory, Inc. moved its operations and inventory about thirty-five miles to Route 1 Devine, TX 78016. Mr. Ballance was receiving mail and had telephone phone service at Route 1 Box 210 Devine, Texas 78016 by no later than March 04, 1972. No M1A rifles or receivers were shipped until after an amended Federal Firearms License with the new

address was issued on March 23, 1972. Before May 13, 1972, Mr. Ballance was marketing his business as Springfield Armory.

In 1972, M1A rifle serial number 000345 failed in the receiver. The owner was shooting the rifle when the new operating rod parted at the weld joining the tube and the handle sections. The receiver cracked at the bolt lock opening and the last ¼ " to ½ " of the receiver heel struck the owner very lightly in the face. The impact of the receiver heel was so light that the shooter aimed the sights and squeezed the trigger again without realizing what had happened. The firing pin gouged itself into the stock. The shooter was using ammunition marked IBI. Although the receiver was ruined, this incident demonstrated the strength of the M1A rifle. Mr. Ballance replaced the receiver and rebuilt the rifle for the owner at a cost of \$12.50 for a new bolt and new operating rod. It was the opinion of Mr. Ballance that the rifle had a loose operating rod guide when it failed. The loose operating rod guide placed a shearing force on the operating rod which resulted in the separation of the operating rod. Mr. Ballance did not perform the original build on this rifle before it failed.

In December 1972, Mr. Jim Lewis of Ohio reported a receiver crack in his M1A rifle serial number 000414. During a session at the range and while changing magazines, he noticed a crack in the receiver heel that ran parallel to the serial number. The crack was visible on the right side of the receiver but the steel held together on the left side. Mr. Lewis also reported "that one of the hammer hooks had broken off." Mr. Ballance replaced the receiver for Mr. Lewis without cost. Mr. Lewis was not injured.

Beginning in January 1973, the rear end of the M1A receiver bolt right lug slot, located under the rear sight base cover, was extended 0.080 " to the rear to prevent possible damage to the bolt roller. In March 1973, Melvin Smith stated that he would adjust his machine tools to remove less steel from the M1A receiver for all future production in order to strengthen the rear end of the receiver. The author examined M1A receiver serial numbers 000049, 002XXX, 030061, 042XXX, 052XXX, 057XXX and 141XXX to verify this. M1A receiver serial number 000049 has a maximum thickness of ¼ " at the heel rear wall centerline. M1A receiver 002XXX has 5/16 " thickness at the same location. Receiver serial numbers 030061 and higher all have a full 3/8 " thickness at the receiver heel rear wall centerline. Additionally, there is noticeably more uncut steel in the bolt raceways aft of the stripper clip guide in the receiver serial numbers 002XXX and up.

Guns Illustrated conducted a test of a bedded but rack grade M1A with a Winchester chromium plated M14 barrel in January 1973. The rifle consistently shot 1.5 to 2 MOA out to 500 yards using 1968 Lake City 173 grain Match and Sierra 168 grain Match hand load ammunition.

In the first quarter of 1973, Mr. Ballance supplied the first recorded commercial 18 " barreled M1A receiver made to Thomas Buss of Springdale, PA. To this, Mr. Buss installed a modified M14 stock with BM59 folding butt stock parts and M14A1 fore grip and a modified gas cylinder lock and front sight assembly to create on March 08, 1973 the M1A Assault Rifle. His M1A Assault Rifle had neither flash suppressor nor muzzle brake. It grouped 4 " at 100 yards in comparison to 2 " groups with the M1A and the Mark IV rifles. The machinist who made these modified gas cylinder lock and front sight

assemblies was Ray Kryza of Michigan doing business at the time as H&R Surplus Sales. Wayne Young was a U. S. Army armorer of eighteen years experience in 1973 when he was stationed at the Fort Benning AMTU. He had a Federal Firearms License and his own work shop off base. He built match grade M1 Garand, M1A and Mark IV rifles for civilian competitors. His gunsmithing work was highly regarded by the shooting community.

On May 06, 1973, a M1A receiver was tested inadvertently when the head separated from a reloaded cartridge during firing. The commercial brass case had been used previously and was loaded with 46.8 grains of H335 gun powder. All of the bolt parts were blown out of the bolt body including the roller except the ejector spring. The stock was split severely, the magazine blown apart, the hammer broken, the sear torn from the trigger. The receiver was scored by the roller-less bolt and by the firing pin. Close visual examination revealed no other damage to the receiver. The shooter only received a superficial cut to the face. Nonetheless, Mr. Ballance offered to replace the damaged parts and the receiver if magnetic particle inspection or proof firing showed any damage at no cost.

In the fall of 1973, a second improperly hand loaded cartridge caused a M1A receiver to crack but not come apart. Both bolt lugs sheared off when an excessively loaded cartridge was fired. There was no serious injury to the shooter.

The M1A became eligible for use in NRA High Power shooting matches on January 01, 1974. The NRA had modified Rule 3.1.1 in the High Power Rifle Rule Book to allow commercial made M14 type rifles to be used in competition shooting matches. At about the same time, the *American Rifleman* tested and reviewed M1A serial number 001562 in the March 1974 issue. The response to the article was overwhelming. By the third week of March 1974, Mr. Ballance was receiving 200 letters a day. In the July 1974 issue of *American Rifleman*, it was announced that commercial versions of the M14 rifle were acceptable for National Board for the Promotion of Rifle Practice sanctioned Excellence-in-Competition matches. These matches are commonly known as "Leg" matches.

In early May 1974 Springfield Armory, Inc. moved its operations and inventory to 12106 Radium Drive in San Antonio to cut costs. Production ceased temporarily while equipment and inventory was moved from the Devine facility to the San Antonio facility and set up. An application was submitted to the BATF on May 13, 1974 to change the address on the Federal Firearms License. The new FFL was not issued by the BATF until late September 1974. Springfield Armory, Inc. at 12106 Radium Drive San Antonio, TX 78216 shipped M1A stripped and barreled receivers to customers until the end of October 1974.

Mr. Ballance never made or converted any M1A or M14 type rifles to select fire. All of the Texas M1A receiver serial numbers start with a zero. It is not possible to determine the original model of a Texas M1A by serial number. The serial numbers were logged in as "manufactured complete" regardless of model type, standard, National Match or E2. The serial number was logged a receiver if shipped unassembled. All Texas M1A receivers were test fired by Mr. Ballance, whether sold stripped or with a barrel. Some of the Texas

M1A receivers were assembled into complete rifles by U. S. Army armorers at Fort Benning, GA. 150 of the M1A rifles assembled in Texas were fitted with T44E4 wood stocks with the selector cutout filled in, e.g., M1A serial number 001830. The first T44E4 wood stock was installed on a M1A rifle under serial number 000100.

Timeline of M1A Receiver Shipments from Valley Ordnance to Springfield Armory, Inc. for 1971 to 1975

The following information includes reports by Melvin Smith to Thomas Buss during Ohio gun shows from 1971 to 1975.

December 24, 1971 - M1A receiver serial number 000065 was received by the original buyer.

January 15, 1972 - Serial numbers over 000400 were being shipped to Texas.

September 23, 1972 - M1A serial number 001056 was the latest finished receiver.

November 11, 1972 - The latest M1A serial number was over 001200.

July 14, 1973 - The latest finished M1A receiver was serial number 001838.

September 22, 1973 - The latest finished M1A receiver was approximately 002150. M1A rifle serial numbers being shipped from Texas were above 001500.

January 19, 1974 - The latest finished M1A receiver was 002504. M1A serial number 001727 was received by the original buyer this month.

July 13, 1974 - M1A receiver 003396 was recently finished.

September 21, 1974 - Valley Ordnance recently resumed production of M1A receivers after a six week shutdown period.

January 18, 1975 - The original buyer took delivery this month of M1A receiver serial number 003322 from Springfield Armory, Inc. in Geneseo, IL.

March 01, 1975 - The latest finished receiver was 004164.

July 12, 1975 - Valley Ordnance Co. had manufactured more than 5000 M1A receivers to date.

Texas M1A Models

From a L. H. Gun Co. brochure mailed on January 06, 1973 from Devine, Texas, M1A models and prices were as follows:

Standard model with fiberglass stock \$200.00

Standard model with new walnut stock \$225.00 or used walnut stock \$215.00

Standard model with new beech stock \$215.00 or used beech stock \$200.00

M1AE2 with birch stock \$250.00

M1AE2 with bipod \$275.00

Match grade model with walnut stock \$250.00

New issue bayonet \$5.00

Texas Barrel Markings

All M1A complete rifles assembled in Texas had barrels with the complete address where it was assembled. These barrel markings were typically located on the underside between the gas cylinder and the flash suppressor. There were three barrel markings for the Texas company. The marking L H GUN CO S A TEX 78226 was found on the first 100 rifles assembled by Mr. Ballance. Additionally, a few of these hand stamped barrels were shipped to Fort Benning (GA). This stamping was done by hand in two lines using serif font characters. L H GUN CO is on the first line and S A TEX 78226 is on the second line.

The barrel marking then changed to RT I BOX 210 DEVINE TEX or RT I BX 210 DEVINE TX. Initially, the Devine address marking was in two lines with RT I BOX 210 or RT I BX 210 on the first line then DEVINE TEX or DEVINE TX on the second line. The two line Devine address marking has been observed as late as M1A serial number 000567. At some point, this marking was changed to one line (RT I BOX 210 DEVINE TEX) to avoid indexing the barrel. The third Texas barrel marking is 12106 RADIUM SA TEX 78216. This third barrel marking first appeared on the barrels some time between May and September 1974. This address is a one line marking. The first Devine address barrel markings appeared in the spring of 1972 on assembled M1A rifles beginning at about serial number 00013X. At least some barreled M1A receivers were not stamped on the barrel, e.g., 000172 and 000214 had no address markings. The original owner received both barreled M1A receivers, 000172 and 000214, on April 21, 1972 from L. H. Gun Company in San Antonio, TX. The Devine address marking was used until at least M1A serial number 002127 in April 1974. The Radium San Antonio address marking appears as early as M1A serial number 002167 in September 1974.

Springfield Armory, Inc. in Texas marked the barrels at the time of rifle assembly. Barrels with the simple address of DEVINE TEX or DEVINE TX are not barrels marked by Springfield Armory, Inc. when it was located in Texas. In the summer and fall of 1974, Mr. Chuck Krause was employed by Springfield Armory, Inc. On at least one M1A rifle assembled by him, he stamped his home address RT I BOX338C DEVINE TEX. Mr. Krause was a neighbor of Mr. Ballance but the FFL address for Springfield Armory, Inc. was not the home of Mr. Krause. Mr. Ballance never used Canadian Arsenals barrels in the assembly of M1A rifles because he did not have any from that maker in his parts inventory.

The barrel of M1A serial number 000564 was electropenciled during assembly as follows: top line - DRW 430, middle line - Devine, bottom line - Texas. The bottom of the bolt and the inboard side of the operating rod were electropenciled 564. The electropenciling appears to have been done by the same person. The May 15, 1973 issue of *Shotgun News* listed a sales advertisement for Springfield Armory, Inc. The ad listed the address for Springfield Armory, Inc. as P.O. Drawer No. 430 Mailing Address RT. 1 Box 210 Business Address Devine, Texas 78016 and included a 512 area code phone number. In September 2006, the owner of M1A serial number 000564 confirmed by telephone interview with Mr. Ballance that it was shipped to Fort Benning by him as a stripped receiver as one of about 100 bare receivers in trade for services rendered.

A very few Texas marked barrels were sent to Geneseo, Illinois. The barrels on the first M1A rifles leaving the Illinois factory were electro-penciled Geneseo Ill. However, M1A rifles in 1975 were sold with a coupon to be used towards the purchase of a spare barrel. Thus, a very few of the spare barrels sold by the Illinois company had Texas markings. It is likely that a very small number of individuals eventually had these Texas marked spare barrels installed on M1A rifles sold by Springfield Armory, Inc. in Illinois.

Transition from Texas to Illinois

An advertisement announcing the sale of Springfield Armory, Inc. in Texas appeared in the September 01, 1974 issue of *Shotgun News*. Springfield Armory, Inc. changed ownership in the first ten days of November 1974 from Elmer Ballance to Bob Reese at 218 North State Street Geneseo, Illinois 61254. ¹ The transfer of the company assets included all of the unused receivers and barrels and many of the USGI parts. Production problems troubled the Reese family for some time. These problems were sorted out over a few months and M1A production resumed by the spring of 1975.

When the Texas company receivers had been used up, Valley Ordnance continued to supply finished M1A receivers to the Illinois company. It did so until July 1996 when Melvin Smith passed away. The bare receivers, barrels and other parts left over from the Texas firm were used to help start production of the M1A rifle in Illinois.

The M1A serial number transition from Texas to Illinois occurs from about 002700 to approximately 003200.

The following individual cases serve to illustrate the transition M1A serial numbers: See Appendix A for further information.

Serial number 002709 - M1A serial number 002709 was shipped as a bare receiver to the original buyer in November 1974. This is the lowest known M1A serial number sold from Springfield Armory, Inc. located in Geneseo, IL.

Serial number 002734 - M1A serial number 002734 was shipped from Geneseo, Illinois on April 28, 1975. Geneseo Ill is electro-penciled on the barrel of M1A serial number 002734.

Serial number 0028XX - An M1A with serial number 0028XX has been identified with the 12106 RADIUM SA TEX 78216 marking on the barrel.

Serial number 002831 - M1A serial number 002831 was sold new to the original owner by a FFL on February 19, 1975. The price was \$309.75 including sales tax. The barrel has the marking RT I BX 210 DEVINE TEX. It is likely that this rifle was assembled in Geneseo, IL with a Texas marked barrel.

Serial numbers 002867 and 002874 – M1A serial number 002874 has the following one line address marking on the barrel: RT I BX 210 DEVINE TEX. According to the original owner and his purchase receipt, M1A rifles with serial numbers 002867 and 002874 were shipped from Devine, TX in May 1974 to his local FFL. Both rifles were then promptly sold to him.

Serial number 002877 – This M1A rifle has an October 1962 production Harrington &

Richardson chromium plated barrel. The barrel marking is identical to M1A serial number 002831 except there is an O between B and X. Springfield Armory, Inc. in Geneseo, IL has no record of this serial number.

Serial number 003139 – M1A serial number 003139 has the 12106 RADIUM SA TEX 78216 marking on the barrel.

Serial number 003159 - Stripped M1A receiver serial number 003159 was received by the original owner on November 01, 1974 from Springfield Armory, Inc. at 12106 Radium Drive San Antonio, TX 78216.

Illinois Production

Bob Reese was an Illinois soybean farmer with an enduring passion for firearms. At some point after World War II, he bought military surplus items including firearms parts. There was a strong public demand for the M1 Garand rifle. Bob Reese served the non-competitor market demand by welding cut M1 Garand receivers back together to help meet this demand. In 1974, Bob Reese became the owner of Springfield Armory, Inc. Bob Reese, his wife and their sons, Tom, David and Dennis, have built the business into an American success story. Starting out in the barns of the family farm and growing to forty employees by 1986, firearms manufacture and assembly have been done in its Geneseo, Illinois factory for decades now. In addition to the M1A, Springfield Armory, Inc. of Illinois has made the M1911 pistol, M1 Garand, SAR 48 and BM59 rifles, and the M60 machine gun. The M1 Garand and BM59 receivers were made by Springfield Armory, Inc. and assembled with surplus parts. The Springfield Armory, Inc. M1 Garand was introduced in 1979 and its BM59 debuted in 1981. BM59 rifles and parts are still available through its sister company, Reese Surplus, Inc. The firearms manufacturer Beretta developed the BM59 rifle from 1957 to 1958. Like the M14, the BM59 is a descendant of the M1 Garand rifle.

The M1A receiver design was further changed prior to serial number 030100 to include a small hemisphere on the outboard side of the rear sight pocket right ear for use of a ball bearing to engage a detent on a newly designed match windage knob. This windage knob allowed ½ minute of angle sight adjustments by allowing eight “clicks” per revolution of the knob. Original USGI NM sights used a more delicate fine thread on the windage knob and rear sight base to effect ½ minute windage adjustments with four “clicks” per revolution.

Springfield Armory, Inc. made further changes to the receiver geometry around serial number 040000. The chamber was moved very slightly forward to improve accuracy and increase bolt lock up time. Some Springfield Armory, Inc. receivers have a ridge on the bottom right hand side that may slightly interfere with the fit of some stocks. This ridge has been identified on M1A rifles from serial number 000049 until somewhere between 0343XX and 0422XX. This bottom side ridge was removed from the design as part of the changes made for economic reasons. It meant two less machining cuts but it has the benefit of better fit with the various stocks. Prior to the May 1986 ban on new manufacture machine guns, Springfield Armory, Inc. had a Full Auto Department that manufactured and assembled select fire M1A rifles.

Springfield Armory, Inc. M1A rifles with serial numbers under 084000 were reportedly made prior to the September 13, 1994 effective date of the U. S. Violent Crime Control and Law Enforcement Act. Springfield Armory, Inc. sold stripped receivers manufactured prior to September 13, 1994 as well. If the stripped receiver was not assembled into a complete rifle by September 13, 1994 it was considered a post-'94 ban firearm by the BATF. During the ten years of the 1994 Assault Weapons Ban, specific features could not be added to M14 type rifles assembled for civilian sale after September 13, 1994 within the United States. These federal restrictions were automatically repealed by the sunset provision (automatic expiration of the law absent further Congressional action) of the same law on September 13, 2004. State and local laws are still in effect though. Certainly, the 1994 Assault Weapons Ban had no adverse effect on the popularity of the M1A. M1A serial number 166761 was built on August 26, 2004, just before the repeal of the ban. Springfield Armory, Inc. had USGI M14 parts kits available to them for assembly of M1A rifles at least through the 100XXX serial number range.

As of February 2004, Springfield Armory, Inc. M1A receivers are cast by Alphacasting, Inc. in St-Laurent, Quebec, Canada for Springfield Armory, Inc. Alphacasting, Inc. makes the M1A receiver by the lost wax investment casting method. In business since 1991, it is a precision casting firm that makes parts from aluminum, bronze, and many grades of carbon and stainless steels. At Springfield Armory, Inc., all basic rifle assemblers have a minimum of two years experience assembling rifles before they are allowed to assemble rifles on their own. A rifle is test fired with five rounds for function and has to function through all five rounds or it doesn't get shipped. If it fails for any reason, it gets torn down and rebuilt. Then the rifle is tested for five rounds again.

On rare occasion, the M1A receiver heel has been stamped erroneously. The letter I is missing from SPRINGFIELD on receiver serial number 062857. The serial number, 064922, is stamped to the right of center on the receiver heel. Nearly 100 receivers in the 165XXX serial number range were stamped AROMRY instead of ARMORY. Specific examples of AROMRY marked M1A receiver serial numbers are 165345, 165412 and 165418. Obviously, these unintentional markings are only cosmetic in nature and have no bearing on the fit or function of the rifle.

M1A Packaging – After assembly and testing, the M1A rifles are packed for shipment. A brightly colored plastic empty chamber indicator is inserted into the chamber and the bolt closed on it. The factory headspace and safety warning tags are attached to the trigger guard. Then the M1A rifle is inserted into a plastic sleeve and placed inside a cardboard shipping box. The shipping box also contains an owner's manual, safety literature, warranty information, and accessories and parts sales brochures. Springfield Armory, Inc. M1A rifles had a limited warranty for one year after the initial purchase for the period September 01, 1985 until December 31, 1992. Effective January 01, 1993, Springfield Armory, Inc. M1A rifles are sold with a limited lifetime warranty that applies to the original retail buyer. In recent years, a gun lock has been included. The shipping boxes were green and white in color until sometime between serial number 0708XX (after July 1992) and 075XXX (fall 1993) when they were changed to blue and white.

Illinois M1A Models

In the August 01, 1975 issue of *Shotgun News*, two M1A models were available, standard and match. At about this time, the Super Match M1A is introduced in the August and October 1975 issues of *American Rifleman*. These first Super Match M1A rifles had Shilen eight groove 1:12 twist molybdenum-chromium alloy steel barrels. The M1A with a USGI M14 NM is now known as the National Match M1A. This selection of M1A models continues until 1981.

The 18" barrel M1A model series debuted in 1981 with the M1A-A1 model, later known as the M1A Bush. In 1985 and 1987, the M1A was available in four models, Standard, National Match, Super Match and M1A-A1 Bush Assault. The manufacturer's suggested retail price for the Standard M1A in 1985 was about \$650.00 and in 1987 it was \$782.00. The factory model designator, M1A-A1, was used until at least serial number 0663XX (1991). The M1A Scout Squad model was first marketed in 1996. Through the years, the M1A with an 18 " barrel has been available at different times as the M1A-A1 (catalog number AA9116), M1A-A1 Bush Assault, M1A Bush and M1A Scout Squad model. The butt stock on the 18 " barrel M1A rifles has been fitted with a USGI butt plate or commercial rubber butt pad.

The Loaded Standard M1A model debuted on September 01, 1996. This model, MA9201, included a medium weight National Match barrel, National Match tuned firing mechanism, and National Match flash suppressor. This promotional version of the Loaded Standard model was shipped from the factory with three twenty round magazines. Unfortunately, the retail buyer wasn't made aware of the extra two magazines at the time of purchase in some instances. Model MA9201 was available until December 31, 1997.

Boyd's Gunstock Industries supplies walnut M1A stocks to Springfield Armory, Inc. for current production. Beginning in July 2005 Springfield Armory, Inc. switched from a textured black surface on synthetic M1A stocks to a smooth black finish.

Small Production Run M1A Models – Springfield Armory, Inc. has produced a number of small production lot M1A rifles through the years.

- 1) Gold Series - In 1987, this competition model M1A was offered in a choice of stocks, National Match walnut wood or aramid material, and in a choice of match barrels, Douglas molybdenum-chromium alloy steel or Hart stainless steel.
- 2) Sport Master - The receiver heel of the Sport Master is stamped as follows from top to bottom: first line – U S RIFLE second line – SPORT MASTER third line – SPRINGFIELD ARMORY fourth line – SM0XXX. These rifles had a wood laminate stock with an integral cheek rest as part of the butt stock. Sport Master serial number SM0117 was built in September 1991. There were no Sport Master receivers manufactured after early 1993.
- 3) Even Thousand Collector Edition – In 1991, Springfield Armory, Inc. produced a small batch of collector grade M1A rifles and an unknown number of M1911A1 pistols. According to a very reliable source, there were probably no more than sixty M1A rifles produced of this type. These rifles had a matte blued finish and gold plated triggers. The highly polished wood stock was inlaid with a large medallion applied to the right side of

the butt stock. The medallions were marked Collectors Edition and Even Thousand Serial Number. The receiver serial numbers were even thousand numbered, e.g., 15000.

4) IDF M1A - In the late 1990s Springfield Armory, Inc. bought the parts from some Israeli Defense Force M14 rifles. The parts from these rifles, including the Harris bipods, Israeli Military Industries stocks and scope mounts and Nimrod 6X range finding scopes, were assembled on to commercial Springfield Armory receivers with heavy weight match grade barrels. They were sold as a limited run model in 1999. The IDF M1A receiver heels are marked with the Star of David just below the serial number. The stocks on these rifles are described in the section Other Stocks. Each IDF M1A was issued a Certificate of Authenticity as part of the literature packed inside the factory shipping box.

5) M25 - The M25 rifle recognizes the service of the late Gunnery Sergeant, USMC (Retired) Carlos N. Hathcock, II. Gunnery Sergeant Hathcock was a sniper who served his country admirably in the Viet Nam War. He is credited with ninety-three confirmed kills and a total of over 300 unconfirmed kills. The Viet Cong nicknamed him "Long Trang," which means "white feather" in the Vietnamese language, because he wore a small white feather in his cover (Marine term for hat) while in the field. Gunnery Sergeant Hathcock passed away in February 1999. This high-end model remains in production in 2005.

6) Vietnam War Commemorative M14 – In 2003, Springfield Armory, Inc. produced a run of 500 Vietnam War Commemorative semi-automatic M14 type rifles. It was available for sale through the American Historical Foundation. This model was fitted with a Reinhart Fajen designed walnut stock containing a circular badge on the right hand side of the butt stock. The stock badge consisted of a red Oriental dragon walking through white color bamboo shoots all against a yellow background. The badge was inscribed with the words REPUBLIC OF VIETNAM SERVICE. It had the following 24 karat gold plated parts: lugless flash suppressor, front sight, safety, front and rear sling swivels, rear sight assembly, trigger and magazine latch. The receiver and operating rod were etched and gold-gilt filled with symbols and inscriptions. The operating rod was marked VIETNAM WAR COMMEMORATIVE M14 and had an American flag to the rear of the inscription. The receiver heel serial numbers were stamped VME001 through VME500. VME is an acronym for Vietnam-Museum Edition. Each unit of this model was issued with a ten round magazine, a USGI field manual, a black M1907 style leather sling and a Certificate of Authenticity.

Springfield Armory, Inc. M1A rifles have been exported to Australia, Belgium, Canada, Finland, Germany, Italy, the Netherlands and United Kingdom for sale to private individuals. Nioa Trading (Banyo, Queensland) first imported M1A rifles into Australia in 1985 or 1986. The company has remained the sole importer of M1A rifles for Australia. M1A rifles have also been offered for sale to U. S. military members and their dependents through the Army and Air Force Exchange Service and the Navy Exchange at locations such as Fort Richardson (Anchorage, AK) and Camp Allen (Norfolk, VA). Springfield Armory, Inc. listed the following rifle model names and catalog numbers in March 2006 on its web site:

Standard M1A (MA9101, MA9102, MA9104, MA9106)

M1A SOCOM 16 (AA9626, AA9628) and SOCOM II (AA9627)
Scout Squad M1A (AA9122, AA9124, AA9126)
Loaded Standard M1A (MA9222, MA9226, MA9822, MA9826)
National Match M1A (NA9102, NA9802)
Super Match M1A (SA9102, SA9802, SA9804, SA9805)
M21 (SA9121, SA9131)
M25 (SA9502)

Collector Edition M1A - M1A rifles have been offered in a number of models with USGI stocks. The Springfield Armory, Inc. May 01, 1998 factory price list had catalog number MA9851 for the M1A with a USGI wood stock and stainless steel barrel at a suggested retail price of \$1351.00. The Collector Edition M1A, catalog number MA9103, was a standard model offered in 2002 and 2003. It had a USGI chromium plated barrel and USGI birch stock. Catalog number MA9101 debuted in 2006 as a standard model M1A with a USGI wood stock.

Standard M1A - The standard model M1A has a 1:12 twist four groove molybdenum-chromium alloy barrel with a standard size rear sight and either a standard or a National Match front sight. Standard M1A rifles are assembled with wood or black or camouflage pattern synthetic stocks. When available, Springfield Armory installed USGI chromium plated barrels on the standard M1A models. During times of scarcity, such as 1978 to 1986 and beginning in 2004 around receiver serial number 162XXX (January 2004), Springfield Armory, Inc. installed Wilson Arms Co. (Branford, CT) commercial manufacture non-plated standard contour barrels instead. In the past, Hillside Manufacturing did the barrel machining on Wilson Arms barrel blanks. Today, Springfield Armory, Inc. buys the barrel blanks from suppliers then performs the finish machining of the barrels itself.

Bush and Scout Squad M1A - The Bush and Scout Squad models are similar to each other. Each has an 18 " 1:11 twist six groove non-plated molybdenum-chromium alloy steel barrel and synthetic stock. The Scout Squad has a scope mount installed on the barrel and is also available in a walnut stock. The barrel scope mount will fit on a standard model M1A barrel and it is available separately. Before 1994, the 18 " barrel M1A model was known as the M1A-A1 Bush. The M1A-A1 Bush model was introduced in 1981. The M1A Bush (AA9104) was a variation of the Scout Squad model. It was last offered in 2002 and 2003.

The following rifles are offered with either molybdenum-chromium alloy steel or stainless steel barrels:

A) The loaded standard M1A has a 1:11 twist medium weight match barrel, National Match modified flash suppressor, 0.0520 " non-hooded rear sight aperture and National Match front sight, National Match firing mechanism and either walnut or synthetic stock.

B) The National Match M1A comes glass bedded in an oversized match grade walnut stock with all of the features of the loaded model plus a National Match gas cylinder, match-fitted operating rod, match-modified operating rod spring guide and National Match hooded rear sight aperture (described above as part of the M14 NM rifle modifications).

C) Throughout its production history, the Super Match M1A model has been made with a standard receiver, a rear lugged receiver or a double lugged receiver. Super Match M1A models were built without a lugged receiver as late as 1990. The barrel will be a 1:10 twist heavyweight Douglas barrel unless the customer selects another brand barrel. Regardless of the barrel make, the operating rod will slide through an oversized operating rod guide made to fit the barrel's larger diameter at that area. The buyer also has the choice of an oversized walnut or a McMillan fiberglass stock.

D) The Springfield Armory, Inc. M21 is the rear lugged Super Match M1A with a walnut stock that has an adjustable cheek piece.

E) The M25 rifle offered by Springfield Armory, Inc. has a rear lugged receiver, McMillan fiberglass stock with adjustable cheek piece, low profile custom muzzle brake, Krieger 1:10 twist heavyweight barrel and no iron sights. The M25 must be scoped to sight a target. There is no stripper clip guide or receiver scope mount bolt hole on this model. The scope attaches to a rail mounted over the bolt.

New in 2004, the M1A SOCOM 16 model had a 16.25 " 1:11 twist six groove non-plated molybdenum-chromium alloy barrel and black hand guard and synthetic stock. The overall length was reduced about 7 " from the standard model to 37.25 ". The synthetic stock had a steel hinged butt plate. The hand guard was cut out to accommodate the installed M1A Scout Squad scope mount. This model was given a retuned gas system and proprietary design gas cylinder plug with a combination muzzle brake and gas cylinder lock assembly. The visible portion of the operating rod was stamped SOCOM 16 on 2004 production M1A SOCOM 16 models. The front sight was an XS Sight Systems 24/7 stripe post and the rear sight aperture had been enlarged to 0.125 ". This change in the sights was done to facilitate faster target acquisition at Close Quarters Battle ranges. The pre-production design gas cylinder plug was flush with the gas cylinder end. It was removed and installed with a hex head wrench. Between February and April 2004 the gas cylinder plug design was changed. Production models of the SOCOM 16 use a proprietary gas cylinder plug that can be removed and installed using a M14 combination tool. After the gas cylinder plug is removed, the combination muzzle brake and gas cylinder lock assembly can be unthreaded from the barrel.

The National Shooting Sports Foundation (Newtown, CT) owns and sponsors the annual Shooting, Hunting, and Outdoor Trade (SHOT) Show. Beginning in 1979, the SHOT Show quickly became the largest gathering of firearms, hunting and outdoor product businesses in the world. The SHOT Show has grown steadily in attendance and floor space through its history. The 2005 SHOT Show had 1,725 exhibitors occupying 569,000 square feet of floor space and show attendance totaled 37,671 over four days.

In 2005, Springfield Armory, Inc. upgraded the M1A SOCOM 16 design with the introduction of three new models, the SOCOM II, the SOCOM II LE, and the SOCOM 16 Urban (AA9628). These new M1A rifles were debuted at the 2005 SHOT Show. The M1A SOCOM II LE is based on the 2004 M1A SOCOM 16 but with significant differences. It is equipped with a Vltor Weapons Systems (Tucson, AZ) supplied collapsing and side folding butt stock, a pistol grip and an aluminum rail mount system that surrounds the

black color synthetic stock. The butt stock can be raised or lowered about 1 " for better alignment between the shooter's eye and any mounted optical sight. The M1A SOCOM II LE rail mount system has four M1913 Picatinny rails. The rail at twelve o'clock extends from the front band to the stripper clip guide. The M1A SOCOM II LE is marketed to government agencies and military forces so it is not listed in the firm's retail catalog or on its web site. The M1A SOCOM II is the same as the M1A SOCOM II LE but sports a traditional black color synthetic stock with steel hinged butt plate. The bottom portion of the M1A SOCOM II rail system can be quickly removed from the rifle by depressing two buttons at the rear of the stock swinging the part downward. The M1A SOCOM 16 models come in a choice of black color or black and gray camouflage pattern synthetic stock. The M1A SOCOM models have been outfitted with the steel hinged butt plate or a rubber butt pad on the stock. The M1A SOCOM II operating rod is marked SOCOM II. The M1A SOCOM II and M1A SOCOM II LE models retain the M1A SOCOM 16 rear and front sight but revert back to a USGI design gas cylinder plug.

Springfield Armory, Inc. M1A Catalog Numbers

Catalog numbers were used by Springfield Armory, Inc. beginning no later than 1989. Catalog numbers were indicated on the end of the factory shipping box. If the factory installed a California compliant muzzle brake on a model that was available with a flash suppressor, the letters CA are added at the end of the catalog number, e.g., MA9102CA. The rifles were assembled with molybdenum-chromium alloy steel barrels unless otherwise noted. Though not complete, the following is a list of catalog numbers used by Springfield Armory, Inc. over the years.

Table 9: Springfield Armory, Inc. M1A Catalog Numbers

Catalog Number	Model Description
AA9116	M1A-A1
AA9122	Scout Squad with commercial walnut stock
AA9124	Scout Squad with mossy oak stock
AA9126	Scout Squad with black fiberglass stock
AA9626	SOCOM 16
AA9627	SOCOM II
AA9628	SOCOM 16 Urban
MA9101	collector edition with standard contour barrel and USGI wood stock
MA9102	standard with commercial walnut stock
MA9103	collector edition with USGI barrel and USGI wood stock

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MA9104	standard with mossy oak stock
MA9106	standard with black fiberglass stock
MA9117	standard with woodland camouflage fiberglass stock
MA9201	loaded standard (promotional)
MA9222	loaded standard with commercial walnut stock
MA9226	loaded standard with black fiberglass stock
MA9801	select fire
MA9822	loaded standard with commercial walnut stock and stainless steel barrel
MA9826	loaded standard with black fiberglass stock and stainless steel barrel
MA9851	collector edition with stainless steel barrel and USGI wood stock
NA9102	National Match
NA9802	National Match with stainless steel barrel
SA9102	Super Match with oversized commercial walnut stock
SA9802	Super Match with oversized commercial walnut stock and Douglas stainless steel barrel
SA9804	Super Match with black McMillan stock and Douglas stainless steel barrel
SA9805	Super Match with camouflage McMillan stock and Douglas stainless steel barrel
SA9115	Super Match with Shaw stock and Douglas barrel
SA9121	M21 with Douglas barrel
SA9131	M21 with Krieger stainless steel barrel
SA9502	M25 with Krieger molybdenum-chromium alloy steel barrel or Krieger stainless steel barrel

M1A Receiver and Parts Production: Gray-Syracuse, Inc., Valley Ordnance Co. and Hillside Manufacturing

H. P. Gray founded Gray-Syracuse, Inc. in 1943 as a business to produce investment castings. Its first plant was located in Syracuse, NY. The company purchased a sand casting facility in Manlius, NY in 1953 and converted it to making parts by investment casting. In the 1960s, the company expanded its customer base to include the atomic energy, space and aerospace industries. In 1975, the company moved its operations to a new, larger facility in Chittenango, NY. Gray-Syracuse was purchased by ESCO Corporation in 1987.

Gray-Syracuse made the raw M1A receiver castings starting around 1973 or 1974 until some time after July 1996 but before February 2004. The casting supplier that preceded Gray-Syracuse has not been discovered. The raw castings and certification papers for each production lot were shipped from Gray-Syracuse to Valley Ordnance until closing in July 1996. Valley Ordnance had been located at 280-282 North Main Street Wilkes-Barre, PA 18702. Valley Ordnance would then send the receivers on to Springfield Armory, Inc. At some point between M1A receiver serial number 030061 and 0389XX, the pour lot code was made a part of the raw casting. This number is found on the underside of the receiver just behind the left leg. This is denoted by one of two formats: 1) the letter A followed by a two or three digit number, e.g., A178 or 2) a five digit number followed by a hyphen then followed by a two digit number, e.g., 14132-01. Valley Ordnance machined receivers had letter A prefix numbers for the pour lot. Casting pour lot numbers observed with the letter A prefix have been as high as A186 and as late as receiver serial number 0982XX. By M1A serial number 115XXX the pour lot code was changed to the latter format.

Valley Ordnance Co. had re-welded over 50,000 destroyed M1 Garand receivers when the owner, Melvin Smith, determined that there was a viable market for a civilian version of the M14 rifle. He visited Springfield Armory before it closed in April 1968. He befriended some of the workers who identified what machine tools would be useful for manufacture of commercial M14 rifles. As a result, Mr. Smith bid upon and won an elevation serration machine and a lathe at the Springfield Armory equipment auction.

Melvin Smith also contacted Winchester to inquire about the machine it had used to make the receiver barrel threads but he was informed that most of its M14 machine tools were going to be sold. Melvin Smith purchased nearly fifty tons of M1 and M14 project machine tools, tooling, fixtures and inspection equipment at government auction so that he could produce civilian M14 receivers and parts. Most of this equipment had been used by Winchester in its M14 rifle production. Valley Ordnance made operation of the fixtures on the machine tools as simple as possible. This minimized the risk of machining errors. Some of the machinery and operations are described as follows:

1. Operating rod channel machine - This was a single spindle mill. Valley Ordnance employees made cutting tools for this machine.
2. Brown & Sharpe spline mill - This 1936 machine was highly sophisticated for its time. It was used in M1 Garand production at Winchester. This was a single spindle mill used to cut the bolt raceway inside the receiver.
3. Circular cut end mill - This machine was used to make the circular cut at the inside rear end of the receiver. A separate machine tool was used to cut the firing pin recess on the inside rear end of the receiver.
4. Elevation serration machine - A receiver was placed under a cutter (similar to a gear cutter) then rotated under the cutter to make the elevation knob serrations. This machine was bid upon and won at the Springfield Armory auction. It was one of eight elevation serration machines at Springfield Armory.
5. Beretta headspacing machine - Winchester did not include a receiver headspacing machine in the government auction of M14 project machine tools. Mr. Smith purchased a receiver headspacing machine from Beretta in Italy. The Beretta

headspacing machine had been used in BM59 production. Valley Ordnance modified it for the M1A receiver. However, during Springfield Armory, Inc. production of its BM59 receivers, this machine was used to headspace the commercial BM59 receivers as a special assignment to Valley Ordnance. The operation of the headspacing machine is described as follows. The operator's left hand worked the cutting tool and the right hand ratcheted movement of the receiver by manipulating a fixture. Some timing was involved but the operator could easily hold within 0.001 " on the tolerance. The cutting tools were sharpened by the employees using a Bridgeport mill and a surface grinder. The headspace machine cutting tools were bought ten at a time from Cline Tool and Service Company (Newton, IA).

6. Rear sight pocket milling machine - This was a Bridgeport mill. It was used to machine the flat surface between the rear sight knobs and behind the stripper clip guide.
7. Receiver scope mount groove milling machine - This was a Bridgeport mill. Separate single pass cuts were made for the horizontal and vertical grooves.
8. Receiver heel stamping machine - The receiver heel markings were made with a metal marking press using straight dies and a rolling fixture. This marking press was manually operated as purchased from the Winchester M14 project. At some point before early 1981, Valley Ordnance had modified it to operate pneumatically. Before then, Melvin Smith operated the metal marking press himself. The dies were obtained from Numberall Stamp & Tool Company, Inc. (Sangerville, ME). The receiver was held by the fixture and rolled on a radius while the pneumatically operated ram holding the die stamped the heel. The first die stamped U S RIFLE and 7.62-mm M1A for receivers just under serial number 0630XX or US RIFLE M1A for receivers over serial number 0630XX. The die was then changed so that the machine could stamp the brand name. Then the third die was installed in the machine to stamp the individual serial number. If the number stamping die trip dog switch counter did not trip, a duplicate number was created. Or on occasion, a Valley Ordnance worker would fail to reset the number stamping die properly. In either case, the letter A was hand stamped under the serial number. By doing so, the receiver was given a unique serial number and then did not have to be scrapped. This explains the letter A under receiver serial numbers 031000 and 032476 as well as others.

Once this equipment was set up in his shop, Melvin Smith designed improvements into the civilian version of the M14 receiver. These changes included increasing the thickness of the receiver bridge, changing the operating rod rail to better support the operating rod and prevent automatic fire, removal of small amounts of material for better clearance, and relocating the operating rod dismount notch. Based on a discussion with his friend, Edward M. "Ned" Hogan, Mr. Smith kept the receiver left side geometry the same as the USGI M14 even though it would add to the manufacturing cost.

Melvin Smith thought about the name for the new commercial semi-automatic only M14 rifle. In the second half of 1969, Mr. Smith referred to the semi-automatic only commercial legal M14 type rifle as the M14C. At the time, M14 was considered by the BATF, then known as the ATFD, to be a machine gun. The model designation, M14, was flatly rejected by the BATF by no later than July 1970. Mr. Smith then considered naming the new commercial rifle, M15. The select fire rifle model name, M16, was not acceptable

either for the same reason as M14.

In a letter from Edward M. "Ned" Hogan dated July 09, 1970, Melvin Smith was given the name for the new commercial M14 rifle. Mr. Hogan suggested M1A with an italicized letter A. Mr. Hogan reasoned that the civilian legal M14 type receiver should be known as the M1A because it was "legally derived from the present legally modified M1 receivers now marketed by you and Mr. Ballance rather than being derived from the illegal M14 or M15." Mr. Ballance agreed with the suggested name, M1A but without the italicized letter A. Had Mr. Ballance not agreed to the model name M1A, Mr. Hogan had suggested model names M10 or M11. Mr. Hogan suggested M10 or M11 as alternate choices since the U. S. Army had never used those model numbers.

By no later than 1971 the Valley Ordnance M1A receiver design was approved as a Title I firearm under the 1968 Gun Control Act by the Department of the Treasury. Melvin Smith signed an exclusive contract with Elmer Ballance for Valley Ordnance to supply M1A finished receivers to Springfield Armory, Inc. These receivers were investment cast of certified AISI 8620 alloy steel. Up to as many as a dozen experimental M1A receivers were made before serial number 000001 was stamped. Serial numbers 000001 through 000010 were in the first casting lot and serial numbers 000011 through 000021 were in the second casting lot. At about serial number 000150, the length of the M1A receiver heel was changed slightly.

In 1972, Winchester did supply Valley Ordnance with Winchester marked hammer forged barrel blanks. Valley Ordnance intended to finish machine and install these barrels on match grade M1A rifles but it was not meant to be. Before Mr. Smith could complete the tool set-up, Mr. Ballance found a lot of over 1,000 USGI chromium plated barrels and so the USGI barrels were used instead. Additionally, another supplier had sold Mr. Ballance 180 USGI M14 NM barrels in late 1972 and early 1973.

When Springfield Armory, Inc. had USGI M14 chromium plated barrels, its workers would often gage the chambers and group them into lots dimensionally. Based on the findings, it had Valley Ordnance cut the M1A receiver headspace to better fit the USGI M14 chromium plated barrels in its inventory. As an example, Springfield Armory, Inc. would request Valley Ordnance make 100 M1A receivers headspaced to -0.003 " from blueprint zero. Thus, match grade and some standard model receivers have a number on the bottom surface. The numbers will range from 1 to 5. The numeral 1 means the receiver is headspace to 0.001 " longer than blueprint zero. If the receiver is marked with the number - 4 this means the receiver is headspaced to 0.004 " shorter than blueprint zero. This manufacturing practice resulted in improved accuracy because of the tighter headspace.

In January 1972, Valley Ordnance Co. performed sixty-three machining steps for machining each M1A receiver. Earlier receivers machined by Valley Ordnance Co. were given a lot of hand grinding and polishing by Melvin Smith. Specifically, these areas were: 1) the exterior heel corners on the sides 2) the flat surface aft of the operating rod channel 3) the top surface of the left receiver wall from the stripper clip guide to the barrel ring 4) the vertical surface on the right side behind the stripper clip guide all the way back including the windage knob ear 5) the left side of the barrel ring forward of the horizontal

scope mount groove 6) the magazine well aft of the feed lips and 7) the top surface of the barrel ring after all machining operations that located off the barrel ring had been done. This cosmetic detailing is evident as late as M1A serial number 057969. Note that the hand polishing served to enhance the aesthetic appearance but did not add to the functional ability of the M1A receiver. As Melvin Smith moved to semi-retirement the receiver surfaces noted above were finished by machine. For example, the magazine well on M1A receivers was cut and broached by machine tool after Mr. Smith purchased Hillside Manufacturing.

The Missing Connector Lock Hole - The USGI drawing 7790189 indicates that there shall be a hole for the connector lock pin on both sides of the receiver. This allows a stuck connector lock to be pushed out if need be. The connector lock hole on the left side of the receiver was drilled in at least the first eleven M1A receivers but it is not present in M1A receiver serial number 000049. The left side connector lock hole is still missing in M1A receiver serial number 002010 but the hole reappears by serial number 002282. The connector lock hole was temporarily omitted to reduce the manufacturing cost.

The receiver heels were stamped and numbered by Valley Ordnance Co. with the exception of custom serial numbers. Custom serial numbers were available through Springfield Armory, Inc. in the 1980s. Valley Ordnance shipped custom serial number receivers to Geneseo, IL without a receiver heel serial number. However, to comply with BATF regulations, Valley Ordnance identified each of these receivers before shipping by stamping the letters VO followed by a unique sequentially issued number that was recorded like all other serial numbers at Valley Ordnance. The VO series numbers were first placed on the side of the receiver legs on earlier receivers, then on the bottom side of the receiver on the flat behind the legs on later production custom serial number receivers.

Before Melvin Smith's involvement with the M1A, Hillside Manufacturing (Dallas, PA) was a subcontractor to Valley Ordnance for portions of its manufacture of the Eagle Arms 9 mm and .45 ACP Carbines. The two companies manufactured and assembled the carbines from scratch. When Melvin Smith contracted with Elmer Ballance for the M1A, Hillside Manufacturing became a subcontractor to Valley Ordnance for that project. Melvin Smith bought Hillside Manufacturing (Dallas, PA) upon retirement of the original owner, William Croughn, in about 1990. Dallas, PA is about ten miles from Wilkes-Barre, PA. Prior to the change in ownership, Hillside Manufacturing was a subcontractor to Valley Ordnance for M1A receivers and parts but also made parts for companies like Piper Aircraft and Mack Truck. Hillside Manufacturing did the rough machining work on the M1A castings from before 1976 until 1996. After the change in ownership, Hillside Manufacturing was almost 100 % dedicated to M1A receiver production due to high market demand. The Valley Ordnance scope of business remained this way until Melvin Smith passed away.

During the entire time Valley Ordnance was in operation, there were no CNC machine tools in its facility. All of the machine tools were single operation units and were set up and operated manually. Valley Ordnance always did the finish machining on the receivers. Valley Ordnance also did some development work on the Springfield Armory,

Inc. M1 Garand receivers before 1987 but no production was done.

Since Hillside Manufacturing did not have a Federal Firearms License (FFL), it was limited in the amount of machining that it could perform on the raw castings. Otherwise, the BATF would have considered Hillside Manufacturing to be a manufacturer of rifle receivers, which are regulated the same as completed firearms. Hillside Manufacturing did machine the receiver heel surface, windage knob detents and ball detent hemispheres, and bored and threaded the barrel ring. The receiver heel surface had to be precisely machined and tolerances held closely in order to produce consistent heel stampings at Valley Ordnance. In the early 1990s, Hillside Manufacturing bought and installed three CNC Moog Hydrapoint Model 83-3000 CNC machining centers for M1A receiver work. Before then, it used Moog Hydrapoint NC tape operated machining centers.

Hillside Manufacturing and Valley Ordnance worked together on an experimental project in 1991 to machine two M1A receivers from AISI 8620 alloy steel billet. This was done solely as a study to see if machining from billet was economically competitive with investment casting. The rough machining was done at Hillside Manufacturing and the finish machining was performed at Valley Ordnance. Disposition of these two receivers is unknown.

M1A Receiver Production Flow – A combined total of seventy different machining operations were performed by Hillside Manufacturing and Valley Ordnance for each M1A receiver. Both companies used quality control procedures after each machining operation. For operations that were cosmetic in nature, one out of every ten receivers was checked dimensionally. For critical operations, e.g., receiver threads, every single receiver was checked for dimensional tolerance. The manufacturing cycle time for the M1A receiver at Hillside Manufacturing in 1976 was 1 hour 50 minutes. By 1996, the cycle time at Hillside Manufacturing had been reduced to 45 minutes by use of CNC machining methods. The following describes the production flow for receivers during the period of 1981 to 1996:

1. Casting – Gray-Syracuse pours the castings using certified AISI 8620 alloy steel. The raw castings and material certification paperwork are shipped to Hillside Manufacturing.
2. Rough machining – Hillside Manufacturing performs rough machining of the M1A receiver. The semi-finished receivers and certification paperwork are shipped to Valley Ordnance.
3. Finish machining and inspection – Samples of semi-finished receivers are pulled and sent to Springfield Armory, Inc. for the heat treating vendor (see subsection 5 below). Valley Ordnance performs the finish machining work and dimensional inspection of the remaining receivers. The finished receivers and copies of the certification paperwork are shipped to Springfield Armory, Inc. in Geneseo, IL.
4. Inspection and additional machining – Springfield Armory, Inc. inspects the finished receivers supplied by Valley Ordnance. Receivers that do not meet its standard are sent back to Valley Ordnance for destruction and recycling at Gray-Syracuse, Inc. Receivers that pass inspection are shipped to a heat treating vendor in the Chicago, IL

area. If the receiver is to get a custom serial number, the heel is stamped prior to heat treatment. If the receiver is to be made select fire or lugged, this work is completed prior to heat treatment.

5. Heat treatment – The vendor performs the heat treatment procedure using the previously submitted semi-finished receiver samples from Valley Ordnance. The finish-machined receivers are then heat treated and shipped back to Geneseo, IL.
6. Coating, assembly, test fire and customer shipping – The M1A receivers are returned to Springfield Armory, Inc. from the heat treating vendor. The receivers are phosphate coated. The receivers, stocks and other parts are assembled into complete rifles and test fired on site. Similar to what existed at TRW, the test firing facility was a water backstop. If the rifle malfunctions during test firing, it is rebuilt and retested. The rifles are boxed with a magazine, factory headspace tag, M14 manual, and sales literature. M1A rifles are then shipped to firearms distributors for delivery to individual FFL holders.

Every M1A receiver was given a final inspection at Valley Ordnance as part of the quality control program. The finished M1A receiver was placed on a magnetic base and compared using a Starrett dial indicator to a Winchester M14 receiver or custom made gage blocks surface ground and hardened to the USGI receiver blueprint dimensions. The Winchester receiver used for quality control purposes was cut off just behind the rear sight pocket. A less-than-80 % finished TRW receiver was used to check dimensional quality of the receiver heel rear end machining cuts. Every M1A receiver had a bolt inserted into it by hand to check for proper function before leaving Valley Ordnance. Springfield Armory, Inc. also performed inspection of finished M1A receivers. Any receiver deemed to have any machining errors, even minor cosmetic flaws, was sent back to Valley Ordnance for destruction. These less-than-perfect receivers, as many as 100 at a time, were destroyed by sledge hammer at Valley Ordnance then shipped back to Gray-Syracuse, Inc. for recycling back into raw castings. There are no “factory seconds” M1A receivers. M1A receivers are of good quality. Springfield Armory, Inc. has never used Chinese M14 parts in the assembly of its M1A rifles.

The Starrett dial indicator and custom gage blocks were transferred to Springfield Armory, Inc. in 1996 along with the machine tools from Hillside Manufacturing and Valley Ordnance. Comparison of select fire M1A serial number 030061 to close up photographs of several USGI Winchester M14 receivers reveals nearly identical machining cuts on all surfaces.

The busiest year for Valley Ordnance was 1994. This was the year the Assault Weapons Ban was passed and enacted. Valley Ordnance employees worked seventy to seventy-five hours to meet orders for M1A receivers. M1A receiver serial number 076539 was shipped to Springfield Armory, Inc. on January 07, 1994. Receiver serial number 088207 was shipped from Valley Ordnance to Geneseo, IL on December 30, 1994. Average weekly production was approximately 100 M1A receivers through Hillside Manufacturing and Valley Ordnance between 1976 and 1996. However, there were weeks where Hillside Manufacturing and Valley Ordnance produced 300 M1A receivers a week in 1994 but quality control was always held to the same high standard. The second busiest year

was 1990. During lean times Melvin Smith found creative ways to keep cash flowing in and his employees busy. For example, in 1986 Valley Ordnance designed, manufactured and marketed a fish scaler. The fish scaler was cast at Gray-Syracuse, Inc. and machined by Valley Ordnance Co. This 7.3 ounce kitchen utensil was made of a single piece of 1704 stainless steel and was backed with a twenty year warranty against wear or breakage when used only for scaling fish.

Later on, Mr. Smith fell very ill and was hospitalized. He sold Valley Ordnance to Springfield Armory, Inc. He treated all of his employees very well. In response, he was loved by his employees. Mr. Smith was a U. S. Army veteran and had served in post-World War II Italy. At his funeral, his employees coordinated with the local VFW Post to give him a twenty-one gun salute using M1A rifles owned by Mr. Smith and the employees.

The last complete finished M1A receiver made at Valley Ordnance Co., serial number 097726 (zero nine seven seven two six), was shipped to Springfield Armory, Inc. on May 16, 1996. Operations were shut down and the production equipment was shipped to Springfield Armory, Inc. in Geneseo, IL on July 22, 1996. Employees from Valley Ordnance and Hillside Manufacturing went to Geneseo, IL to assist in setting up the newly acquired machine tools. This was a very thorough transition taking between four to six weeks which included instruction by the Hillside Manufacturing and Valley Ordnance personnel on all machining operations. Springfield Armory, Inc. graciously offered positions to the employees from Valley Ordnance and Hillside Manufacturing with competitive wages as part of the transition. As of 2003, the M1A receivers are still machined at Springfield Armory, Inc. in Geneseo, IL in the same manner as was performed at Hillside Manufacturing and Valley Ordnance.

In late 1974 and early 1975, Springfield Armory, Inc. had difficulty obtaining a dependable supply of USGI M14 and M14 NM barrels. Thus, Bob Reese contracted with Numrich Arms (West Hurley, NY) to manufacture 300 match grade six groove 1:10 twist AISI 4140 alloy steel barrels. Springfield Armory, Inc. advertised these barrels in the February 01, 1975 issue of *Shotgun News*.

In 1976, Springfield Armory, Inc. was purchasing M14 parts from Sherwood Distributors, Numrich Arms and Sarco, Inc. Sherwood Distributors was owned by Mike Kokin. Sherwood Distributors was a firearms parts and accessories business until the mid-1990s. Mr. Kokin sold his company and the new owner established Northridge International, Inc. (San Fernando, CA). In the mid-1970s, Numrich Arms was owned and operated by George R. Numrich, Jr. Mr. Numrich passed away in 1991. Operations at Numrich Arms were then managed by Ira Trast. Mr. Trast had been with Numrich since at least the mid-1970s. When Mr. Trast retired about 2000, Mr. Numrich's son took the reins. Today, Numrich Arms Corporation and Sarco, Inc. remain very busy supplying firearms parts and accessories for the commercial market.

Hillside Manufacturing produced finished barrels from Wilson Arms supplied blanks from about 1978 until some time before 1990. Only Wilson Arms barrel blanks were used at Hillside Manufacturing. The 1.100 " diameter barrel blanks had the rifling done but otherwise all other machining was performed by Hillside Manufacturing. This included

cutting the external contour, cutting off the breech, cutting the feed ramps, chambering, drilling the gas port, grinding the operating rod guide, gas cylinder and flash suppressor lobes, cutting the gas cylinder and flash suppressor splines, threading the chamber end to mate with the receiver, and threading the muzzle end for the flash suppressor nut. The same machine was used to cut the barrel threads and the receiver barrel ring threads. It was a Planomill thread milling machine. This was the same type of machine tool that was used for U. S. government production of the M1 Garand and M14 receivers and barrels. Springfield Armory, Inc. bought the barrel making operation including all of the associated machine tools. Before 1990, Springfield Armory, Inc. also made non-plated barrels for the M1A.

The 22 " long barrels were made in three grades, standard contour, standard contour National Match, and heavyweight National Match. None of the barrels manufactured at Hillside Manufacturing were chromium plated. A notable exception was a single run of a couple hundred M1A-A1 Bush 18 " barrels made around 1980 or 1981. The rack grade standard contour barrels were supplied to Springfield Armory, Inc. during times when USGI chromium plated M14 barrels were not available. The dimensional tolerances were incredibly tight on the barrels. For example, the diameter of the gas cylinder lobes was held to within 0.0005 " or one-half of one-thousandth of an inch.

The barrel crowning was done by hand. The barrels were lined up by the hundreds on a bench. Melvin Smith then used his steady hand and eagle eye with a portable electric tool and ball stone to machine the crown on each barrel muzzle moving from one end of the bench to the other. The barrels were not stamped GENESEO IL at Hillside Manufacturing. This was done at Springfield Armory, Inc. Some of the machine tools used in the barrel operation by Hillside Manufacturing and transferred to Springfield Armory, Inc. in 1996 are described as follows:

1. German made hydraulically operated tracer lathe – This lathe cut the external contour in one pass.
2. Cincinnati rise and fall horizontal mill – This mill cut the gas cylinder splines.
3. Ward turret lathe – This mill was used to machine the chamber to desired specification.
4. Landis cylindrical grinder – This grinder was used to obtain the final dimension of the operating rod and gas cylinder lobes after turning on the lathe.

By no later than 1978, Hillside Manufacturing machined reproduction operating rods, trigger housings, flash suppressors, bolts, operating rod spring guides and barrels. No gas cylinders were made by Hillside Manufacturing or Valley Ordnance. It has not been confirmed but most likely the trigger housing and flash suppressor castings for M1A parts were also produced by Gray-Syracuse, Inc. since Mr. Smith was loyal to his suppliers. Valley Ordnance did the finish machining on cast semi-finished stripper clip guides supplied to the firm. The reproduction bolts, operating rods and trigger housings were stamped at Valley Ordnance. The operating rod spring guides were made from plate steel using a punch press with progressive dies. The operating rods were supplied to Hillside Manufacturing already welded together. Hillside Manufacturing machined the operating rods to final dimension. In the late 1980s, Hillside Manufacturing made fewer M1A parts as Springfield Armory, Inc. found other sources or did the work itself.

Springfield Armory, Inc. and Glenn Nelson

Glenn Nelson joined the U. S. Army in 1954 and became a member of its shooting team in 1961. He earned Distinguished Rifleman status in 1962 as well. He remained on the Army shooting team until late 1965 when he accepted an offer to become a match armorer. He completed the U. S. Army match armorer school at Rock Island Arsenal then began building M14 rifles for competition as part of the USAMTU at Fort Benning. Mr. Nelson went on to serve in Viet Nam. He retired from the U. S. Army in 1975. Bob Reese hired Glenn Nelson to establish a shop that could build competition grade M1A rifles for Springfield Armory, Inc.

Mr. Nelson began building Ultra Match M1 Garand and National Match and Super Match M1A rifles from his home. However, by 1987 the business had grown such that the custom rifle shop occupied 5,000 square feet of building space. Over the years he put together a first rate staff of former AMTU match armorers and former Army team shooters. Mr. Nelson and his staff kept up with and implemented the latest accurizing techniques used by the AMTU as time went on. Mr. Nelson no longer builds competition rifles for Springfield Armory, Inc. but did so until at least 1993.

The custom Super Match M1A rifles were fitted with either Douglas or Hart heavyweight barrels. These heavyweight barrels were available in 1:10, 1:11, or 1:12 twist rates. Mr. Nelson required the air-gauged and stress-relieved barrel blanks supplied to him have a bore diameter between 0.2999 " and 0.3004 " and a groove diameter between 0.3079 " and 0.3084 ". The heavyweight barrel blanks were supplied with rifling obviously, but the rest of the machining was done by Mr. Nelson or his employees. National Match medium weight barrels were supplied by Springfield Armory, Inc. to Mr. Nelson already for installation by other suppliers. The operating rod guides were soldered on to the barrels. For individual customers, Mr. Nelson machined hand picked medium weight and heavyweight Douglas Premium barrel blanks and installed them in rifle builds unless the customer specified otherwise.

To give the reader an idea of what is possible with the M14 rifle and a talented armorer, the following will illustrate the point. In April 1986, Glenn Nelson built a Super Match M1A rifle from stripped receiver serial number 033187. The build included all TRW parts and a National Match rear sight. After final assembly, this rifle was tested on a machine rest. It grouped fourteen shots under the size of a nickel at 200 yards with 168 grain Sierra bullets. The test target was presented to the buyer, a member of the Second Army Shooting Team.

Mr. Nelson and his staff used the same Springfield Armory, Inc. M1A receivers used on standard models to create state-of-the-art competition rifles. They performed the match conditioning work and 90 % of the assembly on the receivers sent to the Nelson shop in Columbus, GA by Springfield Armory, Inc. Mr. Nelson purchased TRW bolts for building all the National Match and Super Match M1A rifles in his shop. Headspace on these rifles was kept between 1.631 " and 1.632 ". The M1A rifles dressed in wood stocks were coated several times with raw linseed oil. The almost-complete rifles were shipped back to Springfield Armory, Inc. for final assembly, test firing, packaging and shipping. Final assembly in Geneseo, IL included installation of the front and rear sights, operating rods,

hand guards and slings.

Rock Island Armory, Inc.

Rock Island Armory, Inc. (1985 address 111 Exchange Street Geneseo, IL 61254) was a sister company of Springfield Armory, Inc. It mostly performed work for foreign military customers. However, Rock Island Armory did perform thirty-five select fire conversions on semi-automatic Springfield Armory, Inc. M1A rifles. These conversions are stamped with the letters R I A on top of the receiver heel on the flat surface just to the rear of the rear sight base. This company had no connection with the U. S. government Rock Island Arsenal also located in Illinois and which is still in operation as of early 2006. Rock Island Armory, Inc. was in business until the mid-1990s.

Karl Maunz

Karl Maunz began shooting competitively at the age of nine. He started shooting at the Camp Perry matches at fifteen years old. He loved the sport so much that he joined the U. S. Army at the age of seventeen and was an armorer (Military Occupational Specialty was 762.10) at eighteen. He was in active service from 1957 until 1964 in the Army Reserve. He was a member of the U. S. Army shooting team from 1960 through 1964. Lacy DeGrange, a member of the U. S. Army shooting team from 1958 to 1960, helped Karl Maunz build his first M1 Garand rifle. During the early 1960s, members of the U. S. Army Reserve were only allowed to possess a M14 rifle while at Camp Perry. Unquestionably, this put them at a competitive disadvantage with Regular Army competition shooters. So, Karl Maunz ground two M1 Garand receiver halves and Melvin Smith welded them back together with a shorter overall length to replicate most of an M14 receiver's dimensions. Mr. Maunz and Mr. Smith met while at Camp Perry in 1961. While he was on the Army shooting team, Mr. Maunz would practice with this M1 Garand rifle converted to accept an M14 magazine. This is the first known 7.62 x 51 mm caliber magazine fed M1 Garand rifle. At the same time, others had ground out and machined whole M1 Garand receivers to accept M14 magazines. Disclaimer: This must not be done unless one has the proper knowledge, training, equipment and licensing to do so. Metal working operations alter the mechanical properties of steel and can compromise the strength of the finished product.

Mr. Maunz went on to shoot Distinguished Rifleman using the M1 Garand rifle shooting left-handed. He received much encouragement from Colonel Joe Smith, Director of the DCM in pursuing this achievement. In 1965, Karl Maunz scored higher than all shooters using bolt action rifles at the National Matches. He received his Lifetime Master designation from the NRA Competitions Division in 1966. The DCM belatedly awarded Karl Maunz his Distinguished Rifleman award in 1971. In 1972, he was disqualified as a civilian competitor at Camp Perry because he attempted to shoot with a Springfield Armory, Inc. M1A rifle. The National Rifle Association later changed the High Power Rifle match rules to allow civilian competitors to use the M14 type rifle (see Texas Production). Mr. Maunz shot competitively in the years 1960 through 1973, 1978 through 1981 and from 1984 through 1989.

Karl Maunz converted M1 Garand rifles in the 1960s to accept M14 magazines and

installed 7.62 x 51 mm / .308 Winchester barrels on them. This conversion was known as the Maunz Model 57 Rifle. Around 1967 and 1968, Rimer Casting Company (Waterville, OH) produced Maunz Model 67 castings for Karl Maunz. The receiver castings were subsequently machined. The Model 67 receiver was a lengthened M1 Garand receiver with a BM59 style bolt lock but it accepted a M14 magazine. The Model 67 receivers were assembled into complete rifles. There were 400 to 500 Model 67 rifles built. The calibers were .308 Winchester or .308 case with .264 bullet. The Model 67 rifle was still available from Mr. Maunz until 1987. Mr. Maunz got his idea for naming his rifle designs, Models 57, 67, 77 and 87, from the legendary German rifle manufacturer, Mauser.

In the late 1960s and early 1970s he owned and operated Competitive Shooters Supply Company in Defiance, OH and another gun shop in Napoleon, OH. In the early 1970s, Karl Maunz built M14 type rifles using Springfield Armory, Inc. M1A receivers. He later owned American Kit Car Company and a General Motors automobile dealership. He sold a 1970 Cadillac automobile to Melvin Smith in 1971. Later, in 1977, Karl Maunz sold him a 1973 model Cadillac. In 2005, he owns and operates a beverage company and a vineyard.

Maunz M14 Rifle Synthetic Stocks - In 1967, Karl Maunz designed a prototype commercial M14 fiberglass stock and sent it to Reinhart Fajen, Inc. Reinhart Fajen, Inc. made a wood M14 stock from this prototype. Mr. Maunz enhanced his original design in a drawing done at Cincinnati, OH dated April 10, 1977. He specified lightweight synthetic resin foam material to fill the butt stock in these satin black color heavy contour fiberglass stocks beginning in 1977 to enhance hearing protection for the shooter. The Maunz M14 synthetic stock could be reinforced with ballistic resistant material in 1986 for an additional \$25.00. The Maunz M14 rifle stocks were available from 1977 until about 1989. The first of the Maunz M14 synthetic stocks was installed in 1977 on Springfield Armory, Inc. M1A serial number 000011.

Mr. Maunz sent a wood copy of his 1977 design fiberglass M14 stock to Reinhart Fajen, Inc. about 1978 or 1979. He also traded one of his April 1977 design fiberglass M14 stocks to Gale McMillan around 1985 (see Commercial Synthetic Match Grade Stocks). That same year, Karl Maunz drew up the design for a red, white and blue M1A rifle stock to be sold through the American Shooters Union. Reinhart Fajen, Inc. manufactured this red, white and blue wood laminate stock in 1985 for Karl Maunz. This stock was reportedly featured in the 1985 Edition of the Shooter's Bible.

