

FIG. 1

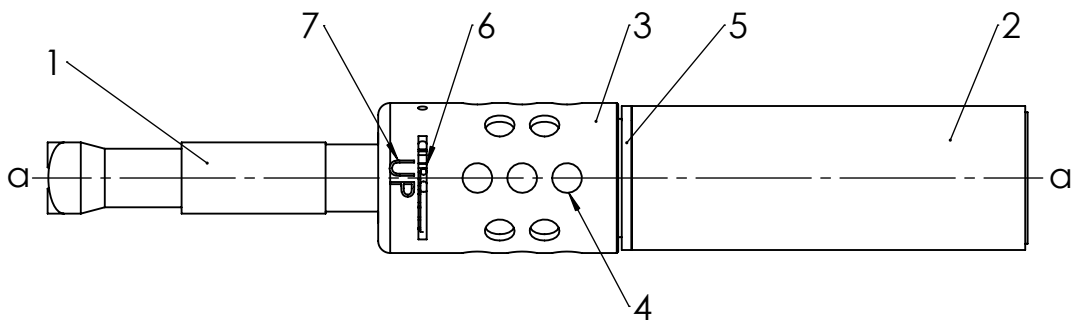


FIG. 2

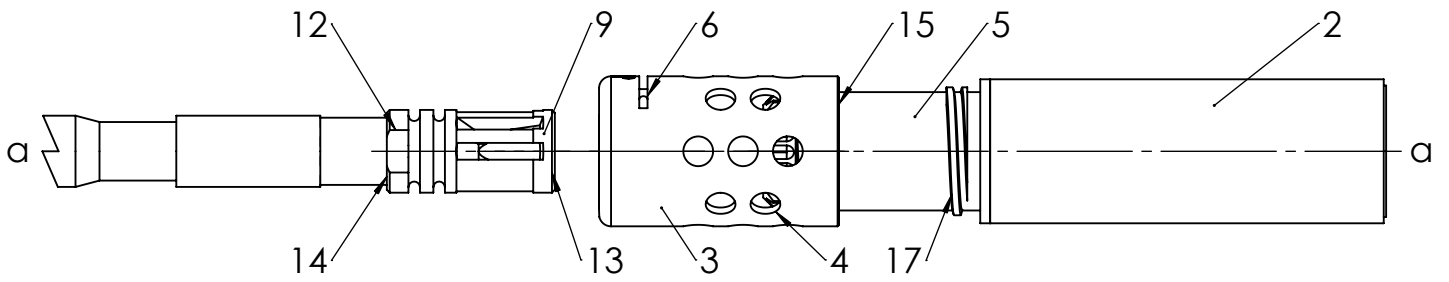


FIG. 3

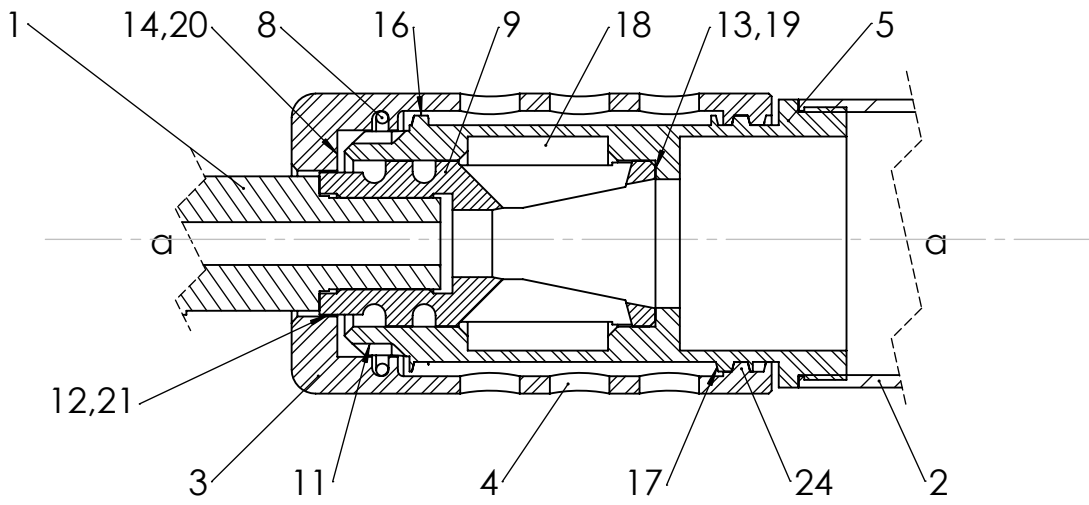


FIG. 4

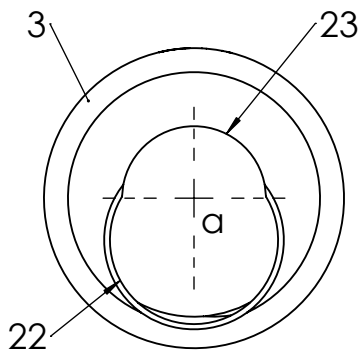


FIG. 5

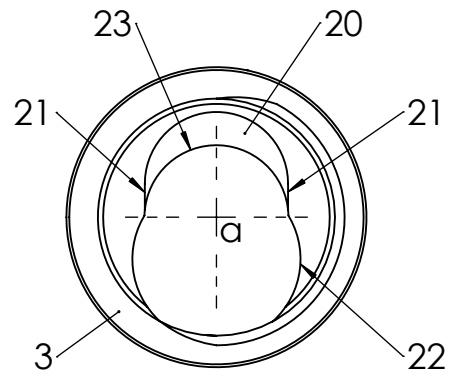


FIG. 6

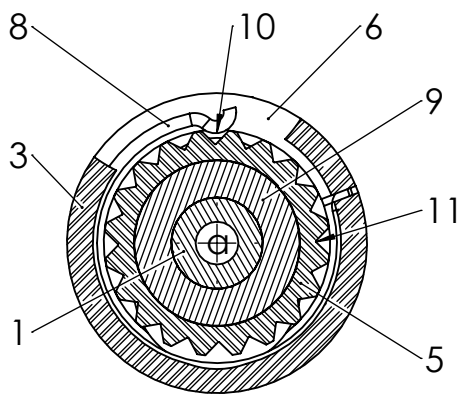


FIG. 7

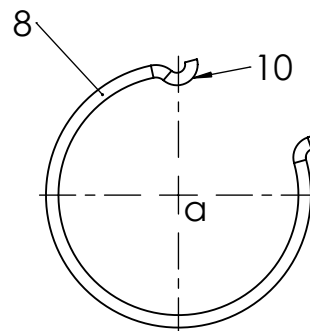
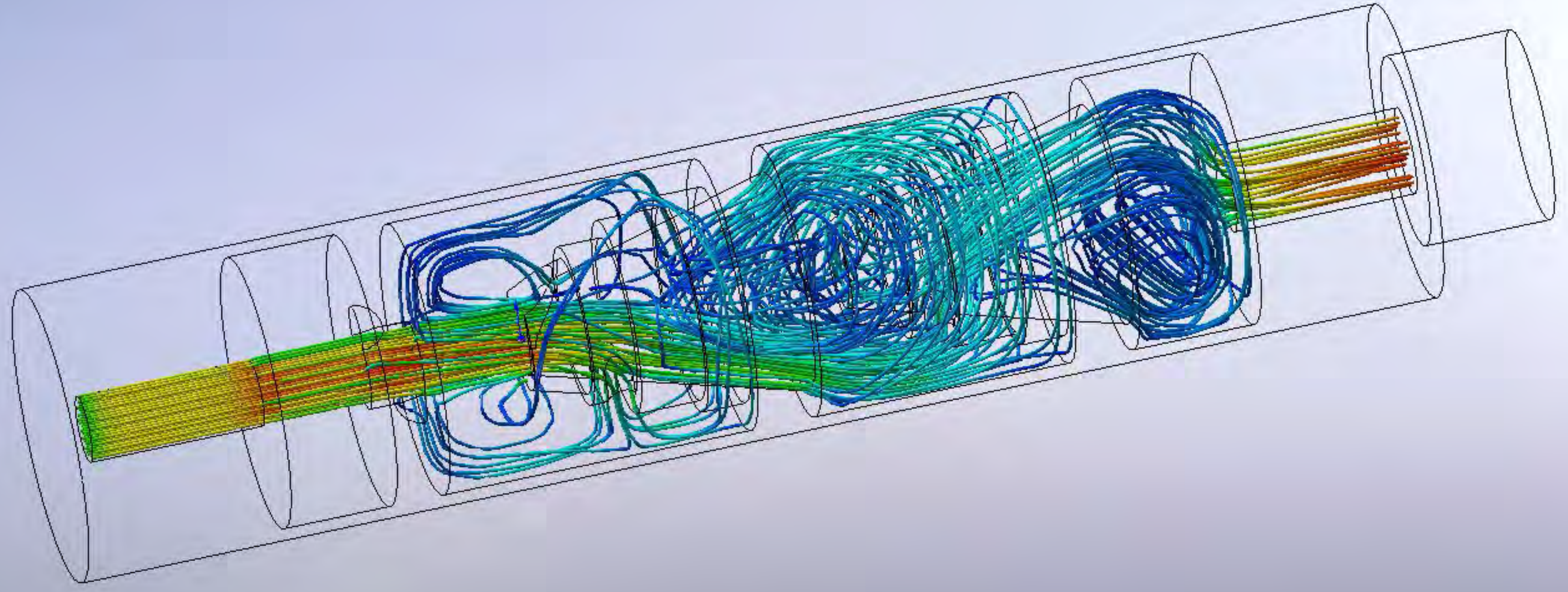
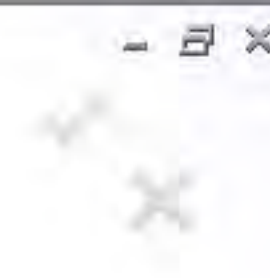
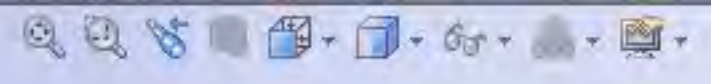
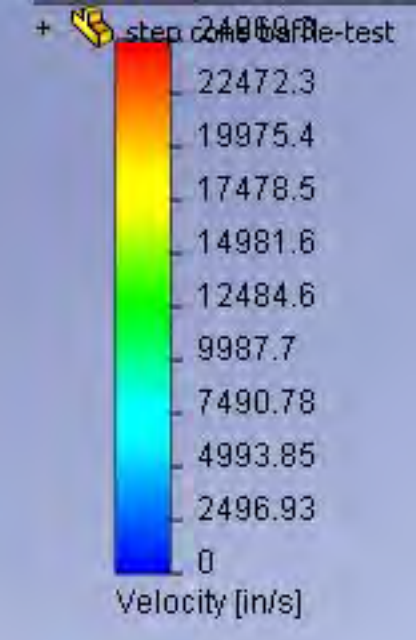


