



COLT'S MANUFACTURING Co, LLC
P.O. BOX 1868
HARTFORD, CT 06144

STANDARD OPERATION INSTRUCTION SHEET

PART NAME: M4/M4A1 CARBINE, FINAL PACK-AGING ASSY, R0920USG/R0921USG
OPERATION: PRESERVE RIFLE PRIOR TO PACKAGING

PART NO: R0920USG TAB

OPER NO: 110

DRAWN: GC

DATE: 12-8-16

DEPT: 153

CHECKED:

DATE:

MACHINE: BENCH

SHT# 1 OF 1

DO NOT SCALE

FINISH REQ'D ¹²⁵ ✓
UNLESS OTHERWISE
SPECIFIED

LOCATE



TABULATION:

MODEL PART NO.

R0920USG 9390000 (M4)
R0921USG 12972700 (M4A1)

MATERIALS:

- ④ 402423 TUBE, BORE, VCI TREATED
(7266299-4, .19" OD x 19" LG)

OIL BARREL &
FRONT SIGHT AT
④ FINAL INSPECTION

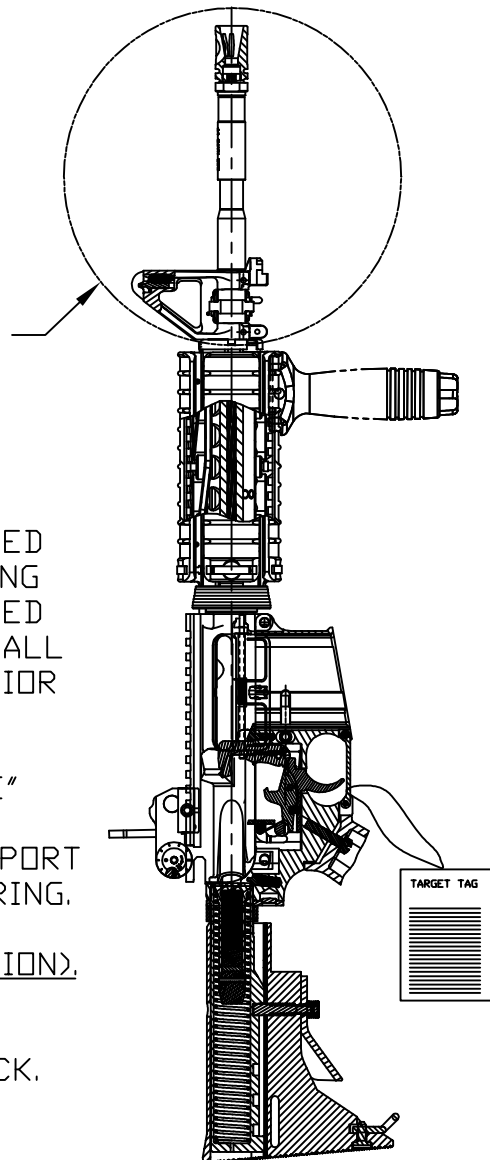
④ NOTE: (REFERENCE)

ALL METALLIC SURFACES OF THE RIFLE SHALL BE COATED WITH TECTYL 802A (MIL-PRF-3150), APPLIED BY BRUSHING OR SPRAYING. EXCESS OIL SHALL BE THOROUGHLY DRAINED FROM THE COATED SURFACES. THE PRESERVED RIFLE SHALL BE ALLOWED TO DRAIN FOR A MINIMUM OF ONE HOUR PRIOR TO CONTINUING WITH THE PACKAGING.

- ④ REMOVE SAFETY PLUGS, SET FIRING SELECTOR TO "SEMI" POSITION. ASSURE THAT THE HAMMER IS IN THE FIRED POSITION (AGAINST THE BOLT CATCH), AND THE FIRING PORT COVER IS LATCHED SHUT. RELEASE TRIGGER BY DRY FIRING.

- ④ ENSURE OIL BARREL & FRONT SIGHT AT (FINAL INSPECTION).

INSERT VCI BORE TUBE INTO BARREL & BEND TO SUIT.
CUT TAGS OFF RIFLE & GROUP TOGETHER, ASIDE TO RACK.



1-82057	BRUSH	
99744	TECTYL 802A / MIL-PRF-3150 (OIL, PRESERVATIVE, MEDIUM)	
TOOL NO	TOOL NAME	SYMBOL

B	9-22-17	BORE TUBE WAS 91178, OIL BBL & FRT SIGHT UPDATED	GC
A	2-7-17	UPDATED PROCESS FOR REFERENCE	GC
-	12-8-16	(RE-COMPETE) INITIAL RELEASE/ECO 52818	GC
SYM	DATE	CHANGE RECORD	BY
F-6004A Rev. 06-14			