Maunz Receiver Master Die – Karl Maunz drew up the semi-automatic M14 receiver master die using a copy of USGI M14 receiver drawing 7790189 in the winter of 1969. A machinist at Rimer Casting Company (then at its address in Waterville, OH prior to Rimer Road Waterville, OH) reviewed it for Mr. Maunz. Mr. Maunz then gave the modified M14 receiver drawing to a tool and die maker in Holland, Ohio. Fabrication of the receiver master die was delayed due to a lack of funds until late 1970. The receiver master die took six months to fabricate. Finally, the receiver master die was completed some time before August 1971. The stamped serial number of the master die is 71-1761-183. The master die was designed to produce a casting with an open barrel ring. It was found that this caused porosity at the front end of the casting. Consequently, the die was modified

on April 05, 1972 by adding an insert that allowed the pour to fill the barrel ring in the casting. Between 1971 and 1987, this receiver master die was used by various entities to birth all of the M14 type receiver castings for A. R. Sales Co., National Ordnance, Inc., Maunz Mfg., Maunz Match Rifle, H&R Gun Co., and Smith, Ltd. and some castings for Armscorp of America and Federal Ordnance. For example, in a purchase order dated June 22, 1987 and signed by Jack Friese, Armscorp of America requested delivery of 1000 semi-automatic M14 type receivers from Karl Maunz.

Maunz Manufacturing, Inc. – Karl Maunz established Maunz Manufacturing, Inc. in 1977 while he lived in Cincinnati, OH. Maunz Manufacturing first used Springfield Armory, Inc. M1A receivers to build complete M14 type rifles. Very quickly though, under the license and supervision of Karl Maunz, his associates cast, machined and stamped Maunz Mfg. receivers. The Maunz Mfg. receivers were cast at Rimer Casting Company. Rimer Casting Company was located on Rimer Road in Waterville, OH from 1970 until June 1997. The owner, Richard Rimer, sold the business and retired in June 1997.

Most of the Maunz named M14 type rifles were stamped Maunz Mfg. The Maunz Mfg. rifles were built between 1976 and 1978 and from 1983 to 1984. From 1983 to 1987, Karl Maunz had M14 parts shipped to and rifles assembled and tested at 3230 Strayer Road Maumee, OH 43537. Maunz Mfg. M14 type rifles were all built with USGI and National Match grade parts. A very few Maunz Mfg. rifles were experimental models. These rifles have a serial number preceded by EX-. One of the EX- series rifles has been observed without the scope mount hole. Both Maunz Mfg. and Maunz Match Rifle receivers are stamped TOLEDO, OHIO on the scope mount (left) side. Karl Maunz only sold Maunz Mfg. rifles to corporations.

Maunz Match Rifle - The Maunz Match Rifle receivers were cast at Funkfein Casting (Columbus, OH). The Maunz Match Rifle receivers were produced by Smith Manufacturing per an agreement with Karl Maunz (see H&R Gun Co. and Smith, Ltd.). Maunz Match Rifle models were all built with USGI and National Match grade parts. The match grade barrels were obtained from Karl Walther, Boots J. Obermeyer, Jack Krieger and barrel blanks from Bob Hart. Obermeyer barrels were only used on a few Maunz Match Rifle models though. The original stocks on these rifles have a Maunz Match Rifles badge embedded in the stock. This 1 ½ " x 2 " badge includes an eagle, crossed Union and Confederate flags and the words In God We Trust against a white color background. All Maunz Match Rifle models were sold originally as complete rifles by Smith Manufacturing and not by Karl Maunz.

Mr. Maunz only built Maunz Match Rifle models for match shooters who had earned an NRA Master or higher classification. Mr. Maunz built his last Maunz Match Rifle for a Master shooter in 1987. One such competitor was the late retired USMC Chief Warrant Officer 4 David I. "D.I." Boyd, II. CWO4 Boyd was the finest American competition shooter ever. He won several team and individual gold medals in various World Championships, Championships of the Americas matches and Pan American Games from 1963 to 1977. He earned at least four National Championship titles from 1972 to 1981 and was the USMC Rifle Champion in 1975. CWO4 Boyd was featured on the

October 1981 issue front cover of *American Rifleman*, the year he won the National High Power Rifle Championship. He was a triple distinguished shooter by earning the United States Distinguished International Shooter Badge, the USMC Distinguished Rifleman Badge, and the USMC Distinguished Pistol Shot Badge. CWO4 Boyd's Maunz Match Rifle serial number was USMC 1. CWO4 Boyd retired from the U. S. Marine Corps in 1998 and passed away in May 2000.

All Maunz Mfg. and Maunz Match Rifle receivers were first examined by X-ray and then by magnetic particle inspection before phosphate coating. These receivers were stamped with a number in the rear sight pocket as part of the quality control program. The quality of Maunz Mfg. and Maunz Match Rifle models is reported as very good or better. Maunz Match Rifle serial numbers 0002 and 0041 are stamped on the receiver heel from top to bottom: first line – MAUNZ second line – MATCH RIFLE third line - MODEL 77 fourth line – 00XX.

The Maunz Match Rifle Model 77 was designed in 1977 by Karl Maunz but not produced until 1985. It was available in 7.62 x 51 mm / .308 Winchester with either 22 " long medium weight or heavyweight match barrels. The synthetic stock was a satin black color finish. The Model 77 rifle was supplied with a removable globe style front sight that could be swapped out with the National Match 0.062 " front sight on the USGI flash suppressor. The rear sight was the National Match hooded aperture model. Fifty of the Maunz Match Rifles were produced in 1985 with ASU series serial numbers. Thirty of these rifles had the 1977 Maunz design satin black color fiberglass stocks. The remaining twenty rifles were fitted with the 1985 Maunz design red, white and blue wood laminate stocks.

The Maunz Match Rifle Model 87 was designed in 1987 by Mr. Maunz. It housed all of the gas system, including the gas cylinder, inside an oversized synthetic satin black color stock and had a 26 " barrel and a globe type front sight. The stock was available in either left-handed or right-handed models. The rear sight was the National Match hooded aperture model. The Maunz Match Rifle Model 87 was available in several calibers (see Other Calibers).

Mr. Maunz does not favor welding a lug onto the M14 type receiver and never did so. Instead, he designed and marketed a bolt-on front receiver lug for the M14 type rifle. The Accuracy Lug attached to the receiver using a pin inserted through the connector lock holes and secured by a screw through the bottom of the stock. The Accuracy Lug was manufactured at Rimer Casting Company for Karl Maunz. In 1986, it was available at Uncle Sam's and through Armscorp of America (see Camp Perry Military Reservation and Armscorp of America, Inc. and Armscorp USA, Inc.). Mr. Maunz designed a rear receiver lug in a December 18, 1984 drawing he made. A steel prototype was made and Rimer Casting Company was going to produce it but the project never moved forward.

H & R Gun Co. and Smith, Ltd.

Mr. Maunz sold his M14 rifle business to Smith Manufacturing in Toledo, OH about 1984. The semi-automatic M14 receiver master die was loaned to them as part of the sale. Smith Manufacturing produced complete rifles built on investment cast H&R Gun Co.

stamped receivers. The H&R Gun Co. Semi-Auto 7.62MM-M14 receivers were marked TOLEDO, OHIO though Smith Manufacturing was physically located in Holland, OH about fourteen miles to the west. H&R Gun Co. Semi-Auto 7.62MM-M14 rifles were assembled with Harrington & Richardson M14 parts kits imported in 1985 by Jack Friese (see Armscorp of America, Inc. and Armscorp USA, Inc.). All H&R Gun Co. models were originally sold as complete rifles by Smith Manufacturing. The highest serial number observed for an H&R Gun Co. Semi-Auto 7.62MM-M14 is 1126. Smith Manufacturing was operated by Carl Hinkelman and two other associates. As an aside, Carl Hinkelman lived in Toledo, OH within blocks of the Schuster family at the time (see Commercial Accessories). Karl Maunz was a consultant to Smith Manufacturing on the H&R Gun Co. project.

Smith Manufacturing machined the first Armscorp of America receivers around 1985 or 1986. A number of these had rear lugs made as part of the casting. The very first Armscorp of America M14 type rifle receiver was hand delivered to Mike Gruber by Karl Maunz (see Armscorp of America, Inc. and Armscorp USA, Inc.). Smith Manufacturing made a few Armscorp of America receiver heel markings using electro-discharge machining (EDM) instead of using stamping dies as an experiment.

Smith Manufacturing also produced Smith, Ltd. investment cast semi-automatic M14 type receivers. Smith, Ltd. receivers were made about 1987. Like Maunz Mfg., a very few Smith, Ltd. rifles were experimental models. An example is Smith, Ltd. M-14 serial number EX-5 which has a front lug and no rear lug. These rifles have a serial number preceded by EX-. Smith, Ltd. receivers were assembled as complete rifles and sold about 1987 and 1988 at Camp Perry shooting matches by Smith Manufacturing. The parts fit if using USGI and/or National Match parts is excellent, based on examination of Smith, Ltd. rifles serial numbered 0210, 0225, 0236 and 0237. A commercial manufacture bolt and commercial manufacture operating rod were found to be too thick to slide smoothly inside Smith, Ltd. serial number 0237.

The following report was given by M14 gunsmith Tim Strait on March 14, 2006 on Smith, Ltd. receiver serial number 0003 [minor spelling and punctuation errors corrected]:

Smith, Ltd M14 # 0003

Receiver specifications as follows:

1. Excellent cast receiver with virtually no machine marks visible. Excellent parkerized [phosphate coated] metal finish on the entire rifle. Surface hardening was checked at the rear sight base with results of 59 HRC according to a local metallurgist.
2. All parts on this rifle are TRW (barrel, operating rod, firing mechanism and bolt). All parts seem to fit well without any fitting at all. Barrel gauges at 0 for throat erosion and 0 for muzzle wear.
3. Receiver threads (barrel) are correct per M14 military specification (barrel timing or indexing).

4. The machine work done on the inside of the receiver is excellent and smooth. No burrs were found on this receiver.
5. The locking lug helix of this Smith, Ltd receiver matches the helix of the USGI M14 bolt very well at approximately 99.9 %.
6. Firing pin retraction was well within standard for USGI military specification.
7. Headspace on this rifle was set at a modest 1.6325 ". This is good enough for commercial .308 Winchester or 7.62 NATO ammunition. The bolt lugs have about 99 % contact with the receiver locking lug engagement area.
8. The receiver heel is just a bit thicker than other commercial receivers being made today.
9. The front pin hole for the bolt stop roll pin is cut exactly the same as USGI M14 rifles.
10. The operating rod dismount notch is 1 ½ times the width of current commercial receivers.
11. The receiver safety bridge was milled correctly and there's no bolt shuck or interference with bolt rotation. The action functions smoothly and without a hitch.

Note

During the 1980s, there were four businesses or individuals with the name of Smith involved with commercial M14 rifles as manufacturers. Neal Smith of Smith Firearms (Mentor, OH) performed NFA registered select fire conversions of already-manufactured Springfield Armory, Inc. M1A rifles. Richard Smith and Ron Smith of Smith Enterprise, Inc. (then Mesa, AZ) produced semi-automatic and select fire M14 rifles stamped SMITH ENT. Melvin Smith of Valley Ordnance (Wilkes-Barre, PA) machined raw castings into M1A receivers for Springfield Armory, Inc. in Geneseo, IL. Smith Manufacturing (Holland, OH) produced Maunz Match Rifle, H&R Gun Co. and Smith, Ltd. semi-automatic M14 rifles and the first Armscorp of America M14 type receivers. None of these entities ever did any work for the others. Although Armscorp of America, Inc. sold Smith Enterprise, Inc. M-14 receivers and Smith Manufacturing made some Armscorp of America M14 receivers, there was never any connection or relationship between Smith Manufacturing (Holland, OH) and Smith Enterprise, Inc. (then Mesa, AZ). The similarity in names is purely coincidental.

A. R. Sales Co., National Ordnance, Inc. and Federal Ordnance, Inc.

A. R. Sales Co. was established in 1968 and owned by Ilia I. Karnes. Jack Karnes, his wife Ilia, and their two children ran the company. Mr. Karnes was a tool and die maker by trade. When the family business started, its first large contract was to make M16 scope mounts. The two letters, A.R., were taken from the first two alphanumeric characters of the commercial name for the M16 rifle. Next, A. R. Sales produced high-end lightweight alloy M1911 style pistol frames and accessories.

It appears that A. R. Sales started on the semi-automatic M14 type rifle project by

October 1971. An advertisement for its Mark IV rifle appeared in the October 15, 1971 issue of *Shotgun News*. The response from the civilian market was overwhelming. This included 2000 or more mail-in orders with the \$15.00 deposit for a stripped Mark IV receiver.

A. R. Sales received its initial batch of Mark IV receiver castings by no later than March 07, 1972. This first set of receivers were used by Jack Karnes to set up fixtures and tooling for the machine tools. There were two Mark IV receiver production lots for the company. The first occurred in the winter of 1973. The first Mark IV rifles and stripped receivers were delivered to customers in January 1973. Mark IV serial number 0143 had been delivered to the buyer on March 02, 1973. The first production lot of Mark IV receivers was cast at Rimer Casting Company (Waterville, OH) using Karl Maunz's receiver master die according to two sources and Prico (Los Angeles, CA) according to a third source, all highly reputable. The first production lot of Mark IV receivers was machined by A. R. Sales. The first lot of receiver serial numbers ended somewhere between 0001 and 0225 with 200 receivers produced.

The second receiver production lot was made in 1976. The receiver serial numbers for the second lot were started at a number below 0226 and ended at number 0250. The second production batch of Mark IV receivers was cast at Gray-Syracuse, Inc. and machined by Valley Ordnance Co. About twenty-five receivers were produced in the second batch.

Twenty-five serial numbers were skipped between the first lot and the second lot. The missing serial numbers were allotted for tool room samples and for intended-but-never-realized forged receivers. Both production lots of Mark IV receivers were heat treated by a local company in southern California.

A. R. Sales Co. at first bought M14 parts brand new directly from USGI contractors. Mark IV rifles were assembled with new and used USGI M14 parts and USGI M14 wood stocks. Any used M14 parts that were broken or worn were compared to the USGI drawings and rejected in the build procedure. The stock selector cutout was filled in for each assembled Mark IV rifle. According to the October 1971 A. R. Sales Co. specification sheet for the Mark IV rifle, "While most of our rifles will be built with N.M. barrels, we do not glass bed the actions, nor do we produce match grade weapons. We feel that this is best left to those who specialize in accurizing and building match grade weapons, and we do not wish to infringe in their domain."

Ford Motor Company was formed on June 16, 1903 by Henry Ford and eleven other business associates. In 1925, Ford Motor Company bought Lincoln Motor Company, a manufacturer of luxury automobiles. For the 1972 model year, Lincoln introduced the Mark IV two-door luxury sport coupe. The Mark IV was longer, wider and slightly lighter than its very popular predecessor; the Lee Iacocca designed Lincoln Mark III. The 1972 Mark IV was Ford's answer to General Motors Corporation's Cadillac Eldorado and was a major success for Ford Motor Company. Lincoln Mark IV automobile production ended with the 1976 model year. Mr. Maunz was impressed with the plush style of the 1972 Lincoln Mark IV. Thus, he suggested to A. R. Sales that its semi-automatic M14 receiver be named Mark IV. A. R. Sales Mark IV receivers are of decent quality. ²

Ilia Karnes sold the manufacturing side of A. R. Sales to Ranger Machine & Tool some time in 1977 or 1978. Ranger Machine & Tool continued to produce the pistol frames and accessories but did not produce any M14 receivers or rifles. The retail business of A. R. Sales was shut down in 1984 by Ilia Karnes.

At the same time, in the early 1970s, when A. R. Sales was developing its Mark IV receiver, John Arnold was pursuing the same goal of manufacturing and marketing his own semi-automatic M14 type receiver. Mr. Arnold owned National Ordnance, Inc., a firearm manufacturing company, and Federal Ordnance, a firearm parts and ammunition supplier. Mr. Bob Penny was a business partner in this endeavor with John Arnold. John Arnold, Jack Karnes and Bob Penny were all former associates of Golden State Arms. Mr. Wyant Lamont, Jr., managed the day-to-day operations of National Ordnance.

The two sister businesses were located adjacent to one another on Alpaca Street at Potrero Avenue in South El Monte, CA. The street address for National Ordnance, Inc. was 9543 Alpaca Street South El Monte, CA 91733 or about one city block from A. R. Sales at 9624 Alpaca Street. From 1965 to 1970, National Ordnance produced 22,500 newly manufactured M1903A3 receivers and assembled them into complete rifles using USGI surplus parts. National Ordnance also manufactured 2000 M1 Garand welded and investment cast receivers and an unknown number of M1 Carbine investment cast receivers in the 1960s. The M1 Carbine and newly manufactured M1 Garand receivers were cast by Rimer Casting Company.

Employees from both A. R. Sales and National Ordnance visited the facilities of one another to discuss set up of machine tools. A. R. Sales did assist National Ordnance in its BM59 project but there was no collaboration between the two firms specific to M14 receivers. A very small number of National Ordnance stamped semi-automatic M14 type rifles were produced. Stephen Fuller reported two completed receivers for the company but a more reliable source closer to the events of the time estimates a half-dozen National Ordnance receivers were finished. The National Ordnance receivers were investment cast by Rimer Casting using the Maunz master die but machined by another Ohio business according to one source. Two other sources state that a business in Spain made the raw castings for National Ordnance. National Ordnance went out of business about 1974 or shortly thereafter with the death of Mr. Arnold. As part of the liquidation of the company's assets, assembled M14 type rifles and parts kits were sold off.

Bob Brenner restarted Federal Ordnance about 1979. Jack Karnes went to work for Bob Brenner when Federal Ordnance was revived. He was employed by Federal Ordnance until 1984. Mr. Karnes then did consulting work for the company until 1985 or 1986. In early 1982, Federal Ordnance had plans to produce M1 Garand Rifles using newly manufactured receivers. Federal Ordnance was located at 1443 Potrero Avenue South El Monte, CA 91733. It sold military surplus firearms. In the late 1980s at least, Federal Ordnance, Inc. supplied a list of firearms manufacturers and importers addresses with its factory literature and a note encouraging customers to contact the manufacturer or importer to get an owner's manual. Federal Ordnance also sold lightweight alloy M1911 style pistol frames marketed under its name and a trade name as well as selling a Springfield Armory, Inc. high-end M1911 style pistol.

Federal Ordnance began production of its M14 type rifles by 1984 and ended around 1992. About 1992 Federal Ordnance, Inc. changed its name to Bricklee then shut down shortly thereafter. The business was revived twice more under different names before finally withering on the vine. According to a very reliable source, Federal Ordnance used the same Spanish company as National Ordnance, at least initially, to supply the raw receiver castings. Karl Maunz supplied some receiver castings in 1987 to Federal Ordnance. Federal Ordnance receivers machined while Jack Karnes was on board were of good quality. ³

The Manufacturer's Suggested Retail Price for a Federal Ordnance M14SA in 1988 was \$629.00. The rifles were sold with a one year parts and labor warranty. Each Federal Ordnance M14 type rifle sold was accompanied by a factory inspection tag, warranty registration card, a copy of U. S. Army FM 23-8 and a fourteen page booklet on firearms safety and care. The safety booklet was written by Federal Ordnance, Inc. in 1984. The factory inspection tag included the following information about each rifle: date, stock number, a description, caliber, and signature fields for checking of headspace, test firing and inspection. The stock number for the fiberglass stock M14 was GU-0715. USGI M14 accessories such as magazines, magazine pouches, slings and cleaning kits were available from Federal Ordnance.

Federal Ordnance built two types of M14 rifles, one with USGI parts and one with Chinese parts. USGI parts were used extensively in Federal Ordnance rifles through at least S/N 8877. Through at least serial number 394X the USGI parts were taken off USGI M14 rifles imported from Israel. By serial number 9844, if not earlier, Chinese and Taiwanese reproduction parts were used to assemble its rifles. For example, Federal Ordnance M14SA serial number 502XX was assembled at the factory on September 13, 1991 with Chinese manufacture bolt, operating rod, firing mechanism and barrel. Receivers with serial numbers above 60XXX have engraved heel markings. Federal Ordnance receivers observed are marked on the side with the letter F inside a circle. This marking is sometimes lightly stamped. Federal Ordnance sold complete rifles as well as stripped receivers.

Synthetic stocks on Federal Ordnance M14 rifles may not have been USGI models but of unknown commercial manufacture. The original owner of Federal Ordnance M14SA serial number 22XX reports that the synthetic stock never had a selector cutout or USGI markings inside the magazine well. Further, the Federal Ordnance stock had a slightly rough finish. The butt plate was glossy black color instead of phosphate coated.

Century Arms International assembled some of these Federal Ordnance receivers with Chinese parts at their facilities in Montreal, Quebec, Canada in 1990 just before the imported parts ban of November 29, 1990, brought them into the United States with the military style features (twenty round magazine, bayonet lug, flash suppressor, and hinged butt plate) which was legal at the time and sold them to the commercial market. Century Arms International ceased operations in Montreal around 1993.

The Federal Ordnance marking may be located on the right receiver leg instead of the receiver heel for Century Arms International assembled rifles. Some Federal Ordnance M14SA receivers have serial numbers with the letter C prefix followed by a hyphen then

four digits, e.g., C-0116. These letter C prefix serial number receivers were sold as stripped receivers to Century Arms International in 1990 for assembly into complete rifles. Century Arms International assembled very few M14 type rifles with Federal Ordnance receivers and Chinese parts, as compared to the number of Chinese rifles it later sold. Serial number C-0581 is the highest serial number for this series observed to date.

As an aside, Jack Karnes manufactured some 81 mm mortar round fin assemblies in 2002 for the Paramount Studios movie *We Were Soldiers*. These rugged fin assemblies were made to withstand the pressure generated by the mortar ignition charges which were designed to create 18 " flames out of the mortar tube. His son was one of the armorers assigned to the movie production unit.

Armscorp of America, Inc. and Armscorp USA, Inc.

Production and Services – Armscorp of America, Inc. was formed in 1981 by Jack H. Friese. It built accurized M14 type rifles for competition shooters. In 1985, the company was located at 9162 Brookville Road Silver Spring, MD 20910. Mike Gruber and Clint McKee, who would later go on to establish Fulton Armory, also worked at Armscorp of America at this time. The company moved to 4424 John Avenue Baltimore, MD 21227 at some point between September 1987 and 1992. The firm reorganized as Armscorp USA, Inc. in 1992 after the move to Baltimore.

Smith Enterprise, Inc. sold some billet machined receivers to Armscorp of America, Inc. about 1985 and 1986 but none were stamped Armscorp of America. They were Smith Enterprise stamped receivers and advertised as such. A complete rifle with a Smith Enterprise receiver, all USGI parts and a used USGI stock was advertised by Armscorp of America initially in *Shotgun News* for \$539.95. The Armscorp of America advertisement listed the bare Smith Enterprise M-14 receiver for sale at \$199.95 and complete USGI parts kits without the receiver for \$239.95. A TRW M14 parts kit was an additional \$10.00. The customer demand for the bare receivers and assembled rifles was so great in 1986 that it took the firm several months to fill the backlog of orders even with a price increase. The June 1986 *Soldier of Fortune* review of the Armscorp of America M14 lists the retail price for the Armscorp of America M14 at \$674.95 with a used USGI stock.

Smith Enterprise sold some casting equipment and tooling to Armscorp of America, Inc. between 1986 and 1990. Armscorp of America, Inc. was manufacturing investment cast receivers at some point by the summer of 1987. As of September 18, 1987 the company had completed the machining of five lots of Armscorp of America M14 type receivers using its own personnel and CNC machine tools. Armscorp of America receiver heat treatment was performed according to the USGI procedure and certified by the vendor.

Armscorp of America receiver with serial number A00326X has been identified as billet machined. An Armscorp of America receiver with serial number A0039XX is investment cast. Armscorp USA, Inc. manufactures standard, rear lug and double lugged receivers. It was the first commercial manufacturer to sell factory new lugged receivers (see H&R Gun Co. and Smith, Ltd.). The firm casts and machines its receivers as well as those for Fulton Armory. Armscorp USA heat treats its receivers to 56 to 58 HRC to a case depth of 0.012 " to 0.018 " per the USGI receiver drawing. Armscorp USA also provides M14

gunsmithing services such as rifle assembly, barrel installation, stock bedding, National Match trigger and flash suppressor modification, and clean and lube. Note that the large majority of Armscorp brand M14 receivers have been sold by the manufacturer as stripped units. In 2006, Armscorp USA was investigating the possibility of manufacturing a number of forged M14 parts.

Receiver Markings - Some of the Armscorp receivers are stamped M21 or XM25 instead of M14 NM or M14 to allow for sale in New Jersey, USA. The State of New Jersey, curiously, has banned new sales of some firearms by name rather than by operating characteristics or features. The USGI M14 receiver drawing numbers 7790189 and 7790189 F have been found on Armscorp receivers under the stock line on the right hand side. Stampings on Armscorp receiver operating rod channels have varied. Until at least serial number A003XXX, the Armscorp receivers are stamped SILVER SPRING MD. The operating rod rail stamping changed to ARMSCORP OF AMERICA SILVER SPRING MD by serial number A0035XX. The next operating rod rail stamping is ARMSCORP OF AMERICA BALTIMORE MARYLAND. This information is stamped on a receiver with a serial number as low as A0039XX. The fourth operating rod rail marking is ARMSCORP USA BALTIMORE MARYLAND as found on receiver serial number 1072X. The fifth variety is ARMSCORP BALTIMORE MD as shown on receiver serial number 11XXX.

Armscorp has issued custom receiver serial numbers in the past and still will today upon customer request. At least one Armscorp custom receiver serial number was preceded by the letter A. The serial number prefix A denotes a design change in the early receiver production at Armscorp of America, Inc. The serial number prefix S indicates the receiver is made of stainless steel instead of AISI 8620 alloy steel.

M36 and M89

The Israeli firearms designer Dr. Nehemiah Sirkis designed the bullpup conversion of the M14 type rifle known as the M36. The M36 appeared in Israel in the mid-1980s as the Sardius M36 SWS. Armscorp of America, Inc. made approximately ten units of the M36 in the mid-to-late 1980s. The M36 has high profile flip up iron sights. The Israel Defense Forces placed an order for 1300 M36 rifles, but Sardius only delivered fifty. Sardius went out of business in the early 1990s. Sardius was bought out by a company called Technical Consulting International (TCI) in Israel. TCI obtained a license to produce the M36. Using surplus U. S. M14 rifles, TCI upgraded the M36 design, including installation of a carbon fiber stock. TCI then reintroduced the rifle as the M89.

There are two models, the M89AR with iron sights and the M89SR with a Leupold & Stevens, Inc. or Zeiss scope and no iron sights. The suppressed model is designated M89SR-SP. The overall length for the M89 is approximately 33.5 " for standard models or 40.5 " with the sound suppressor. The M89 has a 22 " fully floated barrel. The M89 has a modified operating rod handle. The handle at the rear end of the operating rod is ground flat and a circular knob is attached to the front end of the rectangular portion of the operating rod. Fully loaded with a twenty round magazine, the M89 weighs 13.8 pounds, while the M89SR-SP weighs 15.5 pounds with its sound suppressor mounted. The Israelis fitted its M89 series rifles with Harris bipods. The M89SR-SP was used as a sniper weapon system for units concerned with concealment. It was issued mostly to two

IDF Special Forces undercover units, Sayeret Duvedevan and Sayeret Shimshon. Sayeret Shimshon operated in the Gaza Strip until it was disbanded in 1994. The M36 and M89 rifles are fast handling and compact.

Fulton Armory

Fulton Armory was established by Clint McKee in 1987 in Fulton, MD. The business was moved to its present location in Savage, MD several years later. Before starting Fulton Armory, Clint McKee worked with Jack Friese at what was then Armscorp of America. Their relationship remains cordial. Charlie Maloney, former head armorer of the First U. S. Army (Fort Meade, MD) in years past built match grade M14 rifles for Fulton Armory.

Beginning in 2003, Fulton Armory began selling rifles and barreled actions with its own receivers. Receivers FA 00101 through 00110 were manufactured in the winter of 2003. Fulton Armory XM25 serial number FA 00500 is a rear lugged model. Fulton Armory M14 type rifle FA 00550 was assembled in August 2005. Fulton Armory receivers are cast from AISI 8620 steel and machined by a subcontractor with extensive service rifle manufacturing experience. The subcontractor is Armscorp USA (Baltimore, MD). Armscorp USA made many changes to its tooling for production of Fulton Armory receivers. Armscorp USA also made significant improvements in receiver dimensional geometries as specifically requested by Fulton Armory. This includes a wider than USGI specification operating rod rail. The Fulton Armory receiver is custom designed and uniquely manufactured. A sample Fulton Armory receiver heel is marked as follows from top to bottom: U. S. RIFLE 7.62 MM M14 FULTON ARMORY FA00106. The model number may be M14, M14 NM, M21 or XM25. The vertical surface of the operating rod rail is stamped SAVAGE, MD. Customers have a choice of standard or rear lugged receivers.

In 2006, Fulton Armory introduced its M14 *Super Scout* Rifle. This model was built using a Fulton Armory M14 receiver, USGI M14 parts, a Super Scout rail hand guard, new manufacturer military contour walnut stock, rubber recoil pad, and choice of non-plated or chromium plated 18.5 " or 22 " Fulton Armory barrel. The Super Scout rail hand guard is marked on the operating rod side *Super Scout* Made in U.S.A. Fulton-Armory.com. The factory package included one ten round magazine, a rifle sling and owner's manual.

Options for the Fulton Armory M14 *Super Scout* Rifle included: 1) front sling swivel rail section 2) hand guard side rail 3) National Match trigger 4) National Match operating rod spring guide 5) Smith Enterprise, Inc. 7 " long steel M14 scope mount 6) Fulton Armory non-operable replica selector switch 7) muzzle brake for California compliant models. Each side rail is secured to the rail hand guard by two hex head screws.

Fulton Armory offers a host of M14 type rifle gunsmithing services. Its services include technical inspection, clean and lube, barrel installation and headspacing, phosphate coating of parts, firing mechanism tuning, complete rifle assembly, and match conditioning. Fulton Armory has installed USGI bolts and barrels on hundreds of Chinese M14 receivers. Thus, they offer conversion to USGI parts on Chinese M14 rifles as well.

Western Ordnance International Corporation/Smith Enterprise, Inc.

Western Ordnance International, which became Smith Enterprise, has designed and manufactured excellent quality firearm parts and built outstanding quality firearms for American and foreign governments and the civilian market. Its rifles and parts are too numerous to list in this work. For the sake of brevity, only its experience with the M14 type rifle will be discussed at length.

Ron Smith and Sonja Sommers own and operate Smith Enterprise, Inc. Smith Enterprise, Inc. is classified by the U. S. government as a veteran owned and operated contractor. Its CAGE Code is 3A5E1. Ron Smith shot competitively for the Arizona Army National Guard and California Army National Guard. He is a 1986 graduate of the Israeli Defense Force Sniper School. Ron Smith is a fourth generation career professional in the ordnance industry. He has been licensed as a Class 2 SOT / FFL since 1984. He apprenticed under his dad, Richard Smith, and was actively involved in all projects undertaken. This included, but was not limited to, research, development and production of its M14 receivers and the M14K, research and development of Poly Technologies M14 rifles, making parts for the M16 type rifle, and select fire conversions on Browning Hi-Power 9 mm pistols before the May 1986 ban. When Richard Smith retired in 1992, he passed the torch to his son, Ron. From no later than 1994 until at least 1997, the company was known as Smith Arms International.

Without question, Smith Enterprise has much more knowledge of and experience with testing and working on Chinese M14 type rifles than anyone outside the People's Republic of China. Smith Enterprise is a Leupold & Stevens, Inc. optics factory authorized distributor to government and law enforcement agencies as well as a Sage International M14 EBR stock authorized distributor. Among countless customer requests fulfilled, Ron Smith surveyed the Jordan government M14 rifle inventory at the request of King Abdullah in 1999. In late 2004, the government of Jordan had requested further assistance from Ron Smith on its M14 rifle program.

Smith Enterprise, Inc. Receiver Design, Manufacture and Testing

All Smith Enterprise receivers ever made have been out of certified AISI 8620 alloy steel. About 1985, Smith Enterprise began producing M14 receivers after several months of planning and evaluation. This included generating its blueprints and engineering sketches. Smith Enterprise M14 receivers incorporate a number of innovative features that improve upon the USGI design. The receiver locking lugs are adjusted forward to reduce the headspace about 0.003 " to 0.005 ". The receiver bridge is adjusted a little aft (to the rear) to retract the firing pin faster in order to better prevent slam fire. The receiver barrel ring thread starting quadrant was changed to reduce barrel torque to about 50 ft-lbf which is sufficient. Typically, Smith Enterprise M14 rifles headspace at 1.633 ".

Smith Enterprise made its very first receivers by the precision investment casting method. The raw castings left a large amount of metal that had to be machined away to obtain the final form. All Smith Enterprise investment cast receivers have been made with virgin bar stock AISI 8620 alloy steel certified by the supplier and verified by Smith Enterprise. The Smith Enterprise "forged" billet machined receivers are made of fine grade Hart AISI 8620 alloy steel certified by the supplier and verified by Smith Enterprise. Manufacturing of

receivers starting with billet allowed even more control over the receiver form. Billet was plasma cut into the starting shape. All heat treatment of all Smith Enterprise receivers has been certified by the vendor and verified by Smith Enterprise. All of its receivers have been examined by magnetic particle inspection and some were X-rayed. All receiver barrel ring threads were inspected using a USGI thread timing gauge. Post-heat treat receiver surface and core hardness was examined by spectrum analysis using test mounts (receiver specimens) every 100 rounds fired for a time then every 200 rounds for awhile and then randomly after that. The specimens for the test mounts were cut at various points on the receivers. These test mounts show the case depth of Smith Enterprise receivers is 0.012 " to 0.015 " and the core hardness is 35 to 40 HRC in accordance with the USGI M14 receiver drawing 7790189. Smith Enterprise also required spectrum analysis of the receiver when its heat treat vendor changed personnel. Such testing and resultant analysis led to a standard operating procedure for heat treatment. All of this inspection and non-destructive examination was part of the Smith Enterprise quality control program.

Note that the reader MUST NOT perform the testing described herein. Personal injury or death may result. Ron Smith personally test fired the very first receiver without it having been heat treated. He shot it for twenty rounds to prove the material's integrity. The headspace had set back 0.010 " by the twentieth round. Smith Enterprise had Thunderbird Cartridge Company (Laveen, AZ) make up two hand load lots of proof test ammunition for them. One batch of proof test rounds was loaded to 65,000 psi and the other was loaded to 76,000 psi. Thunderbird Cartridge used nickel plated Federal cases and M118 bullets. The bottoms of the 76,000 psi cases were colored purple. Next, a second receiver with no heat treatment was shot twice with 65,000 psi proof test rounds. The headspace had set back 0.010 ". After this, ten receivers were selected out of the first lot of 100 finished receivers. Each of these ten receivers was fired with one round of 65,000 psi proof test ammunition.

Then one finished receiver was selected for destructive testing. Scott Medisha was a witness to this destructive testing. First, ten rounds of 65,000 psi proof test ammunition were fired. Next, 76,000 psi proof test rounds were fired. After four rounds of 76,000 psi proof test ammunition, there were some signs of problems but the receiver had not failed. The cases were seizing in the chamber. Therefore, Scott Medisha went home and loaded up one round of ammunition. Ron Smith states this cartridge was loaded with a large charge of Hercules (now Alliant Techsystems) Unique pistol powder and a 175 grain bullet. Taking suitable precautions, the destruction cartridge was loaded into the rifle chamber and fired. Scott Medisha achieved the desired result. The receiver failed with a dull, muffled boom. The cartridge case vaporized, the barrel blew out about two feet in front of the stock, and the bottom forward one inch of the bolt blew apart, the magazine blew out of the action and all magazine spot welds gave out. The back of the receiver gently rolled off to one side. The receiver on both sides behind the locking lugs cracked. However, the locking lugs on the receiver and the bolt held! The M14 enthusiast should not turn his nose up at a well-made investment cast receiver.

Smith Enterprise also made a single batch of billet machined select fire receivers before

the May 19, 1986 civilian machine gun ban. These select fire receivers were registered under the National Firearms Act and then sold in late 1985 to a Class 3 Special Occupational Tax Federal Firearms Licensee in Oregon.

There is a pronounced difference in the shape of the receiver heel between the Smith Enterprise (and Armscorp of America) billet machined and Smith Enterprise investment cast receivers. The billet machined receivers have almost square heel corners whereas the investment cast receiver heel corners are rounded. Billet machined semi-automatic Smith Enterprise receivers are marked FORGED USA because the company believed it was a simple, but not exaggerated, way to state the receiver quality. All select fire models were machined from billet but lack the FORGED USA marking. The post-'94 ban receivers were produced in small lots of ten to fifteen at a time.

Table 10: Smith Enterprise, Inc. M14 Receivers

Smith Enterprise Receiver Serial Number	Method of Manufacture	Comments and Markings
12XX	investment cast	
185X		built in 1986
1915	billet machined	FORGED USA marking
001985	billet machined	FORGED USA marking
002099	investment cast	made no later than 1988
002197	investment cast	
002198	investment cast	
002292	billet machined	FORGED USA marking, rear lugged
002300	billet machined	FORGED USA marking
00258X	billet machined	FORGED USA marking, lugged, receiver manufactured in March 1994, highest observed pre-'94 ban serial number

Smith Enterprise, Inc. Receiver Identification

Examination of several rifles reveals distinctive markings on Smith Enterprise receivers. Smith Enterprise did stamp some receivers with customer requested serial numbers. Examples of these are serial numbers of the owner's initials and birth date or USGI M14 serial numbers issued to the customer during military service. Some Smith Enterprise receiver heels used serif style lettering, e.g., serial numbers 002197 and 002198 but others do not, e.g., 002292. The number 1 was added to the beginning of some receiver serial numbers to correct the few instances of duplicate numbers. Also, the earlier pre-'94 ban and the post-'94 ban receivers were given a phosphate coating. Latter pre-'94 ban receivers were nitrocarburized. Note that 7790189 is the USGI drawing number for the M14 receiver. Smith Enterprise, Inc. receivers are marked as follows:

Pre-'86 ban billet machined select fire - 1) M-14 on the heel 2) serial number starts with the letters FA followed by five digits 3) MESA, AZ on the vertical surface of the operating

rod rail 4) 7790189 on the right hand side near the connector lock with no other marking below the stock line or 90189 and an eagle, arrow, and stars cartouche below the stock line on the right hand side near the connector lock.

Pre-'94 ban billet machined semi-automatic - 1) M-14 or M-14 NM on the heel 2) MESA, AZ on the vertical surface of the operating rod rail at the forward end 3) FORGED USA on the vertical surface of the operating rod rail at the rear end 4) 7790189 below the stock line on the right hand side near the connector lock 5) ordnance eagle and three stars symbol below the stock line on the right hand side near the connector lock.

Pre-'94 ban precision investment cast semi-automatic - 1) M-14 NM on the heel 2) MESA, AZ on the vertical surface of the operating rod rail at the forward end 3) 7790189 below the stock line on the right hand side near the connector lock.

Post-'94 ban precision investment cast semi-automatic - 1) M-14 NM on the heel 2) serial number is a four digit number beginning with the numeral 5 3) TEMPE, AZ on the vertical surface of the operating rod rail at the forward end.

Examination of two Smith Enterprise M-14 select fire receivers reveal the following characteristics: 1) there is a rear dismount notch 2) the drawing number, 90189 or 7790189, is stamped at the same location as the USGI receiver 3) there is no fixture hole in the right receiver leg 4) the selector lug is a homogeneous portion of the receiver rather than welded on 5) MESA AZ is marked on the operating rod channel vertical surface at the forward end of the receiver and 6) there is an eagle, arrow and stars cartouche on the right hand side below the stock line.

Smith Enterprise, Inc. M14 Services

Smith Enterprise, Inc. offers a host of services for the M14 type rifle. It has performed gunsmithing work for many years and continues to do so for the U. S. Army, U. S. Marine Corps and federal government agencies. Smith Enterprise M14 services include match tuning, assembly, receiver heat treatment, barrel or complete rifle cryogenic treatment, Chinese rifle bolt conversion to USGI bolt, bush barrel conversion and gas piston heat treatment and hard chromium plating. The Chinese rifle bolt conversion includes reworking the receiver to accept a USGI bolt and headspacing the barrel. Smith Enterprise has offered this service since 1994. The bush barrel conversion includes finish reaming, installing and headspacing a 17 5/8 " air gauged medium weight Douglas match barrel to the receiver.

Smith Enterprise will also install rear or rear and front lugs to the receiver upon customer request. Its rear lugs are designed with an innovative three degree release angle on all four sides. This feature reduces wear on the precision bedding material during routine maintenance, and has been adopted by the U. S. Marine Corps. Beginning in July 2005, Smith Enterprise, Inc. is conducting maintenance training classes for U. S. active duty military personnel on the Mk 14 Mod 0 and Mk 14 SEI systems. The first class consisted of twelve U. S. Air Force pararescue airmen.

M14K

Smith Enterprise, Inc. and LaFrance Specialties (San Diego, CA) have collaborated on

various projects through the years. One such venture was the M14K, a very interesting and innovative development of the M14 type rifle. The origin was a desire on the part of Richard Smith and Tim LaFrance in the 1980s to make the M14 more compact and controllable without generating excessive muzzle blast and recoil. Tim LaFrance, Richard Smith and his son, Ron Smith, did the research and development for the M14K. After some experimentation, they found that the M60 machine gun gas system provided great promise in reducing the cyclic rate and in delaying bolt opening. Muzzle blast and felt recoil was softened as well. So, Ron Smith further improved and perfected the M60 type gas system for the M14K. M14K rifles, semi-automatic and select fire, were built by Smith Enterprise, Inc. and LaFrance Specialties. This included the woodworking necessary for the stocks. Stanley Crist fired the prototype M14K rifle and wrote an article on it that appeared in *S.W.A.T.*

The conversion to an M14K consists of installing the improved M60 type gas system, adding a unique combination muzzle brake and flash hider, shortening the operating rod and wood stock fore end and installing National Match front and rear sights. The fore end of the wood stock was shortened to accommodate the new gas system. A side folding pistol grip wood stock was optional for the M14K. The M14K barrel length is 13 ½ ". M14K models purchased by civilians had either 1:10 twist four groove match barrels or 1:12 twist chromium plated barrels. The semi-automatic only M14K rifles were assembled with a permanently attached muzzle brake so as not require registration as short-barrel rifles under the National Firearms Act. The match grade barrels proved to be markedly more accurate than the chromium plated barrels in the M14K. The M14K cyclic rate is about 600 rounds per minute and the muzzle velocity 2560 feet per second using M80 ball ammunition.

During the Reagan Presidency, Smith Enterprise converted some M14 rifles to M14K models for the Colombian government. The M14K was very effective in the hands of the Colombian Army. In fact, it was so effective that the drug cartel FARC threatened bodily harm on the Smith family. Because the Reagan Administration was not able to guarantee around the clock protection, Smith Enterprise decided to cease the conversion work for the Colombian government. In 1988, the M14K was marketed by Tim LaFrance at the Soldier of Fortune Show.

Smith Enterprise plans to reintroduce the M14K in the near future. Boyds' will supply the stocks. These M14K rifles will have Wilson Arms 16 " four groove barrels with 1:10 twist for semi-automatic models and 1:12 twist for NFA registered select fire models. Semi-automatic only M14K rifles will require registration as short-barrel rifles under the National Firearms Act. Smith Enterprise will make all the gas system components. A turnaround time of two weeks will be the goal.

AWC Systems Technology

From 1991 to 1993 or 1994, AWC Systems Technology (Phoenix, AZ) converted some M14 type rifles into a bullpup rifle design. Three models were made, G2, G2A and G2FA. The overall length is approximately 33 ". G2 series rifles were outfitted with a special McMillan stock and muzzle brake. The trigger was moved forward of the magazine well. The G2 was the first version. It had a standard contour barrel and a scope mount. The

G2A features a heavy barrel, modified gas cylinder and a redesigned scope mount. The G2FA is the select fire model. All three models place the scope directly over the barrel. Reportedly, less than 100 G2 and G2A models and less than a dozen G2FA models were produced. At least one unit has been sound suppressed. The G2FA and suppressed models require National Firearms Act registration in the United States.

Entreprise Arms

Beginning in 1996, Entreprise Arms (Irwindale, CA) began offering M14 type receivers for sale. Its standard receiver is available with rear and double lugged receivers as special order items. The receivers are CNC machined from twelve-pound billets of AISI 8620 alloy steel. Entreprise Arms receivers are heat treated to a surface hardness of 52 to 56 HRC and a core hardness of 34 to 38 HRC. Entreprise Arms receivers are given a black oxide finish rather than a phosphate coating. Receivers are sold with an unconditional lifetime guarantee. Its receivers have the stamping ABNI. It is the marking of a subcontractor who previously did some manufacturing for Entreprise Arms. Earlier Entreprise Arms receivers have the serial number stamped on the left side near the rear sight. Later receivers have a wider than USGI specification operating rod rail than earlier receivers and the serial number is on the receiver heel. Entreprise Arms also provides M14 gunsmithing services such as rifle assembly, barrel installation, phosphate coating of parts, NM trigger modification, and clean and lube.

Hesse and Sarco, Inc.

Hesse has made two batches of M14 receivers, the first in 2000 and the second in 2003. No further information has been found on Hesse receivers. Sarco, Inc. (Stirling, NJ), one of the largest small arms parts dealers in the world, was established in the 1960s by Charlie Steen. Sarco, Inc. has dealt in M14 parts since at least 1971. A production time frame for Sarco, Inc. M21 receivers has not been confirmed but its receivers were available for sale in 2002. Sarco, Inc. receiver quality has been reported by owners as good fit and finish.

Troy Industries, Inc.

The M14 type rifle was further refined for civilians in 2002. Mike Rock and Jim Ribordy developed the Rock SOPMOD M14 for the U. S. Navy but the public is aware of it through the efforts of Steve Troy at Troy Industries, Inc. RD Systems (South Beloit, IL) builds the Rock SOPMOD M14 conversion. Troy Industries, Inc. (Lee, MA) marketed and sold the Rock SOPMOD M14 conversion until October 2005. LRB of Long Island, Inc. marketed the Rock SOPMOD M14 conversion from October 2005 until May 2006. RD Systems assumed the marketing duties from that point forward. What follows is a history of the Troy Industries involvement with the Rock SOPMOD M14 project.

Steve Troy was introduced to Mike Rock and the Rock SOPMOD M14 by a mutual business acquaintance. Steve Troy saw the potential in the commercial market for the Rock SOPMOD M14. Consequently, Troy Industries promoted the Rock SOPMOD M14 through printed literature at the annual SHOT Show beginning in 2003, the company web site and Internet discussion boards.

As previously discussed, the Rock SOPMOD M14 carbine had been designed and

developed under contract for the U. S Naval Surface Warfare Center (Crane, IN) for the M14 EBR project. At that time, neither Mike Rock nor Steve Troy knew of the involvement Sage International had with the M14 EBR project. Personnel from NSWC at Crane, IN informed them that the Rock SOPMOD M14 was still too heavy. Both Mr. Rock and Mr. Troy thought a contract was pending so they took steps to reduce the weight of the carbine. Ironically, the M14 EBR design adopted by the U. S. Navy weighs more than the commercial Rock SOPMOD M14 carbine.

The performance of the first commercial production conversions was puzzling since they were not performing as well as the models built for the U. S. Navy. Steve Troy made several trips to RD Systems to help troubleshoot the loss of accuracy. No further conversions were shipped and all those that had been shipped were returned to RD Systems at no expense to the customer. The loss of accuracy was mostly due to changes in materials used in the conversion to reduce weight to comply with the requirements of the unrealized U. S. Navy contract. Additionally, the varying dimensions of commercial M14 type receivers were responsible for complicating the installation of the receiver front lug that is bolted to the metal stock.

The original design of the Rock SOPMOD M14 featured an aluminum stock and steel telescoping rails. Steve Troy has added his input to create the commercial version of the Rock SOPMOD M14. As a result, the Rock SOPMOD M14 is now made with lighter and stronger titanium butt stock assembly. The stock body is machined from alloy aluminum billet. Steve Troy made further design enhancements such as the operating rod protector, sling swivels, the three-way front lug, CQB combination flash suppressor / muzzle brake and textured coatings. The Rock SOPMOD M14 receiver is double lugged.

The pull button 16.5 " long 1:11.27 five radial groove rifle stainless steel barrels are supplied by Rock Creek Barrels, Inc. The new stock and accessory rail system include four military standard M1913 Picatinny accessory rails. The USGI flash suppressor and front sight are replaced with the combination flash suppressor and muzzle compensator that is threaded to accept the optional Troy Industries sound suppressor. An M203 grenade launcher will attach to the Rock SOPMOD M14 stock at the six o'clock rail. The grenade launcher is removed by disengaging a quick release device.

The Rock SOPMOD M14 weighs less than 10 pounds and the overall length is 27 " with the stock collapsed. Using the Rock SOPMOD M14 and bipod, a twenty round magazine can be emptied into a 5 " group on paper at 100 yards in automatic. The Rock SOPMOD M14 can consistently group 3 " at 500 yards in semi-automatic. In either mode, felt recoil is negligible as compared to the standard M14 rifle.

In 2003, Troy Industries introduced the Rock SOPMOD M14 Calimando. This conversion was performed by RD Systems on California resident M14 type receivers to comply with that state's laws governing semiautomatic firearms. The conversion included a 16.5 " barrel and traditional style butt stock without a pistol grip. Overall length for the Rock SOPMOD M14 Calimando was 35 ".

Both Rock SOPMOD M14 Carbine and Calimando models used the stripper clip guide as an attachment point for the accessory rails. The Rock SOPMOD M14 models had the

visible portion of the operating rod marked with all the Troy Industries model information for those units sold by Troy Industries. Several optional items were available through Troy Industries for the Rock SOPMOD M14 models including single point CQB sling, soft or hard case, sound suppressor, and bipod. Standard surface finish for the stocks and pistol grips was textured black.

At the 2004 SHOT Show there were several Rock SOPMOD M14 carbines were displayed at the Troy Industries booth. One of these models was dressed in a medium brown color Rock SOPMOD M14 stock. The receiver, rear sight assembly, all rails, the firing mechanism parts, and the operating rod were all nickel-boron plated. The benefit of nickel-boron plating is wear resistance superior to that of chromium. The nickel-boron plated parts had a color darker than gold but lighter than bronze. That model was a special order item only available in 2003.

Troy Industries sold a total of about thirty Rock SOPMOD M14 carbines. In October 2005, LRB of Long Island, Inc., began marketing the Rock SOPMOD M14. Another three Rock SOPMOD M14 units were sold. By September 2006, RD Systems had dropped the project.

LRB of Long Island, Inc.

In 2003, LRB of Long Island, Inc. began selling semi-automatic M14 type rifle receivers. The manufacturing of LRB Arms M14SA receivers is briefly described here. Bourdon Forge Company, Inc. (Middletown, CT) cuts extruded AISI 8620 alloy steel bar stock into ingots, heats them and then drop forges them into shape. Bourdon Forge Company has manufactured high quality forgings since 1969. It uses Computer Aided Design, Computer Aided Manufacturing and Computer Aided Design for Impact Forging software to develop highly specialized forgings. LRB of Long Island, Inc. designed its receiver forging die from a Winchester USGI M14 forging. The forging die design was slightly altered from the original to accommodate CNC machining operations. Bourdon Forge Company manufactured the LRB Arms M14 receiver forging die but LRB of Long Island retains ownership. Periodically, the die is replaced due to normal use.

The raw forgings are then CNC machined. All LRB Arms receivers are machined at J. V. Precision Machine Company (Seymour, CT) using U. S. government Rock Island Arsenal blueprints for part number 7790189 Revision T (February 10, 1975). Dimensional tolerances are held to within one thousandth of an inch. Most of the receiver dimension gages have been redesigned for compatibility with the CNC machining processes.

LRB Arms receivers are heat treated to a core hardness of 28 to 42 HRC and a surface hardness of 52 to 55 HRC with a case depth of 0.012 " to 0.018 ". Each receiver is tested for hardness in the rear sight pocket since this surface is not visible once assembled as a complete rifle. The final step is a phosphate coating that duplicates the color and finish of the original M14 receivers. The LRB of Long Island, Inc. M14 type rifle receiver design was approved by the Bureau of Alcohol, Tobacco, Firearms and Explosives in January 2003. The law enforcement portion of the Bureau of Alcohol, Tobacco and Firearms was transferred from the Department of Treasury to the Department of Justice and renamed the Bureau of Alcohol, Tobacco, Firearms and Explosives (BATFE) on January 01, 2003

as part of the Homeland Security Act of 2002.

To understand the M14SA receiver numbering sequence the following background is given. In 2002, Mike Kelly Specialties (Grafton, WV), also known as MKS, was marketing the sale of newly manufactured semi-automatic receivers. According to the company's web site at the time, the receivers were forged in Taiwan and machined in the United States.

LRB of Long Island was the distributor for the MKS newly manufactured M-14-A1 receivers. At least 100 of these newly manufactured receivers had made it into the hands of the buying public through Federal Firearms Dealers. As part of the purchasing process, all of the buyers successfully passed a criminal background check. These receivers were stamped on the heel as follows from top to bottom: first line – U.S. RIFLE second line – 7.62 MM M-14-A1 third line – MK SPECIALTIES fourth line – 00XXX.

As built, these receivers were only capable of semi-automatic fire and sold as such. However, the BATFE took the position that these receivers were unregistered machine guns. The presence of certain features discussed below was deemed by the BATFE to make these receivers readily convertible to automatic fire capable. These receivers were later confiscated in 2003 by the BATFE from the owners after being allowed to remove all other attached parts.

One day in 2002, a number of raw MKS receiver forgings were in a machine shop in lots of various stages of the machining process. The then BATF made a visit and seized a number of the receivers. The semi-finished MKS receivers that were seized had features such as a solid (versus drilled per drawing 7790189) lug on the rear right bottom side, an operating rod center notch and a groove on the forward bottom side of the operating rod rail. After the BATF left the building the machine shop was left with some of the MKS forgings in various stages of machining. The receivers the BATF left behind had none of the select fire features mentioned above. Some had a little machining completed and some were almost finished. In 2003, the LRB contractor, J. V. Precision Machine, was able to finish the machining operations on the former MKS forgings. LRB of Long Island, Inc. sold the receivers with the markings LRB Arms M14SA. Based on how many receivers were in each stage of the machining process, they were divided into groups for numbering, i.e., ten in the first group, four in the second group, forty-nine in the third group, and eight in the fourth group.

The first ten LRB receivers sold had the least amount of machining needed for completion. These are marked as X00101 through X00110. The next five M14SA receivers needed a little more machining to complete than the first ten and are marked as 00101 to 00104. These needed a little more machining to complete than the first ten. The third group of M14SA receivers, forty-nine of them, starts at serial number 01001. These required more machining than the first two sets. The fourth group of M14SA receivers which began as MKS units starts at serial number 01101 and ends at 01108. These required even more machining than the first three sets.

Subsequent M14SA receiver serial numbers start at 01201. These receivers are forgings made after the machine shop had used up all the forgings previously made for MKS.

Receivers starting with serial number 01201 are forged at Bourdon Forge Company. Between receivers numbered 01217 and 01227 inclusive, the serial number marking was changed from a dot matrix to a roll die stamping. The first operating rod channel marking for the LRB M14SA receiver was JV PRECISION SEYMOUR CT USA. The operating rod channel marking changed to JVP SEYMOUR CT USA somewhere between serial number 01211 and 01299.

At the 2004 SHOT Show, LRB displayed two prototype M14SA receivers each with two integral M1913 Picatinny rail pads. The receiver rail pads are located on top of the barrel ring and at the stripper clip guide dovetail mount. The first prototypes of these M1913 integrated rail receivers was forged in October 2004. Production of the M1913 integrated rail M25 heel stamped receivers began in September 2006.

In December 2004, LRB Arms began selling complete M14SA rifles in limited quantities. The M14SA rifles are assembled with all USGI parts except for Criterion or Wilson Arms match grade standard contour barrels (see U. S. Commercial M14 Barrels). In April 2005, the LRB Arms M14SA Tanker became available for purchase. This is a LRB Arms M14SA with an 18.5 " barrel and optional Smith Enterprise, Inc. muzzle brake. Chromium plating of either length barrel is an option to the buyer. Complete LRB Arms M14SA rifles built by the firm are warranted for one year. LRB of Long Island marketed and sold the Rock SOPMOD M14 conversion from October 2005 until September 2006.

Origin of Chinese M14 Rifles

A persistent rumor states that M14 rifles produced by the People's Republic of China were reverse engineered from enemy captured M14 rifles in Viet Nam.⁴ Norinco is reported to have produced M14 rifles by the early 1970s.⁵ The story continues that 100,000 Chinese M14 rifles were produced for an armed revolution in the Philippines.⁶ In preparing for this work, the author interviewed a very reliable source with extensive firsthand knowledge of Chinese and Taiwanese production and export of small arms. This gentleman wishes not to be identified. He is referred to as Other Source # 12.

It was policy of the Chinese government until 1978 to export Marxist revolution to the world's masses, much like the former Soviet Union tried to do during its reign in eastern Europe into western Asia. This policy changed dramatically in 1978 when Deng Xiaoping assumed leadership in China. After 1978, the Chinese government pursued economic development and trade for the country, whereas before they promoted and supported communist dissident movements around the globe. In 1965, the Chinese government reverse engineered the design for the U. S. Rifle M14 from weapons captured in Viet Nam. 100,000 M14 rifles and the necessary magazines and ammunition were produced by the Chinese for export to arm rebels in other countries. These Chinese select fire M14 rifles were made to look just like captured American M14 rifles including even the serial numbers. The Chinese government went so far as to produce 7.62 x 51 mm NATO ammunition identical to British issue ammunition, though with corrosive primers. This 7.62 x 51 mm NATO faux British-headstamped Chinese made ammunition was exported to the United States and sold on the commercial market in the 1980s. The rifles and ammunition were manufactured with U. S. and British markings so as to avoid any

connection to the People's Republic of China, and possibly to serve a role in disinformation (propaganda) campaigns for the planned uprising.

The Communist Chinese government made two attempts to ship its select fire M14 rifles to the Philippines. The first attempt was largely unsuccessful and the second was a total failure. In 1971, Jose Maria Sison, founding chairman of the Communist Party of the Philippines, chose Ricardo S. Malay, then a columnist for the *Manila Chronicle*, to arrange the delivery of weapons from China to the New People's Army in anticipation of an armed uprising against then-President Ferdinand Marcos.

The New People's Army (NPA) is the military arm of the Communist Party of the Philippines. The NPA began on March 29, 1969 with sixty fighters and thirty-five rifles and handguns. Its stated goal is to overthrow the government of the Philippines through long term guerilla warfare. The peak strength of the NPA was 25,000 in the 1980s. Present estimated strength is 10,000 and growing. The NPA is organized into twenty-seven battalions of full time fighters. They operate in Luzon, Visayas and Mindanao to this day.

Ricardo Malay and his family made their way to China in July 1971. Malay and his family were later joined in China by Sison's closest colleague, Ibara Tubianosa, and four other individuals. Certain arrangements were made to package 1,200 of the M14 rifles with magazines, a quantity of ammunition, and other military items. The cargo was soon thereafter loaded onto the ship *MV Karagatan*. The ship and its cargo sailed from the Chinese naval base at Swatoy headed for Digoyo Bay, Isabela Province, Philippines.

Victor Corpus was an instructor and a Tactical Officer at the Philippine Military Academy (Fort Del Pilar, Baguio City, Luzon). The Philippine Military Academy is the Philippine counterpart to the United States Military Academy at West Point, NY. While on duty as the Officer of the Day, Victor Corpus allowed the New People's Army to raid the academy armory. He fled to the jungle the same day.

The New People's Army fighters, led by Victor Corpus, were waiting for the delivery of Chinese M14 rifles. However, the Philippine armed forces intercepted the shipment aboard the *MV Karagatan*. Consequently, a firefight ensued between the New People's Army fighters and the Philippine troops. Corpus and Kumander Dante, Chief of the NPA, were captured by the Philippine government troops. The NPA was only able to salvage only 200 of the 1,200 M14 rifles and little of the other military equipment Mao Zedong had approved as aid to the Philippine revolution. The 1,000 Chinese M14 rifles captured by the Philippine military are rumored to have been sent to the Philippine Military Academy and issued to the cadets for drill purposes as symbolic payback for the treachery of Victor Corpus. Victor Corpus went to prison and served his sentence. In an ironic twist of history, the Philippine government made Victor Corpus an Army Colonel after Ferdinand Marcos fled the country on February 25, 1986. Corpus went on to serve the Philippine government in various capacities including head of the National Intelligence Coordinating Agency, the Philippine equivalent of the Central Intelligence Agency.

In 1973, Sison tasked Malay to attempt another delivery of M14 rifles from China to the Philippines. He proposed that the Chinese prepare a shipment of M14 rifles in watertight

packages to be dropped off the Pangasinan coast for recovery by scuba divers. Months later in December 1973, Malay and Tubianosa flew to Sanya, Hainan. Hainan is the southernmost island of China. Sanya is the capital of Hainan as well as the location of a Chinese naval base. When Malay and Tubianosa arrived at Sanya, they were briefed by a Chinese military officer regarding the packaging of the M14 rifles. The rifles were vacuum packed inside reinforced plastic bags with three rifles to a sack. Each sack also contained ammunition. The Chinese military officer had a team that had previously tested the packaging to make sure it would hold in the ocean environment. Malay and Tubianosa flew to Beijing the next day. The ship *MV Andrea*, with four crew members, was assigned to transport the M14 rifles and eight New People's Army fighters to the Philippine Pangasinan coast. Enroute to Sanya, the ship struck a reef somewhere in the Pratas Islands of the South China Sea. The twelve men aboard (four crew members and the eight New People's Army fighters) the stranded vessel were picked up and taken to Hong Kong by a passing Hong Kong salvage ship, the *Oriental Falcon*. In exchange for passage to Hong Kong, the *Oriental Falcon* was allowed to keep the *MV Andrea* for scrap. After a stay in a Hong Kong jail, the Filipino New People's Army fighters were released due to intervention of the Chinese Red Cross and the ship's Chinese crew was quickly moved to the Chinese mainland.

In the early 1980s, Other Source # 12 traveled to China. He was shown the remainder of the approximately 100,000 Chinese manufacture select fire M14 rifles. The Chinese M14 rifles were packed in crates in one warehouse while the British-marked, Chinese produced 7.62 x 51 mm NATO ammunition was stored in a separate warehouse. Some time after this, the select fire M14 rifles were disassembled and only the receivers were destroyed. Since there were no furnaces or ovens in the local vicinity for melting steel, the receivers were mixed with concrete to make concrete blocks for building projects. A limited number of the Chinese select fire rifles, minus the selector lugs, were sold on the commercial market in Canada and New Zealand in the 1980s. Parts from the select fire M14 rifles were later exported to the United States as M14 parts kits for use by Federal Ordnance, Armscorp of America and Century Arms International to build rifles with American made receivers. Surplus parts suppliers such as Northridge International, Inc., Numrich Gun Parts Corporation and Sarco, Inc. stocked Chinese M14 parts for retail sales until they sold out. The ammunition was exported as well to the United States for commercial sale. It was reliable and accurate ammunition.

Norinco and Poly Technologies Corporation

M14 type rifles exported to the United States from China have been stamped as two brands, Poly Technologies Corporation and Norinco (1992 address was 7A Yue Tan Nan Jie P. O. Box 2137 Beijing, People's Republic of China 100045).

Norinco is formally known as China North Industries Corporation. Reportedly, Norinco is a Ministry of Ordnance Industries entity consisting of 150 individual factories associated together for marketing purposes.⁷ Norinco is a government owned conglomerate of factories producing many kinds of military ordnance.⁸ As of 2005, Norinco was an enormous business conglomerate dealing in military defense products, engineering contracting, optical products, oil production, chemical products, small arms, ammunition,

automobiles, hotels and other real estate, travel and logistics services and rare mineral products.

However, Other Source # 12 explained what Norinco is in another way. Norinco was set up as a committee decades ago to supply war materials to prosecute the war in Viet Nam against the United States. Viet Nam was heavily dependent upon China during the war. After the change in government policy in 1978, there was no military need for Norinco. In 1980, Norinco was established as an export corporation since Chinese arms factories cannot sell directly to anyone but the Chinese government. Thus, Norinco has exported small arms and ammunition for sale in the commercial market of various countries since the 1980s. In 1998, Norinco spun off its civilian small arms and ammunition marketing and sales operation, with government approval, into the wholly owned subsidiary registered as Norinco Armsports Co., Ltd. Norinco Armsports Co., Ltd. is also known as Norinco Sports.

Poly Technologies Corporation was established in June 1984 by the People's Liberation Army. Poly Technologies was made a subsidiary of China International Trust and Investment Corporation on paper. In reality, Poly Technologies is under the influence of the People's Liberation Army. Poly Technologies exports military ordnance from small arms to missiles for sale. PTK International (Atlanta, GA) was the main subsidiary of Poly Technologies in the United States. The company was in the business of importing and distributing various semi-automatic rifles for commercial sales from 1987 until August 1996.

Production of Chinese M14 Type Rifles

All Chinese semi-automatic M14 rifle receivers and new (post-1978) production parts for them have been manufactured at State Arsenal 356 in Yunnan Province, People's Republic of China. Yunnan Province is in southwest China and borders the nations of Laos and the Socialist Republic of Viet Nam. All Chinese M14 type receivers are drop forged. Select fire and semi-automatic only M14 type rifles have been produced for Norinco. One Norinco semi-automatic M14 type rifle model is the M305. There were two versions of the M305. Type I was assembled with a standard stock and flash suppressor and Type II featured a pistol grip stock and a stabilizer similar to the M14E2.

Chinese semi-automatic M14 rifles have been directly exported to Canada, Germany, New Zealand, Norway and the United States for sale to private owners. At least one Norinco M14 Sporter imported by Century Arms International had made its way to the Netherlands by no later than 2005. Chinese M14 rifles exported to Canada around 1987 were rendered semi-automatic only in order to comply with Canadian law. Chinese semi-automatic M14 type rifles were imported into Germany in early 1987. Germany requires firearms that are imported or sold to an individual must be proof fired with a cartridge loaded to 30 % higher than normal chamber pressure. After successful firing, the barrel is stamped with a proof marking. This testing was done for the Chinese rifles imported into Germany. The Chinese rifles exported to New Zealand are stamped M14 on the receiver heel and have had the selector lug cut off. New Zealand allows private possession of a semi-automatic M14 type rifle with a flash suppressor and bayonet lug if

the owner has an E Category firearms license.