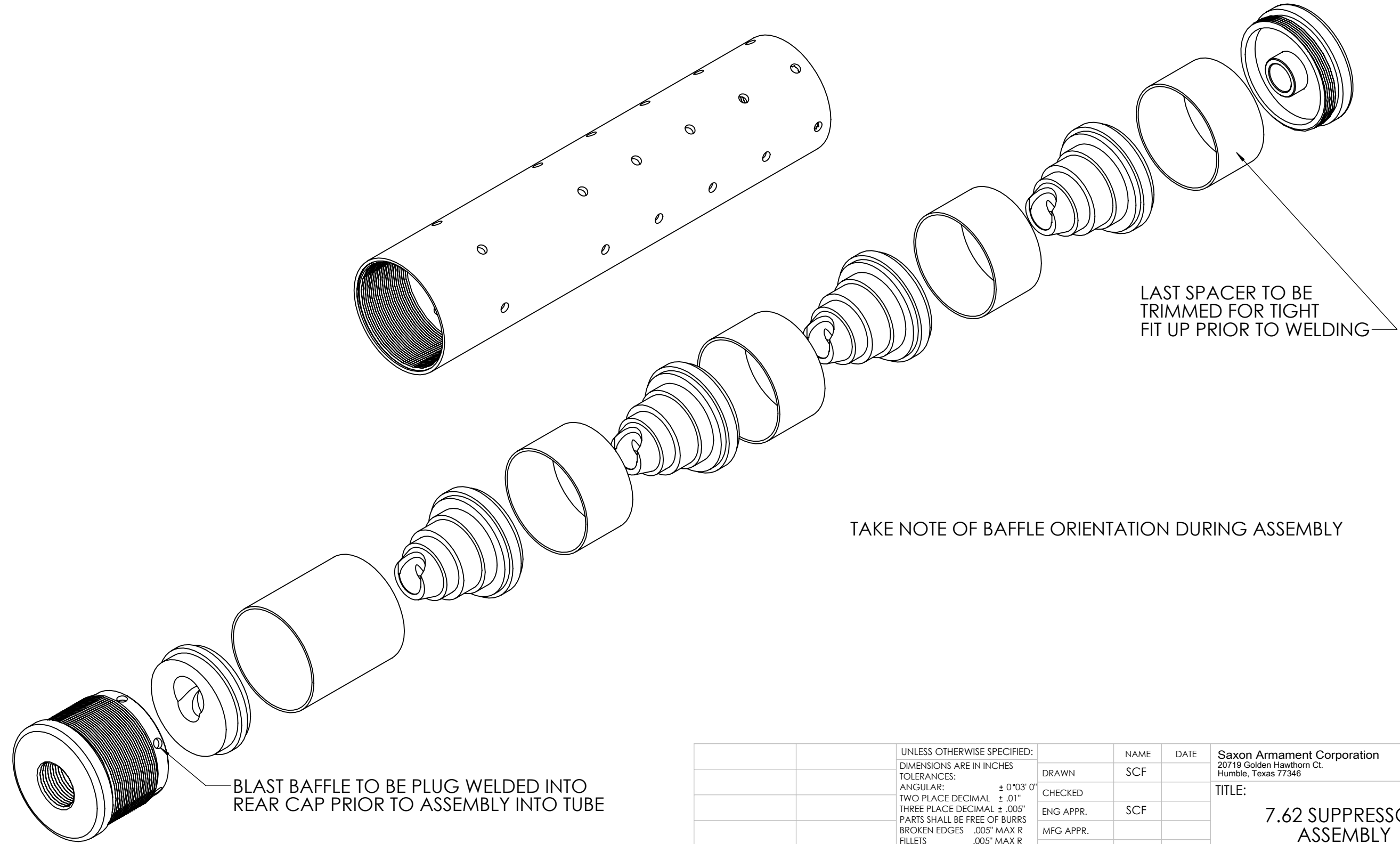
FIG. 8



8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



BLAST BAFFLE TO BE PLUG WELDED INTO REAR CAP PRIOR TO ASSEMBLY INTO TUBE

LAST SPACER TO BE TRIMMED FOR TIGHT FIT UP PRIOR TO WELDING

TAKE NOTE OF BAFFLE ORIENTATION DURING ASSEMBLY

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		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	Saxon Armament Corporation 20719 Golden Hawthorn Ct. Humble, Texas 77346	
		DIMENSIONS ARE IN INCHES		DRAWN	SCF	TITLE:	
		TOLERANCES:		CHECKED		7.62 SUPPRESSOR ASSEMBLY	
		ANGULAR: ± 0°03' 0"		ENG APPR.	SCF	SIZE	
		TWO PLACE DECIMAL ± .01"		MFG APPR.		DWG. NO.	
		THREE PLACE DECIMAL ± .005"		Q.A.		762SUPP-1A	
		PARTS SHALL BE FREE OF BURRS		COMMENTS:	REV		
		BROKEN EDGES .005" MAX R		HEAT TREAT	A		
		FILLET .005" MAX R			SCALE: 1:1.2 WEIGHT: 24 oz SHEET 1 OF 7		
		CONCENTRICITY ± .003"					
		SURFACE ROUGHNESS					
		MATERIAL					
		304 SS					
NEXT ASSY		USED ON					
APPLICATION		DO NOT SCALE DRAWING					