Rifles marked M305 have been exported to Canada, Germany, New Zealand and Norway. These are marked on the left side of the receiver as follows: top line - Model 305 middle line - 7.62x51 bottom line - Made in China. The Norinco symbol is next to the stamped text. A small number of Norinco select fire M14 rifles are available for sale in the United States as post-'86 ban dealer samples.

Chinese M14 Type Rifle Export to the United States

There have been three, possibly four, importers of Chinese M14 type rifles into the United States: 1) Keng's Firearms Specialty, Inc. (then Stone Mountain, GA) 2) Century Arms International (then St. Albans, VT) and 3) IDE USA/CJA (Southfield, MI). The Chinese M14 type rifles were imported from 1988 until September 1994. As shown on an ATF Form 6 related to one of these export shipments, the cost of a Poly Technologies M14S in 1989 was \$225.00. All complete Chinese M14 rifles imported into the United States were assembled with 1965 Chinese production parts.

At this point in the story, it may be helpful to the reader to summarize the number and identifying marks of Chinese M14 type rifles brought into the United States by each importer. Based on personal observation and reports from owners of Chinese M14 type rifles:

- 1) It appears that Keng's Firearms Specialty, Incorporated imported no more than 2800 to 3000 Poly Technologies M14 type rifles into the United States.
- 2) It appears that Century Arms International imported at least 1245 Poly Technologies M14 type rifles into Canada.
- 3) The KFS and Century Arms International imported Poly Technologies rifles have receiver heel stampings. The majority of Century Arms International imported Norinco rifles have receiver heel stampings. No IDE USA/CJA imported M14 type rifles have been observed with receiver heel stampings.
- 4) IDE USA, later known as CJA, appears to have imported all Poly Technologies M14 rifles into the United States after the serial number range of 2800 to 3000.
- 5) The first 150 or so Norinco M14 type rifles imported by IDE USA/CJA are marked IDE USA. After that, the Norinco receivers indicate CJA as the importer.

Keng's Firearms Specialty, Incorporated

Keng's Firearms Specialty, Inc. (now in Atlanta, GA) was established in 1985. The company has imported firearms and firearm accessories for commercial sale in the United States. Specifically, Keng's Firearms Specialty imported Poly Technologies M14 type rifles. Keng's Firearms was the only company that imported Chinese M14 type rifles (Poly Technologies M14/S models) into the United States before the March 14, 1989 ban on importing military-lookalike semi-automatic rifles. This event is commonly referred to as the "1989 import ban." The Chinese M14 (Poly Technologies M14/S) rifles first appeared in the United States as part of the Keng's Firearms Specialty exhibit at the January 1988 SHOT Show. Poly Technologies M14/S serial number 0043X with a

hinged butt plate and bayonet lug was imported by Keng's Firearms before March 14, 1989.

Tim LaFrance noted that he had a concern with the Chinese bolts after examining the Poly Technologies rifles at the 1988 SHOT Show. He suggested to Keng's Firearms that these rifles be evaluated because of his concern with the bolts. Consequently, Poly Technologies representatives from the People's Republic of China contacted Smith Enterprise, Inc. shortly thereafter to discuss the manufacturing of M14 rifles. Representatives from Poly Technologies met for five days with Smith Enterprise personnel, with David Keng of Keng's Firearms acting as translator. The Poly Technologies representatives were supplied with a set of USGI drawings for the M14.

After this first meeting, Poly Technologies sent raw forgings and assembled M14 rifles (Poly Technologies serial numbers 000001 through 000005) to Smith Enterprise, Inc. for evaluation and testing. Ron Smith personally test fired these first five Poly Technologies M14 type rifles. Smith Enterprise thoroughly examined and tested the Poly Technologies receivers and rifles. The receivers were found through spectrum analysis to be made of the Chinese equivalent of AISI 8620 alloy steel, the proper material for M14 receivers. The first Poly Technologies M14 rifles imported into the United States had six digits in the serial number of each rifle. Very quickly though, no later than serial number 00077, there would only be five digits making up the serial number on each Poly Technologies M14 rifle imported into the United States.

Karl Maunz was living in Atlanta, GA when Keng's Firearms imported Poly Technologies M14/S rifles. Keng's Firearms supplied him with two Poly Technologies M14/S rifles for testing and evaluation. He found the receiver to be made of equivalent AISI 8620 alloy steel. The receiver material testing conducted by Smith Enterprise and Karl Maunz was done independently of each other. The Chinese bolts, however, were not made of the USGI drawing specified alloy steel.

The Smith Enterprise testing included hardness testing of the Poly Technologies receiver core by cutting it apart. One Poly Technologies receiver was tested to destruction by loading ammunition to create excessively high chamber pressure. The reader MUST NOT exceed powder charges as listed in reputable reloading manuals if hand loaded ammunition is used. Personal injury or death may occur if done so. The very first Poly Technologies receivers were very hard, harder than a file, which left them without the toughness provided by the relatively soft core of receivers made according to USGI specifications. The Chinese quickly corrected this by strictly adhering to the receiver heat treatment procedure.

After Smith Enterprise completed the evaluation, a second meeting of the parties involved was held. Even after this second meeting, Poly Technologies did not correct all the concerns of Smith Enterprise and Keng's Firearms had regarding the Chinese bolt. Specifically, 1) the bolt locking lugs were too narrow 2) the carburizing and hardness remained unsatisfactory because State Arsenal 356 did not change the material to equivalent AISI 8620 steel but continued to use steel equivalent to AISI 4135. This was in spite of the fact that Keng's Firearms offered to supply USGI M14 bolts until Poly

Technologies could manufacture its own bolts according to USGI specifications. Poly Technologies refused this offer from Keng's Firearms. The Chinese never changed the bolt material for M14 type rifles exported to the United States.

Century Arms International

Century Arms International was located at 5 Federal Street St. Albans, VT 05478 in the mid-to-late 1980s. By 1990, the company's address is listed as 48 Lower Newton Street St. Albans, VT 05478. Century Arms International imported Chinese M14 rifles from 1990 until at least 1993. It imported both completed Poly Technologies rifles and Norinco M14 type rifles and receivers before September 13, 1994. Chinese M14 rifles imported by Century Arms International after March 14, 1989 and before November 30, 1990 were assembled with military style features, i.e., hinged butt plate and flash suppressor with bayonet lug, after arrival in the United States (see U. S. Law and the Chinese M14 Rifle). Norinco rifles imported by Century Arms International had the least aesthetic appeal of all the Chinese M14 type rifles imported into the United States. Typically, the chu wood stocks are serviceable but not pleasing to the eye. The Poly Technologies rifles had better looking chu wood stocks and finish.

Some, if not all, Poly Technologies M14S and Norinco M14 Sporter rifles imported by Century Arms International have serial numbers with a letter C followed by a hyphen and four digits or it is denoted as the letter C immediately followed by five digits. Location of the serial number on the receiver varies too. Some of the Chinese receivers sold by Century Arms International were stamped at State Arsenal 356 in Yunnan Province and the rest were stamped by Century Arms International. For example, Poly Technologies receiver serial number C-0640 was stamped by Century Arms International and the serial number is on the receiver heel. Norinco receiver serial number C00686 was marked at State Arsenal 356 and the serial number appears on the left side of the receiver aft of the bolt lock.

From November 29, 1990 until importation ceased in September 1994, Century Arms International renamed the Norinco rifle, M14 Sporter or M14 S/A Sporter in some instances. Century Arms International modified the imported Chinese M14 type rifles at its Montreal, Quebec facility to comply with the March 14, 1989 import "assault rifle" and November 29, 1990 "assault rifle" parts ban in the United States. Century Arms International removed the military style features previously allowed from each rifle by cutting the flash suppressor just forward of the front sight, replacing the hinged butt plate with a rubber recoil pad and not supplying a magazine.

IDE USA/CJA

In April 1983, the People's Armed Police Force was formed out of the People's Liberation Army in China. The People's Armed Police Force is tasked with protecting government buildings and providing security to public corporations and for large public gatherings. Some time later, China Jin An (CJA) was formed as an arms export firm for the financial interests of the People's Armed Police Force.

The third importer, CJA (Southfield, MI) imported Chinese M14 rifles from until some point before September 13, 1994. For example, IDE USA stamped Poly Technologies M14/S

serial number 090XX was purchased new from a FFL in the United States by the original owner during the fall of 1993. Another original owner reported his purchase of IDE USA imported Poly Technologies M14/S serial number 23XXX in the spring of 1993.

The stamping IDE SLFD MICH appears on the lower serial number Norinco receivers, e.g., 000128. CJA SLFD MICH appears on Norinco receiver serial numbers 00015X and higher. To date, the marking IDE USA SLFD MICH has been observed on Poly Technologies receiver serial numbers 03028 through 25119. CJA imported the best looking Chinese M14 rifles into the United States. Representatives from CJA traveled to State Arsenal 356 in Yunnan Province, People's Republic of China to discuss the assembly process of the M14 type rifles it wished to import. These rifles were assembled with new production parts with a very good finish and some were given walnut stocks. The walnut wood for these stocks was harvested in Yunnan Province.

One Norinco M14 rifle imported into the United States had the following information on the receiver heel, top to bottom: first line – U S RIFLE second line – 7.62 MM M14 third line – SACO fourth line – 94210. No other information has been available to date on this Saco marked M14 type rifle.

Chinese M14 Type Rifle Export to Canada

Alan Lever of Lever Arms Service Ltd. (Vancouver, BC) imported Norinco M14 rifles into Canada around 1990. Century Arms International imported both Norinco and Poly Technologies M14 type rifles into Canada during the early 1990s. Some Norinco receivers imported around 2002 to 2003 by Marstar Canada had a blued finish instead of a phosphate coating. These receivers lack the scope mount vertical groove lug but the drilled and tapped bolt hole and horizontal groove are still present.

In 2004, 2005 and 2006, Marstar Canada, Inc. (Vankleek Hill, Ontario) imported Norinco M14 rifles into Canada with the CJA marking seen on American imports. These complete rifles are assembled with new Chinese manufacture parts but the receivers were the last of the residual inventory from production several years prior. As of mid-2006, the production machines used to manufacture Chinese M14 receivers had been laid up for a number of years.

The Norinco rifles imported by Marstar have the slotted flash suppressor and scope mount recoil lug. The left side of each receiver imported in 2004 and 2005 is stamped as follows: first line - M14 .308 second line - CJA SFLD MICH third line – NORINCO MADE IN CHINA and the six digit serial number. A May 2006 import is marked on the left side of the receiver as follows: first line - M14 .308 NORINCO 00XXXX second line - MADE IN CHINA SFLD, MI. The fit and finish of Norinco rifles entering Canada today are judged to be better than that found on the 1980s and 1990s M14 type rifles exported to the United States. These M14 rifles still have chu wood stocks. Reportedly, USGI bolts fit properly in these post-'00 production Norinco M14 rifles. The bolt hardness is also markedly higher than bolts exported to the United States before 1994. Marstar markets the Norinco M14 rifles as the M-305 and backs them with a one year parts and labor warranty.

Chinese Receivers

On the whole, Poly Technologies rifles have a better reputation for receiver surface

machining and finish as compared to the Norinco stamped rifles. There is no substantial difference between Norinco and Poly Technologies receivers although Smith Enterprise found the surface hardness to vary from 41 to 60 HRC without regard to marking. Smith Enterprise, Inc. has done extensive inspection, and non-destructive testing, and destructive examination of Chinese receivers. These inspections and tests have verified that Chinese M14 receivers are made of AISI 8620 equivalent alloy steel. Chinese receivers are drop forged into forms of larger bulk and less definition than the USGI receivers were. Then, like the American manufacturers, machine tools cut away at the metal from the raw forging to create the final desired shape before carburizing and heat treatment.

Chinese receivers are not made of high carbon alloy steel such as AISI 52100 or other such high chromium alloy steel. Equivalent AISI 5100 series steel is high carbon (1.0 to 1.1 %) alloy steel that is much too hard for a rifle receiver. Because it is a high carbon steel that is thorough hardened it lacks toughness and ductility needed for the M14 type rifle. AISI 52100 alloy steel is the most commonly used steel for bearings. The machinability rating is 40 % when in the spheroidized annealed and cold drawn condition as compared to 100 % for AISI 1112 steel. It is difficult to machine and must be quenched below room temperature to form martensite. Soft receivers can be brought up to USGI specification by nitrocarburizing treatment.

Chinese receivers have a threaded hole for a setscrew in the barrel ring. The Chinese rifles are built with a setscrew threaded far enough through the barrel ring to contact the barrel. The barrel setscrew is unnecessary for securing the barrel in the receiver. However, the Chinese manufactured their receivers this way because it is their psychological mindset.⁹

Markings of Exported Chinese M14 Type Rifles

Model Numbers – Norinco M14 type rifle model numbers observed are M-14, M14 Sporter, M14 S/A Sporter and M305. M14 Sporter appears to be the most common Norinco model designation. The Poly Technologies model number is denoted M-14S, M14S or M14/S. Early U. S. import Poly Technologies and Norinco manufacturer and model markings are marked on the receiver heel (see Table 11).

In 1994, Smith Enterprise, then known as Smith Arms International, offered two match conditioning packages for Chinese M14 rifles, Match Grade Basic and Match Grade U.S. The Match Grade Basic service package included receiver heat treatment and glass bedding, rifle phosphate coating, recrowning the barrel muzzle, a unitized and polished gas system and a firing mechanism tune up. The customer also had a choice with either service package of 1) installation of a Smith muzzle brake or 2) National Match modification of the customer supplied USGI flash suppressor. The Match Grade U.S. service included everything in the Match Grade Basic package plus installation of a Smith supplied American made barrel and USGI bolt, stock refinishing and marking the receiver heel as follows from top to bottom: first line - U. S. RIFLE second line – 7.62-MM M-14 third line – SMITH ENT.

Miscellaneous Notes – A very few Norinco rifles in the United States and Canada have no

manufacturer stamping but are marked with the importer's name. Based on anecdotal reporting, it appears that most, but not all, Chinese semi-automatic only M14 receivers were marked with numbers below the stock line on the left side. Sometimes these numbers match the serial number indicated on the receiver above the stock line and sometimes not. As an example, Norinco receiver serial number 9914 has 9914 stamped on the left side below the elevation knob and 9914 is electro-penciled on the left receiver leg. There are no other markings on the receiver. Poly Technologies M-14S serial number 722X has the following numbers under the stock line on the left side: 3 5 10 24 7. Poly Technologies M-14S serial number 15079 has the following numbers under the stock line on the left side: 3 4 4 38 7. Two Norinco M14 rifles imported into Canada in May 2006 had the following numbers on the receiver under the stock line on the left side, 4 2 28 14 22 and 4 3 42 22 24. The purpose of the numbers under the stock line on Chinese M14 type receivers is not known.

Serial Numbers - Serial numbers of Chinese M14 rifles are usually stamped above the stock line on the scope mount side, below and slightly behind the rear sight elevation knob. It is not unusual for the receiver serial number to be lightly stamped or engraved.

The following serial numbers have been observed on Norinco and Poly Technologies M14 type rifles in the United States:

Table 11: Chinese M14 Rifles Imported Into the United States

Brand	Importer, City and State Markings	Location of Markings	Observed Serial Number Range
Norinco	Century Arms International – St. Albans, VT	C0011X through at least C0769X – Serial number is on the receiver left side. All other information is on the receiver heel. C08610 – All information is on the receiver left side. 9914 – Serial number is on the receiver left side. All other information is on the barrel.	00006 to 9914 with C09036 as the highest C prefix serial number observed

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Norinco	IDE USA /CJA – Southfield, MI	all information is on the receiver left side.	highest observed serial number for IDE USA - 000128 Observed number range for CJA – 00015X to 008108
Poly Technologies	Keng’s Firearms Specialty – Atlanta, GA	importer name, city and state are on the barrel. All other information is on receiver heel.	000001 to 028XX, KFS and CAI markings both on barrels of the first 1900 or so rifles
Poly Technologies	IDE USA/CJA – Southfield, MI	all information is on the receiver left side.	observed number range for IDE USA - 03028 to 25119
Poly Technologies	Century Arms International – St. Albans, VT	all information is on the receiver heel.	C-1245 is the highest observed serial number

The following serial numbers have been observed on Norinco and Poly Technologies M14 type rifles imported into Canada:

Table 12: Chinese M14 Rifles Imported Into Canada

Brand	Importer, City and Province	Observed Serial Number Range
Norinco	Lever Arms Service Ltd. – Vancouver, British Columbia	AL000292 to AL000755 0011XX to 0083XX for CJA
Norinco	Century Arms International – Montreal, Quebec	C09XXX is the highest observed serial number
Norinco	Marstar Canada – Vankleek Hill, Ontario	004262 to 013398 for CJA or SFLD, MI marking
Poly Technologies	Century Arms International – Montreal, Quebec	00042 to 00565X

United States Firearms Laws

The following discussion of firearms laws is not legal advice. It is presented as background information since firearms laws do affect the sale, transfer and possession of the M14 type rifle. United States law separates firearms into two categories, Title 1 and Title 2. Title 2 firearms are those regulated by the National Firearms Act of 1934 (NFA). These include machine guns, short barrel rifles, short barrel shotguns, sound suppressors, destructive devices and a special class of firearm known as Any Other Weapon (AOW). An example of an AOW is a pen gun. Destructive devices include items such as grenade launchers, mortars and High Explosive rounds. Under United States law, a select fire M14 type rifle is a machine gun.

Title 1 firearms are all other post-1899 design firearms with some exceptions (paintball guns, flare launchers, flame throwers, BB guns, etc.). Title 1 firearms are regulated by the Gun Control Act of 1968 (GCA). A M14 type rifle designed as semi-automatic only is a Title 1 firearm. State and local laws place additional restrictions on the sale, transfer, possession and use of firearms in the United States.

Before 1934, there was no regulation of private ownership of any firearms in the United States of America, let alone machine guns. Congress passed the National Firearms Act of 1934 and President Franklin D. Roosevelt signed it into law on June 26, 1934. The National Firearms Act (NFA) became effective July 24, 1934. The NFA was initially implemented through a federal tax regulatory document titled Regulations 88. This document was revised and published again in 1941 and 1952. Later, Regulations 88 was incorporated into the Code of Federal Regulations. Federal firearms regulations are included in Title 27 of the Code of Federal Regulations.

In the United States, a Federal Firearms License (FFL) is granted to an individual by the Department of Justice Bureau of Alcohol, Tobacco, Firearms and Explosives (BATFE). There are several types of Federal Firearms Licenses. The type of FFL held by the dealer legally dictates what kinds of firearms he can buy or sell. A myriad of state and local laws also affect FFL holders. The license types are as follows:

Table 13: U. S. Federal Firearms Licenses

Federal Firearms License Type	Description
1	Title 1 firearm dealer or gunsmith
2	Title 1 firearm dealer who is a pawnbroker
3	Curio & Relic firearm collector
6	manufacturer of non-armor piercing ammunition and reloading components
7	manufacturer of Title 1 firearms and non-armor piercing ammunition and reloading components
8	importer of Title 1 firearms and ammunition
9	Title 1 and Title 2 destructive devices dealer
10	manufacturer of Title 1 firearms, Title 2 destructive devices and non-armor piercing ammunition and reloading components
11	importer of Title 1 firearms, Title 2 destructive devices and ammunition

The type of FFL, among other requirements, also determines if the dealer can pay a Special Occupational Tax to the BATFE to import, manufacture or deal in National Firearm Act firearms (Classes 1 and 4, 2 and 5, and 3 respectively).

U. S. Law and the Chinese M14 Rifle

The U. S. Department of Treasury import ban of March 14, 1989 affected the Chinese M14 rifles then being brought into the United States. After the import ban, Chinese M14 type rifles entered the US market with a rubber recoil pad instead of the M14 style hinged butt plate, the bayonet lug ground off, the flash suppressor castle nut welded on and the

flash suppressor either removed or installed without the open slots which made the item suppress muzzle flash. From November 30, 1990 onward, the Chinese rifles were usually imported without an accompanying magazine. A known exception is the case of Century Arms International. After June 1992, Century Arms supplied a Chinese twenty round magazine blocked to five rounds capacity with each Chinese rifle for an unknown period. Each modified Chinese magazine had a metal block welded to the bottom of the follower to limit its capacity to five rounds. Presumably, the magazine modification was performed to comply with the July 1992 passage of the Canadian magazine capacity ban. Century Arms International imported Chinese M14 rifles into Canada before they arrived in the United States. Until November 30, 1990 one could install imported parts that would restore the Chinese M14 type rifle to a configuration prohibited from import after March 14, 1989.

On November 30, 1990 the assembly of imported rifles using imported parts to circumvent the import ban became illegal by federal regulation, which has the force of law. The BATF on that date published regulations to enforce Title 18 U. S. Code section 922 (r). These regulations prohibit the assembly of a semi-automatic rifle (or shotgun) using more than ten specified imported parts if that firearm was banned from importation after March 14, 1989. So, after November 29, 1990 the importer or owner of a Chinese M14 type rifle could have replaced a sufficient number of Chinese parts with USGI parts to “domesticate” the rifle (create the legal equivalent of a non-import rifle by making it comprise no more than ten specified import parts), thereby allowing the installation of a slotted flash suppressor with bayonet lug, and pistol grip stock or folding stock. This was legal under federal law until September 13, 1994.

On September 13, 1994 the Violent Crime Control and Law Enforcement Act went into effect. Effective September 13, 1994, all semi-automatic M14 type rifles were allowed only one specified feature if assembled on or after that date. Typically, manufacturers chose the lugless slotted flash suppressor for the one feature. If a sufficient number of specified Chinese parts were replaced with USGI parts on a Chinese M14 type rifle after September 13, 1994 so that no more than ten specified imported parts were in the rifle, a lugless slotted flash suppressor was permissible under federal law. Effective September 13, 2004, the 1994 Violent Crime Control and Law Enforcement Act regarding features on semi-automatic centerfire rifles was automatically repealed by the sunset provision. Thus, the federal laws regarding features and imported parts on Chinese and American semi-automatic M14 type rifles revert back to what existed on September 12, 1994. Some cities and states restrict features of magazine fed semi-automatic centerfire rifles, e.g., Buffalo, California, Chicago, Cincinnati, Cleveland, Connecticut, Massachusetts, New York, New York City, Rochester and Toledo. Consult federal, state and local laws before changing any features on any firearm.

After the March 14, 1989 import ban and prior to September 13, 1994, Armscorp USA, Federal Ordnance and Century Arms International assembled M14 type rifles using American made receivers and Chinese parts sets. Poly Technologies M14 type rifles in the United States are generally regarded as having been imported and assembled prior to September 13, 1994. Reportedly, some Norinco M14 type rifles were sold prior to

September 13, 1994 and some were warehoused by Century Arms International and then assembled and sold after September 13, 1994.

Domestication of The Chinese M14 Type Rifle – The owner of a Chinese M14 type rifle imported into the United States after November 29, 1990 may install a slotted flash suppressor with a bayonet lug in the United States if no more ten specified imported parts are in the assembled rifle and if allowed by state and local laws. If the import date or assembly date in the United States for a particular Chinese M14 cannot be solidly documented before November 30, 1990, the rifle owner should not assume it to be so in order to remain within the law. From Title 27 Code of Federal Regulations revised April 01, 2005:

Sec. 478.39 Assembly of semiautomatic rifles or shotguns.

(a) No person shall assemble a semiautomatic rifle or any shotgun using more than 10 of the imported parts listed in paragraph (c) of this section if the assembled firearm is prohibited from importation under section 925(d)(3) as not being particularly suitable for or readily adaptable to sporting purposes.

(b) The provisions of this section shall not apply to:

(1) The assembly of such rifle or shotgun for sale or distribution by a licensed manufacturer to the United States or any department or agency thereof or to any State or any department, agency, or political subdivision thereof; or

(2) The assembly of such rifle or shotgun for the purposes of testing or experimentation authorized by the Director under the provisions of Sec. 478.151; or

(3) The repair of any rifle or shotgun which had been imported into or assembled in the United States prior to November 30, 1990, or the replacement of any part of such firearm.

(c) For purposes of this section, the term imported parts are:

(1) Frames, receivers, receiver castings, forgings or stampings

(2) Barrels

(3) Barrel extensions

(4) Mounting blocks (trunions)

(5) Muzzle attachments

(6) Bolts

(7) Bolt carriers

(8) Operating rods

(9) Gas pistons

(10) Trigger housings

(11) Triggers

(12) Hammers

(13) Sears

(14) Disconnectors

(15) Buttstocks

(16) Pistol grips

(17) Forearms, handguards

(18) Magazine bodies

(19) Followers

(20) Floorplates

Semi-automatic Chinese M14 type rifles as imported into the United States, did not have these five parts: barrel extension, mounting block (trunion), bolt carrier, disconnecter and pistol grip. *One possible method* of installing an American made flash suppressor with a bayonet lug, where allowed by state and local law, while complying with 27CFR478.39, is as follows.

Leave these ten specified parts on the Chinese manufacture M14 type rifle: receiver, barrel, operating rod, trigger housing, sear, trigger, hammer, bolt, butt stock and gas piston. After checking the rifle is empty of ammunition in the chamber and in the magazine, replace these five parts in this order: 1) remove the Chinese hand guard 2) install a USGI hand guard (see Hand Guards for markings) 3) replace the Chinese magazine (three parts) with a USGI magazine (see USGI Magazines) 4) remove the Chinese solid faux or bobbed flash suppressor 5) install a USGI flash suppressor with bayonet lug. By installing an American made flash suppressor last the rifle will not even momentarily exist in a configuration that is prohibited from importation.

American made parts can be installed in a Chinese M14 type rifle but the U. S. owner must not install a slotted flash suppressor or a folding stock or a stock with a pistol grip with more than ten specified imported parts from the list above on the rifle. Disclaimer: As always, local, state and federal laws and regulations are subject to change. Note that the U. S. Code of Federal Regulations is revised annually. The rifle owner or gunsmith is responsible for complying with all current local, state and federal laws and regulations.

On April 06, 1998, U. S. Secretary of Treasury Robert E. Rubin issued an official press release declaring a ban on any further importation of semiautomatic rifles that could accept a magazine capable of holding more than ten cartridges and designed for a military assault rifle. Further, in letters dated July 13 and August 12, 2005, the BATFE stated that ATF Forms 6 would no longer be approved after December 31, 2005 for importing “any frames, receivers, or barrels for firearms that would be prohibited from importation if assembled.” Under these current interpretations of the “sporting purposes” language of the 1968 Gun Control Act, Chinese M14 rifles, receivers and barrels are not eligible for importation into the United States.

1994 Assault Weapons Ban

On September 13, 1994 President William J. Clinton signed bill H. R. 3355 known as the Violent Crime Control and Law Enforcement Act of 1994 (hereafter referred to as the 1994 AW Ban), into law. This law created new legal categories of semi-automatic rifles and semi-automatic pistols called “semi-automatic assault weapons” (AW or AWs). Title XI of the 1994 AW Ban prohibited any future manufacture, transfer to or possession by civilians of certain semi-automatic rifles and pistols made after that date, and also outlawed any future transfer to or possession by civilians of newly-manufactured ammunition feeding devices (commonly called magazines) with a capacity exceeding ten cartridges. This law was written with a ten year sunset provision, wherein the law by its own terms would expire on September 13, 2004 if Congress took no action to renew or extend the 1994 AW Ban.

Before this federal law expired, a number of states enacted their own permanent bans on certain semi-automatic firearms (by name and/or physical features). Some states also prohibited civilian possession of ammunition feeding devices capable of containing a specified number of cartridges, either in connection with their own versions of an AW ban or without affecting civilian ownership of semi-automatic firearms. Most states' laws of this sort did not apply to firearms and/or magazines already in possession, while other states required citizens owning the affected items to either surrender them to law enforcement officials, register them with the state government, sell them out of state (or to a licensed firearms dealer who could then sell the newly-declared contraband only to law enforcement or military users), or store them out of state. Such states included California, Connecticut, Hawaii, Maryland, Massachusetts, New Jersey and New York. As it related to the M14 type rifle, the 1994 AW Ban limited the number of specified features it could possess. The applicable sections of this expired federal law are set forth below:

TITLE XI--FIREARMS SUBTITLE A--ASSAULT WEAPONS

SEC. 110102. RESTRICTION ON MANUFACTURE, TRANSFER, AND POSSESSION OF CERTAIN SEMIAUTOMATIC ASSAULT WEAPONS.

(a) RESTRICTION- Section 922 of title 18, United States Code, is amended by adding at the end the following new subsection: `(v)(1) It shall be unlawful for a person to manufacture, transfer, or possess a semiautomatic assault weapon.

(b) DEFINITION OF SEMIAUTOMATIC ASSAULT WEAPON- Section 921(a) of title 18, United States Code, is amended by adding at the end the following new paragraph: `(30) The term `semiautomatic assault weapon' means-- `(B) a semiautomatic rifle that has an ability to accept a detachable magazine and has at least 2 of-- `(i) a folding or telescoping stock; `(ii) a pistol grip that protrudes conspicuously beneath the action of the weapon; `(iii) a bayonet mount; `(iv) a flash suppressor or threaded barrel designed to accommodate a flash suppressor; and `(v) a grenade launcher;

Consequently, manufacturers and gunsmiths in the United States almost always assembled M14 type rifles with a fixed stock and lugless flash suppressor or muzzle brake while the 1994 AW Ban was in effect. Springfield Armory, Inc. sold the M1A rifle with a ten round magazine during the period of the 1994 AW Ban.

Canada Firearms Laws

Until about 1978, a USGI M14 rifle was treated the same as any other rifle under the law in Canada. Canada then implemented restrictions on the ownership of firearms capable of automatic fire. Since 1992, firearms in Canada have been assigned to one of three legal categories: 1) Non-Restricted 2) Restricted and 3) Prohibited. A semi-automatic only M14 type rifle, e.g., Springfield Armory, Inc. M1A, is classified as a Non-Restricted firearm. Semi-automatic only M16 type rifles are listed as Restricted firearms. Fully automatic and "converted automatic" rifles are both classified as Prohibited firearms. The category of Prohibited Weapon, later changed to Prohibited Firearm, was created in 1978 by passage of a bill in the Canadian Parliament. A select fire capable M14 is considered

as fully automatic. A M14 that was select fire capable but rendered semi-automatic only is called a “converted automatic.” Canadians may still possess USGI M14 rifles but are prohibited from shooting them and the selector shaft and sear release is welded together or the selector lug is cut off.

Effective October 01, 1998, the Firearms Act requires a Canadian firearm owner to possess a valid license, known as a Possession and Acquisition License (PAL). After obtaining the PAL, the firearm owner is required to register each firearm. A Registration Certificate for each firearm is issued to the licensee. To obtain a PAL, the applicant must successfully pass at least one firearms safety course, submit an application and pay a fee. The licensee must pass an additional firearms safety course and pay a higher fee to obtain a PAL that allows possession of Restricted firearms. The PAL is issued for a period of five years.

Moving a Restricted or Prohibited firearm from the owner’s residence requires obtaining an approved Authorization To Transport (ATT) document from the appropriate Province Chief Firearms Officer. Regardless, an ATT cannot be approved for taking a Prohibited long gun to a shooting range. Firearms in Canada are also subject to storage, display, and handling regulations. There are also individual Province regulations and licensing for hunting activities. Interestingly, a non-resident can legally obtain a PAL and all necessary Registration Certificates and ATT documents. Effective July 01, 1993, all semi-automatic centerfire rifle magazines must be modified to accept no more than five cartridges.

Disclaimer: The reader is encouraged to research state and local laws regarding magazine feeding devices and semi-automatic firearms to avoid violating any law. Nothing in this work is to be interpreted as offering legal advice, and the author encourages anyone with legal questions to consult with an attorney, or an attorney with a government authority responsible for enforcing the relevant law(s) and who is assigned responsibilities relating to enforcement of those laws.

Part 2 Notes

1. Duff, Scott A. and CWO John M. Miller. p. 14 and Poyer, Joe. p. 20. Ownership of the company changed in November 1974 according to Duff and October 1974 according to Poyer. A search for “Springfield Armory” on the U. S. Patent and Trademark Office web site shows that the name has been used in commerce since November 01, 1974. Mr. Ballance agreed that the sale to Bob Reese occurred during the fall of 1974 (author’s October 08, 2004 telephone interview).
2. Smith, Ron. Personal discussion. April 09, 2004.
3. Smith, Ron. Personal discussion. April 09, 2004.
4. Poyer, Joe. p. 25.
5. Stevens, R. Blake and Edward C. Ezell. *The Black Rifle M16 Retrospective*. Collector Grade Publications: Cobourg, Ontario, Canada, 1994. p. 327.
6. *Ibid*, p. 328.
7. Poyer, Joe. p. 25.
8. Stevens, R. Blake and Edward C. Ezell. p. 327.
9. Smith, Ron. Personal discussion. April 09, 2004.

Part 3

All Things Small and Wonderful

M14 Barrel Material

Typically, commercial manufacture M14 type rifle barrels are made of AISI 4140 alloy or AISI 416 stainless steel. While much has been written discussing the merits of molybdenum-chromium versus stainless steel for barrels the best evidence seems to indicate that both are equal in match accuracy for at least the first 5000 rounds. Throat erosion and accuracy degradation occurs slowly and steadily in AISI 4140 barrels. AISI 416 stainless steel barrels tend to retain consistent accuracy then suddenly develop significantly larger shot groups. The advantage of the stainless steel barrel is better general surface corrosion resistance.

General Information on AISI 4140 Alloy Steel

The following information on AISI 4140 alloy steel is presented as background information. It is a medium carbon molybdenum-chromium alloy steel. Its description is as follows:

Typical Uses – This is a very common alloy steel. It is used to manufacture gears, axles, connecting rods, hand tools, etc.

Features - Toughness, good ductility and good torsional and fatigue strength

Machinability – Average surface cutting speed is 110 feet per minute. The machinability rating is 66 % of AISI 1112 in the annealed condition.

Forming – Good in the annealed condition

Normalizing – Typically heated at 1675 degrees Fahrenheit for sufficient time to ensure thorough heating then allowed to air cool

Hardening – This alloy can be hardened by 1) normalizing by heating to 1550 Fahrenheit then oil quenching then tempering or 2) annealing then cold working.

Annealing – Heat to 1600 degrees F then slowly cool in the furnace.

Forging – Forging is performed from 2200 degrees to 1750 degrees F.

Tempering – The steel is heated at temperatures ranges from 400 to 1200 degrees F depending on the hardness wanted. The lower the tempering temperature the higher the hardness and tensile strength. For example, AISI 4140 steel that is oil quenched then tempered to 1300 degrees Fahrenheit has an ultimate tensile strength of 118,000 psi. The same steel that is oil quenched and tempered to 700 degrees Fahrenheit has an ultimate tensile strength of 231,000 psi.

General Information on AISI 416 Stainless Steel

The information on AISI 416 stainless steel is presented for the benefit of the reader. Stainless steels are alloy steels with at least 10.5 % chromium content and nickel content ranges from 0 to 22 %. Stainless steel alloys are divided into five types, austenitic, duplex, ferritic, martensitic and precipitation hardening. Each type of stainless steel has its own set of characteristics. This in turn determines the suitability for a given application. For example, martensitic stainless steels are chosen for applications where

high mechanical strength is needed and corrosion resistance is not critical. AISI 416 alloy is a martensitic stainless steel. Its description is as follows:

Typical Uses – Valve parts, pump shafts, bolts and nuts, gears, electric motor shafts, gears

Features – Very good corrosion resistance, good strength, excellent machinability, poor weldability and magnetic in all conditions

Machinability – The machinability rating is 85 % of AISI 1112 steel. This alloy was the first free machining stainless steel developed. It has the highest machinability rating of any common stainless steel.

Hardening – This alloy can be hardened by heating between 1700 and 1850 degrees Fahrenheit, quenching in oil and tempering. This process first produces 100 % austenite structure followed by formation of martensite.

Annealing – For a full anneal, heat AISI 416 stainless steel to between 1500 and 1650 degrees Fahrenheit for thirty minutes per inch of thickness. Cool the steel at a maximum rate of 86 degrees Fahrenheit per hour to 1112 degrees Fahrenheit then air cool.

Tempering – First heat the steel to obtain the hardness and strength wanted. A lower tempering temperature results in higher hardness and tensile strength, while higher tempering temperatures produce lower hardness and tensile strength. When AISI 416 stainless steel is heated, oil quenched and then tempered to 1202 degrees Fahrenheit, it will have an ultimate tensile strength of 109,000 psi and a hardness of 20 HRC. The same steel that is heated, oil quenched and tempered to 399 degrees Fahrenheit has an ultimate tensile strength of 194,000 psi and a hardness of 41 HRC. Industry practice is to avoid tempering this alloy between 750 and 1076 degrees Fahrenheit because poor toughness and corrosion resistance results.

The Barrel Making Process

Barrel making is a centuries old process. Some steps in the process may not be performed in the order described herein, depending upon the method of rifling employed. To make a rifle barrel, a hole is drilled through the center of a piece of round bar stock using a gun drill. The hole is then reamed if it will be cut or button rifled or it is honed if it will be hammer forged. Reaming and honing improve the bore finish and make the interior diameter more consistent. The barrel blank is then rifled. Rifling forms the lands and grooves of the barrel at the desired twist rate. M14 barrels are typically formed with four grooves but some have five, six or eight grooves.

Rifling is performed using one of three methods: 1) cut 2) button and 3) hammer forging. Cut rifling uses a cutter to form the barrel grooves. Krieger and Obermeyer make their barrels by the single point cut method, with the tool cutting in only one groove at a time. USGI National Match M14 barrels were produced by the broach cut method. Button rifling involves pushing or pulling a button with lands through the blank to form the grooves of the barrel. Barrel makers such as Douglas, Hart, Shilen and Wilson Arms use the button rifling method. In hammer forging, the barrel blank starts off shorter than the finished length. The blank has a mandrel passed down the bore then it is pounded on the exterior by opposing hammers. The barrel blank is squeezed off the mandrel and cut to the desired length. TRW made chromium plated USGI M14 barrels by the hammer

forging method.

After rifling, the barrel blank will usually be stress relieved. Stress relieving can be done by heat treatment or cryogenics. When drilling removes material from the bore, stresses build up inside the barrel's remaining material. If this stress is not relieved, the barrel blank can bend during the next step in the process. After stress relief, the barrel blank exterior contour is formed by turning it on a profile lathe. The last major metalworking step is lapping. This is done to polish the bore, remove machining marks, and achieve the desired dimensional consistency. The barrel is stamped as desired by the maker then blued or phosphate coated if made of molybdenum-chromium alloy steel. Finished rifle barrel hardness is typically 25 to 32 HRC. For example, Smith Enterprise, Inc. M14SE 22 " and Mk 14 SEI 18 " chromium plated barrels are hardened to 35 HRC. This leaves the barrel strong enough to handle the chamber pressure with a comfortable safety factor yet tough enough to resist substantial impact.

Winchester used the following procedure to make USGI M14 barrels. Re-sulphurized AISI 4150 molybdenum-chromium alloy steel was hot extruded and sheared into barrel blanks. The barrel blanks were furnace heated and oil quenched with a twenty minute cycle time for the heat treatment. Next, the barrel blank was machined by drilling the bore then turning the exterior contour by four passes on lathes. The barrel was then prepared for chromium plating by electro-polishing the bore. The chromium plating was then applied. The chromium plating was applied 0.0015 " thick at the breech end of the rifling, with the plating thickness intentionally tapered very slightly to a thickness of 0.001 " at the muzzle. The barrel bore was finished to a bright luster. The USGI chromium plated barrel bore has a minimum hardness of 850 on the Vickers scale (better than 65 HRC). The final step was phosphate coating. USGI chromium plated M14 barrels weigh 31.7 ounces and were designed for a minimum service life of 15,000 rounds. The USGI M14 chromium plated barrels have a maximum rate of fire listed in both editions of U. S. Army manual FM 23-8.

M14 Barrel Length

The following is a list of barrel lengths for the M14 type rifle. Troy Industries had barrels less than 16 " in length installed on Rock SOPMOD M14 units upon special request. A rifle with a barrel less than 16 " long is considered a Short Barrel Rifle in the United States (all NFA rules apply).

Table 14: M14 Type Rifle Barrel Lengths

Barrel length (inches)	Description	Contour, rate of twist, number of grooves and chromium plated?	Comments
22	commercial match grade	heavy, 1:10, 1:11, or 1:12, four or six groove, no	various manufacturers
22	commercial match grade	medium, 1:10, four groove, no	various manufacturers
22	Springfield Armory, Inc. M1A	medium, 1:11, six groove, no	loaded standard and National Match models
22	Springfield Armory, Inc. M1A	standard, 1:12, four groove, no	Wilson Arms blanks, standard model, various years of production
22	Fulton Armory, LRB Arms	standard, 1:10 or 1:12, four, no	Wilson Arms, Criterion (1:12), Krieger (1:10)
22	Fulton Armory, LRB Arms	standard, 1:12, four, yes	Criterion
22	M14SE	medium, 1:10, four groove, no	Wilson Arms, chromium-molybdenum alloy steel, M118LR chambered, SEI part number 9345-M14SE
22	M14SE	medium, no	Krieger, stainless steel, M118LR chambered
22	M14 DMR	medium, 1:12, four groove, no	Kreiger, stainless steel
22	USGI M14 NM (part number 9349847)	heavy, 1:12 almost always, four groove, no	various manufacturers
22	USGI M14 NM (part number 9345206)	medium, 1:12, four groove, no	various manufacturers
22	USGI M14 NM (part number 7791362)	standard, 1:12, four groove, no	various manufacturers
22	USGI M14 NM (part number 7791173)	standard, 1:12, four groove, yes	Springfield Armory in 1962

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22	USGI M14 (part 7790190)	standard 1:12 four groove	various manufacturers
22	Chinese	standard 1:12 four groove, yes	Norinco and Poly Technologies
22	State Arsenal, Taiwan		T57 rifle
19.3	Harrington & Richardson Guerilla Gun	standard, 1:12, four groove, yes	H & R, Inc., a subcontractor shortened the barrel
18.5	commercial heavy Bush	heavy, 1:10, 1:11 or 1:12, four groove, no	Krieger
18.5	Fulton Armory Bush, LRB Arms Tanker	standard, 1:12, four groove, no	Criterion
18.5	Fulton Armory Bush, LRB Arms Tanker	standard, 1:12, four groove, yes	Criterion
18.5	LRB Arms Tanker	medium, 1:10, six groove, yes	Criterion
18	Springfield Armory, Inc. M1A Bush and Scout Squad models	standard, 1:11, six groove, no	Wilson Arms blanks
18	Smith Enterprise, Inc.	standard, 1:10, four groove, yes	M118LR chambered
18	M14SE	medium, 1:10, four groove, no	M118LR chambered, SEI part number 9345-MK14
18	Mk 14 Mod 0	standard 1:11, six groove, no	supplied by Springfield Armory, Inc.
17.625	Smith Enterprise, Inc. Bush barrel conversion and initial M14 EBR barrel	four groove, no	
17.625	Chinese	standard, 1:12, four groove, yes	Norinco and Poly Technologies
16.25	Springfield Armory, Inc. M1A	standard, 1:11, six groove, no	SOCOM models
16	Rock SOPMOD 14	standard, 1:11.27, five groove, no	

13.5	Smith Enterprise, Inc. M14K	standard, 1:12, four groove, yes and medium, 1:10, four groove, no	
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USGI M14 Rack Grade Barrels

Military service barrels are made of molybdenum-chromium alloy steel. M14 rack grade barrels are chromium plated, standard (lightweight) contour and have a 1:12 twist rate. There were several contractors for USGI M14 chromium plated barrels: Harrington & Richardson, Saco-Lowell / Maremont, Springfield Armory, TRW and Winchester. TRW made chromium plated M14 barrels until at least May 1964, Harrington & Richardson until at least February 1963, Springfield Armory until at least October 1967, Winchester until at least May 1964 and Saco-Lowell / Maremont until at least February 1983.

Saco-Lowell became a part of Maremont Corporation by no later than 1971. Arvin Industries, Inc. acquired Maremont Corporation in 1986. Colt's Manufacturing Company, Inc. (West Hartford, CT) owned the Saco, ME plant from late 1998 to July 2000. General Dynamics Armament Systems, a wholly owned subsidiary of General Dynamics (Falls Church, VA) bought Saco Defense in July 2000. In May 2002, General Dynamics Armament Systems purchased Advanced Technical Products, Inc. (Roswell, GA). Consequently, the division became General Dynamics Armament and Technical Products, Inc. This facility has manufactured firearms under contract for Magnum Research, Weatherby and other commercial firearms companies. The plant also produced M60 machine guns and Mk 19 40 mm automatic grenade launchers for the U. S. military.

In the spring of 2005, Smith Enterprise, Inc. extensively tested its chromium plated standard contour 1:10 twist M118LR chambered 18" barrel (SEI part number 2027). Production quantities of this barrel were delivered to Smith Enterprise, Inc. beginning in March 2006. This barrel was designed for the Mk 14 Mod 1 rifle. The barrel was intended to replace barrels on rack grade M14 rifles while being able to shoot 110 to 175 grain projectiles. These barrels have a one degree crush angle and are designed to headspace between 1.6325 " and 1.6355 " on USGI M14 receivers. The exterior of the chamber is machined to provide additional gripping surface during barrel installation. Military Specification MIL-R-45012E allows removal of chromium plating to properly headspace a barrel to the receiver. Due to variations in receiver geometry among commercial manufacturers, these barrels may not headspace properly on commercial manufacture M14 type receivers.

USGI M14 Chromium Plated Barrel Markings - From top to bottom: Harrington & Richardson August 1961, TRW September 1963, TRW December 1963 and Springfield Armory August 1962. Photo courtesy of Noname at AR15.com.

Chromium plating of barrel chambers and bores increases barrel life, improves sustained

fire capability, enhances corrosion resistance and makes cleaning easier. The chromium plated chamber aids extraction and allows the rifle to function when fouled with firing residue and dust. The disadvantage of a chromium plated bore is a slight loss of accuracy as compared to a non-plated bore. The loss of accuracy is not an amount the average shooter would notice.

A typical USGI M14 barrel marking is as follows: H R 7790190 1 63 AK. H R is the manufacturer, Harrington & Richardson. 7790190 is the USGI drawing number for the M14 chromium plated barrel. 1 63 is the month and year of manufacture, January 1963. AK was the material lot for this particular barrel. Typically, the barrel manufacturer, drawing number, date and material lot are visible by simply retracting and locking the operating rod. The exception to this rule is that some Canadian Arsenals (National Match), Springfield Armory, and Winchester barrels require the hand guard to be removed to see the factory markings.

The USGI chromium plated M14 barrel will also have the DOD acceptance stamp, magnaflux inspection M stamp and the proof firing circle P stamp all on the chamber exterior. If there is a punch mark just inside or just outside the circle of the proof firing stamp it means the barrel was removed from a M14 rifle by the military, nothing more, nothing less.

USGI M14 National Match Barrels

USGI match grade M14 barrels were made to stricter dimensional standards than the rack grade barrels. In 1963, the M14 National Match barrel bore diameter was specified as 0.300 " + 0.0010 " and groove diameter was required to be 0.3075 " + 0.0010 ". Any taper in the bore had to decrease from the chamber to the muzzle. These dimensions were checked with an air gauge that had an accuracy of 0.0001 ". The M14 National Match barrel was also examined for straightness using an optical straightness gauge. The optical barrel straightness gauge was developed at Springfield Armory and was accurate to within 42 seconds of arc. The maximum deviation for straightness was 2 minutes 23 seconds of angle along the entire length of the barrel. The M14 National Match muzzle barrel was required to be free of all burrs and nicks. USGI M14 National Match grade barrels of all contour sizes were short chambered. Installation of a USGI M14 National Match barrel required finish reaming of the chamber.

According to the August 1975 *American Rifleman*, there were some chromium plated standard contour National Match barrels made at Springfield Armory in 1962 during the production run of the first 3000 M14 NM rifles. The drawing number for these barrels was 7791173. This was an alternative standard match barrel. It was held to the same dimensional tolerances for the bore and groove as the non-plated National Match barrel (USGI drawing 7791362). The chromium plating added to the manufacturing cost but did not enhance rifle performance. Consequently, chromium plating of National Match M14 barrels was discontinued. With this one exception, match grade M14 barrels are not chromium plated.

The U. S. Army Marksmanship Training Unit tested heavyweight design match grade barrels in the mid-1970s at Fort Benning. The heavyweight barrel was found to

significantly improve target group size and required much less external contour machining. All other factors being equal, heavyweight barrels produce tighter target shooting groups because of better resistance to vibration and elongation from prolonged firing and the forces created from sling tension over thinner contour barrels. The National Board for the Promotion of Rifle Practice (NBPRP) approved the heavyweight design for the M14 NM rifle used in its regional and National Trophy competitions by July 1975. The NBPRP required that M14 type rifles used in competition with the heavyweight barrels had to keep the M14 sights, stocks, hand guards, gas systems and flash suppressors. In 1979, Ohio National Guard armorer, (then Staff Sergeant) John M. Miller, tested M1A serial number 010047 for accuracy in a test tunnel. The average extreme spread for ten shot groups of match ammunition fired from a machine rest at 200 yards was 5.25 " with a 1:12 twist standard contour USGI National Match barrel and 3.35 " with a Douglas heavyweight 1:10 twist match grade barrel.

Gene Barnett (using Douglas Premium blanks), Canadian Arsenals, Hall Planetary Company, Harris Graphics, Hart Rifle Barrels, Krieger Barrels, Mike Rock Rifle Barrels, Nomura Machine, Saco-Lowell / Maremont, SGW, Springfield Armory, and TRW made National Match GI M14 barrels. TRW made National Match M14 barrels until at least April 1966 as well as Canadian Arsenals from at least April 1967 until at least June 1983. Saco-Lowell / Maremont National Match M14 barrel markings indicate dates of manufacture from at least July 1965 until June 1985. Harris Graphics made lightweight National Match M14 barrels in 1983.

Gene Barnett was an Army National Guard armorer before going into business. He has supplied the U. S. Air Force, U. S. Marine Corps and U. S. Army National Guard with M14 National Match barrels since at least the early 1980s. The Marine Corps used both medium and heavyweight barrels while the National Guard and Air Force used only heavyweight barrels from Gene Barnett. The U. S. Marine Corps marked its shooting team M14 rifle barrels with the letters RTE. RTE stood for Rifle Team Equipment.

In June 1981, the drawing for the medium weight contour National Match barrel, 9345206, was completed at the U. S. Army Armament Research and Development Command (Dover, NJ). The material, inspection, testing, marking, and coating requirements were essentially repeated from the lightweight National Match barrel drawing. However, the machining tolerances for the barrel bore and groove diameters were held to a more stringent limit. The medium weight NM barrel bore diameter was not allowed to vary by more than 0.0001 " over the entire length. The same restriction applied to the barrel groove diameter.

Dates of production observed for SGW lightweight match barrels extend from July 1982 through January 1983. More than 1,200 of these barrels were produced. Its government contract required SGW to use steel from a particular vendor. SGW manufactured the barrels and delivered them to Rock Island Arsenal for assembly on M14 NM and M21 rifles. At that point, Rock Island Arsenal found the properties of this lot of steel to be inconsistent. This was the fault of the steel supplier and not SGW. The U. S. government canceled the contract and returned the barrels to SGW around 1984. SGW then tested all the barrels for proper hardness. Those that passed testing were remarked OLY and

sold. These OLY marked broach cut match grade barrels give excellent accuracy and service. **WARNING:** At least one of the SGW barrels that did not pass testing was tested for hardness at three positions on the exterior. The result varied from 10 to 14 HRC. This is too soft for a rifle barrel and unsafe to use. If a SGW M14 barrel is encountered it should be tested for hardness and evaluated by a reputable M14 gunsmith. The author observed an SGW M14 barrel for sale at a gun show in Phoenix, AZ in December 2003. Beware!

Nomura Machine made M14 medium weight National Match barrels in 1992 and heavyweight National Match barrels in 1993. Saco-Lowell / Maremont made lightweight (standard), medium weight and heavyweight contour National Match M14 barrels. Maremont produced medium weight and heavyweight National Match barrels in 1983. Mike Rock Rifle Barrels, Inc. M14 barrels were made in 1994 and 1995 for the U. S. Marine Corps. The gas system was moved forward 0.035 " on these heavyweight barrels to increase the dwell time so that 190 grain bullets could be used in competition. Canadian Arsenals, Harris Graphics, Springfield Armory and TRW manufactured National Match barrels in the standard contour.

The USGI National Match barrels for the most part used a 1:12 twist. One exception was several Lackland AFB U. S. Air Force-built M14 NM rifles which were rebuilt by Ted Brown in the past for the Oregon Air National Guard. These Barnett barrels had a twist rate of 1:10 and were stamped USAF on the right side of the chamber.

A USGI contract M14 National Match barrel that has passed all quality assurance inspections will be stamped or engraved NM near the muzzle. Typically, match grade M14 type rifle barrels begin to lose competition level accuracy after 5000 to 9000 rounds depending on use and cleaning regimen. Non-plated barrels can provide rack grade accuracy as long as 12,000 rounds. The approximate weight for a medium weight M14 barrel is 2 pounds 6 ounces and 3 pounds 9 ounces for a heavyweight M14 barrel.

Chinese M14 Barrels

Chinese barrels are lightweight (standard) contour chromium plated barrels. The quality of Chinese barrels is generally very good and the chromium plating is well done. The Chinese have extensive experience in chromium plating parts because of manufacturing AK type and SKS rifles. Chinese barrels are chambered for 7.62 x 51 mm NATO ammunition. Shooters have obtained 1 " groups at 100 yards with Chinese barrels.

U. S. Commercial M14 Barrels

Commercial and match barrel makers include Citadel, Criterion, Douglas, Hart, Krieger, Obermeyer, Shilen and Wilson Arms. Douglas Barrels, Inc. (Charleston, WV) has been manufacturing rifle barrels for over fifty years. Shilen Rifles, Inc. began business in 1955. The company produces various rifle and pistol barrel blanks. For the M14 type rifle, Shilen offers 416 stainless steel .308 caliber barrel blanks in 1:10 and 1:12 twists. Krieger Barrels, Inc. (Richfield, WI) was established in 1982 by Jack Krieger. Krieger Barrels and Obermeyer produce excellent quality custom barrels. Krieger Barrels, Inc. made M82A1 .50 BMG barrels for the U. S. military during the First Gulf War. In 1999, Krieger formed another company, Criterion Barrels, to make rifle barrels for

manufacturers. Barrel makers, such as Douglas and Krieger, offer M14 type barrels in different twist rates and choice of molybdenum-chromium or stainless steel. The standard twist rates are 1:10, 1:11 or 1:12. RD Systems installs a 1:11.27 twist barrel for its Rock SOPMOD M14. Commercial match barrels will be medium weight or heavyweight. 1:10 twist barrels are better for stabilizing heavier bullets, e.g., 168 grain Sierra hollow point boat tail Match. The commercial manufacturers listed above all produce high quality M14 barrels.

In November 2003 Fulton Armory began selling chromium plated and non-plated commercial manufacture standard contour M14 barrels. Criterion Barrels, Inc. supplies these barrels to Fulton Armory. They are marked C.B.F.A. Lightweight (standard contour) and medium weight M14 barrels sold by Fulton Armory are made to its specifications and come with a limited lifetime warranty on materials and workmanship. LRB Arms was selling Wilson Arms chromium plated and non-plated standard contour M14 barrels as of May 2004. These barrels were stamped, e.g., LRB 7790190 5/04 WA. Later that same year, LRB Arms began to offer Criterion 18.5 " chromium plated and non-plated standard contour barrels. Criterion chromium plated barrels assembled on LRB Arms receivers were marked in the following way: LRB 7790190 9/05 JG CBI. The 9/05 is representative of the month and year the barrel was made. Between 2004 and 2006 Springfield Armory, Inc. had used three standard contour barrels of the same length on its SOCOM M1A models but each with a slightly different chamber external profile.

Smith Enterprise, Inc. was to be supplied with barrels from Wilson Arms for future production M14K rifles and to fulfill a 2004 request from the Philippine government for 1,400 M14 barrels. The barrels were to be made to Ron Smith's specification. This specification required the barrel to be 22 " long, four groove standard (lightweight) contour with a 1:10 twist rate and 7.62 mm Navy chamber. The 7.62 mm Navy chamber is sized for heavier bullets. Some of the barrels were to be chromium plated and some not.

Accuracy Systems, Inc. can install a 1.100" diameter 26" stainless steel plain end barrel on a M14 type rifle. This installation includes a modified gas cylinder and gas cylinder lock.

USGI M14 Stock Designs

The following list is a compilation of known USGI M14 stock variations and the month and year of the original drawings. Different part numbers were assigned to the stocks, stock subassemblies and stock assemblies. Typically, a stock subassembly consisted of the bare stock, the ferrule, the front sling swivel assembly and for wood stocks, the liner and two liner screws. The butt plate assembly and fasteners and rear sling swivel were added to the subassembly to form the stock assembly.

- 1) September or October 1954 - T44E4: 7267084 = wood stock assembly (7267083 = bare stock)
- 2) September 1959 - M14: 7790702 = wood stock assembly (7790810 = stock subassembly)

3) December 1961 - M14 NM: 7791175 = wood stock assembly (7791280 = stock subassembly, 7791174 = bare stock)

4A) June 1964 - M14 NM: 11010281 wood stock assembly with routing and bedding (11010282 = stock subassembly, 11010263 = bare stock)

4B) June 1964 - M14: 11010264 = wood stock assembly (11010262 = stock subassembly, 11010263 = bare stock)

5) December 1965 - M14: 11686428 = reinforced fiberglass stock assembly (5910348 = stock subassembly with upper butt screw, nut and retainer, 11686427 = stock subassembly, 11686426 = bare stock)

6) May 1984 - M14 NM: 9392337 = wood stock assembly with routing and bedding (9381706 = stock subassembly, 9362638 = bare stock)

USGI M14 Wood Stocks

Background Information – The information on black walnut, yellow birch and cherry wood is presented below for the benefit of the reader.

Black Walnut (*Juglans nigra*)

Description – The heartwood color is light gray brown to chocolate brown to purple-black brown. The sapwood is colored creamy white to yellow brown. Black walnut has a straight grain typically but the grain can be wavy or curly. Its texture is coarse. Walnut can be steamed to make the sapwood darker and the heartwood lighter which allows more of the tree to be used. Steaming is done for aesthetic purposes and does not otherwise change the properties of walnut.

Common Uses – Gunstocks, furniture, cabinets, musical instruments, and other uses. It is an excellent wood for carving and lathe turning.

Durability – Black walnut is very durable. The sapwood is susceptible to attack by the powder post beetle. The heartwood is resistant to preservative treatment and biodegradation.

Yellow Birch (*Betula alleghaniensis*)

Description – The heartwood color is light brown to reddish brown. The sapwood is colored light red brown or light yellow. Yellow birch has straight, close grain and a fine, even texture.

Common Uses – Furniture, high grade flooring and plywood, upholstery frames among others

Durability – Yellow birch is perishable and susceptible to attack by the furniture beetle. The heartwood is moderately resistant to preservative treatment. The sapwood is permeable.

Cherry (*Prunus serotina*)

Description – The heartwood color varies from red to reddish-brown to deep red. There may be brown flecks in the heartwood. The sapwood is colored creamy white to creamy pink to reddish brown. Cherry has a fine, straight grain and a smooth texture.

Common Uses – Furniture, cabinets, flooring, boat interiors, and others. It is an excellent

wood for carving and lathe turning.

Durability – Cherry is moderately durable. The heartwood is moderately resistant to preservative treatment. The sapwood is susceptible to attack by the furniture beetle.

Table 15: Properties of Walnut, Birch and Cherry

Material Property	Black Walnut	Yellow Birch	Cherry
density (lb/ft ³)	40	43	36
specific gravity	0.59	0.62	0.54
Janka hardness (pounds)	1010	1260	950
modulus of elasticity (psi)	1,790,000	2,010,000	1,665,000
bending strength (psi)	14,800	16,600	13,520
shearing strength (psi)	1,370	1,880	1,700
compression parallel to the grain - maximum crushing strength (psi)	7,680	8,170	7,865

Wood blanks supplied for military small arms were inspected and sampled to meet minimum requirements for general condition, grain slope, moisture content, end coating, and contractually specified dimensions. Wood blanks were inspected to be free of splits, honeycombing, brashness, checks, shakes and excessive warping and shrinkage. Defects such as sapwood, mineral streaks, burly grain and a limited amount of sound pin knots and pinworm holes were allowed. The grain slope for M1 and M14 rifle stock wood blanks could not vary more than 1 " from the horizontal for any 12 " in length in the critical area. The critical area for M1 and M14 rifle wood stock blanks was defined as the forward 26.5 " + or - 1" of the blank. Average moisture content for kiln-dried blanks was limited to 6 to 8 percent. Air-dried wood blanks could not have more than 25 percent average moisture content. Green wood blanks had no limits for moisture content. Both ends of every wood blank supplied were required to be coated to control split ends. If the number of unsatisfactory blanks examined exceeded the allowable number for a given lot size, the entire lot was rejected. Regardless, any unsatisfactory condition specimen was not accepted. Kiln-dried wood blanks were sampled for case hardening. No more than two of the fifty-four specimens of each kiln charge were allowed to fail the case hardening test. If so, the entire kiln charge lot was rejected.

USGI Wood Stock Production - Springfield Armory, Harrington & Richardson, and Winchester made wood stocks for their USGI M14 rifles. Frank Overton was the owner of S. C. Overton & Co. (South Haven, MI). This company was the largest employer in South Haven, MI when it went out of business in 1990. From World War II until 1990, S. C. Overton & Co. produced M1 Carbine, M1 Garand and M14 stocks and M1 Garand hand guards. It was the exclusive supplier to TRW for walnut and birch M14 stocks. Early S. C. Overton & Co. M14 stocks were made from black walnut but most were made from birch harvested from a single forest in Maine near the Canadian border. The black walnut wood came from the U. S. government stockpile. The wood was shipped at government expense to S. C. Overton and formed on government owned stock making

machinery operated by S. C. Overton & Co. employees. The automatically operated multi-station machines performed all woodworking operations except the finish sanding. Overton birch M14 stocks tend to be stained a very dark brown. The production rate for these machines was 400 stocks per hour. The M14 stock making machinery was converted around 1971 or 1972 to produce M1 Garand stocks for a new government contract. S. C. Overton & Co. was still producing M1 Garand stocks and inventoried contract over run M14 stocks when it closed down in 1990. S. C. Overton & Co. had also manufactured match grade M14 stocks for Karl Maunz. Sykes Manufacturing made replacement M14 stocks for Springfield Armory.

The first M14 stocks were made of black walnut. Beginning in 1961, yellow birch was the standard wood with black walnut as the alternate. Some wood USGI stocks have a raised shelf at the base of the firing mechanism inletting. Ferrules, the piece of metal at the very front end of the stock, on wood USGI stocks are either dimpled (round punch mark on the sides) or crimped (half-moon indentation on both sides). Standard size wood stocks were made from 1959 to 1963. In contrast with the high degree of automation in all other production processes for the M14 rifle, the USGI wood stock makers all hand sanded every stock one at a time with a rotary sander. This was done to smooth the stock and ensure that all surfaces were true and all corners sharp. Due to naturally occurring differences in density of wood, the yellow birch and black walnut M14 stocks weighed between 34 and 38 ounces. USGI M14 wood stocks were made with steel liners fitted around the magazine well. This feature was incorporated into the T44 and T44E1 rifle designs in 1953 to prevent the stock from splitting when launching grenades. Military Standard MIL-STD-1270A(WC) is the procedure for repairing M14 and M14E2 wood stocks.

USGI Wood Stock Markings – USGI manufacturers' markings were often stamped in the butt end of the wood stocks as follows: H for Harrington & Richardson, O for S. C. Overton & Co., S A for Springfield Armory, S under a half-diamond for Sykes Manufacturing and W-W for Winchester. It may be necessary to remove the butt plate to see the manufacturer stamping. Mathewson Tool Company and Springfield Armory made T44E4 stocks. The Springfield Armory T44E4 stocks are marked S A and have the DOD cartouche.

Wood stocks were marked with a ½ " high DOD cartouche, also referred to as a Defense acceptance stamp, on the left side near the receiver and a proof mark on the underside of the grip if they passed final ordnance inspection and proof firing, respectively. A DOD cartouche inside a circle on the left side of the butt stock near the rear sling swivel has been observed on a small number of USGI wood stocks. A smaller DOD cartouche is often stamped in the firing mechanism inletting area of Winchester M14 stocks. The proof firing stamping is a 5/16 " high letter P inside a ½ " diameter circle that is stamped on the stock on the forward side of the grip. There appear to be two types of letter P proof marks, one with a serif font P and the other with a sans serif or Arial-style P. The proof firing marking appeared on U. S. military rifles from 1873 until the end of M14 production in the 1960s.

Before final assembly, each wood stock was dipped in tung oil. The walnut stocks were dipped twice but the birch stocks only once. It was found during the first half of 1962 that two coats of oil left excessive oil and residue on the birch stocks due to that wood's different grain characteristics and slower absorption of oil as compared to walnut.

Consequently, the procedure was changed to one coat of oil for birch stocks.

Commercial producers of the USGI M14 rifle sprayed a stain on the birch stocks prior to the dipping in oil. This produced a color very close to that of black walnut. After several days of draining and drying, sample stocks were tested for resistance to smoke and water before the rest of the lot was approved for oil treatment and final assembly. The last M14 rifles assembled with wood stocks left the manufacturers in July 1963. Birch stocks are stronger and harder than walnut stocks. Walnut is about 10 % lighter than birch.

A few cherry stocks were made as well. Some beech M14 stocks with the selector cutout were available in the civilian market in 1973. Reportedly, the beech stocks were manufactured by Reinhart Fajen, Inc. but this has not been confirmed. Springfield Armory was not the source of the beech M14 stocks. The Armory only used walnut and birch for making M14 stocks.

The 1984 design National Match stock (part number 9352638) can be made with the following materials: 1) black walnut 2) English walnut 3) yellow birch 4) sweet birch 5) laminated layers of black walnut 6) laminated layers of English walnut 7) laminated layers of yellow birch 8) laminated layers of sweet birch 9) sycamore 10) pecan 11) black locust 12) maple 13) red birch or 14) heat-moulded plastic. The plastic moulded stock must weigh a minimum of 2.5 pounds and have color Forest Green number 34079 per FED-STD-595.

Replacement Stocks - Most replacement USGI wood stocks will not have the proof P and DOD cartouche markings. Replacement stocks from Springfield Armory, however, were stamped with the DOD cartouche. Some of the Springfield Armory National Match M14 walnut stocks were bedded to a gage rifle. Springfield Armory National Match M14 walnut stocks were given the DOD cartouche and proof P markings. Springfield Armory shipped both bedded and non-bedded National Match M14 walnut stocks.

Winchester National Match "big red" birch M14 stocks have the drawing number 11010263 stamped into the wood under the butt plate. A number of these were also stamped with the DOD cartouche and proof P markings. Some Sykes Manufacturing wood stocks were stamped with the drawing number 7791174 on the butt end. These were replacement National Match stocks. Replacement USGI M14 wood and synthetic stocks were packaged without the hardware with the exception of the ferrule and sometimes the liner and screws for the wooden models. A square shaped piece of plastic was installed in the hinge area and two pieces of thin wood, one on either side inside the packaging, were used to protect the stock during transport and storage. The butt hinge protectors are gold or white in color and have the drawing number 7791050 centered on the top surface.

Around 1982, oversized stocks were allowed for competition at Camp Perry. Quickly, oversized walnut, birch and laminated wood M14 stocks became popular among military and civilian shooters. Solid wood USGI stocks are sought after for the appearance and

historical authenticity. However, solid wood tends to swell or contract with changes in ambient temperature and humidity. At some point no later than the mid-1950s, someone came up with the idea of gluing layers of wood together to create a rough form that could be worked into a finished rifle stock. In fact, Yale University performed destructive testing in 1954 on wood laminate gun stock blanks. This composition of wood and glue is very strong and resistant to impact. Laminated wood stocks are slightly heavier than solid wood stocks but they are more resistant to temperature and humidity fluctuations. They can be bedded just like solid wood stocks.

Reinhart Fajen began making wood gun stocks in the 1950s at a facility in Warsaw, MO. His craftsmanship earned a well-deserved reputation among hunters. Later on, Reinhart Fajen, Inc. purchased Bishop Stocks and grew rapidly. Reinhart Fajen produced factory issue stocks for rifle manufacturers such as Sturm, Ruger & Co. and Savage Arms Company. Reinhart Fajen, Inc. made USGI M14 stocks in 1988 (under 1987 Picatinny Arsenal contract DAAA 09-87-C-1143) and about 1990 for the First Gulf War. It made three styles of M14 stocks in two materials, walnut and laminated wood. Style I was the USGI standard contour and Style III was the oversized National Match stock (USGI drawing number 9352638 NSN 1005-01-233-8635). Later-manufacture oversized National Match stocks do not have stock liners. They were made to be bedded and have been routed for the rear lug. The M14 stocks supplied to the U. S. government for the First Gulf War were shipped to Rock Island Arsenal for cutting the selector cutout, preserving and packing before stocking in the DOD supply system.

Unfortunately, Mr. Fajen passed away in the mid-1990s and the company struggled thereafter. Reinhart Fajen, Inc. was then acquired by the Potterfield Group. The Potterfield family made a valiant but unsuccessful attempt to turn a profit from the plant in Lincoln, MO. Manufacturing operations were suspended in Lincoln, MO by the fall of 1998. Production of stocks for other rifles was then contracted out to several companies around the United States using proprietary CNC software programs. The equipment and inventory was sold off. Boyds' bought the stock inletting equipment from Reinhart Fajen, Inc. Springfield Armory, Inc. bought half of the remaining inventory of M14 stocks and Midway USA purchased the remainder. All of the stocks, including the M14 models, quickly sold out once it was known that the Lincoln, MO plant had ceased operating. Springfield Armory, Inc. installed stocks made by Reinhart Fajen, Inc. on M1A rifles until at least January 1999. As of 2004, Battenfeld Technologies, Inc. continued manufacturing this line of stocks for rifles other than the M14 type.

USGI M14 Synthetic Stocks

Experimentation with synthetic material stocks began in the late 1950s for the M14 project as at least two T44E4 rifles were fitted with black color man-made material gunstocks. General Tire & Rubber Company joined Springfield Armory in 1960 in conducting research to develop a synthetic stock for the M14 rifle. Development of this lighter, stronger stock made of fiberglass reinforced polyester plastic for the M14 proceeded in stages from 1960 until late 1965. The drawing for the final version M14 fiberglass stock is dated December 1965. Beginning in 1962, fiberglass stocks were installed on M14 rifles at the factory but it was not by Springfield Armory. The following

year, Springfield Armory produced a single batch of 10,000 M14 rifles in October 1963 with synthetic material stocks.

The early fiberglass stocks had no checkering and the hole for the upper butt plate screw had a wood insert to which the wood stock upper butt plate screw was anchored. These early issue fiberglass stocks were milk chocolate brown in color. At least some of these early stocks were marked on the inside of the magazine well as follows: right side top line - DM-1775-GB-2, right side bottom line - DT, left side top line - DT and left side bottom line - DM-1775-GB-1. Later-manufacture fiberglass stocks were assembled with an upper butt plate screw with a finer thread. The later upper butt plate screw is anchored to a steel nut held inside a metal bracket inside the stock.

Stock ferrules on synthetic USGI stocks are either crimped or dimpled but the dimpled ferrules are not common. Military Specification MIL-S-45921A and drawing 11686427 require the ferrule to be cemented and crimped to the stock to prevent movement. Thus, it appears that dimpled ferrules are earlier production stocks.

The USGI M14 synthetic stock was designed and tested for ruggedness. Forty sample stocks were selected by the U. S. government representative during initial production and monthly thereafter. Any failure of any test of any sample stock meant the day's production or the represented batch was rejected.

Ten tests were conducted on each sample lot of fiberglass reinforced plastic stocks: 1) physical examination 2) functioning firing 3) targeting and accuracy 4) adhesive and foam 5) twist 6) shock resistance 7) shock resistance endurance 8) low temperature shock resistance 9) low temperature abuse and 10) heat resistance. Some tests were conducted on all forty sample stocks, e.g., visual, functioning firing and targeting and accuracy. Most of the tests though were conducted on a portion of the sample lot. For example, twist testing was performed on five stocks and shock resistance was tested on ten stocks in each sample lot. The sample stock testing is briefly reviewed here:

Physical Examination – The sample stock was examined for proper assembly and measured for compliance to specified dimensions at several points. Both sides of the synthetic stock were tested twice each at the butt, the receiver and the forearm areas for hardness for a total of twelve readings per stock. The readings were required to average a minimum of 50 Barcol. The Barcol scale is used to measure the hardness of reinforced and non-reinforced rigid plastics.

Functioning Firing – The stock was assembled with other components to make a complete M14 rifle. The rifle was placed into a fixture to simulate offhand firing. The rifle was test fired using two full twenty round magazines in both semi-automatic and automatic using M59 or M80 ball ammunition.

Targeting and Accuracy – Again, the sample stock was made part of a complete M14 rifle and placed into a test fixture. The rear sight aperture was set at eight clicks from bottom and zero windage. The rifle sights were aligned at the 6 o'clock position on a target and fired for ten rounds. The results of the sample lot of forty synthetic stocks were compared to the targeting and accuracy results of forty wood stocks known to be satisfactory. The targeting and accuracy results of the synthetic stock sample lot had to equal or exceed

those of the forty wood stocks to pass.

Adhesive and Foam – The stock was sectioned by cutting at a minimum of eleven specified areas along the length of the stock. The foam was examined for any presence of voids. The specific requirement was that the foam fill had to be free of voids more than 10 % of the total volume with none more than ¼” in diameter and no more than one void per two cross-sectioned areas.

Twist – The sample stock was mounted into a test fixture and torqued to 40 ft-lbf once each in the clockwise and counterclockwise directions. The stock was visually examined for any defects.

Shock Resistance – The stock was assembled with other components to make a complete M14 rifle. The M76 grenade launcher was attached to the flash suppressor and the spindle valve turned to the horizontal (gas cutoff) position. The rifle was placed into a fixture. With the toe of the butt stock at 45 degrees, five practice anti-tank grenades were launched using M64 grenade blank cartridges. The sample stock was then removed from the rifle and examined for any defects or signs of damage.

Shock Resistance Endurance – Three of forty stocks in each sample lot were selected for this test. It is performed in the same manner as the shock resistance test but 100 rifle grenades are fired instead of five using each sample stock.

Low Temperature Shock Resistance Test – This test was performed just like the shock resistance test except the rifle was kept at – 65 degrees Fahrenheit + or – 5 degrees for three hours before and then during the test.

Low Temperature Abuse Test – The sample stock assembled into a complete M14 rifle was stored at – 65 degrees Fahrenheit + or – 5 degrees for three hours then dropped from a height of 3 feet on to a hardwood bench. The test was repeated so that the stock would impact at different points (left side, right side, and butt stock toe and heel) on the bench. After this, the rifle was allowed to swing 90 degrees by its own weight from a horizontal position, while held at the muzzle, so that the stock would hit the flat side of the hardwood bench. This was repeated so top, bottom and both sides of the stock impacted the side of the bench.

Heat Resistance – The sample stock was assembled into a M14 rifle with the bolt, firing mechanism and operating rod spring removed. The test rifle was placed in a stand to hold it in the horizontal position. A 115 Volt AC, 1000 Watt heating rod with an effective heating length of 24 " was placed inside the barrel. The heating rod was connected to a variable voltage control. A thermocouple was attached to the top of the barrel about 10.5 " from the end of the muzzle. The thermocouple was wired to a pyrometer to indicate the barrel temperature during the test. By increasing the voltage applied to the heating rod in stages, the rifle barrel temperature was brought up to 1,200 degrees Fahrenheit. At that point, electric current flow through the heating rod was stopped and the barrel cooled to ambient temperature. The stock was then examined for any damage.

USGI M14 synthetic stocks have the letters DT as well as other alphanumeric characters in the magazine well area (see Hand Guards). A small gap between the middle portion of

the receiver and the stock is normal for USGI wood and synthetic M14 stocks, but is more noticeable on many fiberglass stocks. The USGI synthetic M14 stock itself weighs 34 to 36 ounces. A USGI M14 synthetic stock with all the correct metal hardware weighs in at about 46 ounces. USGI fiberglass stocks were made as late as 1968. The U. S. Army awarded a contract to General Tire & Rubber Company in July 1968 for 500,000 fiberglass reinforced polyester plastic M14 stocks to be used as replacement stocks as needed. USGI M14 synthetic stocks have always been allowed for competition at Camp Perry.

USGI M14E2 Stocks

The M14E2/M14A1 rifle was fitted with a walnut or birch straight-line stock. At least one laminate wood M14E2 stock was made and it was issued for service. It appears that at least 10,350 M14E2 stocks were made in the 1960s. At least 8,350 M14E2 stocks were produced in 1963 and 1964 and another 2000 or better about 1967 or 1968. The first M14E2 stocks were made in late 1963. Most of the M14E2 stocks were made of birch at Canadian Arsenals Limited in Long Branch, Ontario, Canada in 1964 to support the M14E2 conversion project at Springfield Armory. Canadian Arsenals Limited produced Browning pistols, Sten submachine guns and other military equipment during and after World War II. Long Branch is a suburb of Toronto.

The few walnut M14E2 stocks were made at Springfield Armory, Rock Island Arsenal and Anniston Army Depot. Springfield Armory walnut M14E2 stocks have the DOD cartouche but Canadian Arsenals birch M14E2 stocks do not. Winchester made at least one cherry M14E2 stock. Sykes Manufacturing also made some birch M14E2 stocks, presumably under contract for Springfield Armory. An additional 2000 or more M14E2 stocks were produced around 1967 or 1968 but without the fore grip and butt plate assemblies. This latter batch of stocks was released around 1978 or 1979. These M14E2 stocks were sold with commercial reproduction fore grip and butt plate assemblies.

In 1971, surplus parts dealer Pete Michaels (Batavia, IL) bought more than 3000 M14A1 stocks without hardware and more than 200 M14A1 stocks with hardware. Springfield Armory, Inc. sold M14E2 birch and walnut stocks before 1994. In 2000, Fred's (Ramseur, NC) was the winning bidder on a U. S. government auction of 2,701 M14E2 stocks. Currently, Fred's is the only known surplus dealer of M14E2 stocks in the U.S.

The USGI M14E2 stock has a selector cutout, rubber recoil pad, smooth surface flip up butt plate, a pistol grip and fore grip. Early model fore grips were made of phenolic resin, while later grips were rubber coated metal. The fore grip locks into place when in use. It retracts and swings upward by pulling on a latch on the rear side of the grip. The position of the fore grip is adjustable. A medium weight or heavyweight M14 barrel will fit in an M14E2 stock with no problems.

Commercial Synthetic Match Grade Stocks

McMillan Fiberglass Stocks, Inc. – As a boy, Gale McMillan became an excellent marksman by hunting rabbits to help provide food for the family. He became a bench rest competition shooter in 1958 and enlisted in the U. S. Air Force the same year. During ten years of military service, Gale McMillan shot competitively and worked on rifles for other

competitors. After the service, he settled in Phoenix, AZ and was employed in plastic mold making. He applied his knowledge and experience to start making fiberglass rifle stocks in 1973. He started his own company in 1975 producing fiberglass rifle stocks and building rifles. Around 1986 or 1987, McMillan Fiberglass Stocks began using CNC machine tools in its manufacturing operation. Through the years, Gale was assisted by his wife, Gloria, and other family members in the day-to-day operations of the business. McMillan Fiberglass Stocks, Inc. has brought many creative designs to the gunstock market.

McMillan Fiberglass Stocks developed its M1A stock to meet the request from the U. S. Marine Corps for a more durable M14 stock. In the present day, McMillan makes three models of fixed butt stock synthetic stocks for the M14 type rifle, M1A, M2A and M3A. The obvious difference between the three models is the grip style but they all must be bedded to the rifle's receiver and firing mechanism before use. These stocks can be fitted with or without a steel liner. The M2A and M3A models have adjustable cheek pieces. The McMillan M1A stock is a traditional design sized for heavy barrel M14 type rifles and is the most common choice of stock for U. S. Army M25 rifles. McMillan M2A stocks have been fitted on M25 rifles for the Army 10th Special Forces Group and M14 DMR rifles for the U. S. Marine Corps. The U. S. Navy SEALs are reported to have M14 rifles dressed in McMillan M3A stocks. The M2A and M3A stocks are not allowed to compete as Service Rifles per the rules for Director of Civilian Marksmanship and NRA High Power Competition matches, but may be used in NRA High Power Rifle competitions as a Match Rifle (a class usually populated by shooters using bolt action rifles).

Bell and Carlson - Bell and Carlson is a designer and manufacturer of synthetic material rifle stocks. Its offering for the M14 type rifle is one model in its special purpose line of stocks (catalog number C190). The stock is built with structural urethane, aramid, graphite and fiberglass. It is offered in a choice of seventeen finishes. This stock will accommodate a heavyweight contour barrel and the magazine well is flared to facilitate quick magazine changes.

Folding and Telescoping Commercial Stocks

Folding and telescoping design stocks have been commercially available for the M14 type rifle since at least 1978. States such as California, Connecticut, Massachusetts and New York prohibit or regulate installation of folding or telescoping stocks on semi-automatic centerfire rifles capable of accepting a detachable magazine, e.g., M14 type rifles. There may be other states and municipalities with restrictions on the installation of folding or telescoping stocks. Consult state and local laws before installing these stocks.

1978 Commercial M14 Folding Stock – About 1978, two gentlemen in New York developed a BM59 Alpine style folding stock for the M14 type rifle. They manufactured ninety-eight of these high quality M14 folding stocks. The folding butt stock mechanism was fabricated by arc welding steel tubes and steel plates together. The upper horizontal tube of the butt stock was 0.9 " in diameter. The folding butt stock was phosphate coated then covered with several layers of black color vinyl. The thick vinyl covering of the wide

upper bar made a firm and comfortable cheek weld possible. The butt stock was folded to the right side by pushing a friction latch, on the left side of the stock, outward from the stock and moving the butt stock to the right. The folding butt stock mechanism was mated to a modified M14E2 stock subassembly behind the receiver heel. The folding stock weighed 3.2 pounds. Length of pull for the folding stock was 14 ". With the butt stock folded, the overall length for a 22 " barreled rifle was 36 ". Thomas A. Buss, a surplus small arms parts dealer hailing from Springdale, PA, bought eighty of these folding stocks. The remaining stocks were sold to various individuals.

Springfield Armory, Inc., Reese Surplus, Inc. and Choate Machine & Tool, Inc. - Choate Machine & Tool, Inc. (Bald Knob, AR) began operation in 1972. Choate Machine & Tool produces gun stocks and other firearms accessories. In early 2005, the company began development on a new design pistol grip folding stock for the M14 type rifle.

Springfield Armory, Inc. offered commercial M1A-A1 folding stocks in the 1980s and early 1990s. The company made three versions of the M1A-A1 folding stock. The first version was either a modified M14 or a modified M14E2 stock. These stocks were cut just behind the receiver well, where an Italian BM59 Alpine metal butt stock was added. These BM59 butt stocks had butt plates with a rubber pad on the upper half of the butt plate and two braces for supporting the butt plate. The first version M1A-A1 stock often used a modified M14 stock and had a plastic pistol grip added to it, rather than starting out as a M14E2 stock. The plastic pistol grip had a storage space accessed by a metal cover on the bottom. The first version of the M1A-A1 stock may or may not have the selector cutout because it originated as a USGI stock. M1A serial number 0663XX, built in the fall of 1991, was assembled with a BM59 Alpine folding stock mated to a commercial walnut stock and plastic pistol grp with the metal cover.

The second version of the Springfield Armory, Inc. folding stock does not have the lower butt plate supporting brace or selector cutout. It has a hardwood pistol grip and full length rubber butt pad. This version is still available from Reese Surplus (Colona, IL) as a modified BM59 folding stock fitted to the M1A or M14. Since it is a modified BM59 stock, it does not have a selector cutout.

Springfield Armory, Inc.'s third version of a folding stock is a Choate Machine & Tool, Inc. plastic butt stock folding arm with steel hinge, mated to a truncated USGI M14 stock. The folding arm mechanism was attached by two large screws to either a M14E2 stock without the selector cutout filled in or a synthetic M14 stock with an added synthetic pistol grip and the selector cutout filled in. The third version synthetic material folding stocks are black color and have a full length rubber butt pad. This type of folding stock was assembled to M1A serial number 081239 in mid-1994 at the factory. The inside of the butt plate on the Choate Machine & Tool folding arm is marked as follows: first line – CHOATE TOOL CO. second line – BOX 218 third line – BALD KNOB, ARK. fourth line – 72010. Springfield Armory, Inc. sold the third version folding stocks as late as 1999 with the instruction that they were to be installed on rifles assembled prior to September 13, 1994, in compliance with the 1994 Assault Weapons Ban still in effect at that time.

SparrowHawk Stocks - In the fall of 2003, SparrowHawk Stocks introduced the M-14CM4

stock to the market. The M-14CM4 stock is the mating of a M16 type four-position telescoping stock and pistol grip to a synthetic M14 stock for use on M14 type rifles where allowed by law. State and local law may allow installation of this stock if the butt stock is fixed and a muzzle brake is permanently installed. Consult state and local laws before installing this stock. A lower front hand guard and M1913 Picatinny style accessory rails are optional. Colors available are black, white, olive drab and earth brown.

Rock SOPMOD M14 Stock - The Rock SOPMOD M14 has a telescoping stock. The alloy aluminum stock body is attached to a titanium six-position collapsible rail butt stock and adjustable cheek rest. Length of pull from the rear of the butt stock to the pistol grip is approximately 11 " when fully extended. This was designed to accommodate operators wearing body armor. The telescoping stock extends and retracts with the push of a button at the end of the stock behind the receiver heel. The stock has ambidextrous sling swivel studs. The stock color is typically black.

Troy Industries Telescoping M14 Stock Project - LAW483 Enterprises designed the Drop-In Modular Battle Stock for Troy Industries. Troy Industries had two prototype Drop-In M14 Battle Stocks on display at the 2004 SHOT Show. Both prototype stocks were made of fiberglass and incorporated a magazine well with an opened up lengthwise dimension, making magazine insertion much easier. The enlarged magazine well also resulted in a hump-like area just in front of the magazine well, providing a grip point on the stock. The Drop-In M14 Battle Stock prototypes had a telescoping M16 type stock that also folded to the left side, an M16 type grip with a textured surface and ambidextrous sling swivel studs. The prototype models had M1913 Picatinny style rails at the three, six and nine o'clock positions on the fore end. The company then expressed plans to add a twelve o'clock rail to the production model.

By the fall of 2004, the M14 Drop-In Modular Battle Stock had been further refined and reclassified as the M14 Modular Stock System (MSS). The M14 MSS was a drop in stock with no replacement of parts needed other than the stock and hand guard. It was designed to fit all standard configuration M14 type rifles and be modified to accept other M14 type models. The stock body was machined from bar stock T6 alloy aluminum and hard coat anodized to military specifications in a choice of black, green, or tan colors. The design called for a six-position collapsible and side folding M16 carbine style butt stock. The butt stock assembly was to have modular storage compartments and a sling swivel on the top edge at the rear end. Further, the M14 MSS included a full M1913 Picatinny rail system with a full length bottom rail, 6 " side rails and a detachable top rail. The side and bottom rails were to be supplied with rail covers. The detachable top rail ran from the front band to just in front of the rear sight aperture. All rails featured numbered cross slots and sported military specification ¼ " x 20 threaded holes. The Troy Industries M14 modular stock weighed less than 3.5 pounds.

Several design changes were made in the M14 MSS project in 2005. Consequently, it made sense to rename the M14 stock project. Troy Industries introduced its Compact Battle Rifle Stock (CBRS) at the Tactical Response Expo on August 30 and 31, 2005 in Chantilly, VA. As introduced in August 2005, the CBRS consisted of a 2.5 pound stock assembly and a 1.9 pound M1913 Picatinny rail assembly. Both assemblies were made

of alloy aluminum and available in either black or dark earth (brown) polytetrafluoroethylene finish with matching pistol grip and rail covers.

By May 2006, the CBRS was renamed the Drop In Stock System (DISS). The M14 DISS is designed to duplicate the ergonomics of the M16A4 carbine. Consequently, no cheek rest is needed for this stock with optical scopes and sights. The stock assembly includes a Vltor Weapon Systems six-position collapsing M16 style butt stock with storage compartments and a six o'clock 12 " rail. The stock assembly is shaped to accommodate standard, medium weight and heavyweight barrels and the M14 select fire components. A side plate can be attached to cover the selector cutout if desired. The stock assembly has adjustable and locking mechanical bedding at the trigger guard, operating rod guide and the gas cylinder. The mechanical bedding feature allows the stock to be tensioned for improved accuracy because the barrel harmonics remain consistent with each shot fired.

The M14 DISS is removed and installed just like a USGI M14 stock. The operating rod guide does not need to be replaced. The Vltor collapsing butt stock can be replaced with Ace stocks and adapter blocks to create a left-hand or right-hand folding stock. The top rail requires removal of the rear sight assembly, but not the stripper clip guide, to allow installation of the rail assembly. The top rail runs from the front band back to the rear sight. The rail assembly has three, six and nine o'clock M1913 Picatinny rails as well.

Sage International, Ltd. – Sage International, Ltd. began operations in 1973. Mr. John Klein is the owner and President of the company. Its modern manufacturing facility boasts extensive machining and welding capabilities. Sage International, Ltd. makes rifle and shotgun accessories, vehicle gun racks and inspection mirrors.

The idea for the M14 Enhanced Battle Rifle began in 2000 with some U. S. Navy SEALs from the Atlantic Fleet looking for a compact M14 rifle for arctic operations. David P. Armstrong (NSWC Crane, IN) designed and patented the M14 EBR stock (U. S. Patent # 6,839,998). He developed the M14 EBR stock by starting with the telescoping mechanism sold by Sage International, Ltd. to NSWC Crane for use on Remington pump shotguns. Other modified USGI M14 stocks were submitted to the U. S. Navy SEALs for evaluation. These experimental M14 stocks included a Butler Creek side folding model, a telescoping M16 type stock assembly and a cut off M14E2 stock with a M2 bipod leg added to the rear. The Navy SEALs preferred the Sage International telescoping modification out of the stocks submitted for evaluation. The Navy SEALs requested an improved cheek rest be developed for the compact M14 design. The M14 EBR concept blossomed from that point onward.

NSWC Crane let a bid for the M14 EBR stock on May 11, 2004. The five year contract was awarded to Sage International, Ltd. The Sage International M14 Enhanced Battle Rifle (EBR) stock was a steel wire telescoping pistol grip stock with adjustable cheek piece and adjustable butt pad. The stock body was CNC machined from 6061-T6 aluminum-magnesium alloy billet. This alloy is commonly used to fabricate items such as aircraft and electrical fittings and bicycle frames. The Sage International EBR stock had ambidextrous sling swivels and four military standard M1913 Picatinny rails around the barrel and one behind the receiver heel. It was designed to fit a M14 type rifle with a

standard contour and medium weight barrels. The Fulton Armory medium weight barrel had been contoured to fit in between the two hand guard screw bosses in the EBR stock. The EBR stock would not fit any heavyweight barrels. The standard size operating rod guide was replaced with an operating rod guide supplied by Sage International. Once that was done, it was a matter of reassembling the rifle with the stock bolted to the new operating rod guide and replacing the traditional front band with a washer to align the gas cylinder to the barrel. The M14 EBR stock operating rod guide was machined from AISI 4130 alloy steel. Sage International, Ltd. also made a stripper clip guide scope mount base for anchoring a scope or dot sight. The clip guide base may be used in conjunction with its stock for mounting optics. Sage International, Ltd. won a contract in 2004 to supply its EBR stock for M14 rifles to the U. S. Navy. The Sage International EBR stock has seen service on M14 rifles in use by U. S. Army soldiers in Afghanistan.

In late November 2004, Sage International produced an unknown quantity of upgraded M14 EBR stocks for the U. S. Navy SEALs for evaluation. The specification for this developmental stock was supplied by Naval Surface Warfare Center at Crane, IN. This upgraded version of the M14 EBR stock was named "Chop Mod." It is to be used on the U. S. Navy Mk 14 Mod 0 rifle. The Chop Mod stock is a lighter non-reflective anodized gray color version of the M14 EBR stock. Twenty-five extra holes are drilled in the frame, rails and butt stock/pistol grip mount to reduce the weight. Additionally, the top rail is 11.25 " long or 1.75 " shorter than the original M14 EBR stock. The side rails are 1.60 " shorter than the original black color M14 EBR version. The shortening of the accessory rails further reduces the stock weight. Consequently, the Chop Mod stock weighs four ounces less than the original M14 EBR model. The six-position steel wire butt stock runs through a sturdier butt stock/pistol grip mount that is fitted with a new internal metal support tab. The side of the Chop Mod stock is marked on the right hand side below the operating rod rail from top to bottom: first line – EBR CHASSIS STOCK second line – SAGE INTERNATIONAL, LTD third line – Oscoda, Mi 48750 Patent Pending. The stock inscription was done with dot matrix style lettering for all stocks produced in November 2004.

During the November 2004 batch production run of M14 Chop Mod stocks Sage International, Ltd. also made twenty-five of these lighter anodized gray color M14 stocks but with a 13 " full length top rail like the original black color M14 EBR stock model. This single lot of twenty-five stocks was released by Sage International through authorized distributors to the civilian market. Beginning in late December 2004, all Sage International M14 stocks available to the civilian market have the same features as this single lot of twenty-five gray color M14 stocks except smooth lettering is used for the manufacturer's inscription. The Chop Mod version is used on the U. S. Navy Mk 14 Mod 0 rifles from the end of 2004 onward. Before production of the original M14 EBR stock ceased by the end of 2004, a number of black EBR stocks were produced with the shorter Chop Mod side rails and smooth lettering inscription described above.

Sage International, Ltd. introduced its Mk14 Mod 0 stock with a collapsible M16 carbine style butt stock in Las Vegas, NV at the 2005 SHOT Show. These stocks became available to the commercial market in April 2005. They are available in black or gray. A

California legal version of the Sage International M14 stock was available to the public by March 2005. This version had a fixed synthetic black stock with butt pad, top, bottom and side rail mounts but no pistol grip. LAW483 Enterprises offers two standard grip butt stocks for the Sage International, Ltd. M14 EBR stocks, 11.5 " and 13.25 " length of pull.

J. Allen Enterprises, Inc. - J. Allen Enterprises produces and markets the JAE-100 stock for semi-automatic only M14 type rifles. Development of the stock began in 2003. The JAE-100 is legal for civilian owners in California. J. Allen Enterprises corresponded with the California Department of Justice for several months to ensure the design of the JAE-100 stock did not meet the California definition of an assault weapon pistol grip stock. This correspondence included a letter from the California Department of Justice dated October 22, 2003 which specifically confirmed the definition of an assault weapon pistol grip stock. The JAE-100 stock design did not meet the definition of an assault weapon pistol grip stock.

The JAE-100 stock is made of a proprietary polymer material molded over a full length aluminum skeleton. It has a textured exterior surface. The JAE-100 stock is offered in six colors: dark earth, coyote brown, olive drab, titanium grey, lowlite green or SWAT black. A cheek rest with adjustment spacers, a palm rest, an off hand rest and butt spacers are supplied with the stock for individual fitting. The cheek rest, palm rest, off hand rest, and butt adapter are made of polymer. The butt pad, butt spacers and grip are made of rubber.

The JAE-100 design changes the way the M14 type receiver is held to the stock. Two adjustable titanium locking plates and two screws lock the receiver to the full length aluminum skeleton. The locking plates rest outboard of the the trigger guard hooks inside the stock. The screws attach to the locking plates from the bottom of the stock. The firing mechanism is installed in the normal manner. The JAE-100 stock weighs 3 pounds 4 ounces stripped and 5 pounds 4 ounces with all accessories installed. The JAE-100 stock will accommodate standard, medium weight or heavyweight contour M14 barrels without any fitting. Sling swivel studs are located on the left hand side of the stock. The bipod stud is aft of the M1913 Picatinny style rail section on the fore end bottom side. Options include textured matching color traditional style hand guard or full length top or full length bottom M1913 Picatinny rails. The JAE-100 stock length of pull can be adjusted from 12.4 " to 15.4 ". The stock dimensions are as follows: overall length - 34.6 ", overall width - 2.1 " and overall height - 6.5 ".

LAW483 Enterprises – LAW483 Enterprises offers two folding M14 stocks. The Drop-In Modular Battle Stock folds, collapses for adjustable length of pull, has rails at three, six and nine o'clock, a LAW483 proprietary enhanced magazine well for easier insertion, proprietary fore end texturing and can be configured for bottom or side sling swivels. The highly modified USGI M14 synthetic stock utilizes a M16 carbine type collapsible butt stock and A1 style pistol grip. Its BSR Folding Stock mates a Beretta BM59 folding mechanism to a modified USGI M14 synthetic stock. The BSR Folding Stock is formed to follow the contours of the USGI M14 wood stock and is given a front end side sling swivel. Filling the selector cutout, various grades of surface texturing, single point sling attachment, and camouflage pattern painting are additional options for either stock.

McMillan Fiberglass Stocks, Inc. – McMillan Fiberglass Stocks completed its first production run of folding MFS-14 stocks in October 2004. The McMillan Fiberglass Stocks tactical MFS-14 stock uses a six-position M16 carbine style padded butt stock that is attached to a folding mechanism mounted to a modified M2A stock. The butt stock folds to the receiver left side which allows for firing while folded. When extended, it locks positively and only requires a tug to release. The sling swivel is located on the right side of the stock just above the pistol grip. The McMillan tactical MFS-14 stock has three different fore end rail configurations. One rail configuration covers the barrel from the barrel ring to the front band and the front 4 " or so at the fore end at the three, six and nine o'clock positions. Another rail arrangement extends the six o'clock rail forward to accommodate a bipod and the third configuration extends the twelve o'clock rail to the rear. The MFS-14 stock requires bedding for installation.

Other Stocks

Generally, commercial market wood stocks will not have a selector cutout. However, as of 2005, Fulton Armory does offer an unfinished new manufacture walnut USGI pattern M14 stock with or without the selector cutout. Typically, Springfield Armory M1A rifles are outfitted in textured and painted USGI synthetic, commercial walnut or USGI birch stocks. Before 1994, Springfield Armory, Inc. offered extra fancy AAA grade walnut stocks as an option for the M1A. Black colored crinkle texture synthetic stocks are fitted with a rubber butt pad. This softens the recoil and the overall length is increased by an inch. Some black color crinkle texture stocks have the selector cutout. The Springfield Armory, Inc. Standard and Scout Squad M1A rifles are available in hunting camouflage synthetic stocks.

Boyd's Gunstock Industries, Reinhart Fajen, Inc., Shaw and Wenig Custom Gunstocks have manufactured wood stocks for the M14 type rifle at one time or another. Reinhart Fajen, Inc. supplied a lot of 100 match grade M1A stocks without the selector cutout to Springfield Armory, Inc. in Texas in late 1971. The Reinhart Fajen, Inc. Style II was a medium contour stock available in walnut or laminated wood. Fred Wenig was the plant manager at Reinhart Fajen, Inc. for many years. He now operates his own gun stock making business in Lincoln, MO. Wenig Custom Gunstocks produces a Monte Carlo style comb M1A rifle stock with a more vertical grip and double palm swells. It is available in walnut or laminated birch. The Wenig traditional style M1A stocks are made in maple or walnut. Wenig also produces the adjustable cheek rest walnut stock for the Springfield Armory, Inc. M21 rifle.

Boyd's Gunstock Industries offers two styles of M1A stock in walnut or laminated wood. The Boyds' Style I is not inletted for bedding but Style II has a semi-inlet cut and must be bedded. Boyds' M1A walnut stocks are slightly wider at the rear end than the USGI M14 butt plate.

Springfield Armory, Inc. offered Shaw stocks as optional items in 1982, 1989 and 1990. In 1982, there were two M1A Combat models. One model had a laminated walnut standard stock and a metal flappered butt plate. The other M1A Combat model was fitted with a laminated walnut pistol grip stock and a rubber butt pad. Both stocks had the John Shaw design forearm. In 1989, both Shaw walnut standard and walnut M14E2 style

stocks were offered. The following year 1990, the Shaw walnut standard stock was an optional catalog item. The John Shaw design stocks were easily identified by the rectangular shaped extra forearm thickness in the area of the front sling swivel. The front sling swivel was secured to the stock by two hex head screws.

The Chinese stocks on M14 rifles imported into the United States by Keng's Firearms Specialty and Century Arms International were made of chu wood. Chu wood only grows in Manchuria, China near the Russian border. Chinese M14 type rifles imported by IDE USA/CJA into the United States have walnut stocks. The walnut for these stocks was harvested in Yunnan Province, People's Republic of China. Chu is softer and lighter than black walnut. Why was chu wood selected for the Chinese M14? Because chu has very good resistance to the effects of mildew.

For long term storage, a rifle fitted with a wood stock should have the trigger guard unclamped from the stock. This will allow the wood stock to expand and contract as the weather changes, avoiding compression of the wood and loosening of the receiver-to-stock fit.

The USGI M14 fiberglass stock lends itself to camouflage pattern finishes by anyone with an imagination, a steady hand and paint. The flip up butt plate on the M14 and M14E2 stocks was adopted from the M15 rifle that was declared obsolete in 1959. An M14 stock can be fitted with an M1 Garand butt plate to shorten the overall length by about ¼ ". However, the part of the stock heel which houses the butt plate's hinge should be filled in with suitable material. An alternate solution provided by SparrowHawk M14 Stocks is to remove the hinge and roll pin from the M14 butt plate. The stock is preserved and the storage compartment is still readily accessible. A USGI M14 stock installed to a Chinese M14 rifle will require fitting, as there are small dimensional differences.

Israeli Military Industries modified the USGI M14 stocks it supplied for the Israeli Defense Forces. An integral cheek rest and rubber butt pad for sniper duty was added to each stock. The Israelis used two different versions of its M14 stock. The early version had a shorter length cheek rest, while the later version used a longer cheek rest. A rubber pad was attached to the rear end of the longer cheek rest on stocks so equipped. The IDF M14 stocks also had left hand side sling swivels just aft of the stock ferrule and just forward of the rubber butt pad and a metal-reinforced bipod stud just aft of the bottom front sling swivel. Some of these stocks have been exported back to the United States for commercial sale. Springfield Armory, Inc. purchased some of these stocks and painted them black. These stocks were used in the assembly of the IDF M1A rifles.

Sage International, Ltd. - Sage International offers its EBR stock with a fixed Remington 870 shot gun butt stock or in conjunction with Fulton Armory, a wood M14 butt stock. This stock is legal under local state law for sale to California residents. The standard finish for both EBR stocks is smooth black with a black textured lower fore end hand guard. Both EBR stock models are CNC machined from 6061-T6 alloy aluminum and supplied with a replacement operating rod guide.

LAW483 Enterprises – LAW483 Enterprises creates fixed butt M14 stocks by modifying USGI synthetic stocks or by forming them from laminated wood or by use of woodworking

methods for extra fancy woods such as maple or walnut. The M14 butt plate can be replaced with a M1 Garand butt plate or a John Masen, Hogue, Leapers or Pachmayr rubber recoil pad. The USGI M14 stocks are typically stiffened in the fore end and any factory depressions filled in. The USGI synthetic stocks can also be modified to create a right, left, or ambidextrous vertical grip. Options include filling of the selector cutout, various grades of surface texturing, single point sling attachment, side sling swivels, LAW483 proprietary enhanced magazine well, camouflage pattern painting, acrylic coating, and reducing or increasing the length of pull per customer order.

LAW483 M14 fixed butt stock offerings can be divided into four categories: 1) pistol grip 2) vertical grip 3) thumbhole and 4) standard grip. The pistol grip models are the M-14 E2, and the M-21 E2. Vertical grip M14 stock choices include the LAW-TAC Vertical Grip Ruck Rest, the LAW-TAC Off-Hand, and the Vertical Grip Match. Two thumbhole style M14 stocks are available, the LAW483 Thumbhole Sporter and the LAW483 Thumbhole Tactical. The more traditional standard grip choices include Standard Grip Recoil Pad, USGI M-14 Buttplate, M-1 Garand Buttplate, Body Armor Designmated Marksman, and the LAW-TAC Patrol Stock

Hand Guards

USGI Hand Guards - The very first hand guards for the USGI M14 were made of black walnut. These were changed to a slotted fiberglass model by May 1960. Later, the under side of the slotted fiberglass hand guards were painted silver to help dissipate barrel heat. Apparently, some of the slotted hand guards stayed with the rifles for some time. From a photograph of PFC John F. Dugan, USMC taken in September or October 1966 near An Hoa, Quang Nam, Republic of Viet Nam, one can see a slotted hand guard on his M14 rifle.

The slotted fiberglass hand guards were found to be relatively fragile (especially by U. S. Marines practicing close order drill), and caused mirage over the barrel on rapid fire. So, some changes were made to the hand guard die to create a solid fiberglass hand guard. The average thickness of the M14 hand guard was increased from 0.070 " to 0.090 ". Both slotted and solid USGI hand guards are ribbed to increase rigidity.

Fiberglass was developed in the late 1940s. It is a composite material made up of glass fibers dispersed throughout a polymer resin matrix. Fiberglass has about the same longitudinal tensile strength as wood but it is not as stiff. The benefits of fiberglass hand guards over wood hand guards are less maintenance and better resistance to the effects of weather. Wood and fiberglass both have poor thermal conductivity which means they are excellent insulators. This is a useful engineering property for the M14 hand guard and stock for obvious reasons.

The solid fiberglass hand guard design was finalized in October 1961. The solid hand guard became the standard in 1962. USGI solid hand fiberglass guards were made in at least four color variations, coffee, brown, dark brown and black. USGI M14 hand guards often have the letters DT followed by a number ranging from 2 to 67 on the bottom side. Earlier hand guards were not painted silver on the under side, e.g., hand guard marked DT 19. A solid hand guard marked DT 27 is painted silver on the bottom for heat

dissipation. The manufacturers of USGI contract M14 hand guards have not been determined with certainty.

Commercial Production Hand Guards - Before 1994, Springfield Armory, Inc. sold heavy walnut match, extra fancy AAA grade walnut and laminated walnut and maple hand guards for the M1A. It has installed commercial reproduction plastic hand guards on M1A rifles from the mid-1990s onward due to the scarcity of new USGI hand guards. Chinese M14 rifles were imported into the USA with a marbled brown synthetic hand guard. Reinhart Fajen, Inc. offered matching wooden hand guards when it was producing M14 stocks. Boyd's' and Wenig also sell matching hand guards for their wood stocks. Commercial wood hand guards are noticeably thicker than the USGI wood hand guards. Fulton Armory offers a more rugged solid glass-reinforced polymer brown color hand guard, as compared to even the USGI solid fiberglass hand guard. The Fulton Armory hand guard may be ordered with an optional black color textured epoxy coating. Fulton Armory glass-reinforced polymer and Springfield Armory, Inc. plastic hand guards are not silver color on the bottom side.

Carbon Fiber Hand Guards - In 2004 and 2005, there was a limited amount of research and development performed by private individuals to manufacture carbon fiber M14 hand guards. Carbon fiber-polymer, or carbon fiber for short, is one of many types of fiber-reinforced composite materials. A reinforced-fiber composite material is made up of strong but brittle fibers residing inside a tougher and more ductile solid matrix material, e.g., bricks made of mud and straw.

The carbon fibers can be loose and randomly arranged inside the matrix or they can be woven into two or three dimensions. Fibers can be formed from metal, glass, plastics, carbon, or other materials. The matrix material can be made from a metal (aluminum, magnesium, tin, etc.) or a polymer (polyester, epoxy, vinyl ester, etc.) or a ceramic (aluminum oxide, zirconium oxide, glass, etc.). Polymer base matrices are suitable for operating temperatures below 600 degrees Fahrenheit, e.g., M14 hand guard.

The size, shape and number of parts to be made will influence the choice of manufacturing method. Loose carbon fibers can be mixed with a liquid resin (matrix material). The mixture could then be loaded into an injection molding machine. The mixture is pushed through a die to the form the part. Or the composite material mixture could be sprayed against a form and allowed to harden.

Loose, random carbon fibers may be held inside a sheet of matrix material. Such a structure is referred to as a mat. The part can be formed by laying and pressing reinforced-fiber resin mat against a die, or pattern of the part. This method is suitable for manufacturing M14 hand guards. Pressing the mat against the die to form the part can be accomplished in a number of ways: 1) pushing a hand roller against the mat while the mat is lying in the die 2) using gas pressure or vacuum to press the mat against the die or 3) using a matching die to push the mat against the die underneath it. The form is taken from the die, cured, and the flashing, or trim removed to create the final product. Fiber-reinforced composite material can be finish machined by conventional means (saw, router, mill, drill, shear, sander, etc.) but precautions must be taken to avoid skin contact

or inhalation with splinters and dust.

Carbon fiber mat is more expensive than fiberglass mat. Carbon fiber-epoxy composite material is several times stronger and stiffer than fiberglass, pound for pound. Not surprisingly, the greater strength of carbon fiber is more expensive. In 2005, carbon fiber mat was about four times the cost of fiberglass mat. Carbon fiber will deteriorate over time from ultraviolet ray exposure (sun light). Thus, a clear polyester coating containing an ultraviolet ray inhibitor should be sprayed on the surface of the die before the carbon fiber mat is laid down.

Epoxy resin is stronger than polyester resin or vinyl ester resin but also more expensive. M14 hand guards made from three layers of carbon fiber-epoxy resin composite material are strong enough to support the weight of a man standing in the middle with the ends supported without breaking or cracking. However, carbon fiber-epoxy resin is a brittle material. When the sides of a carbon fiber-epoxy resin hand guard were flattened together in a vise the material broke where held by the jaws of the vise.

In 2005, a private individual in the United States made carbon fiber-epoxy resin M14 hand guards for himself and a friend. When finished, the hand guards were about 0.030" thick using the vacuum bag method described above. One of the hand guards had an aesthetically pleasing turquoise color. He was able to produce this color by adding a small amount of blue pigment to the clear polyester ultraviolet ray inhibitor coating.

USGI Sights

The M14 type rifle has the best iron sights of any battle rifle. The M14 sights are almost identical to those found on the M1 Garand rifle but it has the longest sight radius of any magazine fed semi-automatic battle rifle in the world. The M14 rifle has a sight radius of 26.75 " with the rear sight aperture set at 100 meters. The very long sight radius helps maximize the battlefield accuracy of the M14 rifle. The long sight radius also makes it easier for farsighted shooters to use iron sights. There are three sizes of front sight blades and three sizes of rear sights.

Rear Sight Assembly - The standard issue rear sight aperture has a diameter of 0.069 " + 0.005 ". The USGI M14 also had two National Match rear sight aperture sizes, 0.0520 " and 0.0595 ". Either National Match rear sight aperture can be fitted with an adjustable hood (National Match rear sight apertures without the hood were made only for the M1 Garand rifle). Use of the hood on the rear sight allows for one-half minute of angle adjustments in elevation. The elevation knob always moves point of impact one minute of angle per click, while rotating the sight hood will add or subtract a half-minute of angle of elevation. A notch in the rear of the hood designates the direction of the extra adjustment—rotating the notch from the six o'clock position to the twelve o'clock position will add elevation, while rotating the notch from the top position to be on the bottom will subtract elevation.

Rear Sight Base - The M14 standard (rack grade) rear sight base was borrowed from the same 1937 vintage part for the M1 Garand rifle. Additionally, three other rear sight bases could fit the M14 rifle. These rear sight bases were marked NM, NM/2 and NM/2A. The NM rear sight base was designed about 1958. It accepted a non-hooded rear sight

aperture but would not allow a hooded aperture to fully lower into the base. The 1961 design NM/2 rear sight base was a NM rear sight base machined after manufacture to allow a hooded aperture to fully seat in the base. Subsequent to the NM/2 modification, the 1963 design NM/2A rear sight base was a newly manufactured part that allowed the rear sight base to be fully lowered into the base.

Elevation and Windage Knobs - The M14 type elevation knob will have the letter M inscribed on it between the numbers 10 and 11. This denotes calibration in meters. If the elevation knob does not have a letter M, the knob is calibrated in yards and was made for the M1 Garand rifle. The windage knob on an M14 type rifle will either be the standard one minute per click adjustment, or the National Match model of one-half minute of angle per click adjustment. The National Match windage knob must be matched to a National Match rear sight base because they both have finer threads than the standard USGI parts. The finer threads of the National Match rear sight parts allow the smaller angle adjustments.

Front Sight - The front sights are classified by the blade width. The standard or USGI front sight is 0.084 " - 0.010 " wide. The military National Match front sight is 0.065 " - 0.005 " wide. The USGI and NM M14 front sights can be used as a range finding device by the shooter. Assuming a 22 " barrel length, a 20 " wide target (frontal view of a deer) will appear to be the same width of the front sight post at the following distances: 0.062 " USGI NM sight - 230 meters (251 yards), 0.072 " Commercial NM sight - 198 meters (216 yards), and 0.084 " USGI sight - 169 meters (185 yards). NM sights will be marked NM 062 or NM 072 as appropriate.

Combination Gas Cylinder Lock Front Sight - The traditional M14 front sight and flash suppressor assembly is not the most suitable attachment point for a sound suppressor. The combination gas cylinder lock front sight was developed by Smith Enterprise, Inc. to meet the U. S. Navy requirement to allow for the possibility of installing a sound suppressor on Navy Mk 14 Mod 0 rifles. There are two basic designs of the Smith Enterprise combination gas cylinder lock front sight, a hooded non-adjustable post type sight and a traditional dovetail type sight.

If a M14 type rifle is assembled with a Sage International M14EBR or Chop Mod stock, the fastening of the Sage operating rod guide to the stock causes the bullet point of impact to be lower than it would be if a non-Sage stock was used. Also, a shorter barrel requires the height of the front sight to be taller to achieve the same point of impact as the standard configuration of 22 " barrel and traditional USGI flash suppressor and front sight. Thus, when SEI installs a combination gas cylinder lock hooded non-adjustable front sight, the barrel length (18 " or 22 ") and the stock (Sage or non-Sage) are factors in setting the height of the post sight.

The hooded non-adjustable post type sight, model GLFS-H, was developed first (SEI part number 2012). The advantages of the hooded non-adjustable post type combination gas cylinder lock front sight over the traditional M14 front sight are faster target acquisition, better front sight protection, and no possible shifting of the front sight. Subsequently, the GLFS-D-18 and GLFS-D-22 combination gas cylinder lock dovetail type front sights were developed for users who wanted to be able to fine tune the iron sights while maintaining

the option to mount a sound suppressor in conjunction with the SEI M14DC flash hider. The GLFS-D-18 model (SEI part number 2013) has a taller sight base to account for the shorter 18 " barrel it is mounted on. Similarly, the GLFS-D-22 part (SEI part number 2011) is intended for use with 22 " length barrels.

A very few of the Smith Enterprise M14 EBR combination gas cylinder lock dovetail type front sights have metal removed from under the front half of the dovetail sight base. The machining cut is a pronounced ninety degrees under the sight base. This particular modification was done an earlier means of allowing installation of a Smith Enterprise direct connect flash hider on a 17 5/8 " barrel.

All Smith Enterprise combination gas cylinder lock front sights are made from nitrocarburized AISI 4140 alloy steel. The hardness specification for the combination gas cylinder lock front sights is 55 to 60 HRC. From 2004 onward, Smith Enterprise is marking its parts with serif font lettering.

Combination Gas Cylinder Lock Front Sight Markings - Some Smith Enterprise, Inc. combination gas cylinder lock front sights are marked PAT. PEND. on the top line and U.S.N. on the bottom line. Beginning in July 2005, the Navy issue combination gas cylinder lock dovetail type front sight is marked U.S.N. on the top line and SMITH ENT on the bottom line. Later that year, Smith Enterprise began marking combination gas cylinder lock front sights with U.S.A.F. and SMITH ENT in a similar fashion. By May 2006, the Navy Mk 14 issue combination gas cylinder lock sight marking was changed to U.S.N. on the top line and MK-14 on the bottom on the front side and S.E.I. on the rear side.

Installation of a Sage International, Ltd. M14 stock locks the stock and barrel together at a third point through the proprietary operating rod guide (the other two contact points are the stock ferrule to barrel front band and the receiver-to-firing mechanism interface). This fastening of the barrel improves accuracy but causes the non-Sage stock combination gas cylinder lock front sight, model GLFS-D-22, to have a point of impact markedly lower than what it would otherwise. The GLFS-D-18 model is employed on U. S. Navy and U. S. Air Force Mk 14 variant rifles which use the Sage International stocks. In 2006, Smith Enterprise, Inc. installed GLFS-D-22 gas cylinder lock front sights installed on M14 rifles rebuilt for the U. S. Army 101st Airborne (Assault) Division.

Both models GLFS-D-18 and GLFS-D-22 have a modest bevel on the front end under the barrel. This bevel facilitates use of the Smith Enterprise direct connect flash hider on 17 5/8 " barrels equipped with these front sights. The longer distance from front to rear of the dovetail style combination gas cylinder lock front sights does not permit use of the M2 type bipod.

Commercial Sights

Chinese rear sight aperture diameter tends to be larger than on the USGI standard model. Tooltech (Oxford, MI) can install a 1/8 " tritium insert into the M14 type front sight for use in low light conditions. Brownells, Inc. sells an Alley Supply globe style front sight and set of inserts for the M14 type rifle. This type of front sight is useful in reducing eyestrain in target match shooting. The Rock SOPMOD M14 can use flip-up type M16

type sights.

Springfield Armory, Inc. - Springfield Armory, Inc. made a 0.072 " NM front sight for its match rifles in the 1980s. It is marked NM 072 on the side. Springfield Armory M1A Scout and Bush rifles are fitted with slightly different front sights to compensate for the shorter barrel. The Scout / Bush front sight blade height itself appears no different, but its base is four millimeters taller.

Smith Enterprise, Inc. – Smith Enterprise M14 National Match front and rear sight parts are machined from AISI 4140 alloy steel bar stock using the wire EDM method. The rear sight aperture is the hooded type. Smith Enterprise plans to produce the standard rear sight aperture in the future. Amherst Arms will be the distributor for Smith Enterprise, Inc. front and rear sight parts.

Close Quarters Battle Application Sights - In 2004, XS Sight Systems introduced a M14 type rifle front sight for Close Quarters Battle situations. It is the factory issue front sight for the M1A SOCOM models. The front sight is a tritium dot halo style sight. This sight set is designed for faster acquisition of targets over the traditional sights. Sight sets for 16 ", 18 " and 22 " barrels are available. The rear sight aperture on the M1A SOCOM models has been enlarged from the standard military diameter for faster target acquisition.

In August 2005 Smith Enterprise, Inc. debuted its M14 dovetail style tritium 0.076 " diameter dot front sight for low light conditions in short range combat. This sight is made from wire EDM manufactured AISI 4140 alloy steel and is finished with phosphate coating (SEI part number 2019). The sealed tritium vial is supplied by Trijicon, Inc. In March 2006, Smith Enterprise, Inc. had made available a second tritium front sight, a luminescent vertical post model. This front sight is supplied by Unertl Optical Company, Inc.

Muzzle Attachments

Several different muzzle attachments are available for the M14 type rifle. They can be classified into four categories, flash suppressors and hidere, muzzle brakes and stabilizers, grenade launchers and sound suppressors. Sound suppressors are discussed in separate sections. The reader should consult federal, state and local laws before removing or installing any muzzle attachments to an M14 type rifle. Some muzzle attachments may be illegal to attach to the rifle.

Closed Prong Flash Suppressors / Flash Hidere - A flash suppressor or hidere is desirable for military purposes. It serves to eliminate the flash signature of a rifle or machine gun thereby conserving the shooter's night vision and concealing his position from the naked eye. The flash suppressor works by cooling the gun powder gas temperature to a point below the flash point. The wider bottom prong of the USGI and NM M14 flash suppressors aids in reducing recoil.

The USGI flash suppressor was fitted on all USGI M14 rifles except for match M14 rifles. Match grade M14 rifles were fitted with flash suppressors that have been reamed out to National Match specification (a standard taper reamer is used to enlarge the end of the flash suppressor to 0.406 " wide). The USGI M14 flash suppressor drawing 7791053

required the wrought or cast specified steel to be heat treated before machining. This heat treatment procedure consisted of first heating the specified steel to between 1350 and 1575 degrees Fahrenheit. The steel was then oil quenched and tempered for a minimum of thirty minutes to achieve the specified hardness.

Brookfield Precision Tool also made a special flash suppressor for the U. S. Navy. It had a front sight machined into it as it was built to support a silencer. The silencer hid or interfered with the standard front sight so the standard flash suppressor was not used. Some Chinese made M14 type rifles imported into the United States after March 1989 have faux flash suppressors or the suppressors completely cut off at the muzzle. They also may be tack welded to the barrel. The Chinese faux flash suppressors were made without milling out the slots between the prongs. Enterprise Arms sells a M16A2 bird cage style flash suppressor for M14 type rifles. This has the advantage of shortening the rifle overall length by about one and one-half inches.

Open Prong Flash Suppressors / Flash Hiders – Smith Enterprise, Inc. makes an open prong flash hider which is not subject to problems normally associated with such designs. The straight prong flash hider design is susceptible to loosening under fire unless it is very tightly torqued on to the barrel. The Smith Enterprise flash hider solves this problem. It was invented, designed and refined by Sonja Sommers of Smith Enterprise, Inc. in 1994 and early 1995. It is a patented accessory (U.S. Patent Number 5,596,161). This flash hider is machined from AISI 8620 bar stock alloy steel then case hardened to provide a tough core and hard surface for maximum strength. It is given a phosphate coating and comes with a conditional lifetime guarantee. The dimensions are 2 ¼ " long and 0.861 " diameter. It is sound suppressor capable. The flash hider is secured to the barrel by threads but it is not a timed item (no specific parts need to be lined up when installed). When the Smith Enterprise flash hider is fastened, it is simply snugged tight and it does not need a lock washer to stop its rotation at any specific alignment. It conceals better than 99 % muzzle flash and greatly reduces muzzle climb even on full automatic. Four specially angled flutes dissipate the gas but contain the unburned powder allowing increased residual burn for less visible flash.

Briefly in 1994, Smith Enterprise manufactured Sommers design M14 flash hiders. These flash hiders had six degree angled flutes, M16 style blank firing attachment grooves and a muzzle end snap ring brush protector groove. These features were incorporated into the 1995 patent.

Subsequently, the Smith Enterprise M14 flash hider design was changed to a helix design without the blank firing attachment and brush protector grooves. The helical flash hider tightens itself on the barrel's muzzle threads when the weapon is fired. The design also helps to evenly align exiting barrel gas to improve accuracy with all bullet types. The flash hider will have "left hand" angled slots for barrels with left hand threads and "right hand" angled slots for barrels with right hand threads. The Smith Enterprise flash hider has successfully passed the U. S. Navy 5000 round endurance test. It is in service with many U. S. law enforcement agencies and has been used in combat by the U.S. military. Smith Enterprise offers two versions. The direct connect model threads directly to the barrel muzzle threads. The traditional style front sight base version attaches to the barrel

using the flash suppressor nut. The direct connect flash hider is sound suppressor capable (all NFA Rules apply).

Springfield Armory, Inc. sold its M1A-A1 model with a short open prong flash hider from 1981 to about 1984. This flash hider was about 1 " long and had a slight taper narrowing to the front end. Enterprise Arms lists a M14 open prong flash hider for sale on its web site.

Adjustable Vibration Flash Hider - In years past, AWC Systems Technology has modified the M14 type rifle to increase accuracy by reducing barrel vibration. This modification included removing the front sight and flash suppressor, cutting the gas cylinder just forward of the spindle valve, welding a HK91 front sight just forward of the front band and threading an adjustable bird cage style flash hider on the barrel. This adjustable flash hider works in much the same way as the vibration reducing muzzle attachment on Browning bolt action rifles. The flash hider is turned on the threads to find the optimum spot where accuracy is maximized for a given cartridge load.

Muzzle Brakes - Muzzle brakes are installed on M14 type rifles to reduce muzzle climb, felt recoil or to comply with state law, e.g., California's prohibition of civilian-owned flash suppressors. JP Enterprises, Inc. (Hugo, MN), famous for its M16 style muzzle brakes, has in the past manufactured a muzzle brake for the M14 type rifle. This muzzle brake included the sight base for the traditional dovetail front sight. Fabian Brothers Sporting Goods, Inc. (1986 address 3333 Midway Drive Suite 104 San Diego, CA 92110) made and marketed its M14 DTA MIL BRAKE muzzle brake in the mid-1980s. It is a two piece muzzle attachment consisting of a muzzle brake and flash hider. It is threaded on to the rear portion and secured with a lock nut. The flash hider is narrower than the muzzle brake section. The rear portion is secured to the barrel with the traditional flash suppressor "castle" nut. The rear portion has a bayonet lug and dovetail mount for the front sight. Jim Clark of Clark Custom bought the design rights from Fabian Brothers and produced another Fabian design muzzle brake for a time.

Springfield Armory, Inc., Smith Enterprise and Enterprise Arms offer muzzle brakes for the M14 type rifle. Springfield Armory, Inc. also installs its standard muzzle brake on the M1A Scout Squad model and all M1A rifles shipped to California except the M1A SOCOM models. The M1A SOCOM models have a proprietary combination gas cylinder lock and muzzle brake. The Smith Enterprise muzzle brake is machined from AISI 8620 alloy steel. It has successfully passed the U. S. Navy 5000 round endurance test. The Enterprise Arms muzzle brake is made from quality steel and finished in black oxide.

Troy Industries offered a CQB combination flash suppressor/muzzle brake for the Rock SOPMOD M14. It was machined from AISI 4140 alloy steel and given a phosphate finish. The front surface of the Troy Industries muzzle compensator consisted of many pyramid shaped points. The purpose of this was to prevent slippage of the muzzle when pressed against an opponent in extreme close quarters combat.

USGI Muzzle Stabilizer - The M14E2/M14A1 was fitted with the M2 bipod clamped to the gas cylinder and a stabilizer assembly fitted over the flash suppressor. The stabilizer assembly has holes drilled in it which direct the majority of the muzzle gas to exhaust to

the left side and slightly upward of the flash suppressor. This helps reduce muzzle climb during automatic fire. The original 1962 design of the M14E2 stabilizer did not include a locking mechanism. Later, a locking mechanism was added and then improved upon. The early style locking mechanism did not lock well enough to keep the stabilizer on the rifle during extended firing. So, the locking mechanism was redesigned to the bolt-tightened unit available today. The second and final versions of the USGI M14E2 stabilizer assembly will be marked on the operating rod side of the locking mechanism with the drawing number. The second version is marked 7791661. The final version is marked ASSY 11686521. Earlier second version muzzle stabilizers were marked M on the front side of the locking mechanism lug while later second version and third version units were marked MPI in the same spot. Presumably, M and MPI mean the part was examined by magnetic particle inspection.

Commercial reproduction M14E2 muzzle stabilizers made by Ray Kryza of Ray's Surplus (Warren, MI) are of high quality. These M14E2 muzzle stabilizers have been made since at least 1987. They will have a drawing number on the right side of the locking clamp.

Commercial Stabilizer – Springfield Armory, Inc. very briefly made its own version of a muzzle stabilizer for its folding stock M1A-A1 Bush rifle. Two variations of the Springfield Armory, Inc. muzzle stabilizer were made, one with a bayonet lug and one without. This muzzle stabilizer was made before the 1994 Assault Weapons ban. The muzzle stabilizer without the bayonet lug was installed at the factory in 1984 on M1A-A1 serial number 0298XX. The front portion of the Springfield Armory, Inc. muzzle stabilizer has a combination muzzle brake and bird cage style flash hider. It threads on to the rear portion but is held in place by a single SAE 10-32 thread setscrew on the bottom. Removing the flash hider reduces the length of the rifle by 2.75 ". The rear portion of the muzzle stabilizer consists of the front sight base and bayonet lug. It is marked on the bottom, front to rear: first line - SPRINGFIELD ARMORY second line - MUZZLE STABILIZER third line - CAL. 7.62. The outside diameter is 0.6 " for the entire length of the stabilizer. Numrich Gun Parts Corporation and Sarco, Inc. imported cast reproduction M14E2 muzzle stabilizers which may or may not have any markings such as numbers or lettering. If there are no numbers or letters on a M14E2 muzzle stabilizer at all, it is of commercial manufacture.

Grenade Launchers – The T140 grenade launcher was developed for the M14 rifle in 1955 (drawing F7267617). For some reason, the T140 grenade launcher was redrawn in 1958 and assigned part number 7790900. The T140 grenade launcher was adopted as the M76 and produced in 1961. The M76 grenade launcher is marked LAUNCHER GRENADE M76 U S on the rear end ring and 7790900 on the right side of the locking clamp. It became obsolete with the introduction of the M79 grenade launcher in the mid-1960s.

The X-1 was an experimental breech-loading 40 mm grenade launcher made for the M14 rifle in 1961. The electro-penciled marking Grenade Launcher 40 mm X-1 appears on the bottom side at the rear end. The X-1 grenade launcher used an experimental sight mounted on the left side of the stock like the issue M15 sight but it was larger with the angles of fire indicated along a protractor. A pull wire mounted along the right hand side

of the stock terminated in a loop at a point between the trigger guard and the magazine. The X-1 grenade launcher was developed by a Springfield Armory research engineer. It was tested at Fort Benning with very good success. However, the engineer, known as "Nick", almost lost his job because of it. Nick was asked by an unnamed official to fit a 40 mm grenade launcher to a M14 rifle. The unnamed official had been told by Rock Island Arsenal personnel that a 40 mm grenade launcher could not be added to a M14. Rock Island Arsenal was the parent command for Springfield Armory in 1961. Unfortunately, some professional jealousy existed at Rock Island Arsenal over the engineering expertise at Springfield Armory. Consequently, Nick's useful invention was not well received by personnel at Rock Island Arsenal.

Mr. Stanley D. Silsby of Granby, MA filed a patent application with the U. S. Patent Office for a M14 rifle barrel mounted breech-loading grenade launcher on June 13, 1961. His grenade launcher design was approved on November 05, 1968 as U. S. Patent Number 3,408,761. To launch a grenade, the operator had to simultaneously push the safety and the trigger buttons together against a spring. The safety and trigger buttons were located at the front end of the launcher on the bottom side.

Two 40 mm grenade launcher systems for the M14 rifle were demonstrated at Fort Benning and tested at Springfield Armory during the period of July 01, 1963 to June 30, 1964. The particular designs demonstrated and tested have not yet been identified.

Rock SOPMOD M14 stocks can accommodate the newer M203 40 mm grenade launcher originally designed for installation on M16 series rifles. Civilians may own 40 mm grenade launchers in the United States in accordance with the National Firearms Act of 1934. Consult federal, state and local laws prior to installing a grenade launcher on a M14 type rifle.

Military Sound Suppressors

Sound suppressors are used to conceal the origin of sniper fire, and/or deceive enemy troops regarding the shooter's location, by minimizing the muzzle blast. During the Viet Nam War, the XM21 rifle was sometimes equipped with the Sionics M14 SS-1 suppressor. Forty Sionics SS-1 suppressors were sent from the U. S. Army AMTU in February 1969 to the U. S. Army 9th Infantry Division Sniper School for testing in combat. More Sionics SS-1 suppressors were shipped to the U. S. Army in Viet Nam after April 1969. This suppressor consisted of a series of counterclockwise and clockwise metal spiral shapes abutting each other around a smooth perforated barrel extension core with rings fore and aft. A gas relief port was at the rear end of the SS-1 suppressor. The SS-1 suppressor was designed for semi-automatic fire only. The Sionics SS-1 parts were made from 6061-T6 alloy aluminum and AISI 4130 alloy steel. Some M21 rifles have been outfitted with Brookfield Precision Tool sound suppressors.

O. P. Seberger, Jr. was an electrician by trade but in retirement he took up sound suppressor design as his new career. He established OPS, Inc. in 1988. OPS, Inc. sound suppressors have seen service in Panama, Desert Storm, Somalia, Haiti and Afghanistan with the U. S. military. OPS, Inc. did more to advance sound suppressor technology from 1988 onward past 2000 than any other concern. One of its sound

suppressors is featured in the 1994 movie *Clear and Present Danger* with Harrison Ford, Willem Dafoe and Anne Archer. OPS, Inc. sound suppressors are self-cleaning, maintenance free and guaranteed for 30,000 rounds or two years, whichever comes first. In today's U. S. military, M14 DMR and M25 rifles are at times suppressed using OPS, Inc. 12th Model muzzle brake mounted sound suppressors designed by Phil Seberger. These are designed to drain water in six seconds or less. The 12th Model muzzle brake sound suppressor is made of fusion welded AISI 300 series stainless steel. Its sound attenuation is listed as 40 decibels. The military version muzzle brake suppressor includes a barrel sleeve and thread protector. To install the OPS, Inc. sound suppressor, remove the thread protector and thread on the suppressor. The rifle's gas piston hole is welded shut then drilled to a diameter of approximately around 0.055 ". The small hole restricts the flow of gas. With the suppressor is installed, the bullet clears the rifle before the operating rod is able to move enough to affect accuracy. Use of the OPS, Inc. 12th Model muzzle brake sound suppressor results in an average accuracy increase of 0.25 MOA and an increase of 20 to 50 feet per second bullet velocity. The muzzle brake portion of the assembly acts to reduce recoil and muzzle climb. If the sound suppressor is not installed, the muzzle brake creates a noticeable flash signature at night when the rifle is fired. These units are self-cleaning, maintenance free and are rated for more than 30,000 rounds. The OPS, Inc. suppressors have seen service in Afghanistan during the War on Terrorism.