8 7 6 5 4 3 2 1

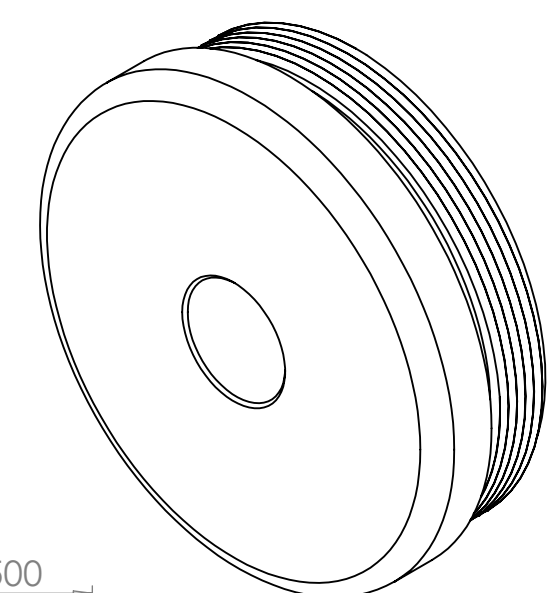
8 7 6 5 4 3 2 1

D

C

B

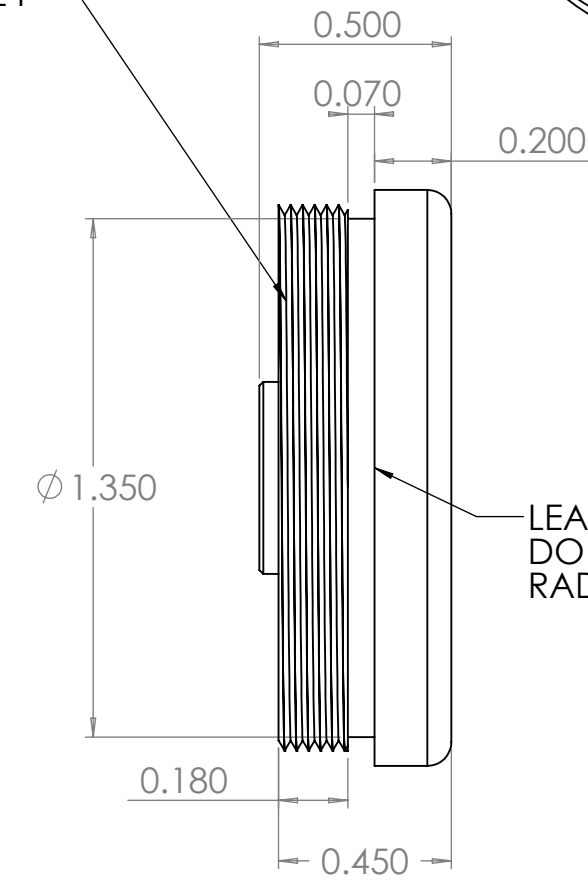
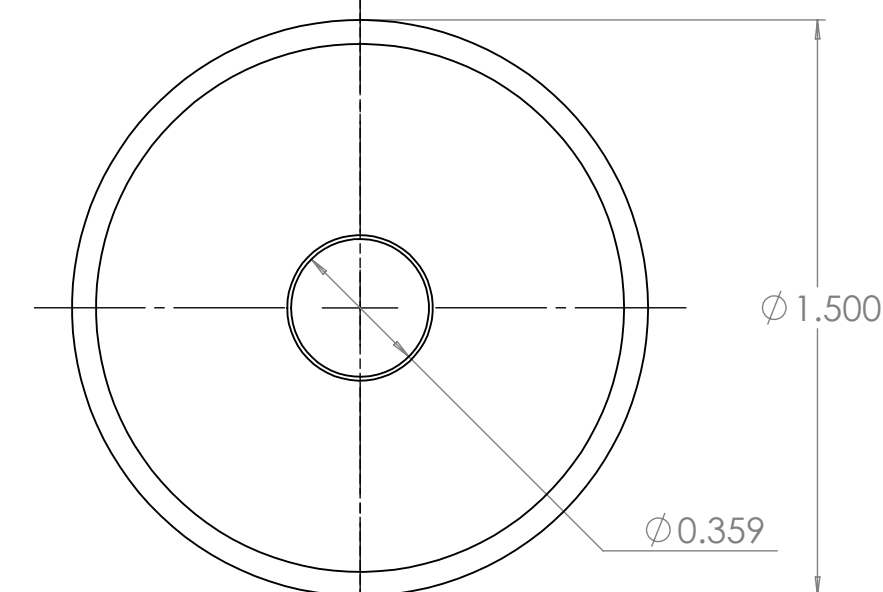
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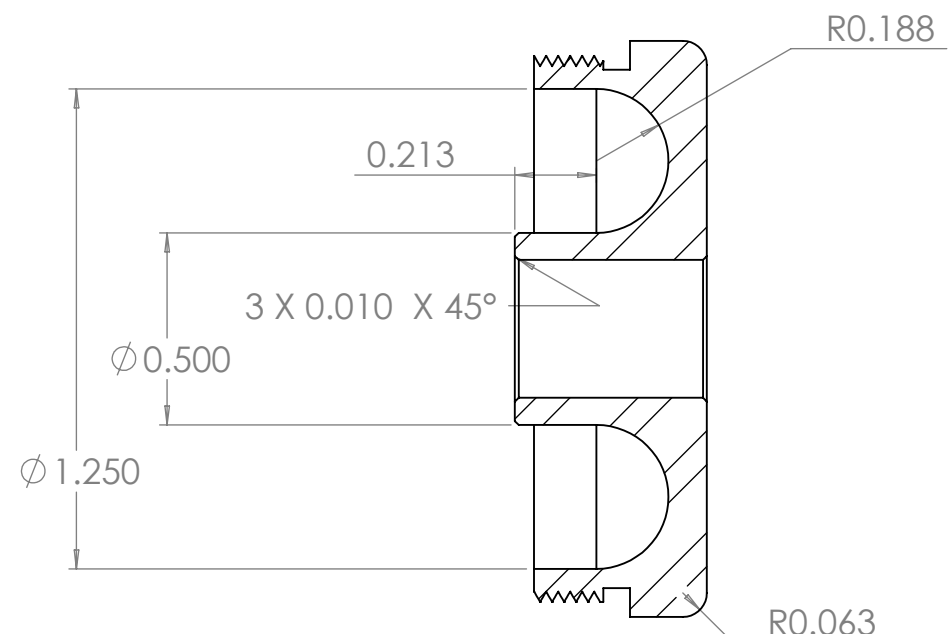
1.4219 X 32 TPI
 OUTSIDE DIA. - 1.420 / 1.414
 PITCH DIA. - 1.4004 / 1.3966
 MINOR DIA. - 1.3824

F

F



LEAVE THIS EDGE SHARP
 DO NOT DE-BURR OR
 RADIUS



SECTION F-F
 SCALE 2 : 1

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		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: ANGULAR: ± 0°03' 0" TWO PLACE DECIMAL ± .01" THREE PLACE DECIMAL ± .005" PARTS SHALL BE FREE OF BURRS BROKEN EDGES .005" MAX R FILLETS .005" MAX R CONCENTRICITY ± .003" SURFACE ROUGHNESS		DRAWN	NAME	DATE	Saxon Armament Corporation 20719 Golden Hawthorn Ct. Humble, Texas 77346	
				CHECKED	SCF		TITLE: 7.62 SUPPRESSOR FRONT CAP	
				ENG APPR.	SCF		SIZE B DWG. NO. 762SUPP-1FC REV A	
				MFG APPR.			SCALE: 1:1 WEIGHT: SHEET 6 OF 7	
				Q.A.				
				COMMENTS:				
NEXT ASSY		USED ON		HEAT TREAT				
APPLICATION		DO NOT SCALE DRAWING						

8 7 6 5 4 3 2 1

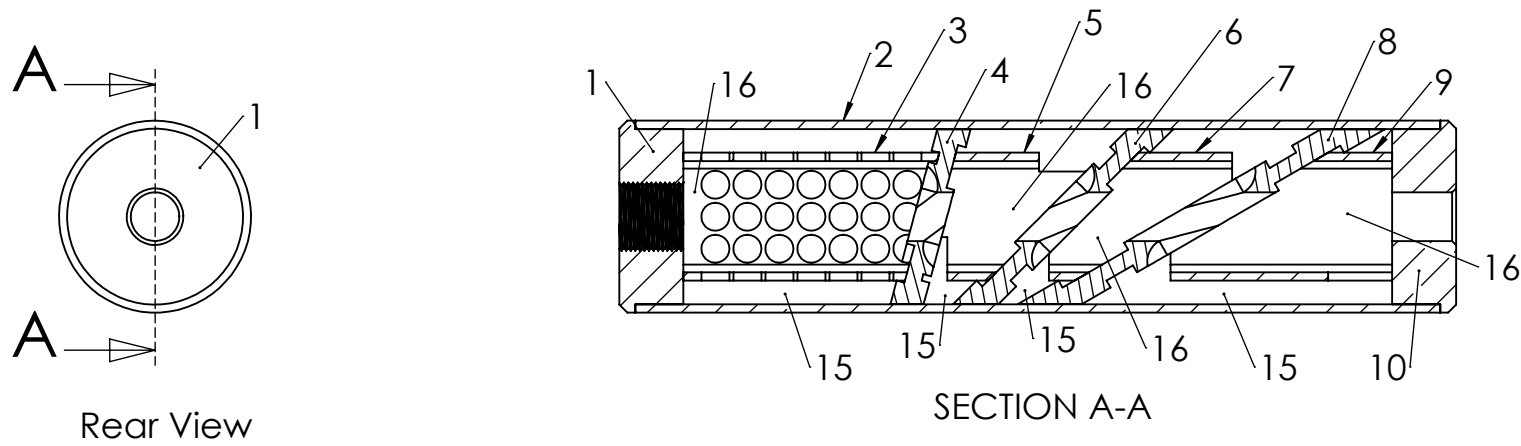
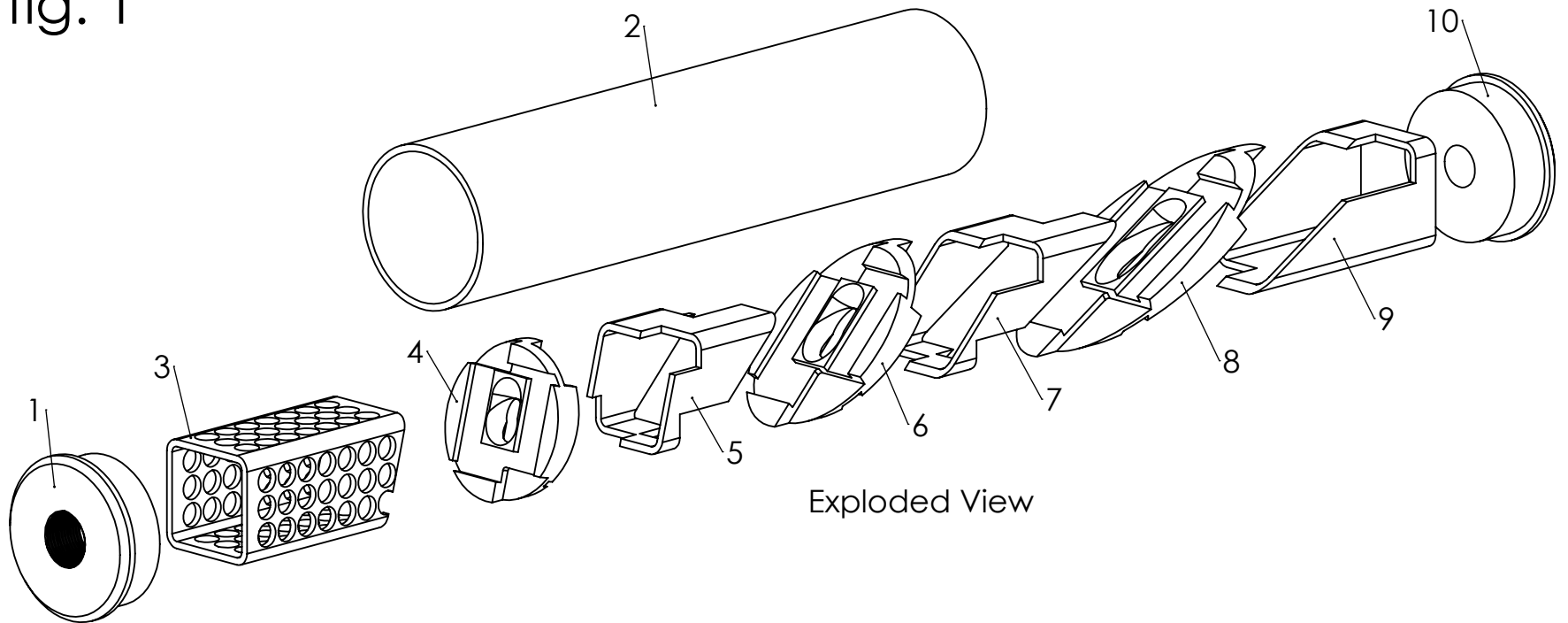


fig. 1



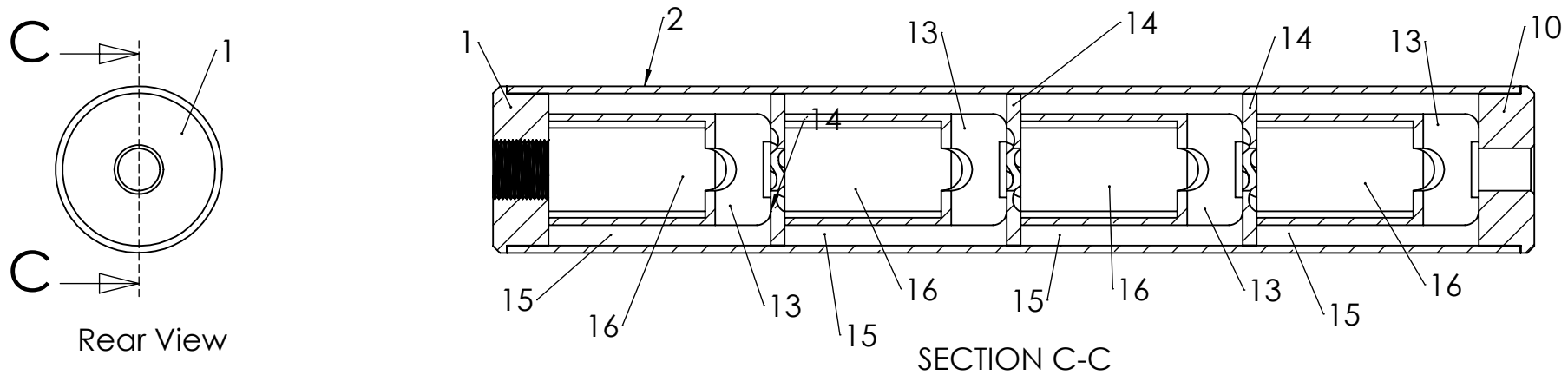
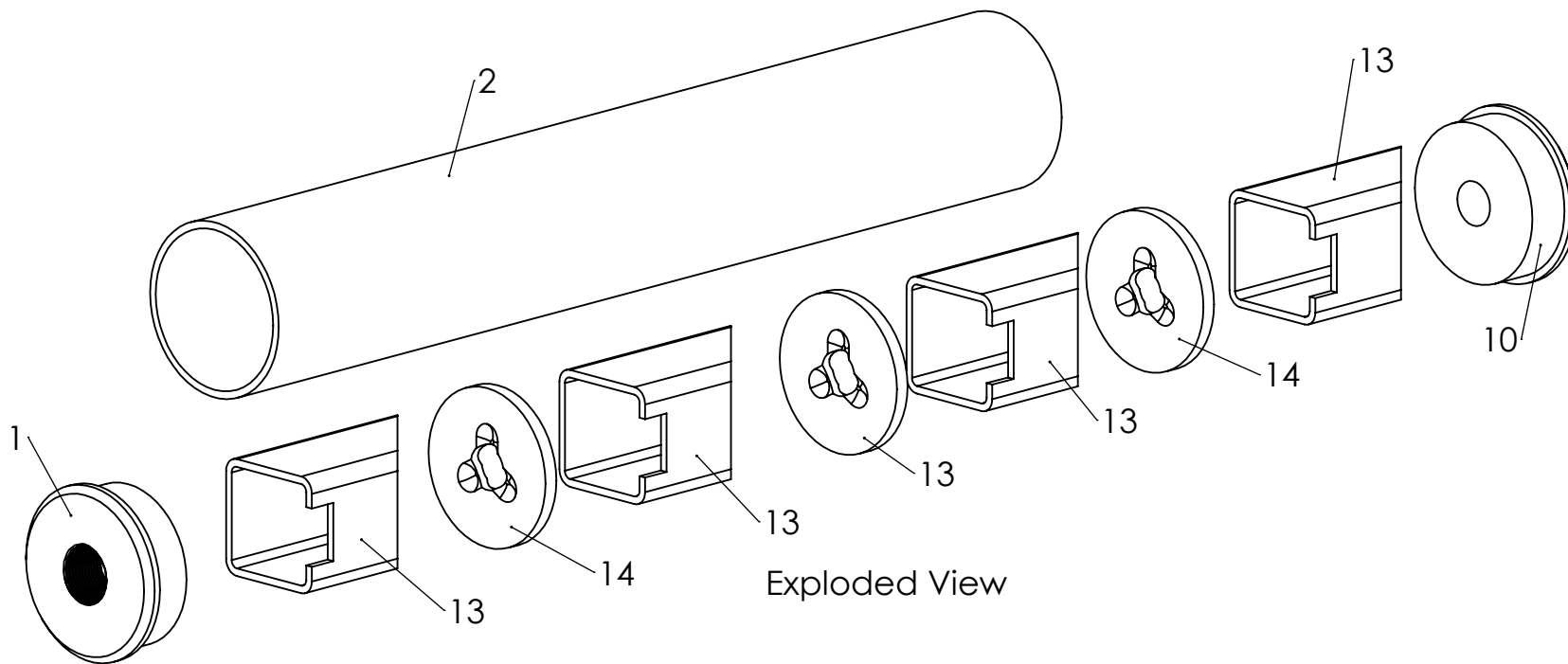