Smith Enterprise, Inc. and Fisher Enterprises (Tempe, AZ) have developed and produce a M14 sound suppressor that quickly attaches and detaches from the Smith Enterprise, Inc. direct connect flash hider. It is part of the M14SE rifle system (SEI part number 0001AK). This sound suppressor weighs 2.08 pounds and has an overall length of 11.2 ". The length of the rifle is extended by 8.9 " with the suppressor installed. The suppressors sold to eligible civilians and U. S. law enforcement agencies are marked on the suppressor body: first line - FISHER ENT. MESA, AZ 85201 and the second line - MDL M14-DC CAL 7.62 S.N. M14-DC-XXXX. M14SE suppressors sold to the U. S. government and to other countries through the Foreign Military Sales program are marked with Smith Enterprise, Inc.

The suppressor body and end cap is made of 300 series stainless steel and has a black oxide finish. The quick detaching locking collar is made of titanium. 17-4 precipitation hardening stainless steel is used to fabricate the locking plates. The suppressor does not require any modification of the M14 type gas system. All of the baffles are coated with thin dense chromium resulting in a surface hardness of 80 HRC. The first baffle in the sound suppressor is coated with polytetrafluoroethylene over the chromium. This sound suppressor can be completely rebuilt in the field. This sound suppressor may also be employed on M16 style, Enfield SA80, Fabrique Nationale FAL and FNC, and Heckler & Koch G3 and G36 rifles with the appropriate Smith Enterprise flash hider.

Commercial Sound Suppressors

Installation of a sound suppressor on an M14 type rifle may require modification of the gas system to prevent parts damage. Using a sound suppressor on a M14 type rifle

generates some gas blow back into the face of the shooter. However, installation of a side three point scope mount on the suppressed M14 type rifle greatly reduces perceived blow back. Be sure to wear proper eye protection when shooting a suppressed M14 type rifle.

Sound suppressors are regulated in the United States of America by the National Firearms Act of 1934 (the "NFA"). Note that the BATFE considers a sound suppressor to be a flash hider as well. It may be legal to own an NFA registered sound suppressor but still be illegal to use it for any purpose, e.g., State of Washington law. Consult all laws and an attorney knowledgeable in firearms laws prior to purchasing a sound suppressor.

American Suppressors - AWC Systems Technology has been manufacturing sound suppressors since 1983. In the past, the firm manufactured the M30 sound suppressor. The M30 suppressor used two mounting points to attach to a M14 type rifle. Today, AWC Systems Technology offers a smaller sized but very efficient sound suppressor for the M14 type rifle based on its Thundertrap model. It is called the Spectrum 2000. The Spectrum 2000 sound suppressor is made from AISI 304 stainless steel, is 1.5 " in diameter, and weighs 28 ounces. It is about 12 " in length, longer than the Thundertrap model, but when installed the overall rifle length is only increased by 6.5 ". The flash suppressor and nut are removed from the rifle barrel. The Spectrum 2000 suppressor is then slid down the barrel and threaded on to the barrel threads for the flash suppressor nut. The rear end of the Spectrum 2000 suppressor stops about an inch from the front end of the gas cylinder plug. The USGI front sight is replaced with a Heckler & Koch style hooded front sight that sits over the gas cylinder portion of the barrel.

Tim Bixler at South Central Research Corporation (Katy, TX) makes a sound suppressor for the M14 type rifle. It is called the Mk23 and can be taken apart for cleaning. Jet Suppressors (Aransas Pass, TX) offers a .308 Winchester caliber sound suppressor that can be threaded on to the M14 barrel flash suppressor nut threads. The 1.5" diameter 9" long titanium sound suppressor is seal welded. It is cleaned by soaking in solvent then air dried.

Troy Industries sold an optional sound suppressor for the Rock SOPMOD M14. It was made of fusion welded and stress relieved AISI 300 series stainless steel. The M14 sound suppressor weighed 22 ounces and had a diameter of 1.5 ". It was 10 " long but only added 5 " to the overall length of the firearm. The sound suppressor screwed on the barrel with left hand threads and self-tightened as the rifle was fired. The Rock SOPMOD M14 conversion allows installation of the Troy Industries sound suppressor without modifying the gas system. This is because the Troy Industries suppressor has a back chamber to accommodate the gas. The Rock SOPMOD M14 will operate normally without harm while this suppressor is in use. The Troy Industries sound suppressor reduces sound level by 30 decibels or better when installed on a Rock SOPMOD M14.

Suppressed Tactical Weapons, Inc. (Rougemont, NC) has a sound suppressor that screws on or permanently attaches to the USGI design M14 flash suppressor. The titanium STW suppressor weighs 14 ounces. The suppressor dimensions are 8.5 " long and 1.315 " in diameter. The advantage of this suppressor is that the front sight is not

removed from the rifle.

Foreign Suppressors – BR-Tuote (Joensuu, Finland) produces a line of suppressors for pistols, rifles and automatic weapons. Its all steel construction T6M14 suppressor screws onto the M14 barrel once the flash suppressor assembly is removed. These suppressors are self-cleaning.

USGI M14 Technical Documentation

Parts and accessories for the M14 rifle were manufactured according to government drawings and item specific military specification documents covering requirements not listed in the drawings. Part drawings for many M14 parts date to as early as 1954 and were updated until at least June 17, 1994 (drawing 7267096 Revision L). Virtually every M14 part drawing has been revised several times since 1958 when the original technical data package was assembled. A typical example is the operating rod spring guide drawing 7267027, originally dated October 04, 1954. It was redrawn and revised on July 10, 1958 at Springfield Armory. Through the years, this drawing has been revised many times. Drawing 7267027 was last updated by Picatinny Arsenal on April 01, 1979 as Revision M.

All of the documents associated with manufacturing the M14 rifle are listed in a Technical Data Package List or TDPL. The M14 Rifle TDPL organizes the documents into five areas: 1) product (parts) drawings and associated lists (162 pages) 2) packaging drawings and documents (15 pages) 3) inspection drawings and documents (1025 pages) 4) specifications and standards (102 documents) and 5) outstanding approved engineering changes (28 pages). Similarly, the M21 Rifle TDPL consists of the following: 1) product drawings and associated lists (189 pages) 2) packaging drawings and documents (16 pages) 3) inspection drawings and documents (1,116 pages) 4) specifications and standards (95 documents) and 5) outstanding approved engineering changes (30 pages).

Specifications and standards in the TDPL fit into one of two broad categories, government and commercial. The government standards and specifications are identified by a MIL, DOD, FED or two letter prefix such as MIL-W-12332 or QQ-S-698. A standard, in contrast to a specification, is denoted by STD in the second part of the document identifier, e.g., FED-STD-595. From 1989 onward, the M14 and M21 TDPLs include commercial standards and specifications from these professional organizations: American National Standards Institute (ANSI), American Society of Mechanical Engineers (ASME), American Society for Testing and Materials (ASTM), American Welding Society (AWS) and the Society of Automotive Engineers (SAE-AS and SAE-AMS). In 1989, the U. S. military services began to adopt commercial manufacturing standards and specifications as they ceased maintaining equivalent federal and military documents. As of 2006, forty-seven of the 102 M14 Rifle TDPL standards and specifications were commercial documents.

Up until the Iran-Contra affair in 1987, the entire M14 Technical Package was available for civilian purchase from the U. S. government for less than \$1000.00. This information is now made available to businesses with a CAGE Code which have a need for it or firms

that are asked to bid on an item that the U. S. government needs. The item contract up for bid will come with the associated drawings and specifications. The term “mil spec” is not a trademark or other protected descriptive term, but is often used freely by sellers when describing firearms parts of uncertain origin or even clearly from non-military sources, so buyers must beware.

The U. S. Army published as many as twenty Field Manuals and Technical Manuals for its M14 rifles. The earliest Army publication on the M14 rifle was likely Special Text 7-179 in December 1958. It was written by the U. S. Army Infantry School at Fort Benning, GA. The latest known U. S. Army manual is TM 9-1005-223-34 dated 1980. In the author's opinion, every M14 type rifle owner should own a copy of TM 9-1005-223-34 dated 2 August 1972 as reference material (see Bibliography). Some of the Technical Manuals were printed more than once. Examples of reprinted manuals include: 1) TM 9-1005-223-12 dated October 1959 was printed in 1959 and 1960 2) TM 9-1005-223-12P dated 23 February 1968 was printed in 1968 and 1970 3) TM 9-1005-223-35 dated July 1968 was printed in 1968 and 1971 4) TM 9-1005-223-10 dated March 1972 was printed in 1972 and 1975 and 5) TM 9-1005-223-34 dated August 1972 was printed in 1972, 1976 and 1980.

Beginning in June 1951, the U. S. Army has produced an equipment maintenance periodical in comic book format for its soldiers. Through the years, *PS The Preventive Maintenance Monthly* has been produced at Aberdeen Proving Ground (MD), Fort Knox (KY), Raritan Arsenal (NJ) and Redstone Arsenal (AL). Issues back to 1990 are also available online. Through its history, *PS* magazine has had two characters, Miss Connie Rodd (no later than April 1954 to the present) and Master Sergeant Half-Mast (no later than July 1954 to the present). Both characters instruct soldiers on proper care of all sorts of equipment. Specifically, there were more than sixty articles related to M14 rifle maintenance in issues between December 1958 and July 1971. The most recent related articles, cleaning tips for the M14/M21 and basic preventive maintenance, appeared in Issues # 441 (August 1989) and # 644 (July 2006), respectively.

Nicolaus Associates (Jefferson, GA) has reprinted many hard-to-find U. S. military small arms documents including some of the early U. S. Army M14 manuals. Nicolaus also offers several informative wall posters compiled from government documents: 1) M14 Be Your Own Inspector 2) Rifle, 7.62 MM, M21 Sniper's 3) Rifle, 7.62 MM, M14 National Match: Initial Specifications 4) Rifle, 7.62 MM, M14: Cycle of Operation and 5) Rifle, 7.62-MM, M14 Nomenclature. William J. Ricca Surplus Sales has compiled all of the relevant *P S Magazine* articles from 1951 to 1973 on the M14 onto a compact disc. The efforts of William J. Ricca and Eric Nicolaus ensure that technical data on the M14 will remain available to those interested.

USGI Parts

Parts for the 1957 design U. S. government M14 rifles were made from December 1958 onward until at least 1992. The bulk of the parts production was, however, from 1960 to 1967. The government contractors involved were held to strict quality control standards. For instance, out of every lot of 100 barrels made nine were selected for inspection. If any of the nine barrels failed inspection, the entire lot of 100 barrels was scrapped. Still,

there are often slight but significant differences in how USGI parts fit, e.g., bolts and operating rods with respect to the receiver. USGI bolts have been found to differ by as much as 0.004 " in length even when made by the same manufacturer.

USGI Part Materials

The USGI drawing specified steel material for the following parts is listed as follows:

Table 16: Material Selection for USGI M14 Parts

USGI M14 Rifle Part	Specified Material
barrel (drawings 7790190, 9345206 and 9349847)	chromium-molybdenum-vanadium or 4150 resulfurized alloy steel
bolt	8620H alloy steel
bolt lock	8620 alloy steel for wrought material and precision casting
bolt lock spring	QQ-W-470 wire steel
bolt roller	ASTM A681 tool steel
bolt roller retaining ring	ASTM A228 steel wire
butt plate cap pin	1050 through 1095 carbon steel
butt plate hinge block	6061 alloy aluminum
butt plate hinge spring	QQ-W-470 wire steel
butt plate screw nut retainer	1050 through 1070 carbon steel
butt swivel	1018 through 1022 or 1141 carbon steel
connector	8645, 8740, or 8742 alloy steel
connector lock	1018 carbon steel
ejector	1060 carbon steel with fracture grain size 7 or finer
ejector spring	ASTM A228 cold drawn high carbon music spring wire
extractor	8645 or 8740 alloy steel grain size 7 or finer
extractor spring	QQ-W-470 wire steel
extractor spring plunger	1060 through 1095 carbon steel
firing pin, third version (October 20, 1965 drawing)	8640 or 8645 or 8740 spheroidized alloy steel with complete chromium plating
flash suppressor	4140 alloy steel for wrought material 4140 alloy steel with carbon content 0.43 to 0.53 % for precision casting
flash suppressor nut	8640, 8642, 8645, 8740 or 8742 alloy steel austenitic grain size 5 to 8
front band	1035 or 1050 carbon steel heat treated to 30 to 35 HRC
front sight	8640, 8740 or 4150 alloy steel for wrought material 4140 alloy steel with carbon content was 0.43 to 0.53 % for precision casting
gas cylinder	416 stainless steel with contents of 0.50 % or less in copper, 0.04 % or less in phosphorus, and 12.00 to 13.50 % in chromium
gas cylinder lock	4150 alloy steel

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gas cylinder plug	416 stainless steel heat treated to 32 to 40 HRC
gas piston	originally 416 stainless steel but later changed to 420 stainless steel with no more than 0.5 % copper content 440 stainless steel for M14SE gas pistons
hammer	8620H alloy steel austenite grain size 5 or smaller and heat treated to 80 to 83 HRA hardness
hammer pin	1060 through 1080 carbon steel
hammer spring	ASTM A228 cold drawn high carbon music spring wire
hammer spring housing	1112, 1117 or 1212 carbon steel
hammer spring plunger	1112, 1117 or 1020 carbon steel
magazine body (tube)	1050 spheroidize annealed drawing quality carbon steel and heat treated to 71 to 76 HRA hardness
magazine floor plate	ASTM A109 carbon steel (no more than 0.25 % carbon) and heat treated to 71 to 76 HRA hardness
magazine follower and stop	Federal Specification QQ-S-698 drawing quality carbon steel and heat treated to file hard
magazine latch	8615 alloy steel for wrought material and 8620H alloy steel for precision casting, heat treated to file hard
magazine latch spring	QQ-W-470 wire steel
magazine spring	ASTM A228 cold drawn high carbon music spring wire
operating rod	8645H alloy steel (Gun Quality) with austenite grain size 7 or finer for the handle portion 8645H or 8742H for the tube portion Both portions heat treated to 40 to 46 HRC
operating rod guide	4140, 8640, 8645 or 8740 alloy steel
operating rod spring	17-7 precipitation hardening stainless steel wire
operating rod spring guide (solid USGI version)	forged 8640 or 8645 alloy steel and heat treated to 40 to 45 HRC
operating rod spring guide (USGI version with holes)	stamped 8640 or 8645 alloy steel and heat treated to 40 to 45 HRC
rear sight aperture	1141 carbon steel forging or 1040 carbon steel seamless tubing
rear sight base	1141 carbon steel
rear sight cover	1055 or 1065 carbon steel austenitic grain size 5 or finer
rear sight elevation dog retainer	QQ-S-698 or ASTM A109 carbon steel
rear sight elevation knob	1016 through 1020 or 1117 carbon steel or 8615 alloy steel
rear sight elevation pinion	1037 or 1141 carbon steel
rear sight nut	1141 carbon steel
rear sight nut lock	ASTM A109 carbon steel

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rear sight spring	1095 carbon steel spheroidize annealed
rear sight windage knob	1022 or 1117 carbon steel
safety	1021 carbon steel for wrought material 8620 alloy steel with 0.08 to 0.18 % carbon content or 1020 for precision casting
safety spring	ASTM A504 wire steel
sear	8620 alloy steel except sulfur content is 0.035 to 0.050 % with austenite grain size 5 to 8
sear release	8615 alloy steel for wrought material 8620 alloy steel except 0.10 to 0.20 % carbon content for precision casting
selector shaft	1141 carbon steel or 8645 alloy steel
selector shaft lock	1025, 1117 or 1118 carbon steel
small arms sling strap (drawing 12624562)	bulked nylon webbing Type II
spindle valve	440A stainless steel
spindle valve spring	303 or 304 stainless steel
stock ferrule	ASTM A619 drawing quality steel
stock ferrule, National Match	ASTM A109 drawing quality steel
stripper clip guide	4140 or 8620 alloy steel
swivel bracket	ASTM A366 or ASTM A109 dead soft temper carbon steel
swivel loop	1018 to 1022 carbon steel
trigger	8620 alloy steel except sulfur content is 0.035 to 0.050 % with austenite grain size 5 or finer
trigger guard	1060 or 1065 carbon steel
trigger housing	1141 carbon steel with austenitic grain size 7 or finer

AISI 440A stainless steel is magnetic and can be heat treated to obtain very high strength, hardness and wear resistance. AISI 440A stainless steel is a martensitic stainless steel. AISI 8645 is a nickel-chromium-molybdenum alloy steel like AISI 8620 steel but it has a much higher carbon content at 0.45 %. This material can be sufficiently hardened and strengthened for USGI uses without carburizing.

Miscellaneous Notes on USGI Parts

Some of the parts are marked with manufacturer codes. Typically, the manufacturers stamped the operating rod, bolt, elevation and windage knobs, trigger housing, and hammer. Sometimes, the manufacturer is identified on the stock, flip-up butt plate, operating rod spring guide, trigger guard, front band, gas cylinder, rear sight base, safety and sear release. Examples of such are the Harrington & Richardson front band, rear sight base, and safety, Killeen Machine & Tool operating rod spring guide, butt plate flapper and trigger guard, some wood stocks, Springfield Armory gas cylinders and the Winchester rear sight base. Springfield Armory gas cylinders are very faintly stamped S A. Gas cylinder markings are generally not visible because the surface finish hides them.

It is possible that Killeen Machine & Tool did not place its manufacturer's marking on each M14 part it made. M14 gunsmith Ted Brown reports that while refinishing a batch of M14 butt plate assemblies he found that seven of the butt plate flappers exhibited

identical flaws left by the stamping die. Of the seven flappers, three were marked KMT CO. and four were unmarked.

Butt Plate and Butt Plate Flapper - USGI butt plates were made of alloy aluminum to help reduce the weight of the M14 rifle. The number 10 has been observed on the back side of one M14 butt plate trap door. This may be a mold number. The USGI M14 butt plate flapper is made of steel and has one hole on the left side of the hinge as the rifle is pointed down range. Several types of USGI M14 butt plate flappers have been observed. The following classification scheme is presented as a means of cataloging the differences:

Group 1 - These butt plate flappers have bumps around the bottom screw only.

Type 1A - round bumps with two weld dimples and no trap door lock

Type 1B - square bumps but no weld dimples

Type 1C - square bumps with two weld dimples

Group 2 - These butt plate flappers have bumps around the top and bottom screws.

Type 2A - round bumps with no weld dimples, truncated hinge slot corners, and a raised trap door pin well

Type 2B - square bumps but no weld dimples or welds filled in

Type 2C - square bumps with two weld dimples (Killeen Machine & Tool made this type)

Type 2D - square bumps with two smaller weld dimples

The DOD acceptance stamp (eagle, arrows and three stars) is usually found on USGI M14 chromium plated barrels, M6 bayonets and M2 bipods. The DOD acceptance stamp, or cartouche, is sometimes found on wood stocks, Winchester gas cylinders, Winchester operating rods with the forward end vent hole and Springfield Armory operating rods. Winchester gas cylinders removed from an unopened tube packed in 1967 had faint DOD acceptance stamps at the rear end of each on the right hand side. The DOD cartouche was used on rifle parts as early as 1953 but certainly was discontinued for M14 rifle parts by 1968 when Springfield Armory closed down. The DOD cartouche was stamped to the M2 .50 BMG machine gun barrel in 1977 and applied with ink to 1980s production Colt M16A2 rifle receivers in the 6,14X,XXX to 6,16X,XXX serial number range.

Bolt Markings - A USGI bolt (and receiver) may or may not have a dimple from a pin punch after successful proof round testing. Replacement bolts were proof round tested using a fixture. Frankford Arsenal and Lake City loaded the proof rounds to 65,000 psi. An inscribed letter M on a USGI bolt means it was examined by magnetic particle inspection. Not all USGI bolts will have the letter M though. USGI M14 bolts have additional stamps besides the part number and bolt manufacturer. The other markings are heat treatment and steel lot numbers. Such an example can be found on a bolt marked 7790186 HRT A20 CDR. These are in order: 1) part number 2) manufacturer code 3) material lot number and 4) steel supplier code. If a manufacturer had only one steel supplier then just the heat treating lot was stamped on the bolt. Other

manufacturers consolidated their markings to include both material lot and steel maker. All M14 type rifles properly assembled will have bolts with rollers attached.

USGI National Match parts such as the barrel, front sight, and rear sight parts will be marked NM or NM/2A if made after October 1963. The NM marking may be stamped or engraved on USGI National Match barrels. The NM marking is performed by engraving to prevent deforming the inside of the barrel. 1983 vintage Maremont Corporation medium weight National Match barrels, as well as others, will have the engraved NM marking.

Smith Enterprise, Inc. manufactures the extended bolt lock for the M14 EBR (Mk 14 Mod 0) and M14SE projects. It was developed for the U. S. Navy SEALs to facilitate ease of chambering the M14 rifle in cold weather. This extended bolt lock is made of AISI 8620 alloy steel and heat treated to a surface hardness of 60 HRC and given a phosphate coating. The first batch of M14 EBR and M14SE extended bolt locks are marked U. S. on the inboard side. U. S. and Tempe, AZ are written on the inboard side of the extended bolt locks for the second production lot. A third marking was also used on Smith Enterprise, Inc. extended bolt locks. Some were stamped MK-14 in serif font on the inboard side.

The U. S. government Springfield Armory bolt markings can be confused with commercial reproduction Springfield Armory, Inc. bolts. The U. S. government Springfield Armory stamped its bolts in one of two ways, one format for 7790185 bolts and another format for 7790186 bolts. If the bolt was made by the U. S. government Springfield Armory and it is marked 7790185 it will have the following: 7790185-SA on the first line and the material lot number on the second line, e.g., YO2. U. S. government Springfield Armory bolts made to the 7790186 drawing have this identification scheme: 7790186 on the first line followed and then SA and the material lot number on the second line, e.g., Z1B. USGI M14 bolts made by Winchester have its CAGE Code, 66118, on the second line whether stamped 7790185 or 7790186 on the first line. Textile Machine Works M14 bolts can have the manufacturer code, HRT, either on the first line or the second line of the bolt markings.

There are bolts with counterfeit markings. Ron Smith of Smith Enterprise, Inc. has seen two M14 bolts stamped TRW that were not made by TRW. Genuine unaltered commercial Springfield Armory, Inc. M1A bolts do not have a pin punch dimple. All USGI bolts were phosphate coated. Any M14 bolt that is bare steel or has a finish other than phosphate coating was not produced that way by the USGI contractor so buyer beware! The bolt installed in the M14 type rifle should be able to pass the slide test as discussed in Kuhnhausen's manual and have proper lug engagement and proper headspace prior to use.

Firing Pin - Three types of M14 firing pins were made. The original firing pins were made of completely phosphate coated AISI 8640 or 8645 alloy steel. The next version was a phosphate coated steel firing pin with a chromium plated tip. These were only made in 1962 and only by Springfield Armory. The last version is a fully chromium plated steel firing pin. These were manufactured from 1965 to 1969. The minimum hardness of the fully chromium plated firing pin is 600 on the Vickers scale or more than 55 HRC.

Chromium plating of the firing pin caused the NO GO (maximum) firing pin hole width at the bolt face to change from 0.083 " to 0.084 ". Only fully chromium plated firing pins are acceptable for overhaul of the USGI M14 rifle. The benefits of chromium plating the firing pin are improved wear resistance and lubricity.

Flash Suppressor – There are no manufacturer markings on USGI or commercial reproduction government design M14 flash suppressors but a number of feature differences are discussed below:

1) Barrel Splines and Suppressor Slots - USGI and commercial reproduction flash suppressors may have barrel splines with square ends. No USGI flash suppressors have been observed with round end barrel splines. The suppressor slots, including the ends, in both USGI and commercial reproduction units vary slightly in width. The slot ends can be rounded or almost square.

2) Front Sight Step - Some USGI flash suppressors, e.g., at least some Harrington & Richardson contract units, will have a "step" directly behind the front sight base while other USGI units do not. The presence of the "step", and the lack thereof, has been observed on commercial reproduction and forged and cast USGI flash suppressors.

3) Muzzle End Bevel - Additionally, some USGI and commercial reproduction flash suppressors have a 45 ° beveled muzzle end while others do not. Beveled and non-beveled ends are not indicative of the manufacturer as both type of muzzle end contours have been observed on commercial and USGI cast and forged units.

4) Cast and Forged Manufacture – Springfield Armory was manufacturing cast flash suppressors as early as 1959 but began producing forged units in September 1960. Flash suppressors made for Harrington & Richardson M14 rifles were cast as observed from New-In-Tube units. Well done finish machining can remove any obvious evidence that the part was made by casting. This is often the case with USGI flash suppressors as they generally have a better finish than commercial reproduction units. The poorer a cast flash suppressor was machined, the more likely the following can be observed: evidence of the casting sprue on the side of the front sight, the longitudinal mold parting line on the suppressor, rough edges on the suppressor slots and a less pronounced circumferential radius in front of the sight base. However, these exterior surface blemishes do not affect the function or reliability of the part. TRW flash suppressors were forged. An experienced machinist equipped with a jeweler's loop can discern if a flash suppressor was made by casting or forging. If the flash suppressor was formed by forging it is a USGI unit since commercial reproduction flash suppressors are made by casting.

Operating Rod - Some Harrington & Richardson, Springfield Armory, and Winchester operating rods do not have a vent hole drilled in the forward end of the cylindrical portion. Three 1961 manufacture new-in-tube operating rods (two Harrington & Richardson and one Winchester) opened for examination had no vent hole. U. S. Army Aberdeen Proving Ground Report No. DPS-471 discusses the testing of twenty-one randomly selected M14 rifles. This testing was performed from September 28, 1961 to January 30, 1962. The Winchester and Springfield Armory operating rods on the rifles in this test did not have the vent hole, but the Harrington & Richardson operating rods did. It appears that

Harrington & Richardson added this change to the operating rod beginning in 1961. Springfield Armory and Winchester did likewise after 1961.

There were at least two USGI contracts awarded in 1984 for M14 operating rods. The operating rods were made by Mercury Tool & Machine for both contracts. However, Mercury Tool & Machine was a subcontractor to Rock Island Arsenal for one of the two contracts. Mercury Tool & Machine operating rods have the marking: top line - 7267064 bottom line - MFR 24411. Mercury Tool & Machine supplied M14 operating rods to the U. S. Navy in the 1980s. Mercury Tool & Machine operating rods sometimes have misaligned factory welds straight out of the wrapper. The welded area is usually easy to see on Mercury Tool & Machine operating rods.

The USGI M14 drawing 7267064 shows the welding of the operating rod handle and cylinder halves together and requires a hole at the front end of the operating rod. The diameter of the hole is specified to be 0.077 " + 0.006 ". The welding techniques for assembling the operating rod were developed in Remington Arms Company in 1951. Only TRW made one piece operating rods. TRW operating rods have a vent hole at the front end. All other manufacturers of USGI operating rods made operating rods by flash welding the two halves together. The front end of the operating rod that contacts the gas piston is chromium plated for improved impact resistance. Rewelded USGI operating rods are sold on the surplus market. Many rewelded operating rods will not function smoothly due to misalignment of the two halves. Operating rods should be able to pass the slide test discussed in Kuhnhausen's manual before the rifle is completely assembled.

Gas System – The design of the gas system for the M14 rifle was decided upon after testing in 1954 of the T44E2 rifle. The cutoff and expansion gas system design used in the M14 rifle was patented by Joseph C. White in 1933. It was more expensive to manufacture and the tolerances were tighter than the M1 Garand impingement design gas system. This gas system design was tested by the U. S. Army Ordnance Command as early as 1942 in an experimental M1 Carbine. The M14 gas cutoff and expansion design produces a longer dwell time and lower peak pressure with service ammunition than the M1 Garand impingement gas system. Thus, it acts more gently on the rifle than the gas impingement design.

Two versions of the M14 gas cylinder were manufactured. The early version does not have a lip just aft of the bottom gas port to support the front band. The late version (March 1960 design) gas cylinder was manufactured with a support lip for the front band. The lip is 0.095 " wide and 0.112 " high but serves a very important purpose (see M14 Problems). These early version gas cylinders were used in the production of T44E4 and some M14 rifles. Bill Ricca estimates that 75,000 to 100,000 of the early version gas cylinders were made by Winchester and Springfield Armory.

A few USGI gas cylinders have been found marked with either 1) G then T inside a circle followed by L or 2) S then T inside a circle followed by L or 3) Y then T inside a circle followed by L or 4) K then T inside a circle followed by L. Two gas cylinders marked in the first manner were removed by Mr. Bennicas from a Harrington & Richardson marked and sealed cardboard tube dated July 1962. Two gas cylinders marked in the fourth case

were removed by Tim Strait from a Harrington & Richardson marked and sealed cardboard tube dated 1964. Based on this information and the opinion of Bill Ricca, these gas cylinder markings are either outside contractor codes or they may indicate completion of a particular manufacturing step. Early version and early production late version gas cylinders were machined from forgings. Rough forgings of gas cylinders were available for sale at gun shows in the 1970s. Late production late version gas cylinders are thought to be made from castings but this has not been confirmed. ¹

Safety Markings - The following safety markings have been observed on USGI M14 safeties: 88 T I, 89 T I, 90 T I, A (raised letter), HA, HB, H&R D, HRA, MXR, O (raised letter), ROBER HT-B, ROBER HT-D, SA 11, T I, HT-B, HT-D, TRW HT-A, TRW HT-B and TRW HT-D. T I was Tong Industries, H&R was Harrington & Richardson, SA was Springfield Armory and TRW was Thompson-Ramo-Wooldridge. TRW safeties were marked in two lines of lettering with TRW on the top line.

Springs and Spring Design – The M14 rifle has fifteen springs though some are not readily obvious: bolt lock spring, butt plate hinge spring, butt plate trap door spring, connector assembly spring, elevation knob screw spring, ejector spring, extractor spring, hammer spring, hand guard clip, magazine latch spring, operating rod spring, rear sight cover, safety spring, selector shaft spring, and spindle valve spring. Additionally, the National Match hooded rear sight aperture has two small coil springs and a beryllium-copper alloy snap ring. The magazine, M3 breech shield, M6 bayonet, M12 blank firing attachment, and M76 grenade launcher each have one spring as well. The M2 bipod has four springs, one for each plunger button.

There are many types of coil springs, compression, die, extension, torsion, etc. A coil spring is typically made by coiling round wire or thin rod into a helical shape. With the exceptions of the elevation knob screw spring, hand guard clip, rear sight cover and the safety spring, M14 type rifle springs are classified as constant diameter compression coil springs. A compression coil spring will resist a force applied straight into the end of the spring. When a compression coil spring is compressed axially (end-to-end), other forces are induced on the spring as well: lateral (side-to-side), a rotating moment and a tilting moment. The constant diameter design means the width of the spring does not vary.

Compression coil springs are further categorized by how the end of the spring is formed and how the material is wound. The end of a constant diameter compression coil spring can be formed in one three ways, tangential or open, squared or closed, and pigtail. The open end spring is cut anywhere along the helix so that there is no change in the pitch or spacing of the coil. The pigtail end means the spring is curled inward on the last coil to a smaller diameter then cut. The closed end spring is formed so that the spring will stand upright when placed on end. Closed end and open end compression coil springs are often ground to create very flat surfaces at each end. The following M14 rifle springs have closed ground ends: ejector spring, extractor spring, hammer spring, operating rod spring and spindle valve spring. The selector shaft spring and bolt lock spring have open ends and are not ground. Magazine latch springs observed have closed ends but do not appear to be ground.

Grinding the end of the spring may be done to better distribute the applied force, make

assembly of the parts easier, or in some cases prevent buckling. The free length of the compression coil spring compared to its mean diameter is known as the slenderness ratio. A compression coil spring with ground closed ends having a slenderness ratio of less than four will not buckle. A compression coil spring with unground closed ends may buckle if the slenderness ratio exceeds 2.63. The slenderness ratios for the bolt lock spring and the extractor spring are 4.05 and 4.03, respectively. It is not known if the slenderness ratio was considered in the designs of the bolt lock spring and extractor spring or if those values were coincidental to any concern for spring buckling.

The direction of the coil spring helix (left-hand or right-hand) is specified in several of the drawings. The bolt lock spring helical direction is optional per USGI drawing 7267074. The USGI drawing 7267078 specifies a left-hand twist for the magazine spring. The USGI drawings for the ejector spring, extractor spring, magazine latch spring and operating rod spring require a right-hand helical direction for each spring. Some USGI contract springs were made with the wrong twist. Such examples are a batch of operating rod springs made in 1983 and Harrington & Richardson contract extractor springs produced in November 1964. If the contractor was able to convince the contracting officer that spring function was not affected, though made with the wrong twist, it was accepted by the U. S. government.

The compression and fatigue strength of a coil spring is dependent upon a number of factors: material composition, wire surface finish, wire diameter and length, coil diameter, total number of coils and heat treatment. Spring manufacturers use a wide variety of materials for coil springs: carbon, alloy and stainless steels, phosphor bronze, copper beryllium alloy and brass depending on the application.

The USGI drawings for the M14 rifle compression coil springs specify the wire material, the wire diameter, the coil outside or inside diameter, the free length, and the total number of coils. The free length of a compression coil spring is the distance from one end of the spring to the other with no force applied. The USGI drawing 7267079 for the operating rod spring is illustrative of the detailed requirements typical of M14 parts production. Some of the drawing 7267079 specifications are described below.

The operating rod spring material was 17-7 precipitation hardening stainless steel wire per military standard Mil-W-46078 and manufactured under military standard Mil-S-13572 Type 1 Grade B. This material was chosen for the operating rod spring in 1952 as part of the T44 rifle modifications. The physical dimension and performance requirements were as follows: wire diameter 0.054 " + or - 0.001 ", coil outside diameter 0.4575 " + or - 0.0025 ", free length = 15.23 ", a total of 104 coils, the direction of the helix must be right-hand wound and have closed ends.

The operating rod spring formed by coiling cold drawn wire had to be heat treated as follows: age hardened at 900 degrees Fahrenheit for one hour then air cooled. After that, the operating rod spring was heat set by heating at 700 degrees Fahrenheit for twenty minutes with the spring compressed to a length between 5.9 " and 6.0 ". Heat setting a spring improves the stress relaxation during use. Age hardening is used to increase the strength and hardness of manufactured parts made from certain alloys, e.g., copper-beryllium and 17-7 cold drawn stainless steel. Each material responds differently to the

age (precipitation) hardening process based on a combination of time, temperature and the amount of cold drawing from the initial rod size into the final wire diameter.

Depending on the material, the toughness, corrosion resistance, fatigue strength, electrical conductivity or thermal conductivity can be improved upon by stopping the hardening procedure before or after the time needed to achieve maximum strength. By age hardening and heat setting the operating rod spring, service life was significantly increased.

The operating rod spring, like other compression coil springs, was designed with a given spring rate. The spring rate is defined as the amount of load (force) needed to compress the spring one inch. The lower the spring rate the softer the spring. After the operating rod spring had been heat treated and heat set it was compressed to solid length three times and then load tested at several specific lengths. These tests verified the operating rod spring met the design spring rate. The design spring rate for the M14 operating rod spring was 1.95. When the operating rod spring was compressed to a length of 10.97 " the applied load had to equal 8.13 pounds + or – 0.81 pounds. When the operating rod spring was compressed to 6.42 " the required load was 17.00 pounds + or – 1.69 pounds.

When the operating rod spring was compressed to the minimum operating length it measured about 7.19 " long with an applied load under 16.00 pounds sufficient to engage the bolt lock. The USGI drawing 7267079 for the operating rod spring specified a maximum length of 5.78 " for the solid compressed length. The design and manufacturing process ensured the USGI M14 operating rod spring would function properly for thousands of cycles. The M14 rifle enthusiast or collector should proceed with caution when hearing the term "mil-spec" in casual conversation with such detailed design, manufacturing and testing requirements for USGI M14 parts.

Spring material is subjected to torsional (twisting) stress. When a wire is twisted the stress is greatest at the surface. Fatigue cracks commonly begin at defects in the spring surface. A very smooth spring surface will prevent fatigue cracking. Consequently, wire surface defects, e.g., pits and seams, are controlled in the cold drawing manufacturing process. For example, Seneca Wire & Manufacturing Company (Fostoria, OH) limits the depth of surface defects in its ASTM A877 chromium silicon alloy steel wire to no more than 1.0 % of the wire diameter. ASTM A877 chromium silicon alloy steel wire is suitable for service applications requiring high fatigue strength at moderately high temperatures, e.g., M14 operating rod spring. Additionally, the USGI drawing 7267078 required the magazine spring to be "free from scratches, splits, laps, cracks, seams, nicks, die marks and other injurious defects." Replacement M14 magazine springs with noticeable nicks, often found on the outside of coil bends, are most likely not USGI manufacture.

The question often arises as to whether or not a compression spring will take a permanent set if compressed to the minimum length and held over time, e.g., a fully loaded magazine or the bolt is held open. Coil springs can be designed to compress to solid height or length without taking a permanent set. If a permanent set is not desired, the spring material and diameter is chosen so that the torsional stress when compressed solid does not exceed approximately 40 % of the material minimum tensile strength. The minimum tensile strength, or yield strength, will vary with the diameter of the wire, e.g.,

231,000 to 399,000 psi for ASTM A228 music wire. A permanent set occurs when the compression spring is compressed beyond its elastic limit and does not return to the original length. This results in a shorter free length but more significantly, lower spring force. M14 magazine springs were tested and inspected to ensure they would not take a permanent set. Magazine springs selected for inspection were compressed to a height of 11/16", essentially compressed solid height, three times then examined for compliance with USGI drawing 7267078. This included meeting the free length requirement of 13" – 2". A permanent set in a USGI M14 rifle compression spring is not formed when compressed to the minimum length and left indefinitely.

The majority of the compression coil springs in the M14 rifle are subjected to fatigue stress over a very large number of operating cycles. These springs were designed with this service requirement in mind. If a spring weakens enough the M14 rifle will malfunction in one manner or another. A weak magazine spring could cause cartridge feeding problems. If the extractor spring is weak the spent case may stick in the chamber after firing. A soft ejector spring could result in a spent case being caught between the bolt and receiver. In a combat situation, such malfunctions could prove fatal. Nonetheless, over the course of thousands and thousands of cycles, the free lengths of the operating rod spring and the hammer spring will gradually shorten so that they will warrant replacement.

The spring design must also consider the temperature to which it will be subjected. The gas piston, and to a lesser degree, the operating rod guide, transfer heat to the operating rod and the operating rod spring. Temperature at the forward end of the operating rod has been measured above 500 degrees Fahrenheit. Chromium silicon alloy steel operating rod springs are rated for service to at least 700 degrees Fahrenheit (see Notes on Commercial Parts).

The spindle valve spring is heated from burnt gun powder gas flowing from the barrel into the gas cylinder. The spindle valve spring is made from stainless steel to resist the high temperature gas. Stainless steel has a higher maximum service temperature than carbon steel. The specific AISI alloy stainless steel for the spindle valve spring was not available but the following serves to illustrate the point. 17-7 precipitation hardening stainless steel wire is rated for a maximum service temperature of 600 degrees Fahrenheit as compared to 250 and 300 degrees Fahrenheit for hard drawn carbon steel and oil tempered carbon steel, respectively.

The hammer spring is made from American Society of Testing and Materials (ASTM) 228 specification music wire according to USGI drawing 6008887. It will have twenty coils and a free length of 2.15". If the hammer spring has been shortened by cutting, it should not be used but replaced with a new one. Cutting the hammer spring coils increases the chance of an accidental discharge. ASTM 228 music wire is a high carbon steel with hardness ranging from 41 to 60 HRC. It is composed of a minimum of 98.4% iron and a range of 0.2 to 0.6% for manganese and 0.7 to 1.0% for carbon content. ASTM A228 music wire is rated for a maximum service temperature of 250 degrees Fahrenheit. This rating is acceptable since the hammer spring is not intended to operate at that high a temperature. ASTM A877 chromium silicon alloy steel wire and ASTM 228 steel music

wire are popular choices for applications requiring excellent fatigue strength such as the M14 rifle hammer spring.

Other Parts and Accessories - Both types of M14 trigger guards were stamped from spring steel. The early trigger guard has a pin to act as the hammer stop. The design of the hammer stop in the late trigger guard is a bent tab. The design change occurred in September 1960 but early style trigger guards were still being made by Winchester in January 1962. Springfield Armory triggers often have a numeral, e.g., 4 or 19, on the side. This number represents the forging die used to make the trigger. Extractors were made by forging. If an extractor is made by casting it is a commercial reproduction. Harrington & Richardson and Winchester rear sight bases were often stamped with a code, e.g., B2, B3, B4, B5 or B10. The meaning of this code has not been determined.

Early version USGI operating rod spring guides have one hole for the connector lock to slide through. The "spine" of the early version operating rod spring guide is machined with a center channel on either side running most of its length. The channel lightens but strengthens the part. The late version USGI operating rod spring guides have four stadium holes in the "spine" as well as the hole for the connector lock. The late version was less expensive to manufacture. Both versions were hardened to give long service life for the magazine catch. The connector lock secures the operating rod spring guide to the receiver. For comparison purposes, the weight of several versions of the operating rod spring guide are as follows: 1) early USGI – 0.81 ounce 2) late USGI - 0.87 ounce 3) master armorer built NM – 2.10 ounces 3) Brookfield Precision Tool NM – 2.24 ounces 4) Sadlak Industries hollow shaft NM – 1.73 ounces 5) Sadlak Industries solid shaft NM – 2.26 ounces.

The earliest and latest observed dates of manufacture noted for the items in Table 17 were either found by firsthand examination or through photographs of the original packaging. A single entry for an item indicates only one date observed so far by the author.

Table 17: Observed Dates of Manufacture for USGI M14 Rifle Spare Parts and Accessories

USGI Contract Item - Spare Part or Tool	Earliest Observed Date of Manufacture	Last Observed Date of Manufacture
AN/PVS-2 carrying case		September 1990
bandoleer		October 1989
barrel, chromium plated	December 1960	February 1983
barrel, NM lightweight	April 1966	June 1985
barrel, NM medium weight	1983	1992
barrel, NM heavyweight	May 1984	January 1993
barrel cleaning rod patch tip		March 1967
barrel reflector		April 1966
bolt with roller	October 1969	March 1970
bolt lock	March 1962	December 1966
bolt lock pin		1963

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bolt roller		October 1967
bolt roller retainer		December 1967
bore reflector		April 1966
broken shell extractor	October 1959	July 1961
chamber brush, black ratchet	June 1960	December 1968
cleaning rod section		September 1968
combination tool	March 1961	March 1968
connector assembly		August 1963
connector lock		November 1964
connector lock pin		March 1996
ejector assembly	December 1960	July 1967
extractor spring assembly		November 1964
extractor (late design)		January 1965
firing pin, first version		December 1961
firing pin, third version	June 1967	August 1969
flash suppressor	January 1961	July 1970
flash suppressor nut	March 1961	July 1961
flash suppressor nut set screw		March 1978
flash suppressor nut wrench		May 1962
front band	December 1961	December 1972 (arsenal rewrap)
front sight screw		October 1966
gas cylinder	April 1962	November 1969
gas cylinder lock	April 1962	May 1966
gas cylinder plug	November 1960	June 1966
gas piston (non-coated)	February 1962	June 1972
gas piston (coated)	July 1993	September 1995
hammer		March 1963
hammer spring		May 1981
M2 aiming device		February 1965
M3 breech shield		June 1973
M5 winter trigger	December 1962	January 1968
M6 bayonet	November 1968	December 1968
M12 blank firing attachment, all versions	October 1964	June 1973
M14E2 muzzle stabilizer modification kit		July 1967
M14E2 stock modification kit		April 1968
M76 grenade launcher		August 1961
M151 vehicle M14 rifle mounting kit	May 1967	November 1969
M1907 leather sling	May 1963	May 1995
M1956 canvas magazine pouch	September 1959	August 1960
M1961 individual equipment belt		1967 contract

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M1967 nylon magazine pouch for the M14		1970 contract
magazine	1959	July 2005
magazine latch	February 1960	December 1963
operating rod	August 1966	October 1986
operating rod guide	November 1959	June 1967
operating rod spring	January 1962	March 1966
operating rod spring guide	March 1961	July 1967
rear sight aperture, standard	April 1963	September 1964
rear sight aperture, National Match hooded		January 1967
rear sight base	October 1970	April 1976 (arsenal rewrap)
rear sight cover		July 1962
rear sight elevation knob and spindle	April 1962	November 1965 (M1 knob)
rear sight windage knob		February 1962
safety	January 1962	June 1969
safety spring	March 1961	July 1969
selector spring		May 1963
selector switch	October 1960	March 1967
sling swivel		March 1968
small arms sling, fabric	April 1964	1975 contract
spindle valve	January 1962	August 1969
stock, fiberglass		January 1968
stock, National Match, 9352638		November 1988
stock, National Match, 11010282		August 1966
stock ferrule, National Match		December 1990
stock repair screws		May 1965
stock screw, wood upper butt		January 1968
stripper clip guide		December 1971 (arsenal rewrap)
trigger and sear assembly	March 1961	March 1966
trigger guard	October 1960	March 1968 (arsenal rewrap)
trigger housing	April 1962	October 1967

USGI Parts Manufacturers and Identification

Springfield Armory made all parts for the M14 rifle but also used subcontractors for various parts in later years. Workers there made production runs of flash suppressors in December 1964 and gas cylinders between July 01, 1964 and June 30, 1965. Between July 01, 1965 and June 30, 1966 the Armory began production to deliver an order of spare M14 parts including 64,000 bolts, 35,000 operating rods, and 12,000 stock assemblies. This spare parts run was expected to be completed by April 1967.

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Springfield Armory also received a production order for 52,700 M14 barrels between July 01, 1966 and June 30, 1967. The first of these barrels were delivered in June 1967 and continued into at least October 1967.

Several companies made M14 parts or accessories for Springfield Armory. The marking BRW S-1 indicates the part was made at the Automotive Spring Division plant of Borg-Warner. The BRW S-1 marking may be stamped upright, upside down or diagonally on genuine USGI M14 magazines. The Borg-Warner Brake Division may have produced the BRW B-2 marked magazines but this has not been confirmed. Borg-Warner made magazines from as early as December 1961 and into the late 1970s. Killeen Machine & Tool Co. produced M14 magazines in 1965. BRW, KMT and UHC marked magazines were made for Springfield Armory in the 1960s.

Table 18: Subcontractors to USGI Contractors

Company	Subcontractor to	Parts made as subcontractor
Atwood Vacuum Machine Co.	Springfield Armory	magazine
Borg-Warner	Springfield Armory	magazine
Bostich	Harrington & Richardson	
Brunswick Sports Products Co.	Olin Mathieson Chemical Corporation	magazine
CPP	Springfield Armory	NM windage knob
General Tire	Harrington & Richardson	
Hesse Machine & Mfg. Co., Inc.	Olin Mathieson Chemical Corporation	magazine latch
Killeen Machine & Tool Co.	Springfield Armory, Harrington & Richardson	magazine
MXR	Springfield Armory, possibly Olin Mathieson Chemical Corporation	safety
Rochester Manufacturing Company	Springfield Armory	magazine
S. C. Overton & Co.	TRW	wood stock
Saco-Lowell	Springfield Armory, Harrington & Richardson	gas cylinder
Sykes Manufacturing	Springfield Armory	wood stock
Stanley-Humason	Olin Mathieson Chemical Corporation	safety spring

Textile Machine Works	Harrington & Richardson	bolt
Torrington Company	Harrington & Richardson	
Union Hardware Company	Springfield Armory, Olin Mathieson Chemical Corporation	magazine
Westinghouse Electric	Harrington & Richardson, Olin Mathieson Chemical Corporation	magazine
Wright Manufacturing Co.	Harrington & Richardson, TRW	windage knob

Winchester made all the major M14 parts and most of the small parts with the exception of springs, pins and screws. The M14 parts Winchester made equaled 80 % of the value of the rifle at the time. Westinghouse Electric made M14 magazines for Olin-Mathieson Chemical Corporation (Winchester) in 1962 and Union Hardware Company did likewise in 1967.

TRW made eleven major parts during its M14 rifle production, which equaled 65 % of the rifle's value. The company's management purposefully produced what it thought could be made economically well. TRW did produce replacement gas cylinders until at least August 1967 and bolts as late as March, 1970. The gas cylinders were packaged in cardboard tubes (see USGI Parts Packaging). The cardboard box containing five cardboard tubes of gas cylinders indicated TRW as the USGI contractor but the individual cardboard tubes did not list TRW as the manufacturer.

Harrington & Richardson subcontracted parts production to a large extent. Parts marked with HR followed by a third letter, e.g., HRT, were manufactured by subcontractors to Harrington & Richardson.

Frazier Manufacturing Company produced elevation knob and pinion assemblies in 1962 as replacement parts and Wilco Electric Company did likewise in 1969. Mechanical Components Corporation made gas cylinders in 1969. Dennison Machine Tool made hammers some time between 1968 and 1972. Harris Graphics made NM barrels in 1983. The Brookfield Precision Tool parts were made from 1988 to 1996.

Watervliet Arsenal - Watervliet Arsenal (Watervliet, NY) was established in 1813. It is famous as the cannon and artillery factory for the U. S. Army and U. S. Navy. However, Watervliet Arsenal did play a part in the production of the M14 rifle. In February 1961, the Arsenal was awarded \$330,906.00 by Springfield Armory to manufacture M14 parts. This work mostly consisted of pilot line production of bolts and stripper clip guides for Harrington & Richardson. Mr. S. J. Soltys, of Troy, NY, was the head of the minor components section. The minor components section made the M14 parts for the Arsenal in 1961. Watervliet Arsenal also made about 500 bolts under emergency procurement at some point between 1969 and the early 1990s.

Genuine USGI stampings are 1/16 " tall on the bolt and trigger housing. Note that not all

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USGI M14 parts were made by forging or extrusion. Some were made by investment casting, e.g., flash suppressors, winter trigger safeties, sear releases and M14E2 muzzle stabilizers. Sometimes a casting can be identified by a raised line on the surface of the part where the halves of the mold were fitted together.

FSCM and CAGE – From late in World War II until late 1974, contractors doing business with the U. S. government were identified by a five digit number known as the Federal Supply Code for Manufacturers (FSCM). The FSCM system eventually ran out of five digit numbers. So, as of October 25, 1974 all new contractors are identified by a five alphanumeric character code known as a Contractor and Government Entity (CAGE) code. The CAGE system includes the old FSCM numbers as well. For example, 0LB99 was a part made by McMillan Fiberglass Stocks. Consequently, any part made by a business assigned an alphanumeric CAGE Code could not have been produced before October 25, 1974.

By 2004, the U. S. military supply system had a shortage of spare M14 parts. On May 04, 2004, a solicitation for M14 parts was posted on the Internet by Rock Island Arsenal. This request for parts included 1,400 hammer spring plungers, 100 operating rods, 150 gas pistons, 750 ejector assemblies and 150 flash suppressors. From 2004 to 2006, Rock Island Arsenal awarded contracts and issued purchase orders for M14 parts:

- 1) December 29, 2004 - 400 gas pistons (Advanced CNC Manufacturing, Inc.)
- 2) March 28, 2005 – 400 ejectors and ejector springs (Anco Machine Co.)
- 3) May 23, 2005 – 700 front sights (Tri-Technologies, Inc.)
- 4) June 08, 2005 – 900 flash suppressors (Airtronic Services, Inc.)
- 5) June 28, 2005 – 450 operating rods (Tri-Technologies, Inc.)
- 6) July 18, 2005 – 400 safeties (Sigma Manufacturing Industries, Inc.)
- 7) August 12, 2005 – 350 trigger and sear assemblies (Tri-Technologies, Inc.)
- 8) September 19, 2005 - indefinite quantity contract for twenty round magazines with a guaranteed minimum quantity of 25,000 (Check-Mate Industries, Inc.)
- 9) January 30, 2006 - 800 gas pistons (Advanced CNC Manufacturing, Inc.)
- 10) March 02, 2006 - 400 hammers (Smith Enterprise, Inc.)
- 11) March 07, 2006 -155 operating rod guides (Beta Engineering, Inc.)

Since late 2001 when hostilities began in Afghanistan, individual servicemen and combat unit supply officers have purchased small quantities of accessories, magazines, parts, and optics from the commercial market to better equip and upgrade the M14 rifles in their custody.

The following is a list of contractors and government facilities that have produced USGI M14 parts. The individual entity is listed first followed by any identifying marks or Commercial and Government Entity (CAGE) Code and what parts the contractor is known to have made.

Table 19: USGI Contractors for M14 Rifle Items

USGI Contractor	Identifying Marks or CAGE Code	M14 Parts or Accessories Made
A-1 Sewing Contractors, Inc. (St. Louis, MO)	0NZ21	nylon dual magazine pouch
Advanced CNC Manufacturing, Inc. (Largo, FL)	1YDC9	gas piston
Aerial Cutlery		M6 bayonet
Airtronic Services Inc. Medical/Aviation Division (Elk Grove Village, IL)	1C5Q6	flash suppressor
Allied Precision Products, Inc. (Dunedin, FL)	24249	NM windage knob
Anco Machine Co. (Huntsville, AL)	3V055	ejector and ejector spring
Anniston Army Depot (Anniston, AL)	AAD	walnut M14E2 stock
Apex	APEX	M14E2 stock fore grip mount, M14E2 stock butt plate bracket
Argo Development Corporation (Inwood, NY)	ARGODEVCORP, 17808	M14E2 stock rubber butt pad
Associated Spring	AO	stripper clip
Atwood Vacuum Machine Co. (Rockford, IL)	AV, 70523	magazine
Barlow Metal Stamping, Inc. (Bristol, CT)	9M944	NM wood stock ferrule
Beta Engineering, Inc. (Arlington, TX)	33436	operating rod guide
BHM Corporation (Monagup Valley, NY)	BHM CORP, 29763	gas cylinder plug wrench
Bishop	possibly B	standard contour M14 stock
Borg-Warner (Rockford, IL)	BW, BRW, BRW S-1, BRW B-2	magazine

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Brookfield Precision Tool (Brookfield, MA)	BKFLD PREC TL, 0DF66	operating rod spring guide, scope mount, gas piston, scope mount adapter for AN/PVS-4, Navy special flash suppressor, sound suppressor
Bruce Machine and Engineering (Peabody, MA)	BME, 02481	windage knob, NM windage knob
Brunswick Sports Products Co. (Torrington, CT)	14530	magazine
Canadian Arsenals, Ltd. (Long Branch, ON)	CA, C A L	standard contour NM barrel, birch M14E2 stock
Cathey Enterprises, Inc. (Brownwood, TX)	8K916	M1907 leather sling
Chase Bag Co.		bandoleer
Check-Mate Industries, Inc. (Wyandanch, NY)	C.M.I., 1M291	ten round and twenty round magazine
Clifton Automatic Screw Machine Co.		gas cylinder plug
Columbus Milpar and Manufacturing Co.	MILPAR COL, 16689	M6 bayonet
Cooper Precision Manufacturing (Oak Ridge, TN)	1JHX1	DMR barrel (see M14 DMR)
Defense Procurement Manufacturing Services, Inc. (Saint Cloud, MN)	40554	trigger housing
Del-Con Supply Co.		wood stock upper butt screw
Delta-X Corporation (Morrisville, PA)	33950	NM/2A rear sight base
Dennison Machine Tool Co. (Hickory, NC)	DM, 96567	hammer
Do Well Mfg. Co., Inc.	27471	M14E2 stock fore grip
Douglas Barrels, Inc. (Charleston, WV)	0K789	NM barrel

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Druge Brothers Manufacturing Co. (Oakland, CA)	DRC, 72757	windage knob, elevation knob
East Moline Metal Products (East Moline, IL)	EMMPCO	blank firing attachment
Eastern Canvas (Haverhill, MA)	08501	M14 magazine web pouch
Enrex Corporation (Sterling Heights, MI)	ENREX, 0BTD4	NM windage knob
Farmer Supply & Tool Mfg. Corp. (Denver, CO)		M2 bipod marked 7790688
Fiske Bros. Refining Co.		Lubriplate 130-A grease
Frazier Manufacturing Co.	FZR	elevation knob, windage knob
Freehold Manufacturing Assembly Co., Inc. (Little Silver, NJ)	2S308	connector lock pin
G. G. Greene Metal (Warren, PA)	GGG, GGG 7791154, 26194	stripper clip, magazine charger
General Tire & Rubber Co. (Pasadena, CA)	89341	M14 fiberglass reinforced plastic stock
Globe Union, Inc. Ignition Division		rear sight elevation knob and spindle
Hall Planetary Company (Philadelphia, PA)	26878	medium weight NM barrel
Harrington & Richardson (Rochdale and Worcester, MA)	H, H R, H&R, HRA, H&R Arms Co., H&R D	receiver, rear sight base, trigger housing, operating rod, chromium plated barrel, front band, safety, trigger and sear assembly, gas cylinder, gas cylinder plug, flash suppressor nut, hammer and wood stock
Hart Rifle Barrels, Inc. (Lafayette, NY)	0FMZ6	NM barrel
Harris Graphics Corp. Commercial Press Division (Clinton, MD)	20084	NM barrel

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Hesse Machine & Mfg. Co., Inc. (Boston, MA)	21935	magazine latch
Imperial Knife Company (Providence, RI)	Imperial, 74846	M6 bayonet
Industrial Home For The Blind (Brooklyn, NY)	83268	soft nylon weave small arms sling
Killeen Machine & Tool (Worcester, MA)	KMT CO., 92983	late style trigger guard, ten round and twenty round magazine, operating rod spring guide, standard M14 stock butt plate flapper
Kingspoint Manufacturing Co., Inc. (Fayetteville, NC)		M1967 nylon magazine pouch for the M14, M1907 sling
Krieger Barrels, Inc. (Richfield, WI)	0DCS1	DMR and NM barrels
Lady Mac Corset Co., Inc. (Buffalo, NY)	18331	M14A1 cleaning kit pouch
Lufkin	Lufkin	stripper clip, elevation knob, windage knob
Mathewson Tool Co. (New Haven and later Orange, CT)	26097	early (T44E4 design) walnut stock, magazine, M14E2 stock butt plate bracket, M14E2 stock rubber butt pad
McMillan Fiberglass Stocks, Inc. (Phoenix, AZ)	0LB99	DMR and NM stocks
Mechanical Components Corporation (Glendale, CA)	27454	gas cylinder
Mercury Tool & Machine (Aston, PA)	24411	operating rod
New Haven Clock and Watch Co. (New Haven, CT)	NHC, 76728	elevation knob and spindle
Nomura Machine (Stockton, CA)	0NWF5	NM heavyweight barrel assembly, NM medium weight barrel
Parr Inc. Warren Refining Division (Cleveland, OH)		Plastilube Grade 1 grease

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Pennsylvania Working Home for the Blind (Philadelphia, PA)	PWH, TWB, 86465	M8A1 scabbard
P. T. E. Inc. (then Hicksville, NY)	26546	NM 0.0520 " hooded aperture assembly
Reinhart Fajen, Inc. (Warsaw, MO)	77742, 3T616	NM stock
Rochester Manufacturing Company (Rochester, NY)	R	magazine
Rock Island Arsenal (Rock Island, IL)	19204	walnut M14E2 stock, operating rod
Saco-Lowell later Maremont Corporation (Saco, ME)	SAK, 26978	chromium plated barrel, standard, medium and heavy contour NM barrel, operating rod, gas cylinder, gas piston
Screwtech, Inc.		flash suppressor nut set screw
Seymour Products Co. (Seymour, CT)	SEY, SEMCO, 78180	stripper clip, magazine charger, bandoleer
SGW (Olympia, WA)	SGW, 4S779	NM barrel (see USGI M14 National Match Barrels)
Sheffield Corporation		M14 fiberglass reinforced plastic stock
Smith Enterprise, Inc. (Tempe, AZ)	3A5E1	hammer, scope mount, flash hider, extended bolt lock, gas cylinder lock front sight, NM rear sight base, NM front sight, 30 mm scope rings
Springfield Armory (Springfield, MA)	S A, Springfield Armory, 19205	all rifle parts and all magazine parts
SPS Co.		bolt lock pin
Stanley-Humason		front band, safety spring
Stewart Iron Works (Covington, KY)	SWK, 82664	windage knob
Sunshine Makers, Inc. (Huntington Beach, CA)	1Z575	Simple Green cleaning compound for the Mk 14 Mod 0
Sykes Manufacturing		M14, M14 NM (drawing 7791174) and M14E2 (drawing 5910438) wood stocks
Textile Machine Works	HRT	bolt

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Thompson-Ramo-Wooldridge (Cleveland, OH)	TRW	receiver, trigger housing, hammer, gas cylinder, gas piston, rear sight base, connector, operating rod, chromium plated barrel, standard contour NM barrel, bolt, flash suppressor, safety, magazine
Tong Industries (Republic of Korea)	88 T I, 89 T I, 90 T I and T I	safety (numerals indicate year of manufacture), windage knob
Tri-Technologies Inc. Thermal and Moisture Protection Division (Mount Vernon, NY)	06MA8	front sight, operating rod, trigger and sear assembly
Union Hardware Company (Los Angeles, CA)	U H C (in a semi-circle), 78988	magazine
Unknown # 1 - possibly American Pin, Inc. CAGE 89695 (Waterbury, CT), a division of Scovill Mfg. Co.	A	magazine and possibly stripper clip
Unknown # 2	raised letter A	safety
Unknown # 3	raised lettering ATW	part number 7790837 M2 bipod left leg shaft assembly
Unknown # 4	raised lettering BKS	part number 7790837 M2 bipod left leg shaft assembly
Unknown # 5	COM	magazine charger
Unknown # 6 - possibly County Machine & Tool	COUNTY MACH	M14E2 stock butt plate base
Unknown # 7	CPP	NM windage knob
Unknown # 8	CTX	magazine follower
Unknown # 10	italicized D	sear release
Unknown # 11	H	blank firing attachment
Unknown # 12	H A, H B	safety
Unknown # 13	HR F	hammer
Unknown # 14 - possibly Nichols Machine	HR-N, OM-N	trigger housing
Unknown # 15	HR-R	magazine
Unknown # 16	K8	safety
Unknown # 17	LPR	NM windage knob
Unknown # 18	MXR	safety
Unknown # 19	N. E. INC.	M14E2 stock rubber butt pad and fore grip
Unknown # 20	NOV PROD CO	bandoleer
Unknown # 21	raised letter O	safety

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Unknown # 22	ROBER HT-B, ROBER HT-D	safety
Unknown # 23	RFM 7791154	magazine charger
Unknown # 24	TOMCO	NM windage knob
Unknown # 25	VIZ/WD, WD	M8A1 scabbard
Unknown # 26	W that is underlined	magazine
Victory Plastics Company (Hudson, MA)	V.P. CO., 96126	M8A1 scabbard
Viz Manufacturing Co. (Philadelphia, PA)	VIZ, 41226	M8A1 scabbard
Watervliet Arsenal (Watervliet, NY)		bolt, stripper clip guide
Weather Manufacturing Co.	W inside a hexagon with an arrow through the base of the W	windage knob
Westinghouse Electric	W	magazine
Wilco Electric Co. (Tenafly, NJ)	WCE, 51128	elevation knob, windage knob
Winchester (New Haven, CT)	OM, W-W, Winchester, 66118	receiver, trigger housing, hammer, chromium plated barrel, bolt, operating rod, stock, flash suppressor, magazine body, magazine follower, safety, trigger and sear assembly, gas cylinder, rear sight base, rear sight aperture, ammunition
Worden Specialty & Machine Tool Co. (Plymouth, MI)	12408	combination tool
Wright Manufacturing Co.	HRA-W, WRIGHT	windage knob
Wyandotte Tool Co. (Wyandotte, MI)		rear sight cover

USGI Parts Stamped With Drawing Numbers

A few parts were also stamped with the USGI drawing number. Most gas cylinders were not stamped with the USGI drawing number. Gas cylinders made in 1963 (Saco-Lowell) and 1969 (Mechanical Components Corp.) have been observed with the stamping S/N 7790902. They are listed as follows:

Table 20: USGI M14 Rifle Parts and Accessories with Part Number Markings

USGI Part	Part Number
barrel, chromium plated	7790190
barrel, National Match, standard contour	7791362
barrel, National Match, medium weight contour	9345206
barrel, National Match, heavyweight contour	9349847
bolt subassembly without the roller	7790185
bolt subassembly with the roller	7790186
gas cylinder	7790902
hammer	5546008
magazine charger guide	7791154
M14 stock hinge inlet protector	7791050
M14 stock hinge transition piece	7790914
M14E2 muzzle stabilizer	7791661
M14E2 muzzle stabilizer	11686521
M14E2 stock butt pad	7791673
M14E2 stock hinged butt plate base	7792062
M2 bipod	7790688
M2 bipod	7790833
M5 winter trigger	7790808
M76 grenade launcher	7790900
M84 scope carrying case	7631596
rear sight protector	7791358
operating rod	7267064
receiver	7790189
stock, National Match walnut	7791174
stock, National Match oversized walnut	9352638
stock, National Match birch	11010263
stock, National Match walnut	11010282
trigger housing	7267030
XM21 ART scope carrying case	11729637

USGI Parts Sales

USGI parts were sold to the American public after termination of M14 rifle production in 1964. Harrington & Richardson, TRW and Winchester all sold off their M14 parts inventory to the commercial market. This was done in an attempt to recoup some of their investment in the M14 program. Additionally, in the 1960s the U. S. Army declared much of its M14 parts inventory surplus and released them to the public for sale. Mr. Elmer Ballance of Devine, Texas purchased the parts inventory from companies who manufactured the M14 and from foreign nations that had received M14 rifles and parts under U. S. military assistance programs. From these parts stocks, he and his company began production of the M1A rifle.