fig. 3



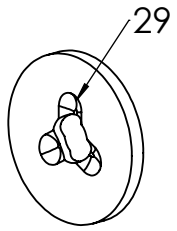


fig. 4

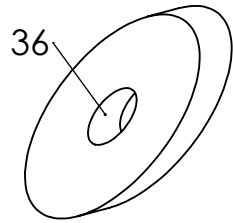


fig. 5

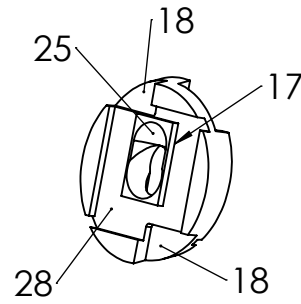


fig. 6

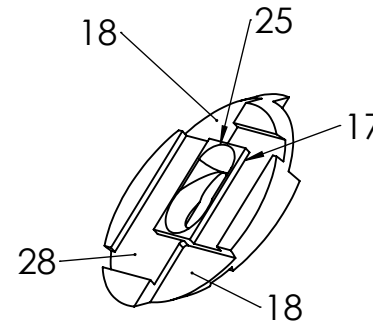


fig. 7

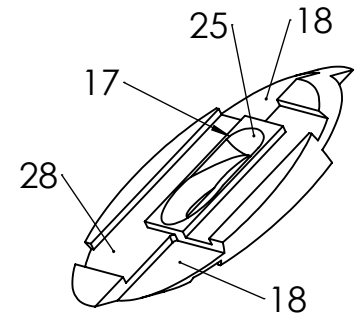


fig. 8

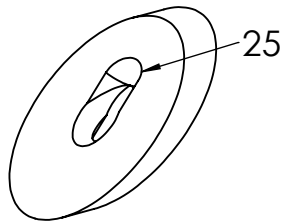


fig. 9

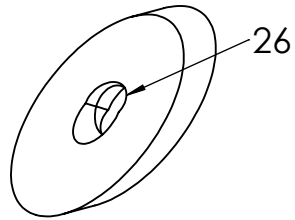


fig. 10

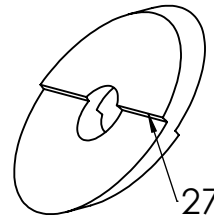


fig. 11

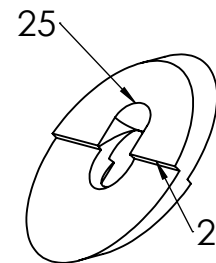


fig. 12

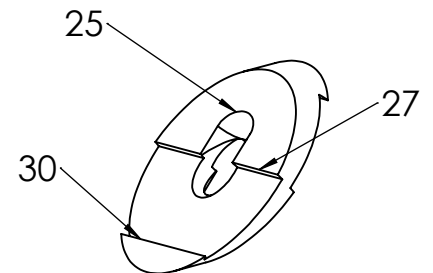


fig. 13

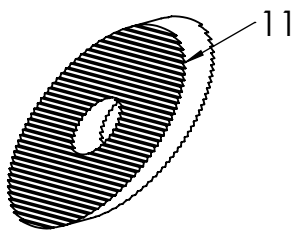


fig. 14

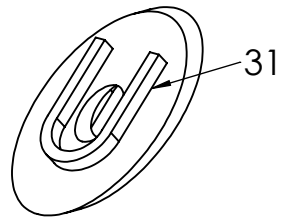


fig. 15

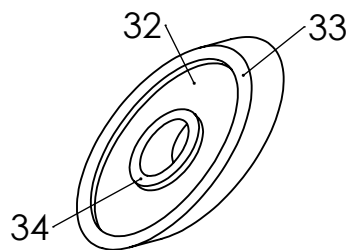


fig. 16

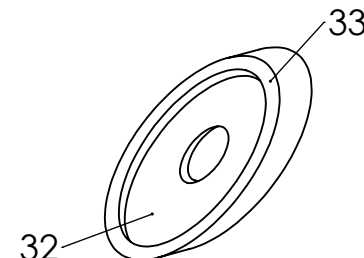


fig. 17

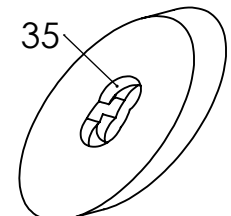


fig. 18

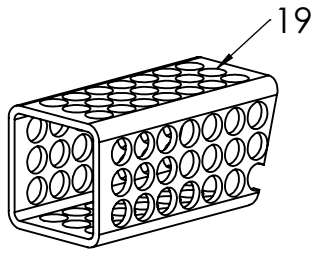


fig. 19

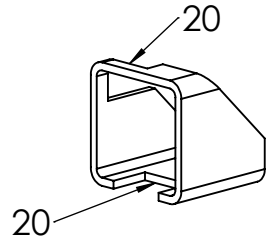


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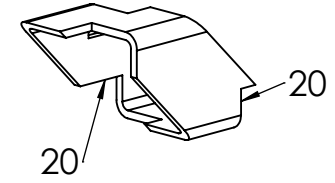


fig. 21

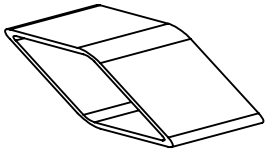


fig. 22

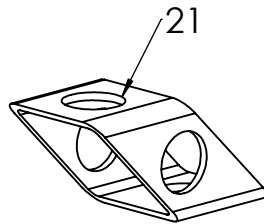


fig. 23

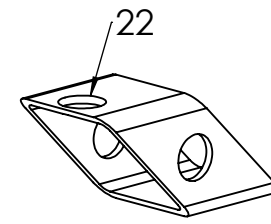


fig. 24

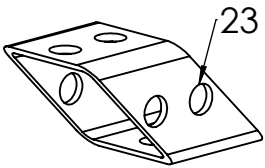


fig. 25

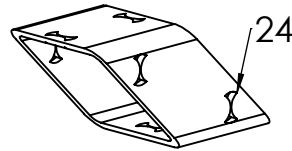


fig. 26

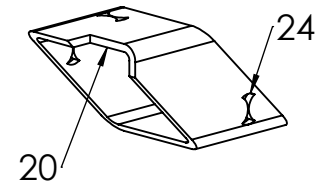


fig. 27

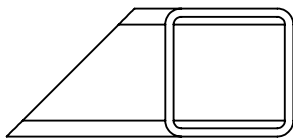


fig. 28

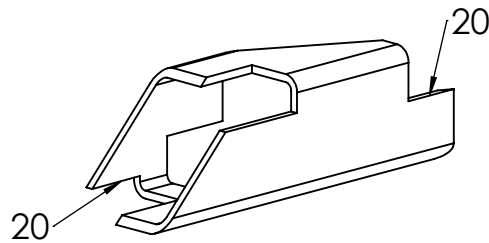


fig. 29

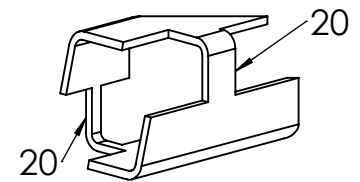


fig. 30

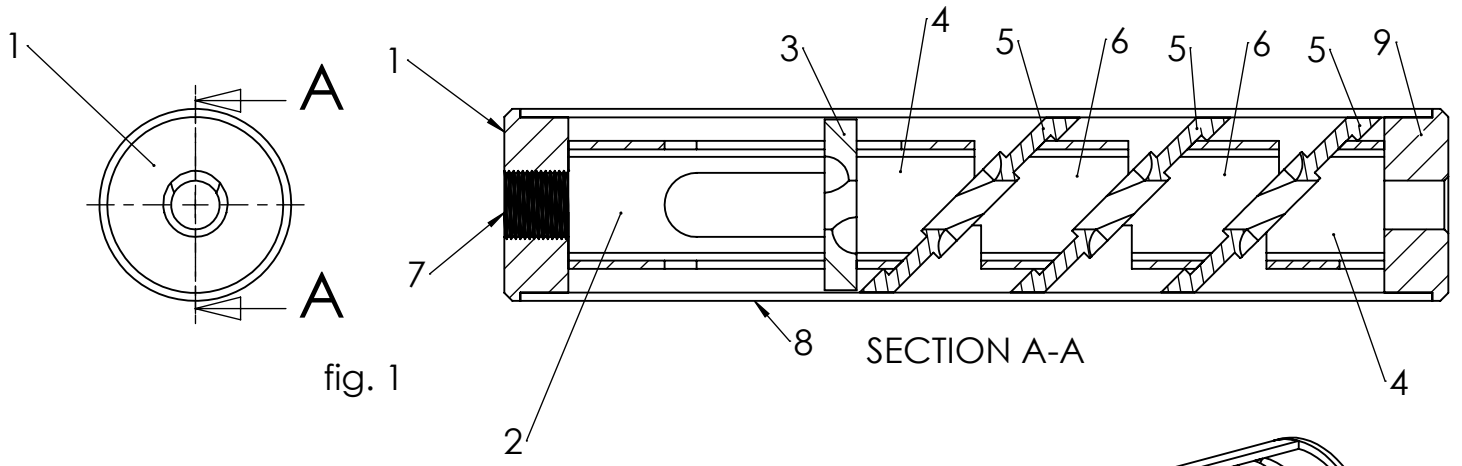


fig. 1

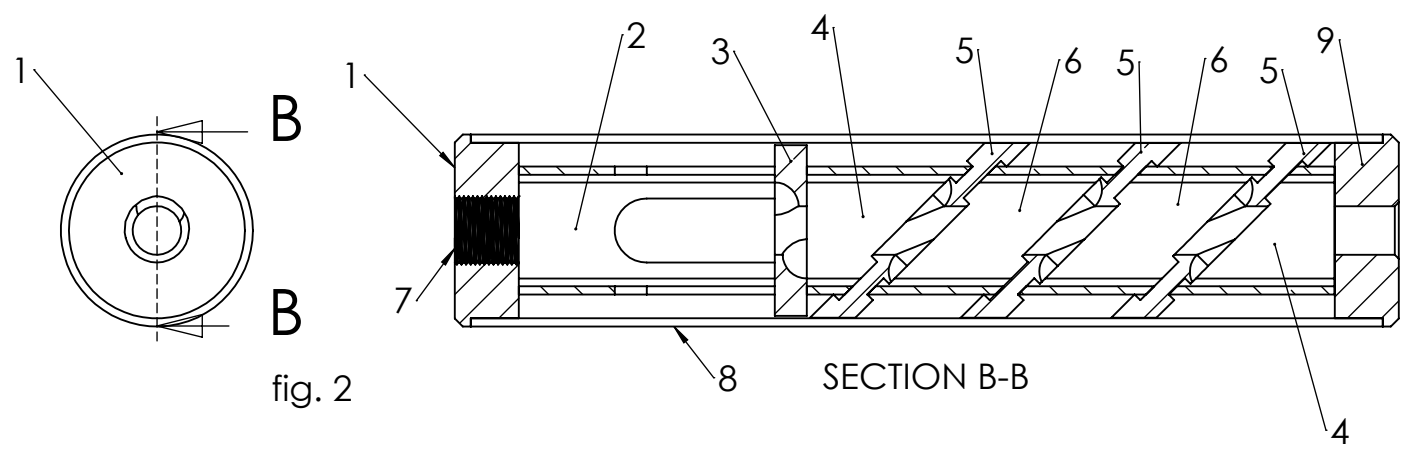
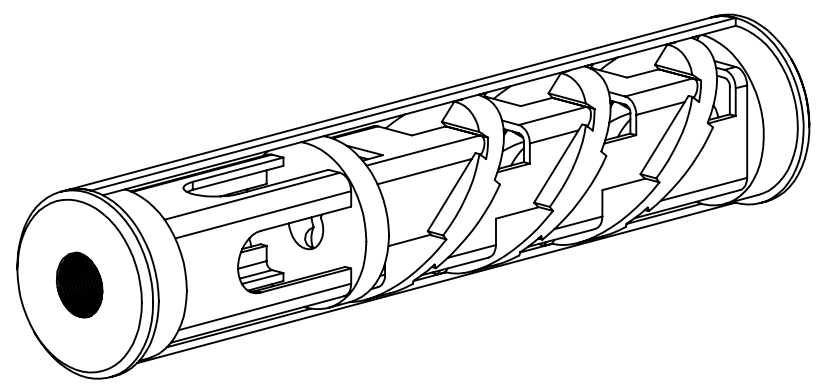
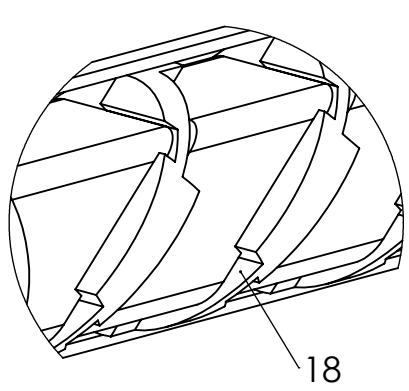
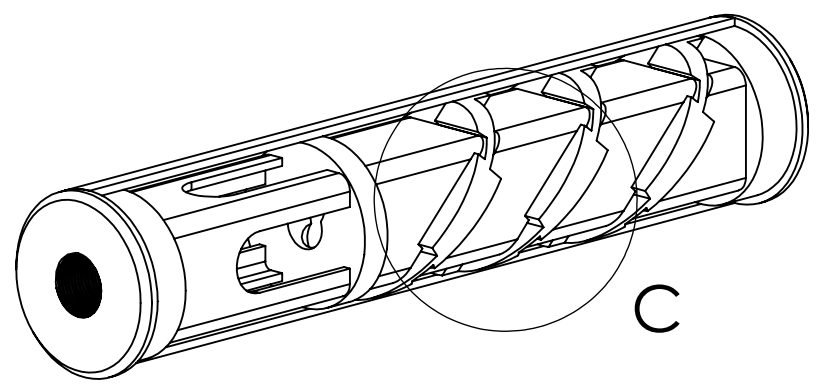


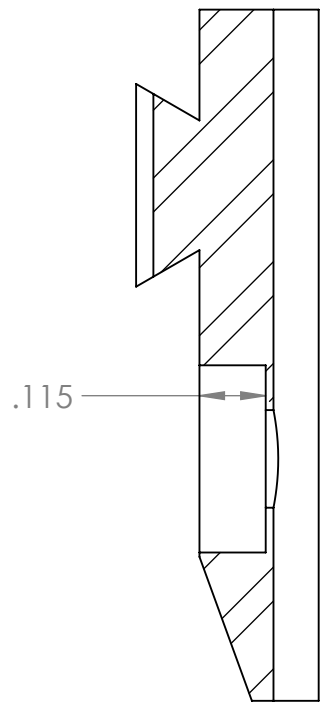
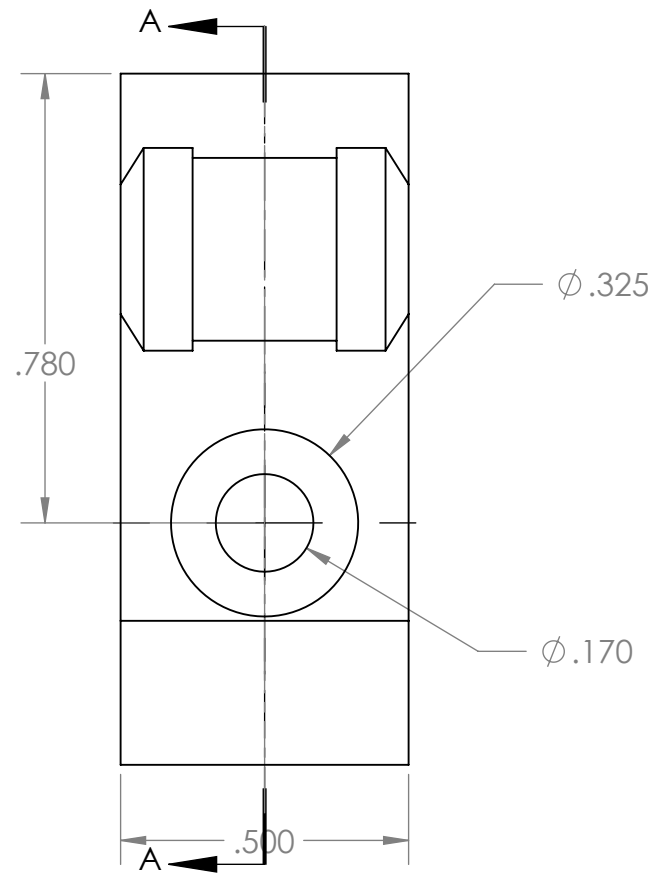
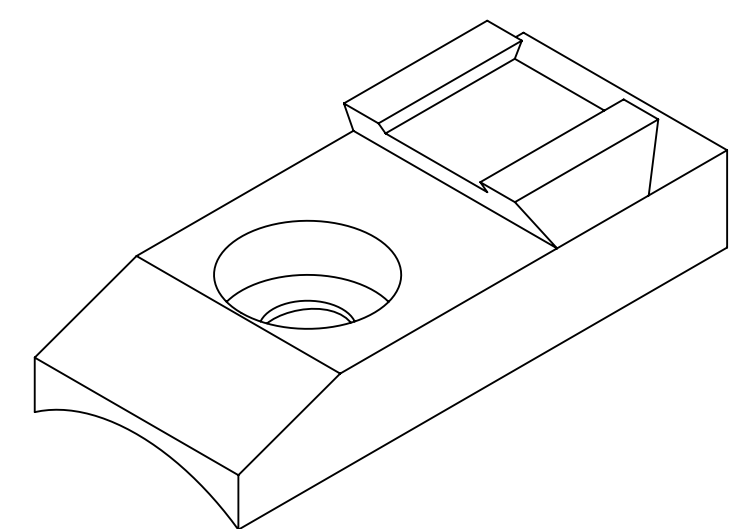
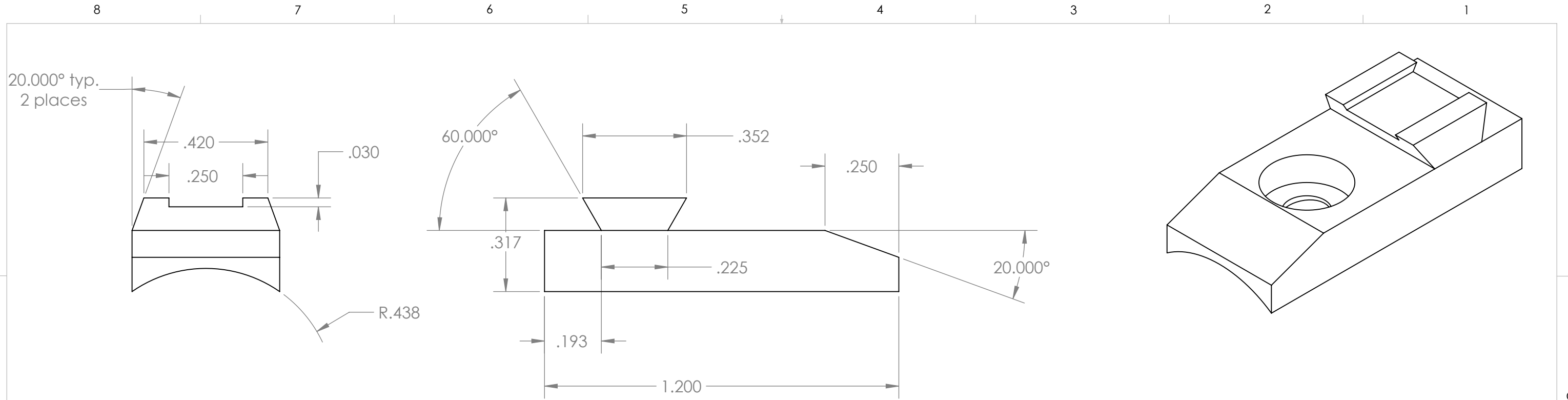
fig. 2