In the early 1970s, surplus small arms parts dealers such as Thomas A. Buss (PA), Gerald Drasen (IL) and William J. Ricca (PA) bought and sold USGI M14 parts from government auction sales and on the open market. In 1970 and 1971, a fair number of

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individuals, small gun shops and large parts and accessories houses sold surplus USGI M14 parts and accessories to the civilian market. AR Sales Co. bought M14 parts directly from the contractors about the same time or earlier. Bob Penny of Federal Ordnance, Inc. in the early 1970s was also buying M14 parts. In 1973, USGI M14 bolts and operating rods could be had at gun shows in San Jose, CA for \$5.00 each and USGI M14 barrels for \$10.00 to \$15.00 each.

Table 21: Retail Suppliers of USGI M14 Related Items - 1970 and 1971

Supplier	Mailing Address City and State
Al's Corral	Atlanta, GA
Arasco	South El Monte, CA
Arizona Ordnance Co.	Phoenix, AZ
Armament Advisors	Phoenix, AZ
B. H. Service	Pandora, TX
Baron's	Oak Park, MI
Bill Edwards	Atlanta, GA
Ed Agramonte	Yonkers, NY
G.F.A. Sales Co.	Plumsteadville, PA
George R. Green & Sons	Willoughby, OH
Greeley Arms Co., Inc.	Fairfield, NJ
Jerry's Guns & Ammo	Hibbing, MN
Karl Keely	
LJZ Surplus	Belton, TX
M. C. Matthews	Snellville, GA
Morris Lawing	Charlotte, NC
Ozzie's Gun Parts	Mineral, IL
P. Michaels	Batavia, IL
Pat's Gun Shop	Columbia, SC
R. Weatherwax	Chicago, IL
Ray A. McKnight	Texarkana, TX
Rydberg	Mountain View, CA
Sarco	Stirling, NJ

Sherwood Distributors	Beverly Hills, CA
The Musket Shop	Dumfries, VA
Thomas A. Buss	Springdale, PA
Tom Forrest	San Diego, CA

About 1985, Jack Friese, owner of Armscorp of America, Inc., imported approximately 2000 M14 parts kits from Israel. Gerald Drasen purchased the bulk of these parts kits. Some of these M14 parts kits were sold by Bill Ricca on a consignment basis. Some of these parts kits were used to assemble H&R Gun Co. semi-automatic M14 rifles. At about the same time, a batch of 1,200 M14E2 stock fore grips and 30,000 M14 gas cylinder plugs were released by Naval Surface Warfare Center (Crane, IN) and purchased and divided among three parts dealers. Armscorp of America, Inc. purchased M14 parts and other items from Karl Maunz from December 1985 until August 1987. Several times in the 1980s, Bob Reese also brought large shipments of M14 parts into the United States. Some other companies also imported M14 parts from Israel during the 1990s. M14 bolts and barrels imported from Israel will have Hebrew markings. These Hebrew letter markings are typically found on the top side of the bolt and on the top of the barrel chamber. Through the years, NSWC Crane and Rock Island Arsenal have released various USGI M14 parts for public sale. Many of these parts were sold as a result of destroying M14 rifles. Some of the operating rods from demilitarized M14 rifles were broken in the process, sold as scrap, welded back together and sold in the surplus parts market.

The Office of the Director of the Civilian Marksmanship Program (ODCMP) received and sold USGI M14 parts in the 1990s. ODCMP received its last shipment of USGI M14 parts in 1996 as part of its normal routine operations. These parts were sold to members of DCM affiliated shooting clubs in the United States until supplies were exhausted at the end of 2003. The sales ended because the ODCMP sold what M14 parts they had, according to Orest Michaels, Chief Operating Officer. In February 2004, he did not know when or if the ODCMP would be able to sell any M14 parts in the future. USGI M14 parts remain available for sale from various gunsmiths and parts houses, but in limited quantities and at increasingly higher prices. Beginning in early 2004, USGI barrels, bolts, gas cylinders, operating rods, and flash suppressors are not widely available in the commercial market.

Parts Interchangeability with the M1 Garand Rifle

The following parts are interchangeable between the M1 Garand and the M14 type rifle: butt swivel, lower butt plate screw, rear sight aperture, elevation knob and pinion (note that the M14 elevation knob is calibrated in meters, while the M1 Garand elevation knob is calibrated in yards), rear sight base, sight cover, trigger (although the sear requires slight modification of the M14 sear for use in the M1 Garand rifle), hammer, hammer spring, hammer spring plunger, hammer spring housing, safety, hammer pin, trigger pin, extractor, extractor spring, extractor spring plunger, hand guard clip (as long as it has not been deformed during removal from the M14 rifle hand guard or the M1 Garand rifle rear

hand guard), and butt plates on certain M14 stocks. Hammers marked with part numbers C46008, C5546008 and D5546008 are often found in the firing mechanisms of commercial M14 type rifles. These markings indicate World War II, early 1950s and mid-to-late 1950s production M1 Rifle hammers, respectively. The letter prefix of the part number indicated the actual physical size of the part drawing.

The M1 Garand rifle hammer spring plunger *may* cause a problem with the M1A rifle. The original date for the USGI M1 rifle hammer spring plunger drawing 6008880 is August 02, 1937. In 1978, Springfield Armory, Inc. assembled M1A firing mechanisms with modified M1 Garand rifle hammer spring plungers. The head portion of the M1 Garand rifle hammer spring plunger was originally designed with “wings” or “ears” akin to the M1 receiver rear sight pocket. The hammer spring plungers were modified by grinding down the left side “wings” before assembling into the M1A firing mechanisms. By not grinding the “wings” of the hammer spring plunger, the hammer spring plunger *may* move out of the hammer notch which could cause the hammer to move. The USGI drawing 6008880 was revised, likely in 1958, to remove the “wings” from the head portion of the hammer spring plunger. Nonetheless, both types of hammer spring plungers are acceptable for USGI M14 rifle overhauls per U. S. Army DMWR 9-1005-223. The M1 hammer spring plunger is often used in match grade M14 type rifles

The following operator level items are interchangeable: web sling, cleaning rod section carry case, cleaning rod sections, cleaning rod patch tip, short oiler bottle, plastic spacer for bore brush and patch tip, 7.62 mm chamber brush for 7.62 mm M1 Garands only, .30 Caliber bore brush (although the drawing during the 1960s shortened the brush slightly to prevent it from hitting the inside of the butt plate), and either plastilube or lubriplate grease was authorized for use on both rifles. The bolt assembly and disassembly tool can be used with either rifle bolt.

M1 Garand Parts on M14 Type Rifles

As part of the Marshall Plan after World War II, Italy was given Winchester's M1 machine tools and dies for producing M1 rifles and M1 parts for our European allies which had adopted the M1 Garand. Beretta was given the machinery for making the M1 Garand but two other Italian companies made M1 rifle parts as well. Italian parts quality is as good as USGI M1 Garand parts quality.

Springfield Armory, Inc., Reese Surplus, AIM Surplus and a few other American and Canadian companies have imported many M1 parts kits from Italy. Springfield Armory, Inc. has used some of these Italian parts in its assembly of M1A rifles. Except for very small parts the Italians marked M1 Garand rifle parts with one of three markings: 1) PB for Pietro Beretta 2) BMR for Breda Meccanica Romana Italia and 3) BMB for Breda Meccanica Bresciana. Inexplicably, Pietro Beretta marked BM59 rear sight knobs were observed on two USGI M14 receivers destroyed by the U. S. government in the 1990s. The destroyed M14 receivers were obtained through U. S. government surplus auction.

USGI Parts Packaging

The USGI contractor who manufactured the part may be identified on the packaging, e.g., Winchester and Harrington & Richardson flash suppressors, Springfield Armory and

Harrington & Richardson gas cylinders and Winchester trigger and sear assemblies. More often than not, the contractor is not identified on the packaging. M14 parts made by Springfield Armory or subcontracted out will usually have the marking Springfield Armory on the package label. M14 parts made by contracts let by the U. S. Army Material Command, Weapons Command or the Defense Supply Agency usually do not identify the contractor on the package label.

Genuine USGI parts were always identified with a Federal Stock Number or a National Stock Number on the packaging. The change from Federal Stock Numbers to National Stock Numbers occurred between 1971 and 1975. Bar codes did not appear on USGI parts packaging until the 1980s. The term REPACK was not used on genuine USGI parts packaging. The Defense Supply Agency was named as such from October 01, 1961 until January 01, 1977. From 1977 to the present, it has been known as the Defense Logistics Agency.

Shell Development Company (San Francisco, CA) and Daubert Chemical Company (then Oak Brook, IL) held a number of U. S. Patents, e. g., 2,449,962, in the 1960s for the volatile corrosion inhibitor used in the wrapping paper for USGI M14 parts, magazines and accessories. Champion Packages Company (Columbus, GA), Chase Bag Company, Crawford Paper & Plastic, Inc., EDCO (Brooklyn, NY), H P Smith Paper Co., Lawrence Packaging (Newark, NJ), Ludlow Manufacturing (Holyoke, MA), Orchard Paper Company (St. Louis, MO), RAP Industries (Columbus, GA), Richmond Corporation, and Seal Bag (Rochester, NY) were among dozens of USGI contractors in the 1960s and 1970s that produced chemical vapor paper for the packaging of USGI M14 parts, magazines and accessories. Additionally, Ludlow Manufacturing produced a private label wrapping paper marked Marvellum. Ludlow was in business manufacturing packaging paper until at least 1977. Daubert Chemical Company and EDCO are still in business. RAP Industries and Seal Bag are no longer in business.

If the packaging was not torn or opened, the part was safe from corrosion for five to twenty-five years. The U. S. government over the years released sizeable quantities of chemical vapor barrier paper used to package USGI M14 parts. This paper has been used to package commercial reproduction M14 rifle items which implies the contents were made as part of a U. S. government contract when such is not the case.

USGI M14 parts wrapped in chemically treated paper got coated with volatile corrosion inhibitor, a white powdery substance, over time. This is perfectly normal and the substance can be wiped off.

A complete list of Federal Stock Numbers for M14 parts, accessories, tools, maintenance supplies, special equipment and special packaging material can be found in Appendix B of TM 9-1005-223-34 (see Bibliography). Some parts such as firing pins and magazines were opened, inspected and repacked by Anniston Army Depot, Crane Naval Surface Warfare Center and other supply depots. Used parts such as blank firing attachments and magazines, were cleaned up and rewrapped by the supply depots for reissue as needed. Spare M14 parts were packaged in the following manner:

Table 22: USGI M14 Rifle Parts and Accessories Packaging

USGI Part or Accessory	Manner of Packaging
AN/PVS-2 carrying case	one per transparent heat-sealed plastic bag
barrel	one per black cardboard tube
barrel cleaning rod patch tip	ten wrapped with vapor barrier paper
barrel reflector	twenty per cardboard box
bayonet	one per cardboard box inside sealed plastic bag
blank firing attachment and breech shield	one pair per cardboard box
bolt with roller	individually wrapped with vapor barrier paper or packed five to a vapor barrier pack
bolt lock	one per heat-sealed pack
bolt lock pin	100 inside cheese cloth wrapper
bolt roller	five per heat-sealed pack
bolt roller retainer	five per heat-sealed pack
bore reflector	twenty per cardboard box
chamber brush	ten per cardboard box with each inside a cardboard sleeve
cleaning rod section	ten per package
combination tool	one per heat-sealed pack or cardboard box or black cardboard tube
connector assembly	one per sealed clear plastic pack
connector lock	five per heat-sealed pack
connector lock pin	one per transparent heat-sealed plastic bag (1990s production)
ejector assembly	two per heat-sealed pack
elevation knob and spindle	twenty per black cardboard tube
extractor spring and plunger	twenty per heat-sealed pack
firing pin	two per heat-sealed pack or cellophane bag, twenty twin packs per black cardboard tube
flash suppressor	black cardboard tube or heat sealable wrap
flash suppressor nut	ten per black cardboard tube
flash suppressor nut wrench	one per heat-sealed pack
front band	one per heat-sealed pack
front sight screw	100 per box
gas cylinder	two per black cardboard tube and five tubes per box or two inside cheese cloth wrapper
gas cylinder lock	one per heat-sealed pack
gas cylinder plug	five per heat-sealed pack with cardboard sleeve around the threads or five per heat-sealed pack wrapped in a single piece of vapor barrier paper
gas piston	one per heat-sealed pack or transparent heat-sealed plastic bag
hammer spring	fifty per paper and / or plastic bag with oil sprayed on the parts (1981 production)
M2 aiming device	one per cardboard box
M2 bipod modification kit	one kit wrapped in foil inside a sealed cheese cloth wrapper

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M5 winter trigger (with or without safety)	one wrapped in foil paper inside cardboard tube inside heat-sealed pack
M6 bayonet	one per cardboard box inside transparent heat-sealed plastic bag
M14A1 stock without hardware	ten per carton
M76 grenade launcher	one per cardboard tube
M151 vehicle mounting kit	one per cardboard box
M1907 small arms sling	one per heat-sealed transparent plastic bag
magazine	one or four per heat-sealed pack or two per cardboard sleeve with outer plastic wrap (1960s production) and blue plastic bag (1990 and later production)
magazine latch	one per heat-sealed pack
operating rod	two per black cardboard tube (1960s production) and transparent heat-sealed plastic bag (1980s production)
operating rod guide	one per heat-sealed pack
operating rod spring	two per heat-sealed pack
operating rod spring guide	one per heat-sealed pack
rear sight aperture, National Match hooded	one per heat-sealed pack
rear sight base	one per heat-sealed pack
rear sight cover	twenty per black cardboard can
rear sight elevation knob and spindle	cardboard tube
rear sight windage knob	twenty per black cardboard tube
safety	one per heat-sealed pack
safety spring	one per heat-sealed pack or 100 per box
selector spring	one per heat-sealed pack
selector switch	one per heat-sealed pack
selector switch and spring	one set per cellophane bag (1960s production)
sling swivel, rear	one per heat-sealed pack
small arms sling, nylon	one per heat-sealed pack
spindle valve	ten per heat-sealed pack or 100 per cardboard can
stripper clip guide	one per heat-sealed pack
stock, National Match (9352638)	one per transparent heat-sealed plastic bag (1980s production)
stock ferrule, National Match	one per heat-sealed pack (1990s production)
stock repair screws	twenty per transparent heat-sealed plastic bag
stock screw, wood, upper butt	one per heat-sealed pack
stock subassembly, National Match (11010282)	ten per cardboard box
stripper clip guide	one per heat-sealed pack
swab holder	ten per envelope
trigger and sear assembly	two per heat-sealed pack
trigger guard	one per heat-sealed pack
trigger housing (with magazine catch, spring and pin)	one per heat-sealed pack

USGI M14 Magazine Packaging - In the 1960s, USGI M14 magazines were wrapped in one of three ways: 1) cheese cloth on the outside and chemical vapor barrier wrapper surrounding the magazine on the inside 2) oil preservative wrapper or 3) chemically treated cardboard sleeve inside a sealed transparent plastic wrap. Either method protected the magazine from moisture inside the package while it remained sealed. Chemically treated sealable wrapping paper was not available until about 1985. Packaging of USGI M14 parts was inspected by government employees as part of the production contract.

As with other USGI parts, the USGI M14 magazine packages were printed with specific information to identify the contents. Markings from a package from 1968 serves to illustrate what information was indicated (from top to bottom): first line – 1005-628-9048 is the Federal Stock Number second line – MAGAZINE ASSY is the nomenclature third line – 2-EA is the quantity fourth line – DAAG-25-68-C-0402 is the contract number fifth line – A-MAR-1968 is the year and date the magazines were packaged. In 1996 and 2005, Check-Mate Industries packaged its USGI contract M14 magazines in blue color plastic bags for the U. S. military. Check-Mate Industries magazines produced in 2005 and 2006 for the U. S. government contract keep the RESTRICTED USE - LAW ENFORCEMENT / GOVERNMENT USE ONLY marking on the magazine body rear side.

Notes on Commercial Parts

Commercial manufacture and Chinese M14 parts are available in much smaller quantities than what USGI parts were back in the 1960s and early 1970s. While certain commercial parts are available at the time of this writing that may not be the case in the future.

Springfield Armory, Inc. - Springfield Armory, Inc. began making parts in the late 1970s as the supply of USGI M14 parts became limited. Commercial reproduction trigger housings marked 7267030-G were installed in M1A rifles as early as April 1978 and as late as May 1984. Standard model M1A serial number 007041 left the factory in 1977 with a commercial manufacture barrel and a commercial manufacture operating rod. A National Match model M1A produced in 1978, serial number 00909X, was assembled with a commercial bolt at the factory. This particular bolt has no markings except for the letter N on the rear end. These cast bolts are referred to as the “lettered series” bolts. A standard model M1A with serial number 0093XX left the factory in early 1979 with a commercial non-plated standard contour barrel, commercial operating rod and commercial bolt. M1A serial number 010047 left the factory in 1979 with a “lettered series” M1A bolt, reproduction ejector and M1 Rifle ejector spring. The “lettered series” cast bolt on M1A serial number 010047 was tested for cracks and hardness by an Ohio National Guard armorer. No cracks were found by magnaflux inspection. The bolt hardness was 55 HRC. However, the bolt firing pin hole was larger than required by the USGI drawing. By April 1979, Springfield Armory, Inc. had changed to “numbered series” reproduction bolts in M1A rifles.

From 1978 to 1986 Springfield Armory, Inc. was short on USGI M14 barrels so it installed non-plated standard contour barrels. The barrel blanks were supplied by Wilson Arms. Springfield Armory, Inc. M1A medium weight stainless steel National Match barrels are marked NM 308-SS. The medium weight molybdenum-chromium alloy National Match

barrels are marked NM 308. The barrel marking is located between the gas cylinder and the flash suppressor. Douglas Barrels, Inc. supplied the stainless steel blanks for standard loaded model M1A barrels.

Springfield Armory, Inc. M1A rifles built from the late 1980s to 1994 *tend* to be built with a majority of USGI parts. For example, M1A serial number 081004 (made between April and June 1994) was built at the factory with the following parts: TRW trigger housing, HR-N hammer, TRW bolt, Winchester barrel, and WCE USGI rear sight elevation and windage knobs. There are USGI parts on M1A rifles built from the mid-1990s until the present day but they are the exception rather than the rule, especially from 2002 onward.

Springfield Armory, Inc. commercial reproduction operating rods are made from two pieces of steel welded together as was done by Springfield Armory, Winchester and Harrington & Richardson. Springfield Armory, Inc. offers an adjustable firing mechanism for sale. The trigger pull can be adjusted from 1 ½ to 4 ½ pounds by using an adjustment screw not visible from outside the stock. It was designed by Dale Rader at Springfield Armory, Inc.

Wayne Machine Inc. – Wayne Machine Inc. of Taipei, Taiwan was established in 1979 and moved to its present location in May 1994. It manufactures ordnance components, combat vehicle parts and military and commercial firearms parts. Wayne Machine Inc. exports 90 % of its production to the United States, United Kingdom, and other countries. It lists the Taiwan Army as one of its customer references. Since the mid-1980s, Wayne Machine Inc. has made and supplied reproduction M14 parts to Century Arms International, Numrich Gun Parts Corporation, Sarco, Inc., and Springfield Armory, Inc.

In 1996 or 1997, Numrich Gun Parts Corporation received a shipment of cast reproduction operating rods from Taiwan. They had Winchester markings. Apparently, Wayne Machine Inc. had been sent a Winchester M14 operating rod as a sample. Most commercial M14 type rifle parts are cast. The April 2004 M14 products list of Wayne Machine Inc. includes the gas cylinder, flash suppressor, M14E2 muzzle stabilizer, front sight, rear sight parts, hand guard assembly, and firing mechanism parts but not the bolt or operating rod. Commercial manufacture M14 bolts have been cast, machined from bar stock and forged. These reproduction parts usually function in a satisfactory manner when fitted and assembled correctly.

Smith Enterprise, Inc. - Smith Enterprise has made or presently does make and sell the following M14 parts: flash suppressors, muzzle brakes, gas cylinder locks, stock ferrules, bolt locks (SEI part number 2010), extended bolt locks, combination gas cylinder lock front sights and National Match (front and rear) sight parts. Smith Enterprise combination gas cylinder lock front sights (see Commercial Sights), bolt locks, extended bolt locks and both versions of the flash hiders are made of carburized and hardened AISI 8620 steel. Smith Enterprise, Inc. also cuts and polishes barrel chambers using Douglas medium weight and heavyweight blanks. Due to growing scarcity of quality M14 parts Smith Enterprise may well manufacture other parts in the future. The company is selective in which parts it manufactures, but when they make parts they are of high quality.

Smith Enterprise offers a safe and reliable adjustable M14 firing mechanism to the public. This adjustable firing mechanism is an optional accessory for the M14SE rifle system. A member of the U. S. Army 5th Special Forces Group was testing it in Iraq in 2004 and into

2005. To make this unit, a USGI firing mechanism is modified by adding parts hidden inside the stock. The rifle stock requires only about 1/8 " of inletting to accommodate the adjustable firing mechanism. The trigger pull can be simply and easily adjusted anywhere from two to five pounds. It remains a two stage trigger even at a two pound pull. An M14 rifle equipped with the Smith Enterprise, Inc. adjustable trigger can be quickly restored to a standard firing mechanism in the field.

Sadlak Industries, LLC – Sadlak Industries, LLC develops, markets, and sells various rifle parts, industrial components and tooling. It is the distribution agent of Sadlak Innovative Design Company. Sadlak Innovative Design Company is a manufacturing job shop and machine design company that was founded in 1989. Mike Sadlak is the President of Sadlak Industries, LLC. He was introduced to the M14 rifle by competition shooter and gunsmith David Ferrante. In 2002, Mike Sadlak asked David Ferrante what parts could be made from a stock of certified titanium on hand. This titanium billet was production contract over run made for Pratt & Whitney. Mr. Ferrante suggested M14 scope mounts and Sadlak Industries agreed. By March 2003, Sadlak Industries was producing high quality steel and titanium scope mounts and an operating rod spring guide for the M14 type rifle (see Side Three Point Scope Mounts).

Sadlak Industries makes National Match operating rod spring guides out of AISI 8620 alloy steel. These spring guides are case hardened to between 40 and 45 HRC. The Sadlak Industries spring guide design is based on the Brookfield Precision Tool part but is an improvement in that it uses a single piece of solid steel stock. In 2003, Sadlak Industries manufactured a single batch of 100 operating rod spring guides with a hollow shaft from two pieces of material.

Sadlak Industries also manufactures National Match gas pistons from AISI 420 stainless steel. One version has the cylindrical portion highly polished. The other version is first polished then coated with titanium nitride. Sadlak Industries, LLC consulted a large firm specializing in metal coatings. Mike Sadlak met with the technical experts at this metal coating firm, showed them the M14 gas system parts and explained to them the nature of the application for a coated gas piston. The gas piston moving forward and aft inside the gas cylinder subjects it to heat and abrasiveness. The coating firm analyzed the situation and selected a specific ingredient mixture of titanium nitride for the M14 gas piston. This specific titanium nitride coating is approximately 0.0001 " thick but it results in high anti-galling and anti-seizing properties. The benefit to the M14 type rifle owner is smoother gas system operation and improved gas system service life (see M14 Rifle Lubrication).

Sadlak Industries can machine the National Match / M21 groove into the gas piston per the USGI drawing number 9352724 at the customer's request. Sadlak Industries also offers very slightly oversized gas pistons to fit worn customer supplied gas cylinders. These custom order gas pistons are typically 0.0002 " or two ten-thousandths of an inch wider than the USGI outside diameter specification. In late 2004, Sadlak Industries was testing a coated gas cylinder designed for longer service life. The Sadlak Industries 2006 SP3 production lot gas pistons were marked: top line - SADLAK INDUSTRIES LLC bottom line - COVENTRY CT USA SP3. Sadlak operating rod spring guides and gas pistons are marked SADLAK INDUSTRIES LLC. The U. S. Army 173rd Airborne Brigade

equipped twenty-two accurized M14 rifles in the fall of 2004 with Sadlak Industries operating rod spring guides and titanium nitride coated gas pistons.

Sadlak Industries, LLC was testing chromium plated M14 gas cylinders in late 2004 and early 2005. A very thin (0.0001 " or one ten-thousandth of an inch thick) but uniform and consistent layer of dense chromium is applied to the interior surface of the gas cylinder. This creates a smooth surface that is less subject to wear. The conclusion of this testing was that it is more affordable to produce custom made oversized gas pistons than to plate the gas cylinder bores.

Troy Industries, Inc. – In 2005, Troy Industries offered an extended magazine release and a bolt lock for the M14 type rifle. These parts were machined from steel bar stock and finished with manganese phosphate coating.

Other Commercial Parts Suppliers - Gerald Drasen, who did business as Nesard and Sendra (Chicago, IL), went into the firearms parts business no later than 1963 selling M1 Garand rifle and M1911 pistol parts. He produced reproduction M14 items such as the flash suppressor nut wrench, bolt assembly tool, front band, gas cylinder, magazine latch, rear sight cover, safety and trigger housing in the 1980s. His business continued to sell reproduction M14 items until at least 2002. Brookfield Precision Tool made match grade operating rod spring guides and titanium-nitride coated gas pistons from 1988 to 1996. In 2004, DPMS, Inc. sold a high quality lugged flash suppressor manufactured in South Korea.

Established in 1982, Badger Ordnance specializes in the manufacture of firearms precision tools, gauges, accessories and scope mounts and rings. It offers a fluted National Match operating rod spring guide designed to minimize spring binding and drag. The Badger Ordnance operating rod spring guide is made from a single piece of AISI 4142 molybdenum-chromium alloy steel. W. C. Wolff Company produces quality M14 type rifle ejector springs, extractor springs, hammer springs, magazine springs and operating rod springs. Laszlo Klementis, doing business as Rooster33 (Chilliwack, BC), produces a M14 type operating rod spring guide and a M14 bolt lock. Its operating rod spring guide is CNC machined from a single piece of 410 stainless steel bar stock.

In 2005, F A Enterprises was manufacturing a M14 flash suppressor nut, also known as a castle nut. It is made from AISI 1018 carbon steel and has a blued finish. Superior Shooting Systems, Inc. (Canadian, TX) M14 type rifle chromium silicon alloy steel operating rod springs and hammer springs are rated for 500,000 cycles. Arrowhead Industries (Afton, MI) manufactures various firearms parts including M14 gas pistons from AISI 420 stainless steel and M14 gas cylinder plugs from AISI 416 stainless steel. Arrowhead Industries M14 gas pistons and gas cylinder plugs are only sold to its distributors, e.g., Sherluk (Delta, OH). Fulton Armory offers commercial manufacture extractors milled from bar stock.

Notes on Chinese Parts

USGI and commercial manufacture parts are theoretically interchangeable but occasionally the fit is too tight or too loose between such parts. Most USGI and commercially manufactured parts are generally interchangeable with their Chinese

counterparts but there are some exceptions. Chinese and American rear sight knobs and bases and gas cylinder plugs are not interchangeable because the Chinese sight parts have metric threads. Chinese gas cylinders and gas cylinder plugs are made of molybdenum-chromium alloy steel and gas pistons are chromium plated. The Chinese gas piston outside diameter and the gas cylinder inside diameter are slightly larger than USGI gas piston and gas cylinder drawing specifications. A USGI gas piston may be too narrow to function properly inside a Chinese gas cylinder. National Match operating rod spring guides will not fit inside Chinese operating rod springs because the interior diameter is too small. USGI stocks require some work to fit properly with Chinese rifles. Chinese hammers and triggers are sometimes a little soft, but this can be corrected with appropriate nitrocarburizing treatment. Chinese M14 firing pins are completely chromium plated. Chinese butt plates, flash suppressors, rear sight bases, and trigger housings are castings. Chinese butt plates and butt plate flappers are both made of steel. The flapper-to-butt plate joint is built up by welding then ground flat. Two types of Chinese M14 butt plate flappers have been observed: Type 1) the flapper has two raised indentations on the right side of the hinge and Type 2) the flapper has one hole on the left side of the hinge as the muzzle is pointed down range.

Three kinds of operating rods have been identified on Chinese semi-automatic M14 type rifles. One kind has no notch at all for the connector assembly. Another has an almost straight angle cut to the notch, which does not closely match the USGI connector's contours. The third version of Chinese operating rod has a connector notch very similar to the USGI model, but with a more circular shape. In all other important dimensions, the three types of Chinese operating rods are the same. Chinese operating rods are forged and are as hard as USGI operating rods.

Chinese barrels have metric dimension barrel shank, gas cylinder lock and suppressor nut threads. However, the Chinese barrel shank thread size is very close to the American made receiver barrel ring thread size. Chinese M14 barrels will usually thread into an American made M14 type receiver without any trouble. Nonetheless, barrel installation and headspacing should be performed by a reputable M14 gunsmith. Neither a USGI gas cylinder lock nor a USGI flash suppressor nut will fit on a Chinese barrel because of the differing thread sizes, and those two Chinese parts will similarly not fit on a USGI or U. S. commercial manufacture M14 type barrel.

For reasons unknown to Smith Enterprise or anyone else the author has contacted, the Chinese did not use equivalent AISI 8620 alloy steel for their bolts as per the USGI drawing for their bolts but elected to make them out of equivalent AISI 4135 alloy steel. Chinese bolts have a surface hardness of 40 to 47 HRC which is too soft. This applies to Chinese bolts exported to the United States prior to September 13, 1994. If the bolts are heat treated to improve the hardness, the hardness increases all the way through the bolt instead of just at the surface. Hardening a Chinese bolt will add only a little more service life to the bolt to the item. In the long term, however, hardening a Chinese bolt is still not desirable. This is because increasing the core hardness of the bolt decreases the core toughness. Another significant problem plagues Chinese bolts. Besides not being made of a material suitable for long term use, the locking lugs are too narrow. Thus, American

and Chinese bolts are not interchangeable. Converting a U. S. imported Chinese M14 type rifle to accept an American made bolt should be performed by an experienced M14 gunsmith.

These problems may or may not continue to affect Chinese M14 bolts which were more recently exported. For example, three Norinco M305 rifle bolts shipped to Canada in 2003 were tested for surface hardness. The results ranged from a minimum of 45 HRC to 48.5 HRC, with the average at 47 HRC. More detailed information on the bolt material or the core hardness of these 2003 vintage bolts is presently unavailable.

Chinese Parts Identification

Chinese M14 parts differ in their markings from U. S. parts as follows:

Table 23: Chinese M14 Rifle Part Markings

Chinese Rifle Part	Identifying Marks
barrel	no markings
bolt	may have numbers electro-penciled on the top or bottom
hammer	no markings
operating rod	may have electro-penciled numbers and the connector notch shape is different from USGI design
trigger housing	five or six digit number
windage knob	counterfeit W C E

The bolts and operating rods of Chinese M14 rifles imported in May 2006 into Canada have etched numbering on the bolts and trigger housings and W C E is marked on the elevation knobs.

Commercial Parts Identification

Barrels - Springfield Armory, Inc. in Illinois marked its USGI and commercial manufacture barrels SPRINGFIELD INC. GENESEO IL or GENESEO ILL or GENESO, IL 308. This marking is typically found on the barrel chamber. Chromium plated standard contour barrels supplied by Criterion Barrels, Inc. to Fulton Armory are stamped C.B.F.A. 7790190 followed by the month and year of manufacture. A photograph of a Wilson Arms chromium plated standard contour barrel sold by LRB Arms shows the following markings: LRB 7790190 5/04 WA. Smith Enterprise, Inc. installed a Douglas 1:10 twist four groove heavyweight barrel on a M1A rifle in January 2003. The barrel is stamped with the following markings from top to bottom: first line - 1 10 308 WIN 1 03 second line - 4 35T SEI. At the bottom of the barrel at the rear end just forward of the op rod spring guide slot it is marked 1.

Bolt - Springfield Armory, Inc. bolts are typically marked 7790186-SA on the first line and A00030, B00048 or F00059 or similar number on the second line. They may have markings such as D and M3 on the rear end and A9 or B1 on the bottom surface. The letter A prefix for the number under 7790186-SA means the bolt was cast then finish machined. The letter B prefix for the number under 7790186-SA means the bolt was machined from bar stock. The letter F prefix for the number under 7790186-SA means the bolt is forged. See 1987 Springfield Armory, Inc. Recall Notice for additional

markings. No M1A parts, including bolts, are made by metal injection molding. Around receiver serial number 165XXX, Springfield Armory, Inc. commercial manufacture factory installed bolts have letters and numerals with a taller and thinner font than the style found on USGI M14 bolts. A Springfield Armory, Inc. M1A bolt not subject to recall was tested for surface hardness. The result was 52 HRC, the same as a USGI HRT marked M14 bolt.

Operating Rod - On Springfield Armory, Inc. operating rods, look for either: 1) 7267064 on the first line and SA centered below it or together in one line 2) 7267064-2 on the first line and SA centered below it. The first example is the earlier of the two markings.

Springfield Armory, Inc. operating rods with the early marking, no -2, will not have a notch under the handle like USGI operating rods. Sometime between 1996 and 1999, the notch under the handle was added to its operating rods. For clarity, U. S. government Springfield Armory operating rods are marked 7267064 SA all on one line and are machined with the notch under the handle but may or may not have the forward end vent hole.

Rear Sight Base - A rear sight base marked NM/2A on the right hand side and BST2 on the bottom is most likely a commercial reproduction. ² A part marked NM/2A with no other markings may be a commercial reproduction.

Trigger Housing - For commercial Springfield Armory, Inc. trigger housings, look for part numbers 7267030-G or 7267030-H or 7267030-I or 7267030-S.

USGI Magazines

The M14 magazine design was finalized by John C. Garand in the first five months of 1954 while he was a consultant to Mathewson Tool Company on the T44E4 rifle contract. The M14 magazine design was borrowed from Garand's T31 rifle project. The T31 (and M14) magazine design requires very low cartridge stripping forces. Rochester Manufacturing Company (Rochester, NY) developed the welding procedure for the M14 magazine parts.

Springfield Armory, government contractors and commercial magazine manufacturers have at one time or another produced five, ten, fifteen, twenty, twenty-five and thirty round magazines for the M14 type rifle. The five, fifteen, twenty-five and thirty round magazines are commercially manufactured but not marked with any manufacturer's initials. The Springfield Armory, Inc. M1A description in the 1987 *Shooter's Bible* lists magazine capacity as five, ten, twenty, and twenty-five rounds.

A seven round magazine was produced by the U. S. Army MTU for use with the XM21 in Viet Nam. The XM21 seven round magazine was small enough to allow the sniper to assume a lower position with the rifle yet long enough to allow the magazine to be removed quickly. The U.S. Department of Defense contracted with several companies to supply five, ten and twenty round M14 magazines. For example, Check-Mate Industries, Inc. made ten round magazines about 1990 for the U. S. Army Marksmanship Unit. The five round M14 magazines were made by Check-Mate Industries but supplied by Springfield Armory, Inc. to the U. S. Department of Defense. The U. S. Marine Corps uses both ten and twenty round magazines in the M14 DMR.

Usually, the U. S. government contractor manufacturer initials were marked on the rear side of USGI M14 magazines. Quantico Arms & Tactical Supply, Inc. purchased a batch of 12,000 New-In-Wrap USGI twenty round M14 magazines in 2004. Quantico Arms found that about 20 % of these magazines either have no manufacturer marking or the initials are very faint. At least at some point, the manufacturer's marking on the magazine body became required per USGI drawing 7790181. USGI Borg-Warner magazines have been unmarked straight from packaging dated as early as January 1963.

The following manufacturer initials have been observed on magazine follower stops: BW and B-W (Borg-Warner), CTX (unknown) and OM (Winchester). The manufacturer's marking on the magazine follower is optional per USGI drawing 7267085. If a USGI magazine follower has spot welds on the flat portion of the stop, there will be three evenly spaced weld "dimples" or "buttons."

Be aware that some commercial reproduction M14 magazines have USGI contractor style markings on the rear side and the packaging has been expertly copied. Such "GI" style reproduction magazines may not charge and reliably feed twenty cartridges. The magazine body thickness of these magazines may be thinner than genuine USGI units. A genuine USGI M14 magazine will hold and reliably feed twenty cartridges then activate the bolt lock. This function requirement is stated on USGI drawing 7790183 (M14 magazine assembly).

The savvy collector can identify genuine USGI and Taiwanese government manufacture M14 magazine bodies. Examine the spot welds on the front side of a known USGI or Taiwanese twenty round magazine. Make notes on the size, number, alignment and location of the spot welds. Note that some KMT marked magazines differ from the typical pattern of USGI magazine body spot welds. The USGI drawing 7790181 requires twelve evenly spaced spot welds up the center of the front side and one spot weld just to the right of the operating rod spring guide hole as the magazine stands up. Use this information when examining M14 magazines for sale to discern whether or not a magazine is a commercial reproduction item.

USGI M14 magazine latch plate weld dimple patterns were consistently the same pattern according to manufacturer. For example, BRW S-I marked magazines have five "dimples" on the latch plate. C.M.I. magazines have six "dimples" on the latch plate. HR-R marked magazines will have four "dimples" in the same area, etc. The USGI drawing 7790197 (magazine body assembly) does not specify a manufacturer's marking but drawing 7790181 (magazine tube) does. Drawing 77901977 allows for the latch plate to be attached to the magazine body by two, four, five or six welds depending on which revision was used. USGI magazine springs were coated with lubricating oil before packaging.

USGI magazine contractors included American Pin, Borg-Warner, Check-Mate Industries, an unknown Harrington & Richardson subcontractor, Killeen Machine & Tool, Olin-Mathieson Chemical (Winchester), Springfield Armory, TRW, Union Hardware Company and Westinghouse Electric. Check-Mate Industries made twenty round M14 magazines around 1990 and then again for 1996 and 2005 dated contracts. The 2005 contract is for a guaranteed minimum of 25,000 and up to a possible maximum of

360,000 twenty round magazines. The USGI magazines are generally regarded as the best made.

M14 magazine replacement parts have been available in the civilian market since about 1989 from Sarco, Inc. Replacement M14 magazine springs should be inspected for signs of any defects and for proper dimensions. The replacement magazine followers should have three neat and evenly spaced spot welds attaching the stop to the follower. USGI M14 magazine followers are heat treated to file hard. Consequently, do not bend the rear tab on USGI M14 magazine followers any appreciable distance as they will snap off. If the rear tab is bent significantly and it does not snap off, it is likely a commercial reproduction part.

Magazine body (tube) wall thickness can vary from 0.028 " to 0.041 " as observed among USGI, Chinese, Taiwanese and U. S. commercial manufacture M14 magazines. The specification per USGI drawing 7790181 for the body (tube) thickness is 0.0310 " + or - 0.015 ". If a magazine body is too thick, e.g., 0.041 ", it may fail to lock the bolt open after the last round is fired.

The following *incomplete* timeline of contractors has been developed from observations made while opening new-in-wrap genuine USGI M14 magazines.

Table 24: Timeline of USGI Magazine Contractors

Year(s)	USGI Magazine Manufacturer
1959	Union Hardware Company
1961	Atwood Vacuum, Brunswick Sports Products, Westinghouse Electric (W marking)
1962	Borg-Warner Spring Division, Brunswick Sports Products, Olin-Mathieson Chemical Corporation (OM marking), Westinghouse Electric
1965	Killeen Machine & Tool Co.
1967	Borg-Warner Spring Division
1968	Borg-Warner Spring Division
1969	Borg-Warner Spring Division
1970	Killeen Machine & Tool Co.
1991	Check-Mate Industries
1996	Check-Mate Industries
2004, 2005, 2006	Check-Mate Industries

Note that assembly of a complete twenty round M14 magazine from spare parts may be a violation of applicable local or state law in the United States, or may violate Canadian law. Possession, manufacturing, importation, sales or transfer of centerfire rifle ammunition

magazines capable of holding more than five rounds may be prohibited or restricted in U. S. cities and states (see Appendix F). Under present Canadian law, magazines for the M14 type rifle and other centerfire long guns are pinned to limit the capacity to five cartridges. Consult state and local laws before purchasing or accepting any firearm magazine.

Foreign Manufacture Magazines

Taiwan and People's Republic of China also produced twenty round magazines that were imported from the late 1980s until 1994. Some Chinese twenty round magazines were blocked to five rounds capacity by welding a metal block under the follower following the 1989 import ban (see U. S. Law and the Chinese M14). Such magazines were included in the shipping boxes for Chinese M14 rifles imported by Century Arms International and IDE USA. While Chinese magazines are narrower than the USGI magazines, they have an excellent reputation for reliability. Chinese magazines imported into the United States in the 1980s and 1990s were coated with grease. Chinese magazines imported into Canada after 2000 were preserved with oil and packed in heat-sealed transparent plastic bags. Canadian plastic twenty round magazines have also been imported into the United States. These magazines have a good reputation but may require a small amount of plastic to be removed from the locking tab to feed reliably.

U. S. Commercial Magazines

Aftermarket magazines often fail to function reliably because of their thinner body sheet metal, weak springs and flashing on their plastic followers.

U. S. aftermarket brand twenty and thirty round magazines were produced before September 13, 1994 by companies such as USA Magazines (1992 mailing address in Downey, CA). A plastic twenty round M14 magazine was developed in 1977, patented in 1979 and manufactured by D. & D. Inc. (Wilson, NC). Springfield Armory, Inc. M1A fifteen round magazines use a twenty round body with a wood block under the follower to prevent loading more than fifteen rounds. Check-Mate Industries has manufactured twenty round magazines for Springfield Armory, Inc. Its 2005 and 2006 production twenty round magazines for the commercial market have no manufacturer markings.

Viking Tool and Machine made a small batch (less than ninety) of seventy-two round Beta C style M14 magazines before the 1994 Assault Weapons ban on new "large capacity" magazines. This conversion consists of cutting then screwing an MG-15 saddle drum to a Viking magazine tower. These M14 type drum magazines have been used at the legendary Knob Creek Machine Gun Shoot held every April and October in West Point, KY. These magazines commanded a premium price during the ten years the 1994 Assault Weapons ban was in effect.

Miscellaneous Notes on Scope Mounts

Mathewson Tool Company in 1954 designed a means to mount an optical scope on the T44E4 receiver. This design feature was adopted by the U. S. government as part of the M14 receiver. As an aside, Mathewson Tool Company later relocated to Orange, CT and was still in business as of March 1971. The following companies have manufactured scope mounts for the M14 type rifle: Accuracy Speaks, Atlantic Research Marketing Systems, Inc., Armscorp USA, B-Square, Brookfield Precision Tool, Entreprise Arms, Global Defense Initiatives, Inc., GG&G, Leatherwood Brothers, Marstar Canada, McCann Industries, ProMag, S&K Manufacturing Co., Sadlak Industries, Smith Enterprise, Inc., Springfield Armory, Inc., Talbot, US Tactical Systems and XTA.

Brookfield Precision Tool, GG&G, Leatherwood Brothers, and Smith Enterprise mounts have been used by the U. S. military on M14 type rifles. GG&G made M14 scope mounts for the U. S. Marine Corps for its M14 DMR. Picatinny Arsenal conducted a study on the difficulties of mounting a scope on the M14 rifle. The U. S. Naval Surface Warfare Center (Crane, IN) also worked on the issue. Scope mount adapters were made for the AN/PAS-4 and AN/PVS-1, -2, and -3 night scopes (NSN 5855-00-941-3036) by GPC Night Vision (CAGE Code 1YE66) and the AN/PVS-4 night scope by Brookfield Precision Tool. The scope mount adapter was issued as part of the AN/PAS-4 sight.

Side Single Point Scope Mounts

The first commercial M14 rifle scope mount was offered by Pete Michaels from 1971 to 1974. This side single point scope mount was a quality copy of the Rock Island Arsenal model used on the M14 NM rifles in the Republic of Viet Nam. There were two versions of this reproduction item. Both versions had horizontal and vertical keys. One version had a clearance undercut at the top of the vertical exterior surface like the Rock Island Arsenal unit. The other copy lacked the clearance undercut.

S&K Manufacturing Co. (then in Pittsfield, PA and now known as S&K Scope Mounts) started producing scope mounts for surplus military rifles in the mid-1960s. It introduced one of the first commercial production M14 scope mount in late 1974. It was of the side single point design. The S&K mount was made from two black anodized pieces of machined 2024 alloy aluminum. The top piece was screwed to the side piece. The top portion of the mount had two blued finish split 1 " scope rings secured by set screws. The rings and screws were made from steel. The S&K scope mount attached to the M14 type receiver by one thumbscrew and alignment ribs.

Side single point design scope mounts like the Bassett Machine, Israeli Military Industries, S&K # 1765 and Springfield Armory, Inc. First Generation models, attach to the receiver left hand side using the only bolt hole, with alignment-theoretically at least-assured through firm contact with the receiver's horizontal and vertical grooves. These mounts do not require removal of the stripper clip guide, while the others mounts do. The Bassett Machine and Springfield Armory, Inc. mounts are made of aluminum, though the Bassett Machine model differs in having hardened steel keys to mate with the receiver grooves. The Bassett Machine scope mount accepts Weaver style rings. The Springfield Armory, Inc. First Generation scope mount was first advertised in the February 01, 1975 issue of *Shotgun News*. Early Leatherwood Brothers scope mounts were made of aluminum and

used a single point of contact to the receiver on the XM21 rifles.

Side Two Point Scope Mounts

The side two point design scope mount uses the receiver bolt hole and the stripper clip guide to secure the mount. The stripper clip guide must be removed before this type of scope mount can be installed. B-Square, Leapers, Inc., Marstar Canada, McCann Industries, Springfield Armory, Inc. Third Generation, T T International, XTA and latter military issue Leatherwood Brothers mounts mount on the side of the receiver at two points. The U. S. Army armorers installed side two point Leatherwood scope mounts on M21 rifles.

The Leapers, Inc. scope mount (Model # MNT914) is made from aircraft grade alloy aluminum and utilizes a Weaver rail. The iron sights can be used with the scope mount installed. The XTA alloy aluminum scope mount (catalog number M14SM) utilizes a Weaver rail. This scope mount is marketed by John Masen Company.

Beginning in 2006, Marstar Canada marketed the M-14 Deluxe Tactical Scope Mount. This is an alloy aluminum scope mount designed and manufactured in Canada for Marstar. This CNC machined scope mount uses a substitute stripper clip guide made of carbon steel. It has horizontal and vertical receiver keys and a Weaver style rail. The McCann Industries M1A/M-14 mount is made of steel and is supplied with two Weaver style ring bases. An optional full length M1913 Picatinny rail is interchangeable with the Weaver style ring bases on the McCann Industries mount. The T T International model TSA scope mount is made of hardened steel with a M1913 Picatinny rail.

The rifle iron sights can be used up to about an elevation of 200 meters with a Springfield Armory, Inc. scope mount. At higher elevation settings the mount will block the shooter's vision through the rear sight aperture. The Springfield Armory, Inc. Third Generation mount uses a supplied substitute guide that replaces the stripper clip guide. It was designed and first manufactured some time between 1975 and 1990. The Springfield Armory, Inc. Third Generations scope mount is marked on the side as follows: top line - SPRINGFIELD ARMORY bottom line - Geneseo, Illinois.

Side Three Point Scope Mounts

Mounts that have three points of contact with the receiver are the most reliable for keeping the scope zeroed under all conditions, including removal and re-mounting on the receiver. This type of scope mount contacts the M14 type receiver at the scope mount lug on the left side, at the stripper clip guide and on top of the barrel ring.

Commercial M14 manufacturers do not and never have guaranteed that their receivers meet the dimensional tolerances of USGI M14 receiver drawing 7790189. Therefore, slight dimensional differences exist between USGI and commercial manufacture M14 receivers. On the other hand, several, but not all, manufacturers have designed their scope mounts to fit USGI M14 receivers without making any accommodation for commercial manufacture receivers. The bottom line for shooters wishing to use a scope sight on an M14 type rifle is that side three point scope mounts do not always fit hand-to-glove on all M14 type receivers. This scope mount style is very popular among M14 rifle enthusiasts. Several models are described below.

Brookfield Precision Tool - The Brookfield Precision Tool mount was developed by Mitch Mateiko. He made the first scope mount in his work shop at home out of steel and subsequently always used steel for the scope mounts. The Brookfield Precision Tool scope mount sits on the military XM25 and M25 rifles. It was sold in the commercial market for a number of years. Brookfield Precision Tool scope mounts and other parts now command a premium due to the collector value. The Brookfield Precision Tool mount allows the shooter to use the rifle's iron sights with or without the scope installed. It is a M1913 Picatinny style rail with a cam type mounting bolt designed to fit all four makes of USGI M14 receivers. Brookfield Precision Tool scope mounts are marked as following on the side:

BKFLD PREC TL U S PROPERTY

One small production batch of Brookfield Precision Tool M14 scope mounts were marked with PATENT PENDING on the mounting bolt side.

Smith Enterprise, Inc. - Smith Enterprise scope mounts are made from nitrocarburized AISI 4140 alloy steel. Their surface hardness is 60 to 62 HRC and they have a matte black finish. As of 2003, the Smith Enterprise MIL-STD-1913 Picatinny rail tactical scope mount was stocked in the U. S. military supply system. This mount allows the shooter to use the iron sights with or without the scope installed. It is in use by the U. S. Army 25th Infantry Division and the U. S. Navy. On September 28, 2005, Smith Enterprise was awarded a contract by the U. S. Army 101st Airborne Division to supply deploying units with this scope mount along with its 30 mm heavy duty scope rings and Leupold & Stevens, Inc. 3.5-10X 40 mm scopes to deploying units. This scope mount is marked

NSN 5855-01-506-5750 U. S. PROPERTY

It is manufactured using the wire electro-discharge machining (EDM) method. EDM can be described as spark erosion of metals by local heating and melting. This metalworking method holds very tight tolerances and leaves burr free surfaces.

In April 2005, Smith Enterprise made available a 7 " rail length version of its wire EDM manufactured scope mount to the U. S. Air Force and U. S. Marine Corps. This scope mount was assigned the National Stock Number 1005-01-533-8160 on September 28, 2005 by the Defense Supply Center - Columbus. This scope mount is marked Smith Ent. "Crazy Horse" MIL STD 1913 United States Property NSN 1005-01-533-8160.

In April 2006, Smith Enterprise, Inc. introduced its Trijicon, Inc. ACOG compatible scope mount for the M14 rifle. This mount is made by the wire EDM manufacturing method. The material is AISI 4140 alloy steel. It is marked with the following information:

US PROPERTY SMITH ENT NSN 1005-01-535-4430

The advantage of this scope mount is the detachable MIL-STD-1913 Picatinny rail. The user can quickly swap a traditional rifle daylight scope for a Trijicon, Inc. ACOG scope. There is no loss of zero when the daylight scope is reinstalled. The detachable rail is removed and installed by loosening or tightening the bolts with a t-shape handle hex head wrench.

Smith Enterprise's earlier M14 scope mounts were made using conventional machining methods but are nonetheless just as trouble-free and durable. The older model Smith Enterprise rail scope mounts were produced in two versions, Weaver style rail and MIL-STD-1913 rail. This earlier MIL-STD-1913 version was sold to the U. S. Army in the late 1980s and 1990s. These scope mounts were marked

SMITH ENTERPRISE. TEMPE. AZ M21

The older Smith Enterprise Weaver style rail mounts were manufactured in 1994. These mounts were marked SMITH ENT. XM-21. This scope mount was reintroduced in 2006 as part number 2024 with the marking

SMITH ENT. M-21.

Both Weaver style rail mounts were made using conventional machining methods.

The Smith Enterprise scope mount has a three degree upward slope on the under side of the rail, just above the rifle's bolt. This allows ejected brass to clear the action while minimizing any contact with the mount because of varying receiver geometries among the manufacturers. This mount utilizes a cam type mounting bolt to compensate for the differing position of the bolt hole on various makes of rifles. For demonstration purposes only, Ron Smith installed a Smith Enterprise scope mount on a commercial manufacture M14 type receiver and torqued the receiver mounting bolt in increments to 140 in-lb. There was absolutely no damage to the bolt, mount or receiver. In field use, 65 in-lb of torque is sufficient for installing any scope mount. Installation instructions are included with every scope mount sold by Smith Enterprise. The mount installation instructions are also posted at its web site. Smith Enterprise will custom fit its M14 scope mounts to customer supplied commercial M14 type receivers.

Armscorp USA - The Armscorp USA M14 scope mount is a very faithful copy of the milestone Brookfield Precision Tool mount. It is machined from steel and heat treated to U. S. military specifications. It has an adjustable cam bolt. The iron sights can be used with this mount installed without removing the scope. The Armscorp USA side three point scope mount is marked as follows on the side

ARMSCORP U.S. PROPERTY

Atlantic Research Marketing Systems, Inc. – Atlantic Research Marketing Systems (CAGE Code 0FBA6) was established by Dick Swan. His 1983 dovetail style rail design for mounting firearm optical sights was adopted by the U. S. Army Picatinny Arsenal in 1995 as the Mil-Std 1913 Rail. Mil-Std is an abbreviation for Military Standard. This rail mount design is referred to as the M1913 Picatinny rail. Atlantic Research Marketing Systems produces a variety of optical sight mounting rails.

Its # 18 mount is designed for use on the M14 type rifle. The # 18 mount has been made in two versions. The early style was first introduced to the commercial market in 1989. It has two base pads, one at each end, for mounting the scope rings. A few of the early style mounts have an integral stripper clip guide in the rear pad, useful only when the mount is installed on the receiver without a scope installed.

Introduced in 2003, the new style # 18 mount has a full-length rail running from the

stripper clip guide dovetail to the top of the barrel ring. The new style # 18 mount has similar markings as the early style unit. Both models are M1913 Picatinny style rails. Both versions are marked as follows on the side below the bolt: first line - A.R.M.S. M21/ M14 W.B. MA. 98 second line – NSN 1240-01-316-0055. There are four additional markings above the bolt: company logo, registered trademark indicator, 18 and SWAN. The new style # 18 is made of case hardened AISI 8620 alloy steel.

The # 18 scope mount sits low enough on the receiver to allow use of the iron sights if the scope is removed. It sits the lowest over the rifle's bore of any scope mount available. Due to differences in commercial receiver geometry the user may find that a little judicious removal of metal at the underside corner of the mount's front end may be necessary to get a # 18 mount to fit perfectly. The # 20 throw lever mount is used to attach an AN/PVS-4 night vision scope to a Weaver style rail scope mount.

Sadlak Industries - Since 2002, Sadlak Industries has made M14 scope mounts. This company offers its M1913 Picatinny style rail scope mounts manufactured from two different materials, titanium and steel. Its titanium scope mounts are machined from hot rolled billet and then heat treated to a hardness of 26 to 30 HRC. From 2002 to 2006, the titanium scope mounts were made from two alloys of hot rolled titanium billet: 1) 6 % aluminum 4 % vanadium 89 % titanium 2) 6 % aluminum 5 % vanadium 2 % tin 87 % titanium. After heat treatment, the titanium mounts are finished with a matte black nitride coating for improved corrosion and abrasion resistance. This coating increases the surface hardness to approximately 80 HRC. The Sadlak titanium scope mount is tougher and stronger than steel but is substantially lighter. A Sadlak Industries titanium M14 scope mount made in 2004 was marked

SADLAK INDUST. LLC COVENTRY CT USA M14 T-02

Before 2005, the manufacturer information was located on the right side of the mount. From 2005 and onward, the marking is indicated on the left hand side of the mount. Scope mounts are coded by a single letter prefix and a two digit number, e.g., S03. T stands for titanium and S for steel. The number means the blueprint revision for the scope mount made from the material denoted by the letter, e.g., S or T. There are slight changes between blueprint revisions. As an example, T-02 scope mounts have a two degree relief angle under the horizontal surface. T-03 scope mounts will have a five degree relief angle under the horizontal surface.

Sadlak's steel scope mounts are made from stress relieved AISI 4142 bar stock with a core hardness of 28 to 32 HRC. The steel mounts are given a military specification manganese phosphate coating. A Sadlak Industries steel scope mount made in 2006 was marked: top line - SADLAK INDUSTRIES LLC M14 RIFLE Steel middle line - COVENTRY CT bottom line - USA.

A 7075 alloy aluminum-magnesium-zinc version of its M14 scope mount was in testing in November 2004. This alloy is commonly used to fabricate aircraft frames. The 7075 alloy M14 scope mount is fully machined and hard coat anodized. It became available in early 2005. In early 2006, Sadlak Industries produced a small batch of anodized gray 7075 alloy scope mounts. Otherwise, the 7075 alloy models have been anodized black.

The Sadlak Industries M14 scope mount is based on the Brookfield Precision Tool model. Sadlak Industries incorporated some new enhancements to its M14 scope mount in late 2004. Two setscrews securely hold the wider adjustable dovetail piece (clip guide key) to the rifle's receiver, to keep it from loosening. The rear end of the scope mount has cutouts to allow wrench access to the dovetail setscrews. The dovetail setscrews securely lock the dovetail piece (clip guide key) into the receiver. The scope mount hole for the adjustable dovetail piece (clip guide) screw has been machined with an oval slot and a larger counterbore to make it more easily compatible with non-USGI receivers. The front post screw size has also been increased for a larger contact area with the receiver barrel ring. The front screw has also been changed from a ¼ " x 28 fine thread to a 5/16 " x 24 fine thread. The new size front screw reduces the number of hex head wrenches from three to two. The front screw and the dovetail key socket screw now both use the same size hex head wrench. 2006 production scope mount weights were 7.258 ounces (alloy titanium), 11.113 ounces (4142 alloy) and 4.331 ounces (7075 alloy).

The original alpha-titanium-carbon-nitride coating used on the titanium model was not always as consistent in color as desired. Sadlak Industries, LLC does not compromise on its quality control. So, those off-color mounts have been rejected even though all other inspections were satisfactory. Unfortunately, the rejection rate due to improper color only was unacceptably high. Consequently, as of late 2004, Sadlak Industries was testing a second and more color consistent matte black nitride coating as well as a tungsten coating for the titanium M14 scope mounts. The tungsten coating is even more durable than the nitride coating and has a slight greenish-gray phosphate coloring reminiscent of older military weapons. The tungsten coating was so successful that the black nitride coating for titanium scope mounts was discontinued in 2005.

Beginning in early 2005, a five degree relief angle is machined into the bottom of its scope mounts to minimize interference from spent cases in rifles with worn ejector springs. Sadlak Industries produced in March 2005 a single batch of six tungsten coated version S03 steel scope mounts. In April 2005, Sadlak Industries started a custom scope mount fitting service to accommodate non-USGI dimension receivers and / or allow for elevation adjustment. At the end of September 2005, Sadlak Industries filled a request from the U. S. Army for ninety-eight steel M14 scope mounts.

Entreprise Arms - This is a Weaver style rail scope mount. It is machined from AISI 4140 alloy steel. The Entreprise Arms web site lists this mount in two lengths, standard and extended. This mount allows the shooter to use the iron sights with or without the scope installed. The Entreprise Arms M14 scope mounts have a military specification phosphate finish.

Global Defense Initiatives, Inc. – By no later than 2003, Global Defensive Initiatives, Inc. designed and produced a side three point mount that differed somewhat from the classic Brookfield Precision Tool design. Its G1 Optical Sight Mount did not allow the use of iron sights with the scope removed. However, the M1913 Picatinny rail extended rearward to a point just behind the rear sight aperture. The rear sight assembly stayed in place with the mount installed. The G1 Optical Sight Mount accommodated an optical sight requiring very short eye relief between the shooter and the ocular lens. The G1 Optical

Scope Mount was made from 17-4 precipitation hardening stainless steel and finished with a black oxide coating.

Leatherwood Brothers, McCann Industries and Talbot – Leatherwood Brothers began advertising its new side three point rail mount in *Shotgun News* in 2004. All parts are made from steel. This mount allows the use of iron sights and is adjustable for windage. It will accept M1913 Picatinny style scope rings. Leatherwood Brothers began shipping its mount to customers in June 2004. The McCann Industries MITS mount is a side three point design unit for the M14 type rifle. Installation requires gunsmithing. A traditional design M14 bolt lock should be used in conjunction with the MITS scope mount as it may interfere with an extended bolt lock. The Talbot steel scope mount for the M14/M1A uses an optic mounting surface and quick detach combination dual ring and rail assembly that is common to the firm's many models of scope mounts. Various interchangeable dual ring and rail assemblies are available for the Talbot family of scope mounts. Talbot also offers a dual ring and rail assembly for M1913 Picatinny rail scope mounts.

Keng's Firearms Specialty, ProMag and US Tactical Systems - These are moderately priced side three point mounts for the M14 type rifle. The Keng's Firearms Specialty unit has a M1913 Picatinny rail. ProMag offers a steel M1913 Picatinny rail scope mount. It has a matte black finish and the iron sights can be used at or below the 100 meter setting with the scope attached. The US Tactical Systems model has a Weaver style rail and is made from AISI 4140 alloy steel. It is heat treated and has a black color nitride surface finish. With the scope removed, the iron sights can be used with all of these mounts installed on the rifle.

Unertl Optical Company - In the summer of 2006, Unertl developed two prototype design M14 scope mounts. Both mounts were improved versions of the basic Brookfield Precision Tool design. Both models were made from alloy steel and had forward and rear M1913 Picatinny rail pads. The shorter of the two prototypes was about 6 " long. The rail pads had four slots each with the rear rail pad extending approximately 3/4 " past the front edge of the rear sight cover. The longer scope mount had an overall length of about 7 " with six front slots and two rear slots. The front rail pad of the longer mount reaches 2 " past the receiver barrel ring. This version better accommodates dot sight optics and scopes greater than 10X magnification. The open space between the two rail pads was designed to avoid stovepiping of spent cases. Both prototype scope mounts were marked on the left side UNERTL ORDNANCE with the company logo to the right of the lettering. Availability was expected for the end of 2006.

Side Three Point Scope Mount Fitting on Commercial M14 Receivers

There are five points of contact between the side three point scope mount and the rifle's receiver that may cause improper fit up with military design side three point scope mounts when installed on commercial M14 receivers. The surface contact between the left side of the scope mount and the left side of the receiver is of primary importance. The more contact between these two surfaces the less likely the mount is to shift from firing recoil. The scope mount should be tested first for fit without the stripper clip guide dovetail key supplied with the mount.

Receiver Bolt Hole - The USGI M14 receiver drawing 7790189 specifies a distance of 1.500 " + or - 0.003 " for the distance between the bolt hole centerline and the front vertical edge of the barrel ring. If the bolt hole is drilled too far to the rear, the rear of the scope mount may contact the receiver stripper clip guide dovetail. This lifts the back of the mount so the mount horizontal key doesn't fully seat in the receiver horizontal groove. Consequently, the mount is moved left or right, and usually also down, at the front end. The rifle is then likely to shoot high and/or to one side. Furthermore, some bolt holes are undersized because the maker used worn out reamers, or the bolt holes may not be drilled perfectly perpendicular to the receiver wall. A very few commercial receivers lack the scope mount recoil lug or bolt hole.

Receiver Horizontal Groove - The height, angle and width of the horizontal groove affect the fit of side three point scope mounts to M14 type receivers. Some commercial receivers have horizontal grooves too shallow and narrow to accommodate military specification mounts such as the Armscorp USA, Brookfield Precision Tool and Sadlak Industries models. A 2002 manufacture commercial M14 type receiver examined by Sadlak Industries, LLC in December 2004 is a representative case study of the mismatch between commercial receivers and military dimension scope mounts. The receiver horizontal groove of this particular 2002 manufacture commercial receiver measured 0.048 " deep, 0.080 " wide at the bottom and 0.134 " wide at the top.

The width at the top of the receiver horizontal groove should be 0.0149 " to 0.153 " by calculation based on the sixty degree angle and groove bottom width dimension as specified in the USGI drawing number 7790189. The bottom of the horizontal groove is required to be 0.070 " to 0.078 " wide according to the USGI drawing number 7790189. The horizontal groove should be 0.062 " to 0.072 " deep by calculation. Commercial M14 receiver horizontal grooves have been measured as narrow as 0.120 " at the top of the groove.

Receiver Barrel Ring - The top front left hand corner of the receiver barrel ring may interfere with the new style Atlantic Research Marketing Systems # 18 mount. This is no fault of Atlantic Research Marketing Systems, Inc. as its mount was designed to fit on USGI M14 receivers.

Receiver Stripper Clip Guide Dovetail - The receiver stripper clip guide dovetail may be machined such that the scope mount adjustable dovetail key will not slide in from the side of the bolt hole, but may do so from the operating rod side. The height of the stripper clip guide dovetail may also be tall enough to push up on the rear end of the scope mount. The stripper clip guide dovetail has been found to be as much as 0.030 " taller than USGI specification.

Barrel Hand Guard - The Atlantic Research Marketing Systems # 18 front rail pad setscrew may contact the hand guard. This can be remedied by replacing the mount's front setscrew with one that fits flush with the pad. Again, this is no fault of Atlantic Research Marketing Systems, Inc. Commercial M14 type receivers are not always machined to the USGI drawing 7790189 dimensions.

Smith Enterprise, Inc. states that it has found as much as 0.010 " variance in a 3 "

distance on USGI M14 receivers. In the 1990s, the U. S. Marine Corps and U. S. Navy had great success with the Brookfield Precision Tool scope mounts. However, the U. S. Marine Corps found that the location of mount bolt holes on Harrington & Richardson M14 receivers adversely affected mount alignment to require excessive windage adjustment to zero the scopes. The U. S. Marine Corps had no such problems with the Winchester M14 rifle receivers.

Scope Mounts Secured to the Rear Sight Pocket

In 1985, Smith Enterprise designed and produced pre-production units of two models of longer side three point scope mounts. Both were 9.250 " long. The rear end of both models mounted to the rifle's rear sight pocket, requiring removal of the rear sight assembly. The front end of the mount rail extended past the receiver barrel ring. One mount was TIG welded to the receiver, while the other was bolted on at the rear sight pocket through the sight knob holes. The heads of the bolts for the rear sight pocket were the same diameter as the sight knobs. The project was not pursued since it was found that the market in 1985 was not ready for this new style of scope mount.

In years past, Atlantic Research Marketing Systems, Inc. marketed its M-14/M-1A Rigid Rail Mount. This mount had a ring at the front end that fit around the barrel just forward of the receiver barrel ring. The rear end of the mount fit inside the rear sight pocket and was secured by a bolt through the sight knob holes. The Atlantic Research Marketing Systems M-14/M-1A Rigid Rail Mount had a M1913 Picatinny rail and was offered in two choices of material construction and three differing lengths. The material was either phosphate coated AISI 4140 alloy steel or an aluminum rail with steel barrel ring. The aluminum and steel model was hard coat anodized for the surface finish treatment. The mount was available in standard, extended front or extended rear lengths. The flash suppressor, gas system and operating rod guide had to be removed to install this scope mount. Installation of this scope mount should be done by a gunsmith familiar with the M14 type rifle.

The Springfield Armory, Inc. M25 and Accuracy Speaks, Inc. M1913 Picatinny rail scope mounts both attach to the rear sight pocket instead of the stripper clip guide dovetail and the barrel. The Accuracy Speaks mount will fit either the M1 Garand or M14 type rifle. This aluminum mount replaces the rear sight and firmly attaches to the barrel. Installation requires drilling and tapping the barrel and removal and modification of the hand guard.