DETAIL C



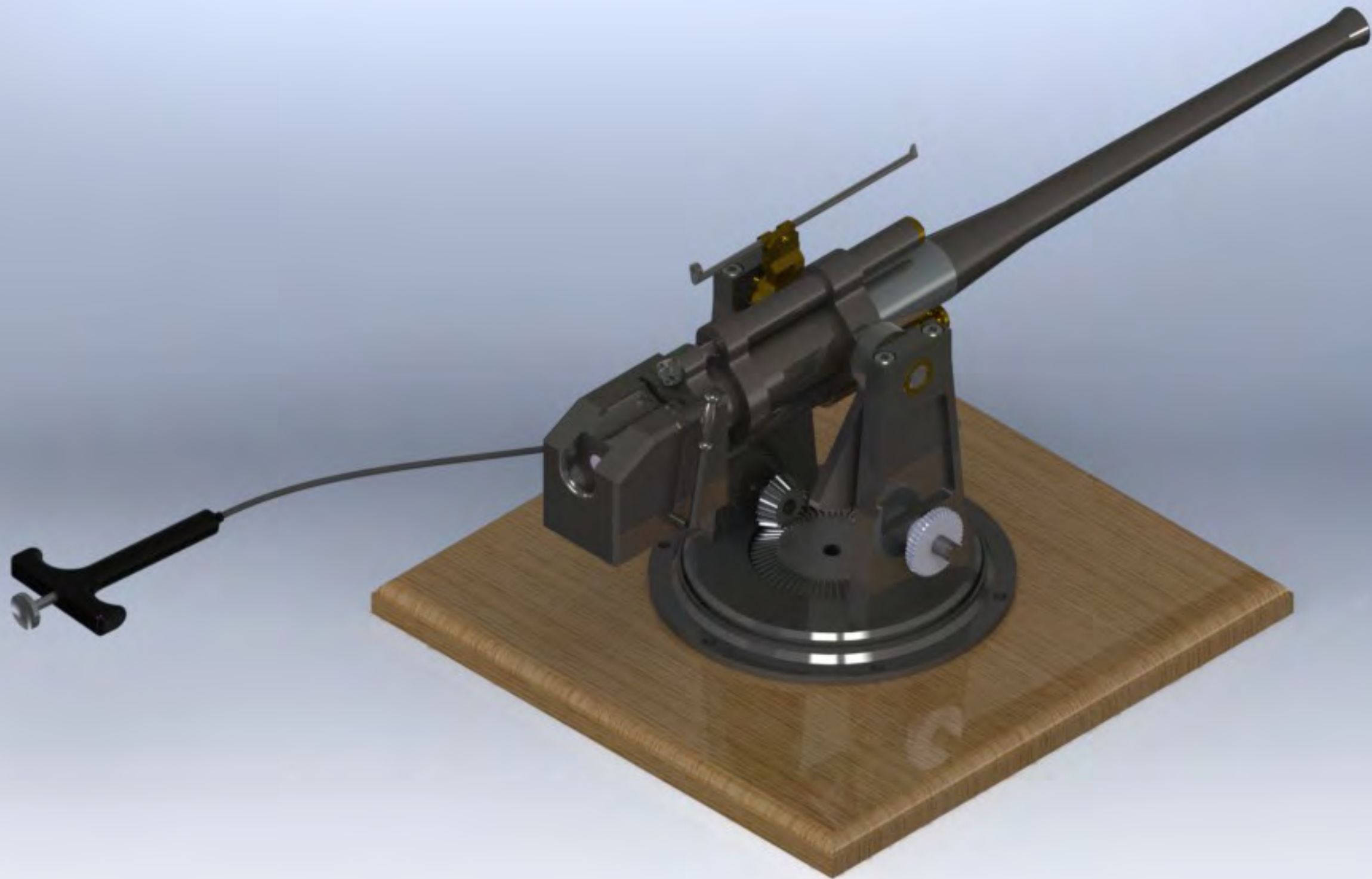
C



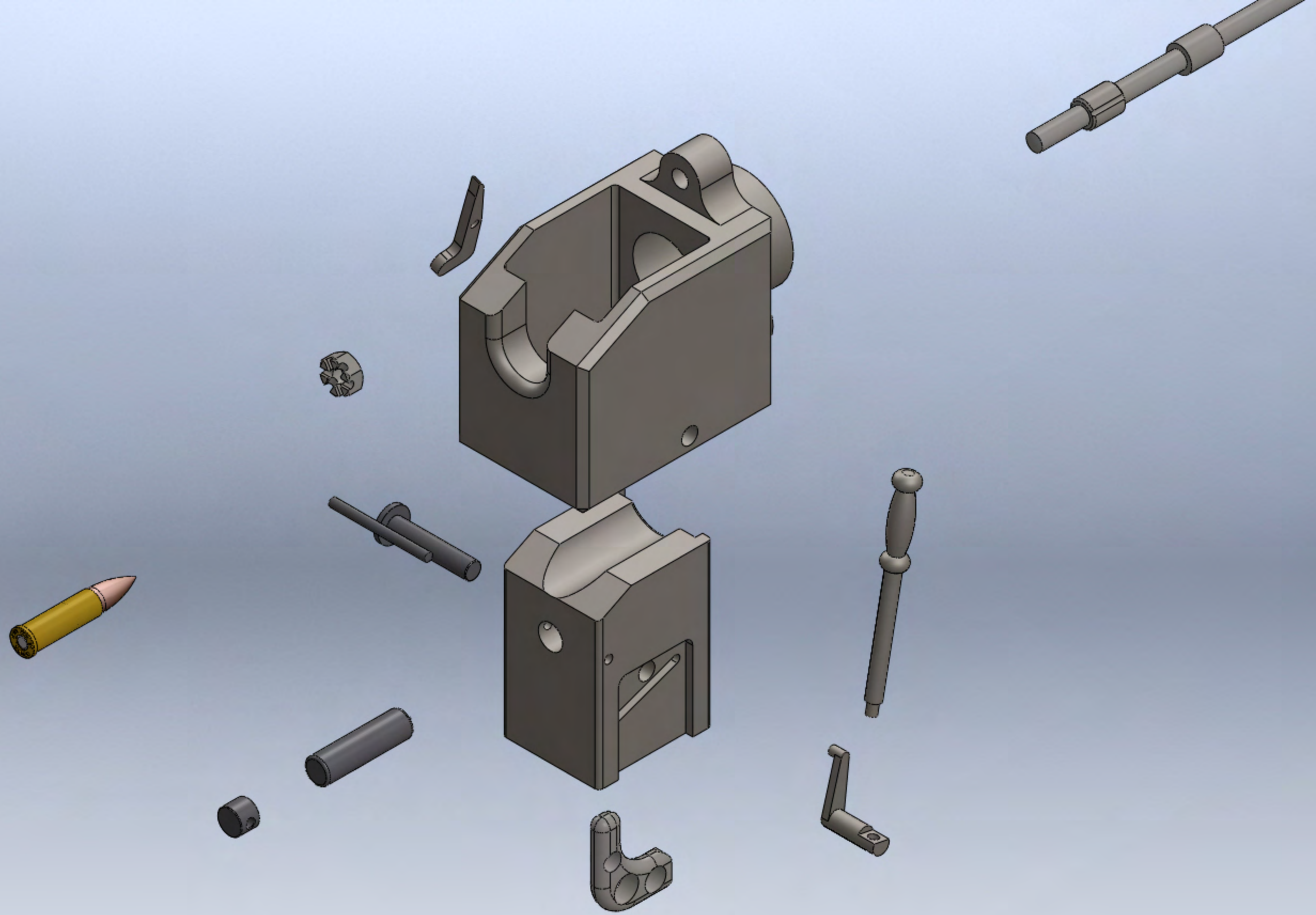
SECTION A-A

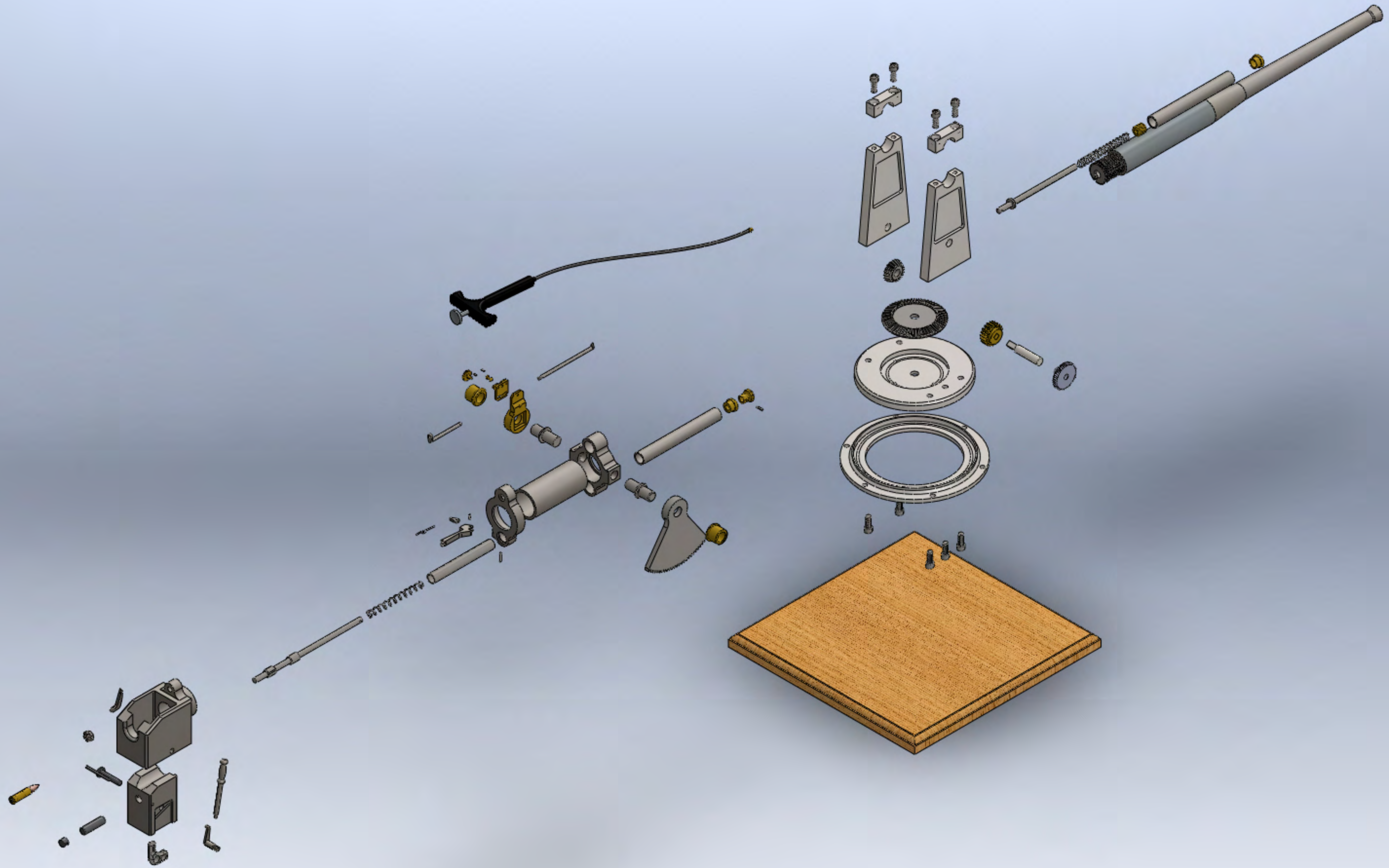
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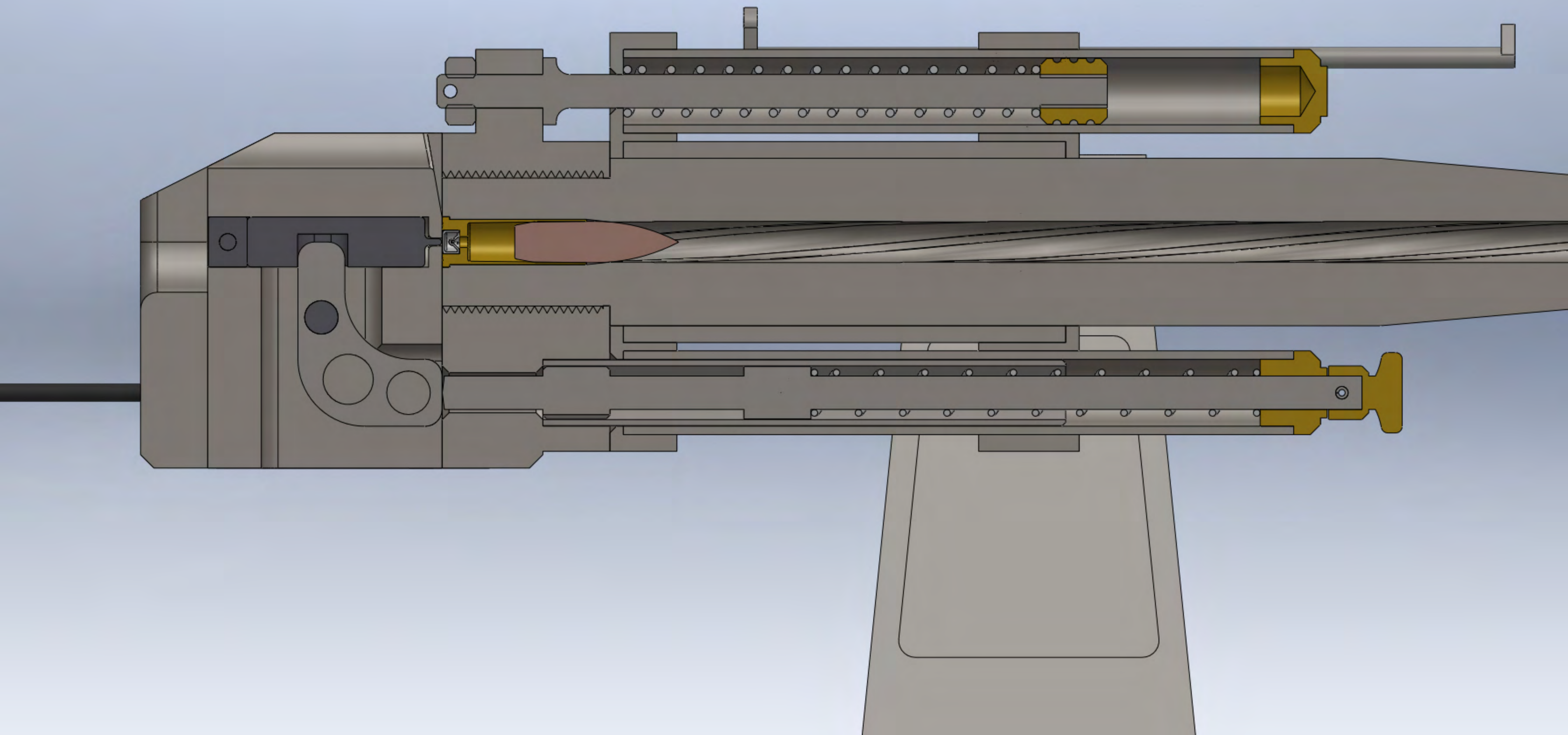
		UNLESS OTHERWISE SPECIFIED:					Saxon Armament Corporation 20719 Golden Hawthorn Ct. Humble, Texas 77346	
		DIMENSIONS ARE IN INCHES			DRAWN	NAME	DATE	TITLE: Sight Base 0.875" Barrel with M1A Sight
		TOLERANCES:			CHECKED			