In late 1997, Derrick Martin and Barrett Tillman conducted some accuracy testing of handloaded 175 grain .308 Winchester caliber ammunition in the Arizona desert. The test rifle was a modified and scoped Springfield Armory, Inc. M1A. This particular M1A was outfitted with a Douglas 1:10 twist bull barrel, a McMillan stock, a Harris bipod, and custom gas system. The test rifle had no iron sights. The rear sight assembly was displaced by the Accuracy Speaks, Inc. scope mount.

Rail System Mounts

Knight's Manufacturing Company (Titusville, FL) produces an M16 Carbine style rail system known as the M14 RAS. It is offered in two models. The rear end of the top rail for both models ends at the receiver barrel ring. The deluxe model has a rear scope

mount base that replaces the stripper clip guide. The standard model resembles the deluxe model, but without the rear scope mount base. This is a very solid mount and is easy to install. The rear end of the M14 RAS bolts to the receiver scope mount bolt hole. It will only fit rifles with standard contour barrels. The RAS' side ribbed accessory panels will interfere with a National Match oversized stock, but not USGI contour stocks. The M14 RAS is marked as follows on the right hand side from top to bottom: first line – KNIGHT'S ARMAMENT CO. second line – TITUSVILLE, FL third line – (321) 607-9900 fourth line – PN #22121. The company logo is just to the left of the text markings.

C. J. Weapons Accessories offers the Striker-14 M-14/M1A Tactical Rail System. This model uses three M1913 Picatinny rails, with the rear end of the top rail attaching to the stripper clip guide. The rifle's iron sights can be used with a scope installed. The Striker-14 unit attaches to the rifle at three points. It is CNC machined from a single piece of aluminum and has a black anodized finish. The Springfield Armory, Inc. M1A SOCOM II LE is fitted with the Vltor Weapons Systems CAS-14 rail system mount.

Barrel Rail Mounts

Springfield Armory, Inc. – Springfield Armory, Inc. offers a barrel scope mount for extended eye relief scopes. The M1A Scout Squad rifle is sold with this M1913 Picatinny rail barrel scope mount installed. Springfield Armory, Inc. also sells it separately. This mount is made of aluminum and attaches to a standard contour barrel using six 7/32 " hex head screws that secure the upper half to the lower half of the mount. Medium weight and heavyweight M14 barrels and M1 Garand barrels cannot accept this mount. Springfield Armory, Inc. offers the Scout Squad scope mount finished in a choice of black or brown.

Rooster33 - Rooster33 began producing and selling its own barrel scope mount in March 2004. It is made of steel and is also sized only for a lightweight (standard) contour M14 barrel. The Rooster33 black color 1 " long scope mount attaches to the barrel by four hex head bolts. It will accept either Weaver style or M1913 Picatinny style rings.

Amega Ranges, Inc. – In 2006, Amega Ranges offers a M1913 Picatinny rail barrel mount for the M14 type rifle. It is made of anodized black color 6005-T6 alloy aluminum. As of May 2006, two variants were available to fit USGI and Springfield Armory, Inc. standard contour M14 type barrels. This rail mount runs from the front end of the barrel ring to the front band. The Amega Range barrel rail mount is attached to the M14 type rifle with screws with no other modification required for installation.

Midwest Industries – Introduced in 2005, Midwest Industries manufactures an anodized aluminum dual M1913 Picatinny rail mount that attaches to the barrel over the gas cylinder. It is useful for attaching tactical lights or lasers. Any rail mount or bipod that is secured to the barrel may change the zero of the rifle barrel. The rifle should be sighted in and test fired to check for any change in accuracy after installation.

Ultimak - The Ultimak Model M8 scope mount is designed to attach to a USGI M14 standard contour barrel only. The M8 mount runs the length of the barrel from the receiver to the front band. The scope mount is a M1913 Picatinny style rail made of CNC machined 6061 T6 anodized alloy aluminum. No gunsmithing is required to install the

unit. The manganese phosphate coated AISI 4142 molybdenum-chromium alloy steel barrel clamps and recoil lug are secured to the barrel by hex head screws. Ultimak offered the M8 scope mount beginning in mid-2006.

Cleaning Kit

Springfield Armory developed and tested the cleaning kit for the M14 from 1958 until 1961, when the final version was fielded. The pre-1961 M14 cleaning kit consisted of the following items: a three piece combination tool (handle, wrench head, and plastic cap), separate oiler case and grease cup, chamber brush without or with a ratchet mechanism, four M3 cleaning rod sections, a 3 " swab holder, and a M1 Garand cleaning rod case. Before the combination tool was designed, a short 3/8 " box end wrench was included.

The 1961 USGI M14 cleaning kit consists of a single piece combination tool, a chamber brush, four M3 cleaning rod sections, bore brush, a 3.5 " swab holder, combination oil and grease lubricant case, a plastic spacer to separate the bore brush and swab holder, and a heavier canvas case for storing the rod sections, bore brush and swab holder. The small chamber of the lubricant case held grease. The large chamber was designed to store small arms lubricating oil known as LSA (Lubricant, Small Arms).

By no later than March 1961, Worden Specialty & Machine Tool won the first contract to manufacture the M14 combination tool. During the 1960s and into the early 1970s, there were several more government contracts awarded to produce the combination tool.

The M14 chamber brush is marked 7790463 on the bottom of the ratchet mechanism. M14 chamber brushes produced in 1959 and 1960 had white color ratchet mechanisms. The color of the ratchet mechanism was changed in 1961 to black. The M14 chamber brush is easily confused with the M1 Garand rifle and M60 machine gun chamber brushes. Unless it is an emergency, those brushes should not be used in the M14 type rifle. The M14 chamber brush was produced by no later than June 1960 for Harrington & Richardson. Either Mill-Rose (OH) or Better Brushes (OH) was probably the subcontractor to Harrington & Richardson for this item.

The M14E2 stock does not have a butt stock compartment like the M14 stock, so the M14A1 cleaning kit was placed inside an olive drab water repellent nylon pouch and carried on the combat web gear by the automatic rifleman. The M14A1 cleaning kit pouch has a single ALICE clip for attachment to the automatic rifleman's web belt. The 1968 production USGI M14E2 nylon pouch is marked on the inside of the flap as follows from top to bottom: first line – CASE, MAINTENANCE EQUIPMENT second line – SMALL ARMS, M-14E2 third line – DSA 100-68-C-1863 fourth line 0465-926-6768. Most of the cleaning kit pouches from the 1968 contract were sent to the U. S. military in the Republic of Viet Nam. The 1970 production M14A1 nylon pouch is marked on the inside of the flap as follows from top to bottom: first line – CASE, MAINTENANCE EQUIPMENT second line – SMALL ARMS, M-14-A1 third line DSA 100-70-O-1941 fourth line – 8465-926-6768 fifth line – LADY MAC CORSET CO, INC. The letters US appear on the outside of the pouch flap on both versions.

Otis Products, Inc. supplies a lightweight and compact cleaning kit for the M14 DMR and M240G machine gun to the U. S. military. The advantage of this cleaning kit design is the

ability to clean from the breech to the muzzle end.

In the civilian market, J. Dewey Manufacturing, Co. Inc. (Southbury, CT) makes a single piece nylon coated cleaning rod that helps the owner from scratching the bore. Creedmoor Sports offers a plastic breech block insert that allows bore cleaning while protecting the bolt and firing mechanism. Alternately, the bolt can be locked back while cleaning with an empty magazine inserted into the well or an empty stripper clip inserted into the receiver stripper guide. To quiet the rattle of the cleaning kit inside the butt stock place three .30 Caliber bore patches through the hex box end of the combination tool then stow it. Wayne Machine Inc. produces reproduction M14 chamber brushes. Sinclair International sells a Dewey Manufacturing M14 chamber brush with a hole drilled through the top ratchet portion. The advantage of this design is that it allows for a two handed pull to remove the brush from the chamber.

USGI Tools

An assortment of maintenance tools was made for the USGI M14 rifle. The carrying case for the armorer's kit was a maple wooden box with internal cutouts for each tool. The armorer's kit carrying case design was modified in 1962 by adding a storage compartment for the flash suppressor alignment tool. The cost to the military in 1988 for a M14 armorer's field service tool kit was approximately \$375.00. All USGI M14 flash suppressor nut pliers were made during one production run in 1962. Smith Enterprise, Inc. supplied combination gas cylinder lock front sight wrenches beginning in August 2005 to the U. S. Army, U. S. Navy and U. S. Air Force as a maintenance tool for the Mk 14 variant and M14SE rifles. These wrenches were made of 7075 T6 alloy aluminum-magnesium-zinc (SEI part number 2017). The wrenches are marked as follows: first line – SMITH ENT second line has the Smith Enterprise, Inc. trademark name for the M14SE system and the third line – M14.

The 7.62 mm NATO ruptured cartridge case extractor was an improvement over the .30 Caliber model used for the M1 Garand rifle and the M1919 machine gun. The 7.62 mm NATO model is designed to be pushed out of the barrel chamber using a cleaning rod. The .30 Caliber ruptured cartridge case extractor often had claws broken when used. The 7.62 mm NATO ruptured cartridge case extractor was used for the M1918 series Browning Automatic Rifle, the M1 Garand and M14 rifles, and the M60 machine gun.

The M14 combination tool is very handy. The USGI M14 combination tool is marked: first line - COMBINATION TOOL second line - 7790769. The handle of the combination tool also holds the chamber brush and protects its bristles while stowed in the butt stock. The following tasks can be performed with this tool:

1. Tighten or loosen the gas cylinder plug
2. Tighten and loosen the rear sight knob screws
3. Remove or install the butt plate screws
4. Remove or install the muzzle stabilizer
5. Remove or install the M2 bipod
6. Act as a handle for the cleaning kit rod
7. Disassemble and assemble the bolt

8. Operate the spindle valve
9. Push cartridges from a stripper into the magazine
10. Disengage the connector lock from the operating rod spring guide for disassembly
11. Clean carbon fouling from the gas piston grooves with the screwdriver blade
12. For emergency purposes, tighten or loosen the hex head bolt of the Atlantic Marketing Research Systems, Inc. # 18, Bassett Machine, Sadlak Industries, LLC and Smith Enterprise, Inc. scope mounts.

Operator level tools – cleaning kit

Organizational level tools – cotton cleaning patch, fabric envelope, barrel reflector, ruptured cartridge case extractor, flash suppressor alignment tool, flash suppressor nut pliers. A set of nine headspace gauges, sizes 1.630 " to 1.638 " is authorized as part of the M14 DMR Organizational and Intermediate Maintenance Special Tools and Equipment.

Direct Support level tools – armorer's kit (firing pin protrusion gage, bolt roller retaining ring pliers, gas cylinder piston hole NOT-GO gage, gas piston diameter NOT-GO gage, breechbore field reject gage, FIELD REJECT headspace gage, field test bolt, firing pin hole gage, and wooden case), flash suppressor alignment tool, and 7/64 " hex head L-shaped wrench. The bolt roller retaining ring pliers are marked 762 MM M14 FIELD SERVICE on one handle and 7799723 (A1) US GOVT INSP on the other handle.

Depot Maintenance (General Support) level tools – Depot kit (GO, 1.6375 " and NO GO headspace gages, headspace reamer assembly with crank handle, bolt assembly and disassembly tool, barrel and receiver disassembling fixture, firing mechanism assembling fixture, bolt and roller grease fitting adapter, gas port alignment gage, bore straightness gage, targeting jack gage, butt stock holes to butt plate GO gage, and torque testing gage). The bolt assembly and disassembly tool is marked 7791607 M14 M1.

Commercially Available Tools

Commercial .308 headspace gauges can be used in lieu of the military 7.62 x 51 mm gauges, but lack of a clearance cut for the ejector requires that the bolt must be disassembled to use them. Throat erosion and muzzle wear gauges are available from Brownells, Inc., Shooters Den and Stone Axe Engineering. Twist drill bits (sizes P and 15) can be used by hand to remove carbon buildup inside the gas cylinder plug and gas piston. A 1/16 " hex head wrench is used for the flash suppressor setscrew. A 7/64 " hex head wrench will fit the front sight screw and Springfield Armory, Inc. Scout Squad forward scope mount screws. USGI early version and some commercial manufacture front sight screws will take a 3/32 " hex head wrench instead. A 3/32 " pin punch is useful in removing the stripper clip guide pin and the magazine latch pin. To install the selector switch use a 1/16 " pin punch to drive the roll pin out of the selector lock. Wayne Machine Inc. has produced reproduction ruptured cartridge case extractors and flash suppressor nut pliers. The tools necessary to remove and install a barrel are available from Brownells, Inc. Badger Ordnance produces a gas cylinder-to-barrel gas port alignment gage, a stock liner screw wrench, hand guard clip pliers and two models of bolt roller greasers.

Fulton Armory offers an anodized alloy aluminum gas cylinder lock wrench. Sherluk markets a carbon steel gas cylinder lock wrench. Sadlak Industries, LLC manufactures CNC machined alloy aluminum and carbon steel gas cylinder lock wrenches, a scope mount hole thread chase tool and a scope mount hole repair tap. Commercial reproduction gas cylinder locks are slightly wider than USGI and Chinese gas cylinder locks. Consequently, some gas cylinder lock wrenches, as manufactured, will not fit commercial reproduction gas cylinder locks.

USGI Accessories

A number of accessories supported the various roles filled by the M14 rifle. These included the M2 bipod, M3 breech shield, M5 winter trigger assembly with or without safety, M6 bayonet with M8A1 scabbard, M12 blank firing attachment, M15 grenade launcher sight, M76 grenade launcher, M151 vehicle rifle mounting kit, M2 aiming device, bandoleer kit (stripper clip charging guide, stripper clips, cardboard sleeves and canvas carrier), empty chamber indicator, front and rear sight and operating rod protectors, Mk 87 Mod 1 line (rope) throwing kit, sling (M1907 leather, canvas web, hard nylon weave, and soft nylon weave), and a watertight aluminum carrying case for the XM21 ART scope. The winter trigger is marked WINTER TRIGGER M5 on one side and 7790808 on the other. The XM152 winter trigger kit was available for the M14A1.

The mounting kit for the M151 vehicle secured the M14 rifle vertically on the front passenger side. The major parts of the kit, butt socket, upper support bracket and spring loaded clamping bar, were coated with plastic to protect the rifle. By 1969, the butt socket was redesigned to fit both M14 and M16 rifles. The mounting kit was also installed on U. S. Army helicopters assigned to combat operations in the Republic of Viet Nam. The rear sight protector was marked by the part number 7791358 on the top surface. The M2 aiming device was made by Weaver Manufacturing, S. I. Howard Glass Co., and a third contractor. Only the Weaver Manufacturing contract aiming devices had a marking, WEAVER B174999.

There were two models of the ART scope and mount carrying case for the XM21/M21. Both versions of the ART scope and mount carrying case were waterproof. The case lids were fitted with a gasket or seal to protect the scope from moisture or immersion. Both versions of the case also had rubber cushions to protect the scope against physical shock. The first carrying case, used during the Viet Nam war, was made of 6061-T6 alloy aluminum and painted olive drab. The first version carrying cases were made by Frankford Arsenal beginning in 1968. It attached to the load bearing equipment belt by use of a single ALICE clip. The second version of the carrying case was made of green color fiberglass and issued with the ART II scopes. The fiberglass carrying case was secured to the user by looping the load bearing belt through the case canvas strap. The AN/PVS-2 carrying case was made of waterproof fiber reinforced neoprene. It had two ALICE belt clips and tie down straps.

Slings - Some canvas slings have a MRT (Mildew Resistant Treatment) and date stamp on the metal tip, such as 4 64. The last USGI canvas web slings were made about 1966. It was known as the M1 Gun Sling. Subsequent slings have a different National Stock Number and are known as Small Arms Slings. The hard nylon weave sling was

introduced in 1969. The first soft nylon weave sling was produced for the U. S. Navy about 1973. The hard nylon weave sling had cadmium plated fittings. The soft weave nylon sling had cadmium plated fittings as well until the 1990s. In recent years the soft nylon weave sling has been made with phosphate coated fittings. The M1 Gun and Small Arms Slings have a metal clamp designed to attach to the stock rear sling swivel. The free end is looped through the stock front sling swivel then secured in the sling keeper. The M14E2 sling was made of canvas and longer than the standard small arms sling. It had two clamps instead of one. The clamps attached to the M2 bipod sling swivel and the M14E2 vertical fore grip.

The M1907 leather sling was issued with the M14 NM, XM21 and M21 rifles. The M1907 leather sling is marked MRT and some have a date code. M14SE system leather slings are marked as follows: first line has the Smith Enterprise, Inc. trademark name for the M14SE system second line – SMITH ENT. third line – M-14 fourth line M-118 LR. A Defense acceptance stamp is centered between the second and third lines.

Bayonet - The M6 bayonet (NSN 1095-00-722-3097) was used for close combat, guard duty, riot duty, and as a general utility knife. The final production drawing for the M6 is dated January 24, 1955. Thus, the T12 bayonet was developed and adopted as the M6 bayonet even before adoption of the M14 rifle in May 1957. Initially, the decision was made that there would be no bayonet issued for the M14 rifle. So, the M6 bayonet was not produced in significant numbers until 1961. Eventually, 1,633,000 M6 bayonets were delivered to the U. S. Army between July 1961 and February 1969. Aerial Cutlery, Imperial Knife, and Columbus Milpar and Manufacturing Company all made M6 bayonets. Imperial Knife made the most M6 bayonets of the three contractors and Aerial Cutlery made the fewest. Beware that there are commercial reproduction M6 style bayonets marked AERIAL.

Out of the packaging, the blade bevel angle on Columbus Milpar and Manufacturing Company M6 bayonets typically requires more stoning to hone the edge than the other two M6 bayonet manufacturers. The bayonet blade material is AISI 1080 high carbon steel and the grip is made of molded plastic. Its weight is 12 ounces. The overall length is 11.51 " with a blade length of 6.75 ". The bayonet is designed to be loose when attached to the M14 rifle in an effort to minimize its effect on the bullet point of impact. The internal parts of the M6 bayonet are interchangeable with the M5 bayonet which is used on the M1 Garand rifle.

Is Your Bayonet Combat Ready? - The U. S. Army maintenance inspection for the M6 and M7 bayonets required soldiers to check the following: 1) handle latches had to snap back when depressed and lock the bayonet securely to the rifle 2) no rust or corrosion allowed on the metal 3) no nicks in the blade edges 4) misalignment between the blade and the handle could not exceed 3/16 " 5) the bayonet hand guard was allowed to be slightly loose.

Scabbard - One manufacturer of the M8A1 scabbard (NSN 1095-00-508-0339) was Victory Plastics Company (Hudson, MA). Victory Plastics produced M8A1 scabbards in 1953 (for the M1 Garand rifle) and in 1961. Its 1961 production scabbards have the metal tip protector while those made in 1953 do not. The metal tip protector was added to

scabbards made after 1955. The phosphate coating on the 1961 scabbards is lighter gray and more granular than on the 1953 scabbards, and the webbing is a darker green with a lighter sewing thread. Viz Manufacturing had a contract in 1967 to produce M8A1 scabbards. Another contractor was Pennsylvania Working Home for the Blind who made M8A1 scabbards between 1966 and 1968. Scabbards made by Pennsylvania Working Home for the Blind in the 1970s are marked TWB because the business's name was changed to The Working Blind. Eichorn-Solingen in Germany manufactured M8A1 scabbards for the government of Denmark with both British and U. S. compatible belt attachments, although they were never U. S. Government Issue. Eichorn-Solingen M8A1 scabbards did not have the metal tip protector.

Magazine Pouches and Bandoleer Kits - Magazines were carried in pouches attached to the USGI web belt. Early made pouches were made of canvas and held one twenty round magazine. Later-made pouches were made of canvas, then nylon, and each held two twenty round magazines. The M14 bandoleer will hold twelve stripper clips, two clips in each of six pockets. Each stripper clip will hold five rounds of ammunition, for a total of sixty rounds. There may be an exception, but as a general rule the U. S. never placed a date code on M14 stripper clips. Ammunition could be manufactured several years apart from the stripper clip so there would be no benefit in date coding the stripper clips. USGI M14 stripper clips will have one nib on each side. .30 Caliber stripper clips with two or three nibs on either side were not manufactured for the M14 Rifle.

Grenade Launcher Sight - The M15 grenade launcher sight was used on the M1903 Springfield and M1 Garand rifles and carried over to the M14. The M15 sight base was mounted to the M14 stock on the left hand side with two wood screws. The M15 sight could be installed or removed quickly from the sight base by the grenadier. A canvas pouch that attached to the web belt was used to carry the M15 sight and instruction sheet.

Blank Firing Attachment - The M12 blank firing attachment (BFA) was issued to the individual soldier for training purposes, along with the M3 breech shield. The M12 blank firing attachment is a simple device used to operate the M14 rifle for training purposes without sending bullets down range. It is a metal stem that is long enough to enter the barrel a short distance from the muzzle end of the flash suppressor. The metal stem is hollow so that gunpowder residue and gas from the fired M82 blank cartridge is restricted as it flows out of the barrel. The flow restriction of propellant gas creates enough pressure to fully cycle the bolt. The hollow metal stem is attached to the rifle by a sheet metal spring that fits over the bayonet lug. The M12 BFA will not cycle the bolt if installed on a rifle with a National Match dimension flash suppressor. The M3 breech shield was intended to protect the shooter from any blow back particles when firing blank ammunition, and to prevent loading live ammunition through the stripper clip guide.

There were three versions of the M12 BFA and two versions of the M3 breech shield. The first version BFA was packed with the early style breech shield. These were produced in 1962. The second version blank firing attachments were packed with the early style breech shield in 1964 and the late style breech shield in 1968. The first and second versions were later modified at the General and Direct Support levels by riveting a curved 1/8 " thick piece of steel to the horizontal surface of the spring latch. The steel strap was curved at the front end in order to dissipate gases exiting the muzzle. The M12

BFA modification was implemented with Change 2 to TM 9-1005-223-35 dated February 03, 1970.

The third version of the BFA (USGI drawing 7793000 FSN 1005-893-0902) was made from 1969 to 1973 and packaged with the late style breech shield. Two companies made all the M12 blank firing attachments. East Moline Metal Products Company made some M12 blank firing attachments in 1973 at the end of its production that were phosphate coated instead of painted orange and silver. The BFA is designed to operate using the U. S. made M82 blank cartridge. It will not cycle the bolt using European blank cartridges.

Line Throwing Kit - The U. S. Navy Mk 87 Mod 0 and Mod 1 kits allow the M14 rifle to reliably launch a nylon cord attached to a butyl rubber projectile up to 90 yards. The projectile will travel 55 yards with the M14 fired horizontal to the surface and 90 yards if shot at an angle of 45 degrees. The launcher is attached to the M14 by a wire loop that is placed around the bayonet lug and secured by the safety retaining pin. Once the projectile with the attached nylon cord has been launched from one ship to another, a line (heavy rope) for underway replenishment chores can be pulled from the first ship to the second. The Mk 87 Mod 1 line throwing kit consists of one launcher, one butt stock recoil pad, six reusable projectiles, eighteen chemical light wands, one wound spool of 550 feet of 125 pound test orange color water repellent nylon cord and an optional canister to hold the spool of nylon cord. The line throwing kit requires the use of M64 grenade blank cartridges. The butyl rubber projectiles have a stainless steel disk on the rear end to absorb the cartridge propellant gases and wadding. For night time use, an activated chemical light wand is inserted into the butyl rubber projectile. This helps the ship's crew on the receiving end find the front end of the nylon cord after launching.

While not made for the M14 rifle specifically, in the 1960s the U. S. military issued a canvas web Universal Rifle Case. The universal rifle case could hold a scoped rifle such as the M1903A4, the M1C, the M1D, the XM21 or the M21. There were two versions of the rifle case. One version had leather reinforcement points and was marked: first line - UNIVERSAL-RIFLE-CASE second line - D78926. The other version had double thick canvas reinforcement points and was marked: first line - RIFLE CASE, UNIVERSAL second line - ORD. PART NO. 6578296. Both cases had full length stainless steel zippers.

The canvas M1950 individual weapons case was made for Army paratroopers. This case could hold a M1 Garand or M14 rifle. Some M1950 cases were produced in 1968 under a DSA contract. This was a U. S. Army Quartermaster Corps item.

Commercial Accessories

Commercial accessories include bipod, brass catchers (canvas and plastic), butt stock recoil pad, dual magazine clamp, elevation sight repair disk, front and rear sight protectors, keyed cable lock, gun cases, magazine loader and unloader, magazine pouches, recoil buffer/reducer, slings (nylon, biothane synthetic and leather), and stock comb/cheek rest. Reproduction front and rear sight protectors have been produced in green and in white. The green color protectors were made overseas. Shooters can

purchase dry fire devices in the civilian market for practicing trigger squeeze, shooting position, and competition courses of fire. B.Jones Sights makes a prescription lens insert for the hooded National Match rear sight aperture. Entreprise Arms once made an extended bolt lock for the M14 type rifle but currently does not.

Magazine Pouches – Commercial reproduction ALICE system M14 magazine pouches have been made in black, green and tan colors. Commercial manufacture M14 dual magazine canvas and nylon pouches have been produced since at least 2001 until the present day. M14 magazine pouches made by BlackHawk Products Group, S.O. Tech, Tactical Assault Gear and Tactical Tailor are compatible with the U. S. Army MODular Lightweight Load-carrying Equipment (MOLLE) system of load bearing equipment. The MOLLE load bearing equipment was introduced to the U. S. Armed Forces in 2001. In 2006, Best Made Designs offered a M14 butt stock magazine pouch. These magazine pouches are very good to excellent quality. These commercial quality magazine pouches are popular with U. S. servicemen in Afghanistan and Iraq.

Adjustable Gas Plugs - Rich Schuster (Toledo, OH) designed and makes Schuster Nuts. These are aftermarket M14 type gas cylinder plugs that can be used in competitive shooting. The top of the plug has a vent hole drilled to 0.015 " diameter. The interior diameter of the plug is larger than the standard M14 gas cylinder plug. This allows the gas pressure to drop about 2600 psi (equivalent to the effect of reducing a cartridge's charge weight by ½ grain of powder). The result is less wear and tear on the rifle through lower initial pressure and less vigorous operation of the gas system. By adjusting a nut inside the plug, the net volume of gas in the cylinder is changed. This in turn changes the speed of the operating rod and the harmonics of the barrel vibrations. M14 gunsmith Clint Fowler (Barboursville, VA) and Derrick Martin (Accuracy Speaks in Mesa, AZ) can supply adjustable gas cylinder plugs for the M14 type rifle. These adjustable gas plugs use socket screws to vary the size of the opening in the top. Thus, the competition shooter can set the amount of gas venting to maximize accuracy and minimize wear.

Slings - Turner Saddlery and Les Tam M1907 style slings are highly regarded by M14 enthusiasts. Tactical nylon slings of various configurations are available for the M14 type rifle from Specter Gear or Tactical Intervention Specialists.

M2 Type Bipods

The M2 bipod design was standardized in December 1959 and improvements were added later. M2 bipods have been produced in the United States, Taiwan and China. Chinese copies of the M2 bipod do not have as excellent a reputation as compared to the USGI and Taiwanese models.

Taiwan models - The Taiwanese M2 bipod is reliable and suitable for civilian use. Beginning around 1998, some Taiwanese M2 bipods were sold to the U. S. Navy through Sarco, Inc. (CAGE Code 8R320). Taiwanese M2 bipods are made by Wayne Machine Inc. of Taipei, Taiwan. Taiwanese copies of the M2 bipod may have W M I stamped on the yoke. Taiwanese bipods sold by Sarco to the U. S. Navy do not have the W M I mark.

Early Taiwanese bipods were brazed but failed routinely. Otherwise, Taiwanese bipods are welded and have had no problems through thousands of rounds of automatic fire.

Some of the Taiwanese M2 bipods were installed on M14 rifles and used in combat in Afghanistan in 2005. Seven of these bipods were removed from combat service in July 2005 because each suffered the loss of the retaining pin holding the spring and button in one of the leg folding pushbutton assemblies.

Chinese models - The Chinese M2 bipod is marketed by Norinco. The Chinese versions will have the W M I marking. If the yoke screw requires a hex head wrench to tighten or loosen, it is a Chinese bipod.

USGI models - An American made USGI contract M2 bipod will have the following markings on the yoke: U. S. 7790833 BIPOD RIFLE M2 or U. S. 7790688 BIPOD RIFLE M2. A USGI M2 bipod will be of brazed, not welded, construction. The USGI M2 bipods left the factory with a yellow DOD acceptance stamp and a blue letter M, one on the bottom of each leg pad and also on the outside of the right hand clamp. The yellow DOD acceptance stamp was usually, but not always, applied to the left hand front side of the yoke. The yellow DOD acceptance stamp has been observed on the rear side of the yoke of a genuine USGI M2 bipod. The yellow and blue markings tended to wear off with use in the field and are rarely seen on bipods found today.

Both versions of the USGI contractor M2 bipod, 7790688 and 7790833, were initially produced without a sling swivel. The sling swivel was added to the M2 bipod in 1963 as part of the M14E2 rifle design. M2 bipods marked 7790688 were later manufactured with a sling swivel. Sling swivels were also added to quantities of both versions of M2 bipods while in service through a Modification Work Order or a Direct Support level field modification. M2 bipods with swivels will have a longer pin to secure the swivel to the yoke. Some early USGI M2 bipod locking bolts do not have a screwdriver slot. A small screw and nut were added to the plunger assembly of each leg for the 7790833 version M2 bipod.

Other Bipods

In 1979, Rock Island Armory (Geneseo, IL) produced and sold a reproduction T44 Type II bipod (referred to as a Type I bipod in other references). The item was marketed as BIPOD, M1. This bipod attached to the bayonet lug of any M1 Garand or M14 type rifle. Reportedly, 200 of the BIPOD, M1 units were made. They retailed for \$42.00 each.

GG&G and Harris bipods are typically mounted to the rifle's stock just aft of the front sling swivel. A hole is drilled in the stock to which an adapter is fitted and secured. The stock forearm may or may not be reinforced per the owner's preference. Alternately, some rifle owners use the 5/16 " diameter drain hole located 1 " behind the stock ferrule. Either way, this method of attachment avoids changes in point of impact that may occur with the M2 bipod. These bipods are also lighter than the USGI M2 bipod.

The 5/16 " diameter drain hole behind the stock ferrule is an acceptable location to mount a bipod. According to M14 gunsmith Ted Brown [minor spelling and punctuation errors corrected]:

Actually, the hole is not meant to bleed off gas from the gas cylinder. All of the gas is blown back on to the stock and vents between the stock and hand guard. The hole is primarily designed to drain water from the stock. Of course, it come

out everywhere else too. The hole is a reasonably good place to mount a Harris bipod. One must keep in mind that it is not the strongest part of the stock, but it does work.

The Keng's Firearms Specialty M14 bipod is a Chinese copy of the Parker-Hale precision rifle bipod. Its bipod mounting adapter for the M14 type rifle is catalog number 150-102. This bipod mounting adapter replaces the American threaded gas cylinder plug to allow a Keng's Firearms Specialty bipod to be mounted to the rifle. This mounting adapter will not work on Chinese manufactured M14 gas cylinders because of the different thread pitch. A Keng's Firearms Specialty M14 bipod can also attach to a standard quick detachable sling swivel with its universal mounting adapter (catalog number 150-100). In 2005, the firm introduced a 3 3/8 " long MIL-STD-1913 Picatinny rail that attaches to the bottom of the M14 stock just forward of the front sling swivel (catalog number 150-807). This steel M14 stock MIL-STD-1913 Picatinny rail section requires no stock modifications to be installed. The KFS rail section has a channel machined on the top surface to allow gas from the gas cylinder to vent out of the stock. The KFS rail section includes a 1 5/8 " freely rotating sling swivel.

Troy Industries offered a bipod for the Rock SOPMOD M14. It mounted to the six o'clock rail on the stock and had a quick release mounting lever. The Mk 14 Mod 0 bipod was developed by Keng's Firearms Specialty and Mike Rock. This bipod has a patent pending quick detach clamp that attaches to the bottom rail of the Sage International, Ltd. stock. The bipod legs are adjustable for height. The patented design of the bipod feet keeps them from sinking into the soil.

Ammunition

Headspace - USGI, Chinese and Taiwanese M14 type rifles are chambered for the 7.62 x 51 mm NATO cartridge. Chinese M14 rifles from the factory are headspaced long. The majority of Federal Ordnance M14 type rifles were assembled with Chinese barrels and bolts or sold as bare receivers. U. S. commercial manufacturers typically headspace M14 type rifles to Sporting Arms and Ammunition Manufacturers' Institute (SAAMI) specifications for .308 Winchester unless chambered for another caliber. However, some U. S. commercial M14 type rifles built by armorers and gunsmiths for competition were headspaced for 7.62x51 mm NATO ammunition. Therefore, the buyer should check the headspace when purchasing a rifle unless the factory or gunsmith supplies the headspace reading at the time of purchase. If the headspace is from 1.630 " to 1.634 ", then either commercial manufacture .308 Winchester or military manufacture 7.62 x 51 mm NATO ammunition can be used. The subject of hand-loaded ammunition in the M14 type rifle is beyond the scope of this work.

If a USGI M14 rifle bolt closed on a USGI FIELD REJECT gage with a FIELD TEST bolt (drawing 7274799) installed, the rifle was removed from service and the receiver and barrel declared unserviceable. If the FIELD TEST bolt would not close on the FIELD REJECT gage but the issue bolt did then the bolt was removed from service and replaced. The USGI M14 headspace gages were sized as follows: 1.6355 " GO (drawing 7274780), 1.6375 " (drawing 7274782), 1.6415 " NO GO (drawing 7274786) and 1.6445 " FIELD REJECT (drawing 7274790).

Table 25: M14 Type Rifle Headspace Dimensions

Reference	GO (inches)	NO GO (inches)	FIELD REJECT (inches)
SAAMI	1.630	1.634	1.638
Drawing F7267000 Rifle, 7.62 MM, M14 Revision AH dated January 24, 1986	1.6355	1.6405	
Drawing F7790476 Rifle, 7.62 MM, M14 NM Revision D dated April 10, 1969	1.6355	1.6385	
1967 National Match Rifles - U. S. Army Materiel Command	1.6355	1.6385	
AMU M14 MTU-NM Manual	1.631	1.635	
MIL-R-45979 dated 24 Sep 76 Military Specification M14 NM	1.6355	1.6385	
TM 9-1005-223-34 August 1971 and TM 9-1005-223-35 July 1968			1.6455
DMWR 9-1005-223 October 1971	1.6355	1.6415	
TM 02648C-24&P/2 July 2000	1.632	1.638	

Ammunition Variety and Suppliers - The U. S. government (Frankford Arsenal, Lake City and Winchester) has produced 7.62 x 51 mm NATO ammunition as follows:

Table 26: 7.62x51 mm NATO Ammunition Cartridges

Cartridge	Description
M59 Ball	150.5 grain mild steel core bullet with lead tip and base all contained inside a gilding metal jacket, produced about 1959 and 1960 only
M60 High Pressure Test	171.5 grain bullet with tin coated case
M61 Armor Piercing	150.5 grain boat tail steel core bullet with black tip
M62 Tracer	142 grain bullet with orange tip, traces out to 800 meters
M62 Tracer Overhead Fire Mission	146 grain bullet with red tip
M63 Dummy	fluted case, no primer
M64 Grenade Blank	rosette crimped case mouth, original drawing dated July 1955
M80 Ball	146 grain lead-antimony core bullet, original drawing dated January 1962
M80 Ball Overhead Fire Mission	149 grain bullet
M82 Blank	double tapered neck, front portion replicates loaded cartridge length for reliable feeding
M118 Match	172 grain bullet headstamped MATCH or NM, no NATO circle-cross, primer not crimped to enable marksmanship units to easily reload training ammunition
M118 Special Ball	172 grain bullet usually headstamped L C and the last two years of manufacture at ten, two, four and eight o'clock for each character, no NATO circle-cross
M118LR	175 grain hollow point boat tail bullet
M160 Frangible Ball	108.5 grain lead and phenolic resin bullet with green and white tip or green tip with white primer annulus
M172 Dummy	black case and bullet
XM178 Ball Overhead Fire Mission	bullet made of bronze to prevent fragmentation
M192 Blank	rosette crimped case mouth with red wad or purple lacquer
XM192E1	lightweight ball with white tip
M198 Duplex Ball	two copper plated steel core bullets, effective range was less than 150 meters. This cartridge was developed by Winchester-Western and standardized on May 07, 1964. The front bullet has a light green tip and hollow base and the rear bullet has a slanted base. Bullet weight is uncertain.
XM256E1	low recoil steel core copper jacketed bullet with white tip This cartridge was developed and tested by Frankford Arsenal in 1975. This bullet is physically the same as the M198 cartridge upper bullet. Bullet weight is uncertain. One reference says 80 grains and the other, 90 grains.

M276 Dim (Night Vision) Tracer	140 to 150 grain bullet with violet tip after 09/94, green tip with pink primer annulus before 10/94
M852 Match	168 grain hollow point boat tail bullet headstamped MATCH, case body knurled about ½ " from the head, primer not crimped
M948 Saboted Light Armor Penetrating (SLAP)	tungsten bullet in an amber plastic sabot
M959 SLAP Tracer	M196 5.56 mm tracer bullet in a plastic sabot
M973 Training Ball	fluted bullet
M974 Training Tracer	fluted bullet with red tip
M993 Armor Piercing	126.6 grain bullet with black stripe at the tip

Frankford Arsenal was founded on May 27, 1816 and was located in what is now northeast Philadelphia, PA. It was an ammunition research, development and production facility throughout its history. During World War II, as many as 22,000 personnel were employed at the arsenal. Frankford Arsenal produced small arms ammunition as late as 1965, e.g., M198 cartridges. In 1968, Frankford Arsenal was part of the U. S. Army Materiel Command with 5,714 workers. Frankford Arsenal closed in the mid-1970s. The 112 acre property was eventually sold by the U. S. government and is now an industrial park.

Lake City Army Ammunition Plant (Independence, MO) was established in 1940 to produce small arms ammunition for the U. S. Army. Lake City manufactured M852 Match ammunition was introduced in 1980 for military competition shooters. This cartridge was first classified as XM852 in 1981 and then M852 later in the same year. It provided better performance than the M118 Match cartridge at distances out to 600 yards. Lake City remains in operation today as part of the U. S. Army Industrial Operations Command. The Industrial Operations Command is a subordinate command of the U. S. Army Materiel Command.

U. S. military ammunition is either linked for machine gun use or packed in cardboard boxes or in bandoleer kits for rifles. Due to the expense, ammunition packaged in bandoleer kits is issued for combat use only. Subsonic ammunition was hand loaded at Fort Benning, GA for XM21 sound suppressed rifles in Viet Nam. This subsonic round was designed to be stable for a distance of 100 meters or less. Placing the spindle valve in the "OFF" position reduces the muzzle velocity by only 15 feet per second using M118 Match ammunition but it does noticeably intensify felt recoil. Likewise, removal of the flash suppressor does not significantly alter bullet muzzle velocity. M62 tracer ammunition burns out at about 900 meters down range. Match grade ammunition has been in use by competition shooters since the 1921 National Matches.

Surplus military ammunition can be of high quality. Ron Smith was a member of the Arizona and California National Guard Shooting Teams. He reports that his scores were from 490 to 495 in High Power Shooting competitions (fifty shot National Match Course) with match grade ammunition. Using surplus Portuguese military ammunition, his scores ranged from 485 to 490!

Commercial ammunition in .308 Winchester is available in varying bullet weights of full metal jacket, soft point and hollow point. Black Hills, Federal, Remington, and Winchester all produce high quality ammunition. Springfield Armory, Inc. does not recommend the use of soft point ammunition in the M1A rifle. Use of soft point cartridges can cause build up of lead deposits in the chamber. Dirty barrel chambers will cause excessive pressure which may result in serious personal injury. The M14 type rifle can be loaded using magazines or stripper clips. If the M14 type rifle has a scope mount installed, then it will be loaded only using a magazine.

Other Calibers

After then-Secretary of Defense Robert McNamara announced the cancellation of M14 rifle production in 1963, TRW attempted a conversion of the M14 to .223 Remington in an effort to save what it could of its investment with the M14 Rifle. This conversion included modification of the M16 magazine follower and magazine latch, and installation of a filler block for the rear of the magazine well. Only one M14 rifle was converted to .223 Remington by TRW. In 1992, Armscorp USA made at least one receiver stamped 5.56 MM M14 NM. It was made to the same dimensions as the 7.62 x 51 mm receiver and no modifications were made. Gene Barnett made a 5.56 mm 1:12 twist M14 barrel for the receiver. The bolt bolt and extractor were modified for the smaller 5.56 mm cartridge case. This rifle uses a twenty round M16 magazine that is riveted inside a M14 magazine tube.

In the late 1970s and early 1980s Karl Maunz converted about 100 M1 Garand rifles to a number of experimental calibers such as 6.5 mm, 7 mm, .45 ACP and "wildcat" calibers .451 through .459. Through the 1960s, 1970s and 1980s, Karl Maunz drew up drawings for these wildcat cartridges and sent them to Clymer Manufacturing Company (Rochester Hills, MI) to have chamber reamers made. This included manufacture of a .308 Winchester caliber headspacing chamber reamer in 1963 for the M1 Garand rifle. Karl Maunz obtained the wildcat caliber barrels from Jack Krieger and Bob Hart after Clymer Manufacturing Company had supplied the Maunz designed chamber reamers. Clymer Manufacturing Company was established in 1958 by Max and Tina Cramer. In 2005, Karl Maunz is developing a .45 ACP cartridge for the M1 Garand and M14 type rifles.

Karl Maunz came up with the idea of mating a 6.5 mm 140 grain bullet to a 7.62 x 51 mm cartridge case. He named this cartridge the .630 Maunz. As a matter of personal preference, he used Frankford Arsenal match cartridge cases over Lake City match cartridge cases. Karl Maunz came up with .630 Maunz design after looking at the .276 cartridge that had been originally developed for the M1 Garand rifle. It proved to be an exceptionally flat shooter at 600 yards. He did some development work in 1964 on a muzzle-feeding chamber reamer. This chamber reamer was intended for use in the .308 Winchester barrel M1 Garand rifle. This preliminary work was done while he was still in the Army Reserve. He was able to finish the design and manufacture of the original .630 Maunz muzzle-feeding headspacing chamber reamer in 1965. Later, the use of .308 Winchester cartridge cases mated to smaller bullets was made available in the Maunz Match Rifle Model 87. The Model 87 was available in the following calibers: 7.62 x 51 mm / .308 Winchester, .308 case with .224 bullet, .308 case with .244 bullet, .308 case

with .264 bullet or .308 case with .284 bullet.

Springfield Armory, Inc. offered M1A rifles chambered in .243 Winchester from at least mid-1984 until at least 1990. In 1991, the M1A was available in 7mm-08. These M1A rifles were sold in the United States and in countries where civilians were prohibited from owning military compatible ammunition. Armscorp M14 NM serial number 12148 was built with a .243 Winchester 18 " barrel long but it is not known if the barrel was installed by Armscorp USA.

Arizona Expert Arms (Mesa, AZ) and Dow Arms Room (Dade City, FL) can do conversions on M14 type rifles to .300 Winchester Short Magnum upon customer request. As an example, the Arizona Expert Arms conversion includes installation of a custom Krieger heavyweight barrel, machining the bolt face and extractor, drilling the proper size barrel gas port, and relieving the stock to accommodate the barrel. Standard USGI M14 twenty round magazines will hold and feed eleven .300 WSM cartridges without modification.

Mr. Roland Beaver of Old Corps Weaponry (Bald Knob, AR), a M14 gunsmith, has built several commercial M14 trainer rifles in .22 LR caliber using Sturm, Ruger & Co., Inc. 10/22 rifle receivers. Mr. Beaver adds a .22 LR caliber chambered barrel, a custom carved walnut stock and hand guard and M14 gas cylinder, flash suppressor and front sight to create a custom made M14 training rifle. He made both prototype and production models of his M14 trainer.

M14 Problems

After production began, the M14 rifle experienced occasional failures where the bolt did not strip the next round from the magazine and so closed on an empty chamber. Sometimes, the bolt would contact the cartridge halfway through the cycle causing a jam. This occurred because the bolt speed increased with using ball-shaped gunpowder while the M14 rifle had been originally designed to use ammunition loaded with extruded gunpowder. Springfield Armory redesigned the magazine spring to help raise the rear end of the follower and shortened the rear end of the cylindrical portion of the operating rod by 0.1 ". The shortening of the operating rod increased the bolt cycle time to give the magazine spring sufficient time to raise the top cartridge to where it needed to be. These changes were successful in eliminating the cartridge stripping problem.

In the early 1960s, U. S. Marines used the M14 rifles with fixed bayonets for Close Quarters Battle training. When Marines executed the movement known as the vertical slash, the stock would sometimes disengage from the front band causing the barrel to separate from the stock. Also, a similar problem occurred when the Marines used the M14 rifle as a step to hurdle over obstacles. Two Marines would hold the rifle, one at either end while a third Marine stepped on to the rifle in the middle to clear a fence or wall. To keep the stock from separating from the barrel under such combat conditions, the gas cylinder was redesigned to incorporate a lip just aft of the bottom gas port to support the front band (see Miscellaneous Notes on USGI Parts).

The most common failures of the M14 rifles while in service were cracked stocks and rear sight pinions, missing rear sight nuts, and misaligned flash suppressors. Less common

failures were broken safeties, broken firing pins, and out of specification gas cylinders. The least common problems were broken hammer hooks or spurs, extractors and bolt locks. No problems were reported with the operating rod, firing mechanism (except safety), butt plate, or front sight itself. The early version front sight screw was often stripped and could not be removed. Repeated automatic fire from the hip with the M14E2 stock will cause it to crack at or near the pistol grip joint.

The U. S. Army anticipated a certain amount of parts failures. TM 9-1005-223-35 July 1968 Section II Repair Parts List indicated the maximum number of repair parts allowed in inventory per 100 rifles at the following maintenance levels: Direct Support thirty day supply, General Support thirty day supply, one year contingency and Depot Support. Many M14 and accessories parts were only authorized two spares per 100 pieces supported at the Direct Support and General Support levels. Aside from small pins, the front sight screw (76) and the firing pin (48) were the parts with the highest authorized quantity for Depot Support.

There were two versions of the M14 extractor. The early version was identical to the M1 Garand rifle extractor and had a sharp point on the lower front right-hand corner which could snag the cartridge. This caused the extractor to leave the bolt when firing M82 blank cartridges. This problem was corrected with the late version (drawing changed in March 1963) extractor. The late version extractor was milled with a beveled lower front corner which allowed the M82 cartridge to clear the extractor. The early version extractor is unacceptable for overhaul of USGI M14 rifles.

No projectile weighing over 168 grains should be used in an unmodified M14 type rifle with standard barrel chamber.³ This is because of increased chamber and gas port pressure with heavier bullets. Thunderbird Cartridge Company (Laveen, AZ) tested some M118 ammunition for Smith Enterprise in 1990. The chamber pressure measured from 53,000 to over 59,000 cupric units of pressure (CUP). The adjusted average chamber pressure was 57,000 cupric units of pressure at 78 degrees Fahrenheit. U. S. Army M14 rifles in Iraq in 2004 were experiencing overpressure problems with M118LR 175 grain ammunition. An M14 rifle may safely shoot M118LR ammunition if the barrel chamber is reamed to the M118LR chamber dimensions. At the time of this writing, Smith Enterprise, Inc. is the only firm with a M118LR cartridge chamber reamer. The M118LR reamer is made only for Smith Enterprise, Inc. by Dave Manson Precision Reamers (Grand Blanc, MI). Dave Manson started Dave Manson Precision Reamers in 1999 after having worked at Clymer Manufacturing Company for sixteen years as Production Manager.

Ammunition must NEVER be loaded by hand into the chamber with the bolt allowed to close at full speed driven the operating rod spring. That practice presents the risk of slam fire. Ammunition should instead be fed only from the magazine. Always point all firearms in a safe direction and always assume a loaded chamber for safety reasons.

The user should not attempt to engage the safety on an M14 type rifle unless the hammer is cocked. Otherwise, the safety can fail. Other components of the firing mechanism are remarkably trouble-free and durable, so long as amateurish "trigger jobs" are avoided.

Based on civilian experience, USGI gas pistons have a useful life between 10,000 and

15,000 rounds. USGI gas cylinders will require replacement after approximately 40,000 rounds. Flash suppressor prongs experience signs of gas erosion near the muzzle after thousands of rounds fired. The prongs will eventually crack at some point after 15,000 rounds.

Some Viet Nam War veterans have stated that the M14 magazine feed lips could and did bend when hitting the deck hard in a combat situation. While this is a true statement, it is not unique to the M14 rifle. This is a concern with other magazine fed military rifles as well.

Some M14 type rifles left the factory with loose flash suppressors and operating rod guides. The flash suppressor nut can be over-tightened causing slight stretching of the barrel. This was an issue with XM21 and M21 rifles. The gas cylinder plug can and has loosened during firing and in combat at that. The prepared M14 type rifle owner always carries a M14 combination tool to check the gas cylinder plug on a routine basis. Once these parts are correctly installed, the M14 rifle is almost always trouble free. If the bolt does not cycle after the first shot is fired check the spindle valve to see if it is in the open position (slot in the vertical). The wise M14 type rifle owner carries a spare complete bolt assembly already headspaced to the rifle.

A few M1A receivers between serial numbers 007000 and 020000 tend to wear prematurely on the elevation serrations. These receivers can be heat treated and the surface hardness increased to correct this condition. There are sixty elevation serrations on the M14 type receiver. As an alternate solution, the receiver serrations can be covered with a hardened steel elevation serration repair disc. This disc was developed by Fort Benning USAMTU armorers. It has 120 serrations on one side and sixty serrations on the other side. The disc can also be used to obtain half-minute elevation adjustments with a standard rear sight aperture. In 1973, the elevation serration repair disc was manufactured by Liberty Tool & Die Corporation (Rochester, NY). Currently, it is available through Fulton Armory. The design of the standard windage knob detents prevents similar problems on that side of the receivers.

There have been cases where commercial manufacture extractors have flown out of the bolt while the rifle is cycling. These extractors can usually be made serviceable by further machining of the divot where the extractor spring plunger rests on the extractor, or by replacing the extractor spring plunger. An alternate solution is to replace the commercially-made extractor with a USGI extractor. Often, the commercial extractor spring tension is incorrect, the extractor spring detent is too large or the extractor stem is too long. Extended bolt locks may require some gunsmithing work to install on commercial receivers. This is because the bolt lock window dimensions or location or the receiver left side exterior surface above the bolt lock window may not exactly match the requirements of USGI drawing 7790189. So, the extended bolt lock may require modification to fit on a commercial M14 type receiver.

Chinese M14 type gas cylinders and gas cylinder plugs are prone to rusting because they are not made of stainless steel. Chromium plating on the Chinese gas pistons makes rust less of a problem with that part.

From late 2001 when M14 rifles were fielded with the 82nd Airborne Division until the present day operations in Afghanistan and Iraq, the U. S. Army suffers from a dearth of armorer expertise to maintain the M14 rifle in combat theaters at the Direct Support and General Support maintenance levels. Nonetheless, the M14 rifle has proven itself over and over in combat with even less-than-adequate support.

1987 Springfield Armory, Inc. Recall Notice

Springfield Armory, Inc. issued a recall of specific bolts and safeties in 1987. Some Springfield Armory, Inc. M1A, M1 Garand and BM59 rifle firing mechanism safeties could be disengaged by pulling on the trigger with a heavier than normal amount of force. These rifles would not fire after the trigger was pulled the first time but would fire after the trigger was released and pulled again with a normal amount of force. After unloading the rifle of all ammunition and pointing the muzzle in a safe direction, the firing mechanism should be tested as follows: 1) cycle the bolt 2) place the safety in the off position 3) place the safety in the on position 4) pull the trigger with more than a normal amount force then release it. Perform this test several times. If there is any forward movement (disengagement) of the safety, the firing mechanism should be removed from the rifle and Springfield Armory, Inc. contacted.

The 1987 recall applies to M1A bolts marked as follows:

- 1) No numerical or alphabetical characteristics on either the top or back of the bolt (completely unmarked)
- 2) Any bolt with any numerical or alphabetical markings at all on the back of the bolt
- 3) Any bolt with the top marked 7790185 and with SA RRR centered below that number
- 4) Any bolt with the top marked 790185 and with SA centered below that number

If the reader has such a bolt, contact the Customer Service Department at Springfield Armory, Inc. Politely discuss your situation with the Customer Service Representative. Springfield Armory, Inc. still honors this recall if applicable to the part concerned.

Accurizing Tips

A competent gunsmith can enhance the accuracy of an M14 type rifle. Some of the procedures the gunsmith may perform include: checking the operating rod spring guide for parallel, padding the hand guard, gluing the gas spindle valve open, measuring the operating rod spring for proper length, unitizing the gas cylinder to the front band, shimming the gas cylinder to the barrel to correct gas cylinder lock timing, peening or knurling the barrel to ensure interference fit of the gas cylinder, operating guide, and flash suppressor, tuning the firing mechanism, backing off the flash suppressor setscrew, reaming the flash suppressor, polishing the gas piston, hand fitting various parts, installing National Match front and rear sights, bedding the stock, modifying the stock liner, and lapping the bolt. Springfield Armory developed the concept of bedding military rifle stocks in the early 1880s. Stock bedding of match rifles was done as early as 1903.

U. S. Army M14 match armorers used the more labor intensive method of screwing the gas cylinder to the front band to unitize the gas system. Before the spindle valve can be drilled and tapped, it and the front band must be annealed. The spindle valve is heated to

1300 degrees Fahrenheit then allowed to slowly cool for twelve hours. The front band is spot annealed with a torch. Stainless steel screws are then screwed into the front band and spindle valve with epoxy adhesive applied to the threads. Finally, the screws are staked to the front band to keep them from loosening. A special jig is used to keep all the parts aligned while this is accomplished. U. S. Marine Corps M14 match armorers unitized the gas system by silver soldering the gas cylinder to the front band. This method is much less time consuming.

As a general rule, U. S. Army MTU armorers modified the following M14 parts: flash suppressor, front band, gas cylinder, gas piston, hammer, operating rod, operating rod spring guide, sear, and stock. Some shooters have a National Match front sling swivel installed on their stock. The USGI riveted front sling swivel is removed and replaced with a quick detach sling swivel that is mounted to the stock with bolts and nuts. This increases the strength of the swivel attachment and allows the shooter to wrap his arm into a tighter sling when shooting.

Miscellaneous Tips

The M14 extractor can be removed from the bolt with the rifle still assembled. Pull the operating rod handle rearward and lock the bolt. Place an empty .30-06 cartridge case inside the barrel chamber. Gently ride the bolt forward until it stops. The empty .30-06 cartridge case will keep the ejector and ejector spring depressed. This facilitates removal or installation of the extractor without use of the M14 combination tool.

When removing the firing mechanism (first check that the rifle is clear of ammunition, cycle the bolt, and engage the safety) keep fingers out of the inside of the trigger guard when pulling the trigger guard away from the stock to avoid injury. Instead, use a thin metal object and place the end into the hole on the rear end of the trigger guard and pull out away from the stock. If a screw driver or the M14 combination tool is not available, the rim of an empty cartridge case can be used to tighten the elevation knob screw. To begin disassembly of the firing mechanism, place the hammer in the "as fired" position before removing the trigger pin.

When cleaning the inside of the receiver, lower a stripper clip through the stripper clip guide to a point below the bolt face. This will keep the bolt from going into battery and causing injury. Removing the sling keeper from the sling and then looping the sling through the rear sling swivel will reduce noise from the sling while carrying the rifle.

Write down sight adjustments for various ranges and points of impact for different cartridges on a small piece of paper. Tape this note sheet to the inside surface of the butt plate flapper.

Suggestions for Your Relationship with M14 Gunsmiths and Firearms Dealers

The following suggestions will enhance your experience with these professionals if you adhere to them: 1) keep a written detailed journal of problems with your firearm 2) do not whine 3) listen before you speak 4) be willing to learn 5) be patient 6) accept the fact that quality service is never the least expensive 7) submit clear and complete written information describing the problem(s) or work to be done in the same package with your insured and unloaded firearm 8) be polite 9) educate yourself on your firearm and 10) the

original equipment manufacturer should be contacted first if possible.

M14 Gunsmiths

The following is a partial list of gunsmiths with experience working on M14 type rifles. No particular business is being endorsed. They are listed alphabetically. If a web site or e-mail address is not listed, consult telephone directories for contact information.

Armscorp USA Baltimore, MD www.armscorpusa.com See section on Armscorp USA.

Arrington, Phil Scottsdale, AZ www.arringtonaccuracy.com Phil specializes in M1 Garand, M14 type and semiautomatic M16 style rifles.

Brown, Ted Shooters Den Jacksonville, OR www.tedbrownrifles.com Ted retired as a Master Sergeant from the U. S. Air Force and Air National Guard. He has been a team member, armorer and coach for National Guard shooting teams and successfully coached Junior Rifle Teams for several years. He earned the U. S. Air Force Distinguished Rifleman Badge (# 214) and Master Class designation in 1988. He has built National Match M14 type rifles since 1978. Ted specializes in M1 Garand and Carbine, M14 type and semiautomatic M16 style rifles.

Entreprise Arms Irwindale, CA www.entreprise.com See section on Entreprise Arms.

Evan's Gunsmithing and Shooter's World Orange, CA www.egsw.com/home.htm
Featured in *American Survival Guide* and *Gun World*.

Ferrante, David Heart Mountain Precision Powell, WY Dave is a High Master shooter with the M14 type rifle as well as a highly reputable M14 gunsmith.

Fowler, Clint Barboursville, VA www.m1-m1a-ar15.com Clint earned his Distinguished Rifleman badge in 1964. He has set several national shooting records and won four Camp Perry Nathan Hale Trophies and numerous shooting medals and state championships. Clint has been a gunsmith since the early 1980s specializing in the M1Garand, M14 type and semiautomatic M16 style rifles.

Gronning, Jim Gruning Precision Riverside, CA Jim is featured in *The M14-Type Rifle*.

Luhmann, Tom TLC Gunworks Clovis, CA

McKee, Clint Fulton Armory Savage, MD www.fulton-armory.com See section on Fulton Armory. Clint also works on M1 Garand and semiautomatic M16 style rifles.

Morris, Ronnie Match Service Works Madison, TN

Pierce, Eric National Match Armory Rendon, TX

Rader, Dale Springfield Armory, Inc. Custom Shop Geneseo, IL www.springfield-armory.com

Smith, Ron Smith Enterprise, Inc. Tempe, AZ www.smithenterprise.com See section on Smith Enterprise.

Strait, Tim Warbirds Custom Guns Houston, TX <http://www.warbirdscustomguns.com>
Tim has twenty-five years experience as a military armorer and commercial gunsmith specializing in Mauser, M1 Garand, and M14 type rifles and M1911 pistols. His

experience includes performing M1A receiver warranty work during the 1980s for Springfield Armory, Inc. Tim has performed hundreds of USGI bolt conversions on Chinese M14 receivers.

Tabor, Frank San Bruno, CA

Tank, Jon Tank's Rifle Shop Fremont, NE www.tankrifleshop.com Jon specializes in M1 Garand and Carbine, M14 type, and semiautomatic M16 style rifles and Remington shotguns.

Part 3 Notes

1. Ricca, Bill. E-mail correspondence with the author.
2. Ricca, Bill. March 06, 2004 post on www.m14forum.com.
3. Smith, Ron. Personal discussion. February 18, 2004.

Appendix A

Springfield Armory, Inc. Dates of Manufacture

The following is a list of M1A serial numbers and the month and year the receiver was assembled at or shipped from Springfield Armory, Inc. Some serial numbers were shipped from the factory as bare receivers. The month and year of assembly was obtained from either the factory headspace tag or Customer Service at Springfield Armory, Inc. Use of the letter "X" in the serial number denotes that the specific digit was not revealed by the source.

Table 27: Springfield Armory, Inc. Dates of Manufacture

Receiver Serial Number	Month and Year	Comments
000065	12/71	sold as a receiver
000172	04/72	sold as a barreled receiver
000214	04/72	sold as a barreled receiver
000567	12/72	
001695	12/73	
001727	01/74	sold as a receiver
001988	04/74	sold as a barreled receiver
002127	04/74	sold as a barreled receiver
002167	09/74	sold as a barreled receiver
002168	09/74	sold as a barreled receiver
002282	09/74	sold as a barreled receiver
002283	09/74	sold as a barreled receiver
002284	09/74	sold as a barreled receiver
002293	09/74	sold as a barreled receiver
002709	11/74	sold as a receiver, lowest known Illinois serial number
002734	04/75	sold as a rifle, Illinois
002774	11/74	sold as a receiver, Illinois
002808	11/74	sold as a receiver, Illinois
002923	11/74	sold as a receiver, Illinois
002979	11/74	sold as a receiver, Illinois
002985	12/74	sold as a receiver
002990	10/74	sold as a barreled receiver, Texas
002992	10/74	sold as a barreled receiver, Texas
002995	10/74	sold as a barreled receiver, Texas
002996	10/74	sold as a barreled receiver, Texas
002998	10/74	sold as a barreled receiver, Texas
003109	10/74	sold as a barreled receiver, Texas

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003124	10/74	sold as a receiver, Texas
003129	10/74	sold as a barreled receiver, Texas
003139	10/74	sold as a barreled receiver, Texas
003140	10/74	sold as a barreled receiver, Texas
003142	10/74	sold as a receiver, Texas
003159	10/74	sold as a receiver, Texas
003210	10/74	sold as a receiver, Texas
003217	10/74	sold as a receiver, Texas
003270	11/74	sold as a receiver, Illinois
003306	10/74	sold as a receiver, Texas
003322	01/75	sold as a receiver
0034XX	01/75	sold as a barreled receiver
00356X	04/75	verified with Springfield Armory, Inc. Customer Service
004357	12/75	
0066XX	10/76	sold as a receiver
007297	06/77	
0082XX	07/78	
0087XX	06/78	sold as a receiver
008977	10/78	
009334	02/79	
009690	05/78	verified with Springfield Armory, Inc. Customer Service
0108XX	08/79	
0125XX	02/80	
013000	10/74	sold as a barreled action, highest Texas serial number, stamped out of sequence
013195	05/80	
013308	05/80	
013853	06/80	
014095	06/80	sold as a receiver
014233	07/80	
014619	08/80	
014806	09/80	
0195XX	09/81	
021075	02/82	
021941	04/82	
022186	06/82	
022482	07/82	
024095	12/82	
024740	03/83	
02555X	05/83	
0272XX	10/83	

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0277XX	12/83	
028260	11/83	
028342	12/83	
029390	03/84	
030036	04/84	
030061	05/84	sold as a select fire model
030310	05/84	sold as a receiver
0309XX	06/84	
032951	12/84	sold as a receiver
033283	02/85	
0339XX	04/85	
034299	05/85	
034651	06/85	
036600	12/85	sold as a barreled receiver
036945	12/85	
037343	11/86	
037405	01/86	sold as a barreled receiver
0383XX	04/86	sold as a receiver
039619	12/86	
040555	03/87	
0426XX	08/87	
0444XX	03/88	
045377	05/88	sold as a receiver
045515	07/88	
0459XX	10/88	
047122	12/88	
047824	03/89	
04886X	04/89	
0492XX	05/89	sold as a receiver
050000	12/89	
050438	07/89	
051753	10/89	
052122	11/89	
052724	12/89	
053079	12/89	
053554	01/90	
053815	01/90	
054507	03/90	
0548XX	02/90	
054999	02/90	
055491	05/90	
0557XX	04/90	
05649X	04/90	
0565XX	05/90	
057106	05/90	
05842X	07/90	
059194	08/90	
060736	10/90	sold as a receiver
060890	10/90	
061026	11/90	
061320	10/90	
061388	11/90	

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062380	01/91	
062672	09/91	
062680	08/91	
0630XX	03/91	
0635XX	03/91	
0640XX	05/91	
064872	11/91	sold as a rear lugged Super Match rifle
064880	12/91	sold as a rear lugged receiver
065323	10/91	
066425	10/91	sold as a receiver
066425	10/91	sold as a receiver
066871	10/91	sold as a receiver
06812X	02/92	
068177	01/92	
068978	04/92	sold as a receiver
069101	04/92	sold as a receiver
069860	07/92	
070005	07/92	
072074	03/93	
072253	05/93	
072562	04/93	sold as a receiver
07465X	11/93	
075704	11/93	
075874	12/93	
076392	01/94	
078191	04/94	
078839	03/94	
079085	03/94	
0797XX	04/94	
079836	04/94	
080377	05/94	
081435	06/94	
082619	07/94	
084469	09/94	sold as a receiver
084627	09/94	
08493X	10/94	sold as a receiver
085735	09/94	
085992	11/94	
088936	03/95	
08911X	03/95	
089693	03/95	
0899XX	03/95	
090354	03/95	
092371	07/95	
092426	06/95	sold as a M1A-A1 model
0931XX	10/95	
096025	03/96	
097333	05/96	
097345	08/96	

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100222	02/97	
1006XX	03/97	sold as a rear lugged receiver
101285	03/97	
10129X	04/97	
1013XX	04/97	
1017XX	04/97	
101945	05/97	
102570	05/97	
1027XX	06/97	
103355	06/97	
1037XX	07/97	
1049XX	08/97	
1065XX	10/97	
10755X	12/97	
108873	01/98	
109770	03/98	
110125	03/98	
110129	03/98	
110232	03/98	
1110XX	04/98	
111434	05/98	
113667	11/98	
115296	02/99	
1159XX	03/99	
116733	04/99	
1168XX	06/99	
117268	04/99	
117369	06/99	sold as a barreled receiver
118401	08/99	
118861	07/99	
1189XX	07/99	
1200XX	09/99	
121590	11/99	
122961	12/99	
123035	12/99	
124046	01/00	sold as a barreled receiver
1244XX	01/00	
124998	02/00	
1255XX	03/00	
126057	03/00	
126142	03/00	
1264XX	05/00	
127335	04/00	
128222	06/00	
1284XX	06/00	
129313	07/00	
1304XX	09/00	
1308XX	12/00	
131290	12/00	
131585	11/00	
1317XX	03/01	

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1332XX	03/01	
133405	05/01	
133605	03/01	
133665	03/01	
1340XX	06/01	
134855	07/01	
135551	08/01	
136425	10/01	
136732	10/01	
13694X	10/01	
137075	11/01	
137432	11/01	
137546	11/01	sold as a receiver
1376XX	11/01	
137777	11/01	
139240	01/02	
139401	01/02	
139488	01/02	
13979X	01/02	
1400XX	02/02	
1403XX	03/02	
140898	03/02	
141455	03/02	
141575	03/02	
142118	04/02	
142243	04/02	
1432XX	05/02	
143583	05/02	
144278	06/02	
1445XX	06/02	
14477X	07/02	
144999	06/02	
145288	07/02	
1459XX	07/02	
1460XX	09/02	
146246	08/02	
148639	10/02	
149063	10/02	
1466XX	08/02	
147042	09/02	
1473XX	09/02	
1476XX	09/02	
14779X	09/02	
148934	10/02	
148998	11/02	
149004	11/02	
149645	12/02	
1499XX	11/02	
150156	12/02	sold as a receiver

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150506	12/02	sold as a receiver
150555	12/02	sold as a receiver
150648	12/02	
150686	12/02	
1509XX	02/03	
1510XX	12/02	
151496	01/03	
1515XX	02/03	
151600	01/03	
151707	01/03	
152377	02/03	
152451	02/03	
152750	04/03	
1529XX	03/03	
15388X	03/03	
15389X	03/03	
155359	04/03	
1554XX	05/03	
1555XX	05/03	
1557XX	05/03	
155865	04/03	
1567XX	11/03	
157036	07/03	
157128	07/03	
1576XX	07/03	
157704	06/03	
157735	06/03	
1581XX	10/03	
1584XX	09/03	
1586XX	09/03	
1596XX	10/03	
1601XX	10/03	
16037X	11/03	
16050X	12/03	
161034	12/03	
161068	11/03	
161112	12/03	
161246	12/03	
1619XX	01/04	
161737	12/03	
162053	01/04	
1622XX	02/04	
162664	03/04	
162708	02/04	one of the first M1A SOCOM models
162961	03/04	
163386	04/04	
164618	05/04	

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164659	05/04	
164758	05/04	
164935	06/04	
1653XX	06/04	
1654XX	07/04	
165747	07/04	
16604X	07/04	
1664XX	08/04	
166719	08/04	
166784	08/04	
166912	09/04	
1672XX	09/04	
167417	09/04	
1678XX	10/04	
1681XX	10/04	
1690XX	12/04	
169375	12/04	
169425	12/04	
169790	12/04	
17011X	12/04	
170157	01/05	
170616	02/05	
17062X	01/05	
17074X	01/05	
17110X	01/05	
171127	02/05	
171450	03/05	
172009	03/05	
172203	03/05	
173180	06/05	
173559	05/05	
174269	05/05	
17439X	05/05	
174514	05/05	
1747XX	06/05	
175055	06/05	
175450	06/05	
176167	07/05	
176635	07/05	
1769XX	08/05	
177998	09/05	
1783XX	10/05	
178745	11/05	
178898	10/05	
1801XX	12/05	
1802XX	11/05	
1812XX	01/06	
181429	12/05	
182201	01/06	
182867	01/06	

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183075	03/06	
1841XX	04/06	
185270	04/06	
185796	04/06	
186793	05/06	
191506	09/06	
2300XX	08/00	verified with Springfield Armory, Inc.
230112	08/00	
246XXX	09/01	
SM0117	09/91	
IDF026	05/99	
IDF067	07/99	
WF027X	12/02	

Appendix B

Federal Ordnance, Inc. Dates of Production

The following is a list of Federal Ordnance serial numbers and the month and year the rifle was assembled or purchased, if available. Federal Ordnance did sell stripped receivers as well. The month and year of assembly or purchase was obtained from the factory inspection tag or from the owner with the original purchase receipt. Use of the letter "X" in the serial number denotes that the specific digit was not revealed by the source.

Table 28: Federal Ordnance Dates of Manufacture

Receiver Serial Number	Month and Year	Comments
22XX	02/26/87 per factory tag	USGI parts
232X		USGI parts
3058		USGI parts imported from Israel
394X		USGI parts imported from Israel
46XX		USGI parts including H&R barrel
4894	04/89 FFL delivery to original owner	USGI parts including Winchester barrel
677X	11/17/89 per factory tag	USGI parts
7010	12/89 original owner purchase	USGI parts
7089	06/89 original owner purchase	USGI parts
8042		USGI parts
824X	02/01/90 on receiver	USGI parts
8877		USGI parts
205XX		Chinese parts
21136		Chinese parts
21200		Chinese parts
214XX		Chinese parts
227XX		Chinese parts
23111	05/91 per factory tag	Chinese parts
502XX	09/13/91 per factory tag	Chinese parts
60308		highest observed serial number

Appendix C

Armscorp of America and Armscorp USA Dates of Production

The following is a list of Armscorp serial numbers and the month and year the rifle or receiver was manufactured or purchased if available. Armscorp has built relatively few complete rifles at its factory in comparison to its total receiver production. So, most receivers were sold bare for build projects by gunsmiths or individual owners. The month and year of manufacture or purchase was obtained from the original owner. Use of the letter "X" in the serial number denotes that the specific digit was not revealed by the source.

Table 29: Armscorp Dates of Manufacture

Receiver Serial Number	Month and Year	Comments
A00391X	04/89 purchase	
A0070XX	03/92 purchase	
0071XX	01/91 purchase	
10451	04/93 manufacture	
115XX	07/94 manufacture	sold as a complete rifle
151XX	05/99 purchase	
15906	01/00 manufacture	
16633	07/02 purchase	sold as a receiver
1664X	07/02 purchase	sold as a receiver
17011	07/03 manufacture	
17013	07/03 manufacture	
1708X	11/03 purchase	
1728X	07/06 purchase	sold as a rear lugged XM25 receiver
17396	05/06 purchase	sold as a barreled receiver
7	09/92 shipped to FFL	sold as a receiver marked 5.56 MM M14 NM

Appendix D

LRB of Long Island, Inc. Dates of Production

The following is a list of LRB Arms M14SA serial numbers and the month and year the rifle was assembled or purchased if available. The month and year of assembly, purchase or shipment date to the FFL was obtained from the original owner. Use of the letter "X" in the serial number denotes that the specific digit was not revealed by the source.

Table 30: LRB Arms Dates of Manufacture

Receiver Serial Number	Month and Year	Comments
01001	10/03 purchase	sold as a receiver, dot matrix serial number
01018	09/03 purchase	sold as a barreled receiver, dot matrix serial number
0102X	11/04 purchase	sold as a barreled receiver, dot matrix serial number
01038	09/03 purchase	sold as a receiver, dot matrix serial number
01211	09/03 purchase	sold as a receiver, dot matrix serial number
01217	10/03 purchase	dot matrix serial number
01237	01/05 built into rifle at LRB	
01263	09/06 built into rifle at LRB	
01275	01/04 shipped to FFL	sold as a barreled receiver
0128X	01/06 built into rifle at LRB	
0129X	01/05 shipped to FFL	
0129X	08/06 built into rifle at LRB	
01301	09/06 built into rifle at LRB	
01304	10/04 purchase	sold as a barreled receiver
0131X	09/04 purchase	sold as a receiver
01318	05/04 purchase	sold as a rear lugged receiver
0132X	09/04 purchase	sold as a receiver
01339	05/04 shipped to FFL	sold as a receiver
01364	07/04 purchase	sold as a receiver
01367	09/06 built into rifle at LRB	
0138X	08/06 shipped to FFL	sold as a complete rifle
01408	12/04 shipped to FFL	sold as a receiver
01437	01/05 purchase	sold as a receiver
01444	01/05 purchase	sold as a receiver
01445	01/05 purchase	sold as a receiver
01494	03/05 shipped to FFL	
0151X	03/05 purchase	sold as a barreled receiver
01531	05/05 shipped to FFL	sold as a barreled receiver
01533	03/05 shipped to FFL	sold as a receiver
01534	05/05 delivered	sold as a barreled action

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01537	04/05 shipped to FFL	sold as a barreled receiver
01545	04/05 built into rifle at LRB	
01548	05/05 shipped to FFL	sold as a receiver
01550	05/05 purchase	sold as a receiver
01555	03/06 purchase	sold as a complete rifle
01584	01/06 purchase	sold as a complete rifle
0159X	09/05 purchase	
01606	09/05 built into rifle at LRB	
01612	07/05 delivered	sold as a receiver
01629	09/05 purchase	sold as a barreled receiver
0164X	12/05 built into rifle at LRB	
01645	05/05 purchase	sold as a rear lugged receiver
01646	03/06 built into rifle at LRB	
01652	11/05 purchase	sold as a rear lugged receiver
0166X	01/06 built into rifle at LRB	
01665	09/06 built into rifle at LRB	
01668	11/05 built into rifle at LRB	
01705	06/06 built into rifle at LRB	
01707	06/06 built into rifle at LRB	
01711	06/06 purchase	sold as a receiver
01724	08/06 built into rifle at LRB	

Appendix E

M14 Rifle Item Descriptions and Federal Stock Numbers

Most of the information in this Appendix was compiled by Thomas A. Buss in 1971. It is reproduced here with permission.

Table 31: Barrel and Receiver Group Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
M14 Rifle	7267000	1005-00-283-7695 1005-00-770-3559	original drawing dated March 1955
M14 Rifle with equipment	8413866	1005-00-589-1271	equipment includes sling, combination tool and cleaning kit
M14 M Rifle	7790485	1005-00-678-9829	
M14 M Rifle with equipment	5910842	1005-678-9829	part number as listed in TM 9-1005-223-12P February 23, 1968
M14 NM Rifle	7790476 9386974	1005-00-678-9828	drawings originally dated April 1959 and September 1984 respectively
M14 NM Rifle with equipment	5910841	1005-678-9828	part number as listed in TM 9-1005-223-12P February 23, 1968
M14 NM Rifle with M84 scope		1005-937-8777	
M14A1 Rifle with bipod and sling	11010108	1005-00-072-5011	
M14A1 Rifle with equipment	8427044		
M14 DMR Rifle	98003A0000	1005-01-458-6235	
M21 Rifle	9386973 11838704	1005-00-179-0300	original drawing 9386973 dated September 1984

M14 RIFLE HISTORY AND DEVELOPMENT

optical scope (sight, telescopic)	9349352		M21, original drawing dated November 1981
optical scope	98003A0020	1240-01-470-6548	M14 DMR, 10X
scope ring (assembly, ring, telescopic sight)	98003A0030	1005-01-470-7458	M14 DMR
scope ring screw (screw, cap)	MS 16995-18B	5305-00-145-0713	M14 DMR
scope ring upper half (cap, ring)	98003A0033	1005-01-470-9060	M14 DMR
scope ring lower half (ring, base)	98003A0031	1005-01-470-9065	M14 DMR
scope ring nut	98003A0036	5310-01-147-2385	M14 DMR
scope ring washer	DOD-W-63474/3	5310-01-360-4766	M14 DMR
scope ring clamp	98003A0034	1005-01-470-9595	M14 DMR
elevation knob assembly	7267099	1005-628-9047 5355-00-628-9047	calibrated in meters, original drawing dated September 1965
elevation knob lock washer	11010359		original drawing dated September 1965
elevation knob indexing dog assembly	11010362		original drawing dated September 1965
elevation knob screw blank	7267096		original drawing dated July 1958
elevation knob indexing dog	7267097		original drawing dated July 1958
elevation knob	7267098		original drawing dated July 1958
elevation pinion assembly	11010363	1005-999-3399 5355-00-999-3399	original drawing dated September 1965
windage knob assembly	7312737	1005-731-2737 5355-00-731-2737	original drawing dated December 1944

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windage knob nut	7312726		original drawing dated December 1944
windage knob nut lock	7312731		original drawing dated December 1944
windage knob spring	7312732		original drawing dated December 1944
windage knob assembly, National Match	7790386	1005-649-9275	original drawing dated November 1958
windage knob, National Match	7790358	5355-00-649-9275	original drawing dated November 1958
rear sight aperture	6008868	1005-00-600-8868	original drawing dated August 1937
rear sight base	5546001	1005-00-554-6001	original drawing dated August 1937
rear sight base, National Match	7791341	1005-875-6281	marked NM/2, undercut for hooded aperture
rear sight base, National Match	7791571	1005-754-6799	marked NM/2A, original drawing dated November 1963
rear sight cover	6008872	1005-00-600-8872	original drawing dated August 1937
rear sight eyepiece, National Match	7791131		marked 595, 0.0595 " peep hole original drawing dated December 1961
rear sight eyepiece assembly, National Match	7791132		original drawing dated December 1961
rear sight aperture assembly, National Match	7791133	1005-864-2926	0.0595 " peep hole, original drawing dated December 1961

M14 RIFLE HISTORY AND DEVELOPMENT

rear sight eyepiece, National Match	7791281		marked 520, 0.0520 " peep hole, alternate design
rear sight aperture assembly, National Match	7791282	1005-864-2928	0.0520 " peep hole, alternate design
rear sight aperture, National Match	7791134		original drawing dated December 1961
rear sight eyepiece spring, National Match	7791135		two coil springs, original drawing dated December 1961
rear sight eyepiece spring, National Match	7791136		one cone disk spring, original drawing dated December 1961
selector shaft pin	96906-16562-107	5315-051-6891 5315-058-6045	interchangeable with the spindle valve pin and connector pin, 5/64 " diameter x 3/8 " long
selector lock	7267172	1005-587-8420	standard for M14, M14 M and M14 NM, original drawing dated October 1954
selector switch	7267071	1005-587-8408	standard for M14A1, optional for M14 in lieu of selector lock, original drawing dated October 1954
selector shaft spring	7267081	1005-587-8415	standard for M14A1, optional for M14 in lieu of selector lock, original drawing dated September 1954
selector shaft	7267072	1005-587-8409	original drawing dated October 1954

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sear release	7790192	1005-628-9053	original drawing dated July 1958
gas cylinder plug	7267053	1005-00-587-8400	original drawing dated October 1954
gas cylinder piston	7267047	1005-00-587-8398	original drawing dated October 1954
gas cylinder piston, National Match	9352724		gas piston with axial groove, original drawing dated June 1982
flash suppressor set screw	7790300	5305-042-6426	make from 6-40 x 0.25 " set screw, tip is 0.092 " diameter x 0.070 " long, original drawing dated July 1958
flash suppressor set screw	MS 51976-16	5305-01-221-3230	M14 DMR
flash suppressor nut	7267039	1005-00-587-8394	original drawing dated November 1954
flash suppressor	7791053	1005-545-1573	original drawing dated September 1960
flash suppressor, National Match	9352718		M14 NM, original drawing dated June 1982
flash suppressor, M14 DMR	98003A1001	1005-01-471-3532	M14 DMR
frong sight, National Match	7791122	1005-00-980-5203	marked NM 062, original drawing dated November 1961
front sight, standard	7791445	1005-084-8435	original drawing dated October 1962
front sight screw	96906-35460-3	5305-655-9483	early version, 3/32 " socket cap screw, 40 NF x 1/2 " long

M14 RIFLE HISTORY AND DEVELOPMENT

front sight screw	11010298	5305-00-921-6155	late version, 7/64 " socket cap screw, 40 NF x 1/2 " long, original drawing dated November 1964
front sight screw	MS 16998-11	5305-983-6650	late version, 7/64 " socket, cadmium plated
gas cylinder lock	7790188	1005-00-628-9051	original drawing dated July 1958
gas cylinder	7790902	1005-790-8766	original drawing dated March 1960
gas cylinder and band assembly, National Match	9352725		M14 NM, original drawing dated June 1982
gas cylinder and band assembly, M14 DMR	98003A1002	1005-01-472-3924	M14 DMR
spindle valve pin	96906-16562-107	5315-051-6891 5315-058-6045	interchangeable with the selector shaft pin and connector pin, 5/64 " diameter x 3/8 " long
spindle valve pin	MS 171401		M14 DMR
spindle valve (gas cutoff valve)	7267604	1005-00-587-8421	original drawing dated December 1954
spindle valve spring	7267605	1005-587-8422	original drawing dated December 1954
front band	7267001	105-587-8375	original drawing dated September 1954
operating rod guide pin	96906-51923-465 MS 51923-465	5315-00-923-9440	1/8 " diameter x 3/4 " long
operating rod guide pin	96906-51923-491	5315-993-3247	1/8 " diameter x 3/4 " long

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operating rod guide	7267025	1005-587-8385	original drawing dated October 1954
operating rod guide, National Match	9349846		original drawing dated March 1982
bolt lock pin	96906-16562-124	5315-00-839-0897	3/32 " diameter x 1 " long
bolt lock	7267034	1005-00-587-8390	original drawing dated December 1954
bolt lock spring	7267074	1005-587-8411 5360-00-587-8411	original drawing dated September 1954
connector lock pin	7267042	1005-00-587-8396	original drawing dated August 1954
connector lock	7267035	1005-500-87-8391	original drawing dated September 1954
stripper clip guide pin	96906-16562-120	5315-051-8636 5315-058-6065	3/32 " diameter x 9/16 " long
stripper clip guide	7790184	1005-628-9049	original drawing dated July 1958
barrel, chromium plated	7790190	1005-628-9052	original drawing dated July 1958
barrel and receiver assembly	7790191		chromium plated barrel, original drawing dated July 1958
barrel and receiver assembly, National Match	9352636		original drawing dated May 1982
receiver lug	9352637		original drawing dated January 1986
barrel, National Match	7791173		chromium plated standard contour, original drawing dated November 1961

M14 RIFLE HISTORY AND DEVELOPMENT

barrel, National Match,	7791362	1005-00-018-3255	non-plated standard contour, original drawing dated December 1961
barrel and receiver assembly, National Match	7791363		receiver with non-plated standard contour barrel
barrel, National Match	9345206	1005-01-120-4513	non-plated medium weight contour, original drawing dated June 1981
barrel, National Match	9349847		non-plated heavy-weight contour, original drawing dated March 1982
barrel assembly, National Match	9362529	1005-01-272-0970	non-plated heavy-weight contour barrel with operating rod guide, original drawing dated March 1982
barrel, M14 DMR	98003A1220	1005-01-470-6710	M14 DMR, non-plated medium weight contour barrel
receiver	7790189	1005-628-9052	original drawing dated July 1958

Table 32: Bolt Assembly Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
bolt	7790185		original drawing dated July 1958
bolt with roller	7790186	1005-00-628-9050	original drawing dated July 1958
bolt assembly	7790187		original drawing dated July 1958
bolt roller	7267065	1005-00-587-8405	original drawing dated September 1954

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bolt roller retaining ring (bolt roller retainer)	7267059	1005-00-587-8402	original drawing dated September 1954
extractor	5546003	1005-554-6003	M1/early M14 extractor
extractor	7791578	1005-953-9504	late M14 extractor, original drawing dated October 1954, changed in March 1963
extractor, M14 DMR	98003A1231	1005-01-472-3098	M14 DMR
extractor spring	6008886		original drawing dated August 1937
extractor spring plunger	5013671		original drawing dated August 1937
extractor spring with plunger	6008618	1005-600-8618	original drawing dated August 1937
ejector	7267014		original drawing dated June 1954
ejector spring	7267959		original drawing dated September 1955
ejector with spring	7267015	1005-00-587-8381	original drawing dated June 1954
firing pin	7267043	1005-587-8397	non-plated
firing pin	7791417	1005-962-8344	chromium plated tip
firing pin	11686413	1005-00-921-5248	100 % chromium plated, original drawing dated October 1965

Table 33: Operating Rod Group Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
connector assembly	7267012		early style with slot for the connector lock

M14 RIFLE HISTORY AND DEVELOPMENT

connector assembly	7790424	1005-678-9824	original drawing dated April 1959
connector assembly, M14 DMR	98003A1004	1005-01-472-3121	M14 DMR
connector pin	96906-16562-107 MS 16562-107	5315-051-6891 5315-058-6045	interchangeable with spindle valve pin and selector shaft pin, 5/64 " diameter x 3/8 " long
connector plunger	7790426	1005-678-9826	original drawing dated April 1959
connector spring	7790427	1005-678-9827	original drawing dated April 1959
connector body	7790425	1005-678-9825	original drawing dated April 1959
operating rod spring guide	7267027	1005-00-587-8386	original drawing dated October 1954
operating rod spring guide, National Match	9352726		original drawing dated June 1982
operating rod spring guide, M14 DMR	98003A1005	1005-01-472-3905	M14 DMR
operating rod spring	7267079	1005-587-8413	original drawing dated September 1954
operating rod	7267064	1005-00-587-8404	original drawing dated September 1954

Table 34: Firing Mechanism Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
complete firing mechanism	7790195		original drawing dated July 1958

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complete firing mechanism, National Match	9354354		original drawing dated June 1982
sear	7267070		original drawing dated August 1954
sear, National Match	5546016		original drawing dated August 1937
trigger	5546020		original drawing dated August 1937
trigger pin	7791367	1005-00-819-4501	original drawing dated April 1962
sear pin	5013673		original drawing dated August 1937
trigger and sear assembly	7267090	1005-587-8419	original drawing dated September 1954
trigger and sear assembly	5546026		M14 NM and M21, original drawing dated August 1937
trigger and sear assembly	98003A3001	1005-01-471-1810	M14 DMR
hammer spring housing	6008883	1005-00-600-8883	original drawing dated August 1937
hammer spring housing, National Match	8448292		original drawing dated May 1969
hammer spring	6008887	1005-00-600-8887	original drawing dated August 1937
hammer spring plunger	6008880	1005-00-600-8880	original drawing dated August 1937
hammer spring plunger, National Match	8448692		original drawing dated March 1971
hammer pin	5013668	5315-00-501-3668	0.187 " diameter x 3/4 " long under head, original drawing dated August 1937

M14 RIFLE HISTORY AND DEVELOPMENT

hammer	5546008	1005-00-554-6008	original drawing dated August 1937
hammer, National Match	8448293		original drawing dated May 1969
safety	5546015	1005-00-554-6015	original drawing dated April 1937
safety spring	7267080	1005-00-587-8414	M1 rifle clip ejector can be cut to 1.1 " length as an emergency repair, original drawing dated September 1954
trigger guard	7790194	1005-628-9054	early style with hammer stop pin
trigger guard	7790990	1005-00-587-6988	late style with bent tab, produced from May 1962 onward, original drawing dated September 1960
trigger housing assembly	7790196 8448290	1005-00-628-9055	original drawings dated July 1958 and May 1969 respectively
trigger housing	7267030		original drawing dated October 1954
magazine latch pin	7791418	1005-00-994-4242	original drawing dated August 1962, 0.121 " diameter x 0.640 " long
magazine latch	7267032	1005-00-587-8389	original drawing dated August 1954
magazine latch spring	7267041	1005-00-587-8395	original drawing dated August 1964

Table 35: M14 Stock and Hand Guard Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
butt stock sling swivel	6008889	1005-600-8889	original drawing dated August 1937
lower butt screw	6008881	5305-600-8881	slot drive, 0.216 " diameter x 28 NF-2A x 3.171 " long, original drawing dated August 1937
upper butt screw	6146873	1005-614-6873	for wood stock with M1 rifle butt plate, original drawing dated March 1935
upper butt screw	7791036	1005-474-2754	0.212 " diameter, 10 threads per inch, 1.140 " grip length, 2.136 " long, for wood stock with hinged butt plate, original drawing dated August 1960
upper butt screw	7791267	5305-999-1875	for production reinforced fiberglass stock, original drawing dated July 1965
upper butt screw nut retainer	11010414	5340-999-1854	for production reinforced fiberglass stock, original drawing dated July 1965
upper butt screw nut (10-32 threads)	7791339	5310-999-1891	for production reinforced fiberglass stock, 10 - 32 square nut, original drawing dated July 1965

M14 RIFLE HISTORY AND DEVELOPMENT

wood stock that fits the M1 rifle butt plate	7267083 per Picatinny Arsenal CMT IG Number 38 dated 2 January 1958		T44E4 bare walnut stock
wood stock that fits the M1 rifle butt plate	7267084 per Picatinny Arsenal CMT IG Number 38 dated 2 January 1958		T44E4 walnut stock with butt plate, ferrule, front and rear sling swivels, stock liner and liner screws
wood stock assembly	7790702		M14 stock includes the front and rear sling swivels, stock liner, liner screws, ferrule and butt plate assembly
wood stock subassembly	7790810		M14 stock subassembly for 7790702, includes stock, ferrule, front sling swivel, stock liner and liner screws
wood stock, National Match	7791174		M14 NM bare stock for 7791175
wood stock assembly, National Match	7791175		M14 NM stock includes front and rear sling swivels, ferrule, stock liner, liner screws and butt plate assembly, original drawing dated December 1961
wood stock subassembly, National Match	7791280		M14 NM stock subassembly for 7791175, includes front sling swivel, ferrule, stock liner and liner screws, original drawing dated December 1961

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wood stock, National Match	9352638	1005-01-233-8635	M14 NM bare stock for 9392337, routed for bedding, original drawing dated May 1982
wood stock subassembly, National Match	9381706		M14 NM stock subassembly for 9392337 with front sling swivel, ferrule, liner, liner screws and routed for bedding, original drawing dated May 1984
wood stock assembly, National Match	9392337		M14 NM stock with front and rear sling swivels, ferrule, butt plate assembly, routing and bedding, original drawing dated May 1984
wood stock subassembly	11010262		M14 stock subassembly includes front sling swivel, ferrule, stock liner and liner screws, original drawing dated June 1964
wood stock	11010263	1005-754-6462	M14 and M14 NM bare stock, original drawing dated June 1964
wood stock assembly, National Match	11010281		M14 NM stock includes front and rear swling swivels, ferrule, stock liner, liner screws, butt plate assembly, routing and bedding, original drawing dated June 1964

M14 RIFLE HISTORY AND DEVELOPMENT

wood stock subassembly, National Match	11010282	1005-00-912-3711	M14 NM stock sub-assembly includes stock, ferrule, stock liner, liner screws and routing, original drawing dated June 1964
stock liner	7267033		
stock liner screw	7267063		two per stock, 10-32 threads, 7/16 " overall length
stock ferrule	7267017		M14 and M14A1, original drawing dated October 1954
stock ferrule	9352720	1005-01-271-1027	M14 NM stock 9392337
stock rivet, tubular oval head	7790473 MS 16535-302		M14 wood stock, original drawing dated September 1959
stock rivet, tubular oval head	11010260 MS 16535-307	5320-01-272-5023	M14 reinforced fiberglass stock, original drawing dated June 1964
stock rivet, solid, belt	MS 35745-18		M14 NM and M21
stock rivet burr	7790474		original drawing dated September 1959
sling swivel bracket	7267007		original drawing dated September 1954
sling swivel loop	7267037		original drawing dated September 1954
sling swivel loop assembly	7267089		M14, original drawing dated September 1954

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sling swivel loop assembly	9352716		M14 NM, original drawing dated June 1982
pin, straight, knurled	11010261		M14 reinforced fiberglass stock pin inside the butt stock, original drawing dated July 1965
screw retaining plate	7791340		reinforced fiberglass stock plate inside the grip, original drawing dated July 1965
production reinforced fiberglass stock	11686426		original drawing dated December 1965
production reinforced fiberglass stock subassembly	11686427		stock with ferrule, original drawing dated December 1965
production reinforced fiberglass stock assembly	11686428		stock includes the butt plate, front sling swivel and ferrule, original drawing dated December 1965
production reinforced fiberglass stock subassembly	5910348	1005-00-999-1871	subassembly consists of stock, upper butt screw, nut retainer and nut
hand guard band	6008870		also known as hand guard clip, original drawing dated August 1937
hand guard assembly	7267021	1005-587-8382	walnut hand guard with metal clip
hand guard assembly	7790689	1005-690-4068	slotted fiberglass-hand guard with metal clip

M14 RIFLE HISTORY AND DEVELOPMENT

hand guard	7791285		solid fiberglass hand guard, original drawing dated October 1961
hand guard, National Match	9352722		M14 NM, original drawing dated June 1982
hand guard assembly	7791286	1005-856-2108	solid fiberglass hand guard with metal clip, original drawing dated October 1961
hand guard assembly, National Match	9352721		M14 NM, original drawing dated June 1982
hand guard assembly, M14 DMR	98003A1008	1005-01-472-3209	

Table 36: M14 Stock Butt Plate Assembly Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
M1 butt plate assembly	5564277	1005-556-4277	for early M14 stock with M1 butt plate
M1 butt plate hinge pin	5152865	5315-515-2865	interchangeable with M14 stock butt plate door pin, 0.126 " diameter x 1.00 " long, original drawing dated March 1940
M1 butt plate plunger	5152864	1005-515-2864	for early M14 stock with M1 butt plate
M1 butt plate catch spring	5152863	1005-515-2863	for early M14 stock with M1 butt plate
M1 butt plate door	6147465	1005-614-7465	for early M14 stock with M1 butt plate
M1 butt plate	5564283	1005-556-4283	for early M14 stock with M1 butt plate

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M14 butt plate assembly	7790686	1005-690-4067	original drawing dated September 1959
M14 butt plate hinge pin	7790695	1005-981-1254	original drawing dated September 1959
M14 butt plate stop pin	7790695	1005-981-1254	original drawing dated September 1959
M14 butt plate	7790696		original drawing dated September 1959
M14 butt plate rest	7790697	1005-981-1255	also known as butt plate flapper, original drawing dated September 1959
M14 butt plate ball bearing	96906-19059-49 96906-19059-88	3110-100-6151	
M14 butt plate hinge spring	5013747	1005-501-3747	original drawing dated February 1935
M14 butt plate door pin	96906-16562-98	5315-597-5086	1/16 " diameter x 3/8 " long
M14 butt plate door catch	7790693	1005-981-1252	original drawing dated September 1959
M14 butt plate door catch spring	7790699	1005-981-1256	original drawing dated September 1959
M14 butt plate catch pin	5152865	5315-515-2865	original drawing dated March 1940
M14 butt plate door plunger	7790698		original drawing dated September 1959
M14 butt plate door	7790692		original drawing dated September 1959
M14 hinge block	7790691		original drawing dated September 1959

M14 RIFLE HISTORY AND DEVELOPMENT

M14 butt plate assembly	7790700		original drawing dated September 1959
M14 hinge transition piece	7790914		black soft rubber filler block that allows use of the M1 rifle butt plate on a standard M14 stock, not the same as the hinge inlet protector part number 7791050

Table 37: M14E2/M14A1 Stock Assembly Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
stock assembly	7791671		early version
stock assembly	11686528		late version, original drawing dated April 1966
recoil pad plug	7791674	1005-072-5386	two required, original drawing dated September 1963
lower recoil pad screw	7791676	1005-072-5388	original drawing dated September 1963
butt stock sling swivel bushing	11010047	1005-072-5379	original drawing dated October 1963
butt stock sling swivel	11010046	1005-072-5378	original drawing dated October 1963
upper recoil pad screw	7791677	1005-072-5389	original drawing dated September 1963

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recoil pad	7791673	1005-072-5385	early version made of natural rubber, late version made of synthetic rubber to minimize deterioration from oil and cleaning liquids, original drawing dated September 1963
butt plate bracket screw	6146873	1005-614-6873	two required, original drawing dated March 1935
butt plate flapper assembly	7791678	1005-072-5390	original drawing dated September 1963
butt plate flapper pin	7791682	105-016-2624	original drawing dated September 1963
butt plate flapper	7791683		original drawing dated September 1963
butt plate bracket	7792062		original drawing dated September 1963
hand grip rubber bumper	11010048	1005-072-5380	for early stock burr version, four required
hand grip rubber bumper	11686524	5325-904-9393	for late stock burr version, four required, original drawing dated April 1966
hand grip screw	7791675	1005-072-5380	for early stock burr version, two required
hand grip screw	11686523	5305-956-3401	for late stock burr version, two required, original drawing dated April 1966

M14 RIFLE HISTORY AND DEVELOPMENT

hand grip lock washer	96906-35335-32	5310-596-7691	for early stock burr version, two required, No. 10 screw size
hand grip lock washer	96906-35336-21	5310-194-9209	for late stock version burr, two required
stock assembly burr	7790474	1005-072-5381	early stock version burr, two required, original drawing dated September 1959
stock assembly burr	11686522	1005-951-3254	late stock version burr (backing plate), one required, original drawing dated April 1966
hand grip assembly	11010044	1005-072-5377	
upper hand grip pin	96906-39086-205	5315-836-0643	3/16 " diameter x 7/8 " long
hand grip subassembly	7791672	1005-016-2623	
lower hand grip pin	96906-39086-211	5315-269-4080	0.187 " diameter x 1.750 " long
hand grip	11010001		original drawing dated October 1963
front sling swivel pin	96906-39086-202	5315-050-1233	3/16 " diameter x 1/2 " long
front sling swivel	6008890	1005-600-8890	original drawing dated August 1937
hand grip block	11010004	1005-016-2621	original drawing dated October 1963
stock subassembly	7791679	1005-072-5391	early stock subassembly includes stock, stock liner and liner screws

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stock subassembly	11686527		late stock subassembly includes stock, stock liner and liner screws, original drawing dated April 1966
stock subassembly	5910438	1005-599-4200	includes stock, four late style hand grip rubber bumpers, two late style hand grip screws, two late style hand grip lock washers, and one late style burr (backing plate)
M14E2/M14A1 sling	11010038	1005-072-5376	64.5 " long, original drawing dated October 1963, essentially a M1918 Browning Automatic Rifle sling with an extra standard sling hook

Table 38: M14 DMR Stock Assembly Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
cheek rest, adjustable (cheekpiece)	98003A2104	1005-01-470-6741	
stock	98003A2101		McMillan Fiber-glass Stocks M2A model
escutcheon	98003A2002	1005-01-470-9632	
stock ferrule	9352720	1005-01-271-1027	
bipod mounting stud	98003A2003	5307-01-472-3395	
front sling swivel screw	98003A2004	5305-01-472-3539	two required

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front sling swivel, M14 DMR	98003A2001	1005-01-472-4551	
rear sling swivel	6008889	1005-00-600-8889	
cheek rest screw (cheekpiece screw)	98003A2105	5305-01-472-3465	two required
rear sling swivel screw	98003A2005	5305-01-472-3465	
butt pad spacing (butt pad spacer)	98003A2103	1005-01-470-7122	two available, ½ "
butt pad spacing (butt pad spacer)	98003A2107	1005-01-470-7096	two available, ¼ "
butt pad	98003A2102	1005-01-470-7096	
butt plate screw (screw, machine, rear butt plate)	98003A2106	5305-01-470-7017	two required

Table 39: Twenty Round Magazine Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
magazine assembly	7790183	1005-628-9048 1005-00-628-9048	original drawing dated June 1958
magazine base	7790182		original drawing dated June 1958
magazine spring	7267078		original drawing dated October 1954
magazine follower	7267018		original drawing October 1954
magazine follower assembly	7267019		original drawing dated October 1954
magazine follower stop	7267085		original drawing dated October 1954
magazine tube	7790197		original drawing dated June 1958

magazine latch plate	7791098		original drawing dated June 1958
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Table 40: M2 Bipod Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
M2 bipod assembly	7790688	1005-711-6202	early version, original drawing dated March 1960
M2 bipod assembly	7790833		late version
pivot plunger pin	96906-16652-96	5315-282-3642	two required, 1/16 " diameter x 1/4 " long
pivot plunger pin	7790820	1005-772-6361	two required
pivot plunger spring	7790824	1005-772-6365	two required
pivot plunger	7792846	1005-740-0053	two required
leg plunger pin	96906-16562-99	5315-514-2358	two required, 1/16 " diameter x 7/16 " long
leg extension plunger	7790836		two required
leg extension spring	7790838	1005-897-6156	two required
shaft stop pin	96906-39086-88	5315-839-2327	two required, 1/8 " diameter x 3/8 " long
leg screw	MS 16997-9	5305-978-9342	for late version, 4-40 threads x 1/4 " long, two required
leg screw nut		5310-167-1376	for late version, 4-40 threads hex head nut, two required
right leg assembly	7790822	1005-772-6363	original drawing dated March 1960
right shaft assembly	7790840		

M14 RIFLE HISTORY AND DEVELOPMENT

right leg extension assembly	7790839		
left leg assembly	7790821	1005-772-6362	original drawing dated March 1960
left shaft assembly	7790837		
left leg extension assembly	7790835		
yoke assembly	7791106		
cotter pin	96906-24665-151	5315-815-1405	1/16 " x 3/8 " long
yoke assembly pin	7791104	5315-474-4115	short pin that won't allow installation of the sling swivel, 0.217 " diameter, 1.041 " effective length, 1.180 " nominal length, 0.078 " cotter pin hole diameter
yoke assembly pin	7791669	1005-072-5383	long pin that will allow installation of the sling swivel
bipod sling swivel	7791670	1005-072-5384	original drawing dated September 1963
left jaw	7791102	1005-474-4116	the jaws were improved in the period 1965 to 1966
right jaw assembly	7791107	1005-474-4118	
self-locking bolt	7791103	5306-474-4114	original drawing dated November 1960, 5/16 " diameter - 24 UNF x 3/4 " long self-locking hex head bolt with nylon insert

right jaw	7791101		the jaws were improved for better grip in the period 1965 to 1966, original drawing dated November 1960
welded head assembly	7792847		

Table 41: Organizational Maintenance Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
fabric envelope, two button	7228907	1005-722-8907	3 " x 4 7/8 "
flash suppressor nut wrench	7790315	4933-652-9949	predecessor to 7790493
flash suppressor nut pliers	7790493	4933-690-3497	6 ¼ " overall length
ruptured case extractor	7790352	4933-652-9950	
barrel reflector	7265789	1005-786-5789	early version
barrel reflector	7790138	4933-628-9700	
M2 aiming device	6174998	1005-617-4998	
M15 sighting device	7160903	6910-716-0903	cardboard, 3 ½ " x 7 "
M63 dummy cartridge	7553706		training device
brush, artist	96906-16840-	8020-244-0153	7/16 " wide x 1 1/8 " long
brush, cleaning	96906-16746-29	7920-205-2401	1 1/16 " diameter x 2 7/8 " long
brush, camel hair		7920-00-205-0565	M14 DMR
brush, cleaning	8448462	1005-00-494-6602	M14 DMR, Mk 14 Mod 0

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carbon removing compound		6850-620-0610	P-C-111A
cleaning compound solvent		6850-224-6656	MIL-C-372, 2 ounces can
cleaning compound solvent		6850-00-224-6657	MIL-C-372, 6 ounces can
cleaning compound solvent		6850-224-6658	MIL-C-372, 1 quart can
cleaning compound solvent		6850-224-6663	MIL-C-372, 1 gallon can
cleaning compound solvent		6850-01-381-4401	Mk 14 Mod 0, Skysol 100
cleaning compound solvent		7930-01-342-5316	Mk 14 Mod 0, Simple Green, 5 gallon container
cleaning compound solvent		7930-01-306-8369	Mk 14 Mod 0, Simple Green, 1 gallon container
cleaning compound solvent		7930-01-342-5317	Mk 14 Mod 0, Simple Green, 24 ounce bottle
bore cleaner			Mk 14 Mod 0, Shooters Choice, gallon size
grease			Mk 14 Mod 0, Shooters Choice
abrasive cloth		5350-221-0872	9 " wide x 11 " long, 42-C-20420-50
fluorescent coating compound		8010-811-1845	red orange, 1 quart can, MIL-P-21563 No. 633
dry cleaning solvent		6850-281-1985	1 gallon can, PS661
rifle grease	8448693	9150-754-0063	1 pound can, Lubriplate 130-A or equal, BF-00-00140
linseed oil, raw		8010-221-0611	1 gallon can, TT-L-00215

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lubricating oil, general purpose		9150-273-2389	4 ounces can, PL Special
lubricating oil, general purpose		9150-231-6689	1 quart can, PL Special
lubricating oil, semi-fluid	8436792		2 ounces flat oval bottle, support level not available
lubricating oil, weapons		9150-00-292-9689	1 quart can, for below zero degrees operations
cleaner, lubricant and preservative		9150-01-102-1473	M14 DMR, 1/2 ounce bottle
cleaner, lubricant and preservative		9150-01-054-6453	Mk 14 Mod 0, MIL-L-63460
cleaner, lubricant and preservative		9150-01-079-6124	Mk 14 Mod 0, 4 ounce bottle
cleaner, lubricant and preservative		9150-01-054-6453	Mk 14 Mod 0, 1 pint bottle
cleaner, lubricant and preservative		9150-01-053-6688	Mk 14 Mod 0, 1 gallon can
bedding compound	185-366		M14 DMR, Marine Tex, gray, 1 pound
clay, modeling		7510-00-275-2679	M14 DMR, 1 pound
mold release compound		8030-01-064-4951	M14 DMR, can
shim stock			M14 DMR
paper, lens		6640-00-663-0832	M14 DMR, pack of 50 sheets
rag, wiping	96906-16746-131	7920-00-205-1711	50 pound bale, cotton, A-A-2522
swab, small arms cleaning	5019316	1005-00-288-3565	2 1/2 " x 2 1/2 ", cotton, 1 pack
acetone		6810-00-223-2739	M14 DMR, 1 quart
alcohol, cleaning fluid		6810-00-983-8551	M14 DMR, 1 quart
applicator, cotton tip		6515-00-303-8250	M14 DMR, 1 pack

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die-cut box	7267724		shipping box for .30 Caliber and 7.62 MM rifles, double-faced corrugated fiberboard with B flute, original drawing dated March 1955
barrier bag	7265933	1005-336-0211	VCI treated
protector, front sight and muzzle	7790232	1005-875-9766	natural color polyethylene, Type 1, Class L, Grade 1 or 2
protector, operating rod handle	7790231	1005-875-9765	natural color polyethylene, Type 1, Class L, Grade 1 or 2
protector, rear sight aperture	7791358	1005-441-8807	natural color polyethylene, Type 1, Class L, Grade 1 or 2
cap, rear sight elevation knob	7791345	1005-018-3254	
bore tube	7266316	1005-336-0212	VCI treated
hex head wrench, 1/16 "		5120-198-5398	for the flash suppressor set screw
hex head wrench, 3/32 "		5120-242-7410	for the front sight screw part number 96906-35640-3
hex head wrench, 7/64 "		5120-889-2162	for the front sight screw part number 11010298

Table 42: Direct Support Maintenance Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
tool and gage set for direct, general and depot maintenance	8421895	4933-647-3703	7.62 MM Rifle, M14 Series

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field maintenance gage case	7799702	4933-678-9830	
breech bore field reject gage	7274761	4933-647-3697	limit 0.310 "
field test gage bolt	7274799	4933-647-3699	0.615 " right lug, 0.515 " left lug
head space field reject gage	7274790	4933-647-3698	limit 1.6455 "
gas piston snap gage	7274757	4933-647-3695	NO-GO, 0.4968 " piston diameter
gas cylinder plug gage	7274755	4933-647-3693	NO-GO, 0.5009 " piston hole diameter
firing pin protrusion gage	7274736	4933-345-6122	0.044 " minimum, 0.060 " maximum
firing pin hole plug gage	7458406	4933-917-1067	NO-GO, 0.083 " maximum
flash suppressor alignment tool	7799705	4933-856-2561	
flash suppressor nut pliers	7790493	4933-6903497	
bolt roller retaining ring pliers	7799723	4933-563-0436	
hex head wrench, 7/64 "		5120-889-2162	for late front sight screw part number 11010298
head space gages		5220-00-921-6054	set of nine gages, 1.630 " to 1.638 ", USMC M14 DMR
3/8 " combination open end and socket end wrench			for USMC M14 DMR
gas cylinder lock tool (wrench)			locally fabricated, USMC M14 DMR intermediate level item
Dremel Moto-Tool kit		5120-01-014-6856	for USMC M14 DMR

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test fixture, measuring, trigger pull		4933-00-647-3696	for USMC M14 DMR
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Table 43: General Support (Depot) Maintenance Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
bolt assembly and disassembly tool	7144854		M1 tool adapted to the M14
bolt assembly and disassembly tool	7791607	4933-00-055-5996	M1 and M14 variants, organizational and intermediate level item for the USMC M14 DMR
small arms shop set		4933-754-0664	reference SM 9-4-4933-A13
small arms repairman's tool kit		5180-754-0640	pre-'62 tool kit
small arms repairman's tool kit		4933-357-7770	twenty-seven items added to 5180-754-0640, adopted January 1962, reference SM 9-4-5180-A57
tool set, direct and general support maintenance, basic small arms	8426358	4933-775-0366	reference SM 9-4-4933-E04
tool set, depot maintenance	8432422	4933-930-5598	7.62 MM Rifle, M14 Series
head space gage	7274780	4933-916-9271	1.6355 "
head space gage	7274782	4933-916-9275	1.6375 "
head space gage	7274786	4933-069-8676	1.6415 "
head space reamer assembly	24-013863	4933-809-7980	

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head space reamer assembly crank handle	10-013069	4933-105-2835	
barrel and receiver assembly disassembling fixture	10-013027	4933-439-6089	
bolt and roller assembly grease fitting adapter	10-013635	4933-450-6725	
bolt and roller assembly assembling and disassembling fixture	10-016057	4933-439-6088	
firing mechanism assembling fixture	443448	4933-439-6090	
gas cylinder piston hole plug gage	8440826	5220-437-1152	NO-GO, 0.5009 " piston hole diame- ter
gas port alignment plug gage	11015316	4933-916-9188	
bore straightness drop plug gage	11015416	4933-916-9189	
targeting jack gage	6511841	4933-916-9193	
GO relationship of storage holes to buttplate plug gage	7271641	4933-916-9194	
torque testing gage	7271792	4933-916-9196	
receiver and trig- ger housing clamp- ing surfaces flush pin gage	7799742	4933-916-9341	
operating rod spring length gage	7799743	4933-916-9360	
extractor assembly length gage	7799744	4933-916-9362	
ejector assembly length gage	7799745	4933-916-9365	

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hammer spring length gage	7799747	4933-916-9444	
rear sight aperture length gage	7799746	4933-916-9437	
connector assembly straightness gage	7799748	4933-916-9464	
barrel alignment gage	7799749	4933-916-9468	
selector slot location gage	7799750	4933-916-9487	
firing pin intrusion flush pin gage	7799751	4933-916-9527	
adjustment snap gage	7479462	4933-917-1068	MIL-STD-118
barrel and receiver assembling fixture	7799718	4933-937-4068	
fixed open end wrench	10-012952	5120-156-8735	
facing cutter	7799721	4933-937-4069	
bolt face firing pin hole plain cylindrical plug gage	7458398	5220-745-8398	NO-GO, 0.083 " maximum diameter, MIL-STD-111
chamfer tool (field)	7799719	5220-00-937-4536	also known as a profile gage
proof firing cover	7273975	4933-838-5472	for depot rebuild program only
firing stand	7273901	4933-916-9207	for depot rebuild program only
target, 1000 inch	8448435	6920-240-9349	roll of 500
target, M14 rifle	11686842	6920-021-2477	for depot rebuild program only, roll of 500 targets per box, original drawing dated November 1966
adjustable base assembly	7692125		support level not available

timer cycle gage	7273920		support level not available
trigger pull gage	7274758		support level not available
bolt lock pin removal tool	improvised		see drawing at TM 9-105-223-35 July 1968 page 6
flash suppressor seating tool	improvised		see drawing at TM 9-1005-223-35 July 1968 page 7
stock liner screw wrench	improvised		
M15 grenade launcher sight drill jig	improvised		see drawing at TM 9-1005-223-35 July 1968 page 7, use mild steel or aluminum
M15 grenade launcher sight drill jig	7310066		
firing mechanism assembly and disassembly fixture	improvised		

Table 44: Procurement Substitutions - M1 Rifle or Interchangeable Items

Description	Federal Stock Number	Identical to the M14 item?	Comments
elevation pinion assembly		not suitable	early style with small screw and smooth face marked battle range
elevation pinion assembly	1005-731-2738	no but suitable	calibrated in yards
windage knob		not suitable	early style with winged lock nut
windage knob	1005-731-2737	yes	original drawing dated December 1944

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rear sight aperture	1005-600-8868	yes	original drawing dated August 1937
rear sight cover	1005-600-8872	yes	original drawing dated August 1937
rear sight base	1005-564-6001	yes	original drawing dated August 1937
extractor	1005-554-6003	no but suitable	early M14 extractor
extractor spring w/ plunger	1005-600-8618	yes	original drawing dated August 1937
trigger pin	5315-501-3669	no but suitable	early M14 trigger pin
trigger pin	1005-819-4501	yes	on 1964 DCM list
trigger and sear assembly	1005-554-6026	no but suitable	for semi-automatic fire only
sear		no but suitable	for semi-automatic fire only
sear pin		yes	original drawing dated August 1937
trigger		yes	original drawing dated August 1937
hammer spring housing	1005-600-8883	yes	original drawing dated August 1937
hammer spring	1005-600-8887	yes	original drawing dated August 1937
hammer spring plunger	1005-600-8880	yes	original drawing dated August 1937
hammer pin	5315-501-3668	yes	original drawing dated August 1937
hammer		dimensionally identical	World War II production marked C46008, original drawing dated August 1937
hammer	1005-554-6008	dimensionally identical	1950s production marked D5546008, original drawing dated August 1937

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safety	1005-554-6015	yes	original drawing dated April 1937
hand guard clip		yes	original drawing dated August 1937
lower butt stock screw	5305-600-8881	yes	original drawing dated August 1937
butt stock sling swivel	1005-600-8889	yes	original drawing dated August 1937
small butt plate screw	1005-614-6873	early M14 and M14A1	also available from M1903, can be used on standard M14 stock by plugging hole, original drawing dated March 1935
butt plate assembly	1005-556-4277	early M14 only	can be used on standard M14 by using hinge transition piece 7790914 or equivalent
NM front sight			marked NM 062, original drawing dated November 1961
NM rear sight base	1005-875-6281	yes	marked NM/2, original drawing dated December 1961
NM rear sight base	1005-754-6799	yes	marked NM/2A, original drawing dated November 1963
NM windage knob	1005-649-9275	yes	original drawing dated November 1958
hooded rear sight aperture	1005-864-2926	yes	0.0595 " diameter
hooded rear sight aperture	1005-864-2928	yes	0.0520 " diameter
NM rear sight aperture	1005-348-8654	yes	0.0595 " diameter, drawing number 7268109

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NM rear sight aperture	1005-348-8655	yes	0.0520 " diameter, drawing number 7268110
M1907 leather sling	1005-00-714-1245	yes	series of original drawings dated November 1950
small arms sling, cotton web	1005-654-4058	yes	olive drab, drawing number 6544058, last contract circa 1966
small arms sling, hard nylon weave	1055-714-5320		issued for use in the Republic of Viet Nam, introduced about 1969, drawing number 7145320
small arms sling, soft nylon weave	1005-00-167-4336		first produced in 1973
small arms sling	1005-01-216-4510		drawing number 12624561 originally dated January 1986
cleaning rod case	1005-716-2792	no	M1 case made of light cloth with integral tab, M14 case of heavy cloth with sewn on tab
M10 cleaning rod section		yes	drawing number 7162920
bore brush	1005-556-4174	yes	drawing number 5564174
swab holder		yes	
barrel reflector	4933-726-5788	no	
stock ferrule sling swivel	1005-600-8890	M14A1 only	

Table 45: Accessories for Various USGI M14 Rifles

Description	Part Number	Federal Stock Number or National Stock Number	Comments
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AN/PAS-4		1090-797-8217	infrared scope
bipod	98003A2200	1005-01-472-3902	M14 DMR, Harris Bipods
bipod			Mk 14 Mod 0, Harris Bipods model 1A2-BRM
bipod adaptor plate			Mk 14 Mod 0, Knights Armament
cartridge clip	7790130		five round, commonly known as stripper clip
chamber brush	7790463	1005-633-7165 1005-00-690-8441	The FSN was changed between 1960 and 1967 but the reason is not known. The part number did not change.
cleaning kit		1005-01-451-5119	M14 DMR and Mk 14 Mod 0, Otis Products, Inc.
bore snake, .30 caliber			Mk 14 Mod 0, Hoppes
cleaning rod case with spacer	7267754	1005-650-4510	
cleaning rod section	7266109	1005-726-6109	four required
cleaning rod swab holder	7266110	1005-726-6110	3.5 "
Mk 14 EBR tool		MSC	Bondhus/MSC, 67255281
combination tool with cleaning rod	7790769	4933-00-768-0211	FSN listed as 4933-768-2011 in TM 9-1005-223-34
gas cylinder plug wrench	7267693		pre-'61 cleaning kit item, 3/8 " box end
combination tool			pre-'61 cleaning kit item, three pieces

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oiler case			pre-'61 cleaning kit item
grease cup			pre-'61 cleaning kit item
chamber brush	7267713		pre-'61 cleaning kit item, no ratchet mechanism
M1 cleaning kit case	7162792	1005-716-2792	lighter cloth material than 7267754 and has an integral tab
cleaning rod swab holder	6147417	1005-614-7417	pre-'61 cleaning kit item, 3 "
lubricant case	7790995	1005-791-3377	two compartment plastic case
magazine filler	7791154	1005-00-052-4336	commonly known as stripper clip charger guide
M3 bipod with carrying case	8445081	1005-890-2609	M16 accessories
M3 bipod		1005-992-6676	M16 accessory, sometimes used on the M14 in the Republic of Viet Nam, Colt Industries part number 62122
M3 bipod carrying case	2-2-246	1005-999-2430	
M3 breech shield	7790929		
M5 winter trigger kit	5910520	1005-777-1369	M14
M5 winter trigger assembly	7790808	1005-775-0364	M14
M6 bayonet	7267616, 8427015	1005-00-722-3097	
M6 bayonet blade assembly	7267649		
M6 bayonet spring	7267645		
M6 bayonet lever	7267648		

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M6 bayonet pin	MS 16562-125		
M6 bayonet right side grip	7267652		
M6 bayonet left side grip	7267653		
M6 bayonet screw	7266548		
M8A1 scabbard			
M11 small arms storage rack	8429990	1095-00-897-8755	original drawing dated October 1961
M12 blank firing kit	5910570	1005-00-893-0902	
M12 blank firing attachment	7793000		third version
M15 grenade launcher sight	5750053	1005-049-9428	
M15 sight body	7310096		
M15 sight level assembly	7310097		
M15 sight level assembly screw	7310093		two required
M15 sight bracket screw	7310059		two required
M15 sight stock plate	7311859		
M15 sight tapping screw	7310009		two required
M15 grenade launcher sight carry case	7160198	1005-716-0198	canvas pouch with two snap buttons
M76 grenade launcher	7790900	1005-722-3098	M14
T140 grenade launcher	7267617	1005-722-3098 per MIL-STD-1266 dated March 23, 1961	M14

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M76 grenade launcher with equipment	5910536	1005-778-8812 1005-00-778-8812	M14
M151 vehicle mounting kit		2590-045-9611	Early version for M14 rifle
M151 vehicle mounting kit		2540-763-7348	Late version for M14 and M16 rifles
XM152 winter trigger assembly	11010283	1005-919-9915	
muzzle stabilizer	7791661	1005-722-3097	original drawing dated September 1963, second version
muzzle stabilizer	11686521	1005-930-0806	original drawing dated April 1966, final version
muzzle stabilizer yoke pin	7791664	5315-929-0862	
muzzle stabilizer yoke washer	7791668	5310-962-0873	0.098 " ID x 0.315 " OD x 0.060 " thick flat washer
muzzle stabilizer yoke assembly	11686520	1005-951-3232	
muzzle stabilizer yoke screw	11686519	5305-956-3127	¼ " diameter - 28 UNF x 1.215 " long hex head bolt
muzzle stabilizer yoke nut	7791663	5310-953-6340	¼ " diameter - 28 UNF x 0.270 " thick hex nut
muzzle stabilizer yoke	11686517		
muzzle stabilizer stop	11686518	1005-951-3056	
muzzle stabilizer	7791667		

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rifle carrier		8465-782-2799	nylon webbing carrier to attach a M14 rifle to an ALICE ruck sack, U. S. Army Quartermaster Corps item
M84 scope carrying case	7631596		marked MRT on the inside of the flap
ART scope carrying case	11729637		waterproof alloy aluminum or fiberglass container
AN/PAS-4 scope	19000	1090-797-8217	Varo model 9903, 4.5 X, total weight 13 pounds
AN/PVS-2 scope		5855-832-9223	
AN/PVS-2 carrying case		5855-00-832-6525	
scope mount		1240-01-316-0055	Atlantic Research Marketing Systems, Inc. # 18, Mil-Std-1913
scope mount		5855-01-506-5750	Smith Enterprise, Inc., part number 2006, Mil-Std-1913, 5.38 " long
scope mount		1005-01-533-8160	Smith Enterprise, Inc., part number 2008, Mil-Std-1913, 7.0 "
scope mount		1005-01-535-4430	Smith Enterprise, Inc., part number 2005, Mil-Std-1913, ACOG sight compatible
scope ring			Mk 14 Mod 0, Badger Ordnance, two required

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sling, rifle			Mk 14 Mod 0, Buffer Technologies item TAS-M14
storage case			Mk 14 Mod 0, Eagle Industries model DCM14
weapons record book		0000-00-005-9811	Mk 14 Mod 0
XM152 winter trig- ger kit	5910322		for M14A1

Table 46: Repair Items

Description	Part Number	Federal Stock Number or National Stock Number	Comments
combination tool spring pin	MS 16562-98	5315-597-5086	1/16 " diameter x 3/8 " long
combination tool screwdriver blade	7790786	4922-780-1982	0.220 " wide x 0.527 " long
enamel, walnut stock touch up		8010-145-0042	number 21089, 1 gallon can
M5 winter trigger kit screw	7791231		two required, TM 9-1005-223-12 January 1963
M5 winter trigger kit thread forming tap- ping screw	7791415	5305-990-6435	two required, TM 9-1005-223-34 August 1972
M5 winter trigger kit retaining hinge washer	7791237	1005-010-5022	
M5 winter trigger kit lever	7791211		
M5 winter trigger kit safety	7790903	1005-778-0580	

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stock repair screw, large	5233523	5315-523-3523	3/32 " diameter, for repair of wood stock FSN 1005- 754-6462
stock repair screw, small	7190954	5315-719-0954	1/16 " diameter x 2 " long, for repair of wood stock FSN 1005-754-6472

Appendix F

M14 Magazine Capacity Restrictions in the USA as of May 2006

The following table is an *informative guide* to state and local jurisdictions that restrict possession, sales or transfer of M14 magazines in some manner. Obviously, any changes in the laws restricting magazine capacity will degrade the usefulness of this table. This table does not address any restrictions on handgun magazines, shotgun capacity, rimfire ammunition feeding device capacity or belt fed firearm feeding device capacity. The author has made reasonable effort to be thorough and accurate but the information cannot be guaranteed. The U. S. Department of Justice BATFE Publication P5300.5 26th Edition is a very good reference on firearms laws. However, even that publication is incomplete as the firearms ordinances, including the magazine capacity restriction, are not contained therein for the City of Philadelphia, Pennsylvania.

Disclaimer: Firearms owners are responsible for their actions. If you are unsure of the law, consult the local law enforcement agency and/or an attorney knowledgeable in firearms laws. This is not legal advice. Consult an attorney for any legal matter.

Table 47: M14 Magazine Capacity Restrictions in the USA

Jurisdiction	Centerfire Rifle Magazine Capacity Prohibited
California	> 10 rounds made after January 01, 2000
District of Columbia	semi-automatic firearm with a magazine > 12 rounds capacity is defined as a machine gun and thus prohibited
Aurora, Illinois	> 15 rounds
Chicago, Illinois	> 12 rounds
South Bend, Indiana	> 15 rounds
Maryland	> 20 rounds
Massachusetts	> 10 rounds made after September 13, 1994
Boston, Massachusetts	> 10 rounds
New Jersey	> 15 rounds
New York	> 10 rounds made after September 13, 1994
Buffalo, New York	> 5 rounds

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New York City, New York	> 5 rounds
Rochester, New York	> 5 rounds
Ohio	> 30 rounds
Cincinnati, Ohio	> 10 round
Cleveland, Ohio	> 19 rounds
Columbus, Ohio	> 20 rounds
Dayton, Ohio	> 10 rounds
Toledo, Ohio	> 10 rounds
Philadelphia, Pennsylvania	> 10 rounds

Appendix G

T44E4 Rifle Parts and Recommended Spare Parts

The U. S. Army Ordnance Corps at Rarital Arsenal promulgated an Instructor Guide on the M14 (T44E4) Rifle on January 02, 1958. This guide, CMT-IG Number 38 Notes on Rifle Caliber 7.62MM M14 (T44E4), included physical data, a general description and a list of T44E4 parts and required spare parts. M14 parts production did not start until December 1958. Some of the associated drawings, including the M14 receiver, had not yet been drawn. The following is a list of T44E4 parts and the numbers of spare parts for maintenance of 100 rifles from CMT-IG Number 38.

Table 48: T44E4 Rifle Parts and Recommended Spare Parts

Ordnance Drawing Number	T44E4 Part Description	Number of Spare Parts for Maintenance of 100 Rifles
BCTX2.2 (147457)	full dog point set socket screw	10
BEAX1 (138534)	lock tooth type washer	
BFSX2.1 (586045)	selector shaft pin	2
BFSX2.1 (586062)	spindle valve pin	50
BFSX2.1 (586072)	bolt lock pin	10
BFSX2.1 (586081)	magazine latch pin	9
BFSX2.1 (586085)	pin	20
BMCX1.3 (135285)	(2) truss head rivet	10
B5013668	hammer pin	4
B5013669	trigger pin	4
A5013673	sear pin	
B5152863	butt plate plunger spring	
B5152864	butt plate plunger	
A5152865	butt plate cap pin	
D5546020	trigger	
D5564277	butt plate	
D5564283	butt plate assembly	
B6008870	hand guard band (clip)	

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C6008872	rear sight cover	2
B6008880	hammer spring plunger	2
C6008881	long butt plate screw	2
C6008883	hammer spring housing	2
B6008887	hammer spring	5
C6008889	butt swivel	2
B6146873	small butt plate screw	2
D6147465	butt plate cap	
B7267007	front swivel bracket	
D7267013	gas cylinder	4
B7267017	stock ferrule	
D7267018	magazine follower	
C7267019	magazine follower and stop assembly	
D7267020	hand guard	
D7267021	hand guard assembly	10
D7267022	trigger guard	
D7267023	trigger guard and stop assembly	4
C7267025	operating rod guide	4
C7267027	operating rod spring guide	10
F7267029	operating rod handle	
F7267030	trigger housing	
D7267031	trigger and latch housing assembly	4
C7267032	magazine latch	5
C7267033	stock liner	
C7267034	bolt lock	5
C7267036	gas cylinder lock	4
B7267037	front swivel loop	
D7267038	magazine assembly	1000

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B7267039	flash suppressor nut	5
B7267041	magazine latch spring	5
D7267047	gas piston	4
B7267050	connector plate	
C7267051	magazine floor plate	
C7267053	gas cylinder plug	4
D7267058	sear release	5
B7267063	(2) stock liner screw	8
D7267064	operating rod assembly	8
D7267066	safety	2
D7267067	front sight screw	2
D7267070	sear	
C7267071	selector switch	5
C7267072	selector shaft	5
D7267073	front sight	2
B7267074	bolt lock spring	5
B7267076	connector spring	
C7267078	magazine spring	
B7267079	operating rod spring	5
B7267080	safety spring	5
B7267081	selector spring	5
F7267083	stock	
F7267084	stock assembly with butt plate	10
B7267085	magazine stop	
F7267088	flash suppressor	5
C7267089	front swivel assembly	2
C7267090	trigger and sear assembly	4
D7267091	magazine tube	
B7267092	operating rod tube	

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C7267604	spindle valve	5
B7267605	spindle valve spring	10
D7267963	hammer	4
B7312633	hammer stop	
C7312725	indexing dog	
C7312726	rear sight nut	
B7312727	dog retainer	
B7312728	rear sight nut retainer	
B7312729	rear sight screw retainer	
C7312730	rear sight screw	2
C7312731	rear sight lock nut	
C7312732	rear sight spring	
C7312733	indexing dog assembly	
D7312734	elevating knob	
D7312735	windage knob	
D7312736	elevating pinion	
D7312737	windage knob assembly	4
D7312738	elevating pinion assembly	4

Appendix H

USGI M14 Rifle Spare Parts Allowance

U. S. Army Technical Manual 9-1005-223-35 July 1968 lists the maximum parts quantity allowed at the Direct Support, General Support and Depot Maintenance levels.

Table 49: M14 Rifle Spare Parts Allowance for 100 Rifles

M14 Rifle Part	DS 30 Days for 100 Rifles	GS 30 Days for 100 Rifles	Depot Main- tenance for 100 Rifles
magazine	6	4	15
hand guard assembly	2	2	20
small arms sling	2	2	
trigger pin	2	2	12
trigger and sear assembly	2	2	6
hammer spring housing	2	2	6
ejector spring	2	2	12
hammer spring plunger	2	2	4
hammer pin	2	2	8
hammer	2	2	12
safety	2	2	10
safety spring	2	2	12
trigger guard	2	2	12
trigger housing assembly	2	2	6
magazine latch pin	2	2	100
magazine latch	2	2	6
magazine latch spring	2	2	6
stock subassembly	2	2	20
upper butt stock screw	2	2	6
stock nut retainer	2	2	12
stock nut	2	2	12
lower butt stock screw	2	2	12

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butt swivel	2	2	6
hinged butt plate assembly	2	2	12
butt plate hinge pin			24
butt plate stop pin			24
butt plate rest (flapper)			10
butt plate ball bearing			10
butt plate hinge spring			10
butt plate door pin			10
butt plate door catch			10
butt plate door catch spring			10
connector assembly	2	2	6
connector pin	2	2	300
connector plunger			12
connector spring			12
operating rod spring guide	2	2	6
operating rod spring	2	2	24
operating rod	2	2	8
extractor	2	2	24
ejector with spring	2	2	24
extractor spring plunger	2	2	12
firing pin	2	2	48
bolt	2	2	12
bolt roller	2	2	24
bolt roller retainer	2	2	24
elevation knob and pinion assembly	2	2	20
windage knob	2	2	24
rear sight aperture	2	2	6
rear sight cover	2	2	6
rear sight base	2	2	6

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selector shaft lock	2	2	6
selector switch	2	2	6
selector shaft spring	2	2	6
selector shaft	2	2	10
sear release	2	2	6
gas cylinder plug	2	2	20
gas piston	2	2	6
flash suppressor set screw	2	2	24
flash suppressor nut	2	2	12
flash suppressor	2	2	20
front sight screw	2	2	12
front sight	2	2	12
gas cylinder lock	2	2	12
gas cylinder	2	2	12
spindle valve	2	2	6
spindle valve spring	2	2	24
front band	2	2	10
operating rod guide pin	2	2	100
operating rod guide	2	2	6
bolt lock pin	2	2	100
bolt lock	2	2	6
bolt lock spring	2	2	20
connector lock pin	2	2	100
connector lock	2	2	6
stripper clip guide pin	2	2	100
stripper clip guide	2	2	5
barrel			20

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