		ANGULAR: ± 0°03' 0"			ENG APPR.	SCF		
		TWO PLACE DECIMAL ± .01"			MFG APPR.			
		THREE PLACE DECIMAL ± .005"			Q.A.			
		PARTS SHALL BE FREE OF BURRS			COMMENTS:			SIZE B
		BROKEN EDGES .005" MAX R			HEAT TREAT			
		FILLETS .005" MAX R						REV A
		CONCENTRICITY ± .003"						SCALE: 3:1
		SURFACE ROUGHNESS						WEIGHT:
		MATERIAL						SHEET 1 OF 1
		X						
		PROTECTIVE FINISH						
NEXT ASSY	USED ON	DO NOT SCALE DRAWING						



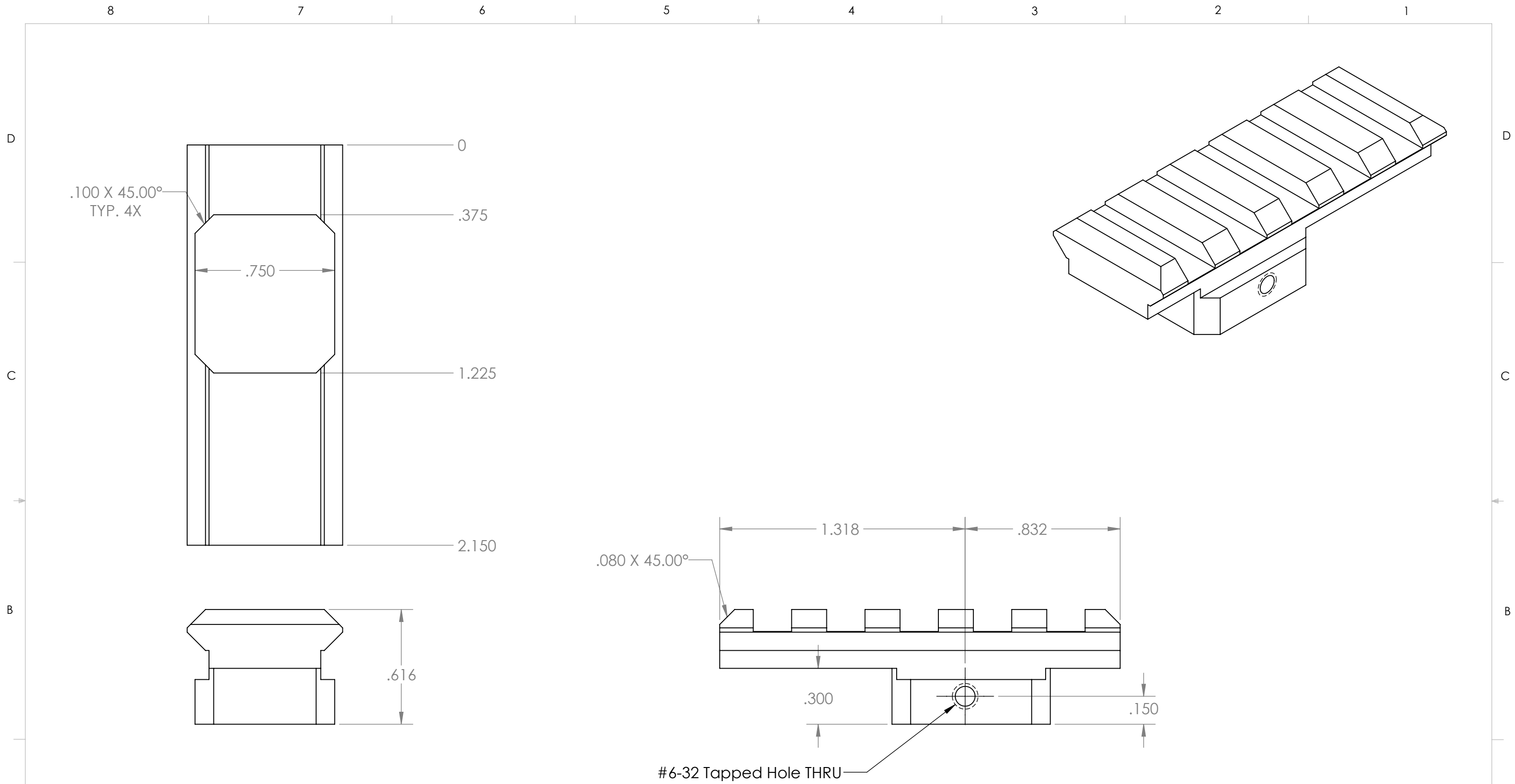












#6-32 Tapped Hole THRU

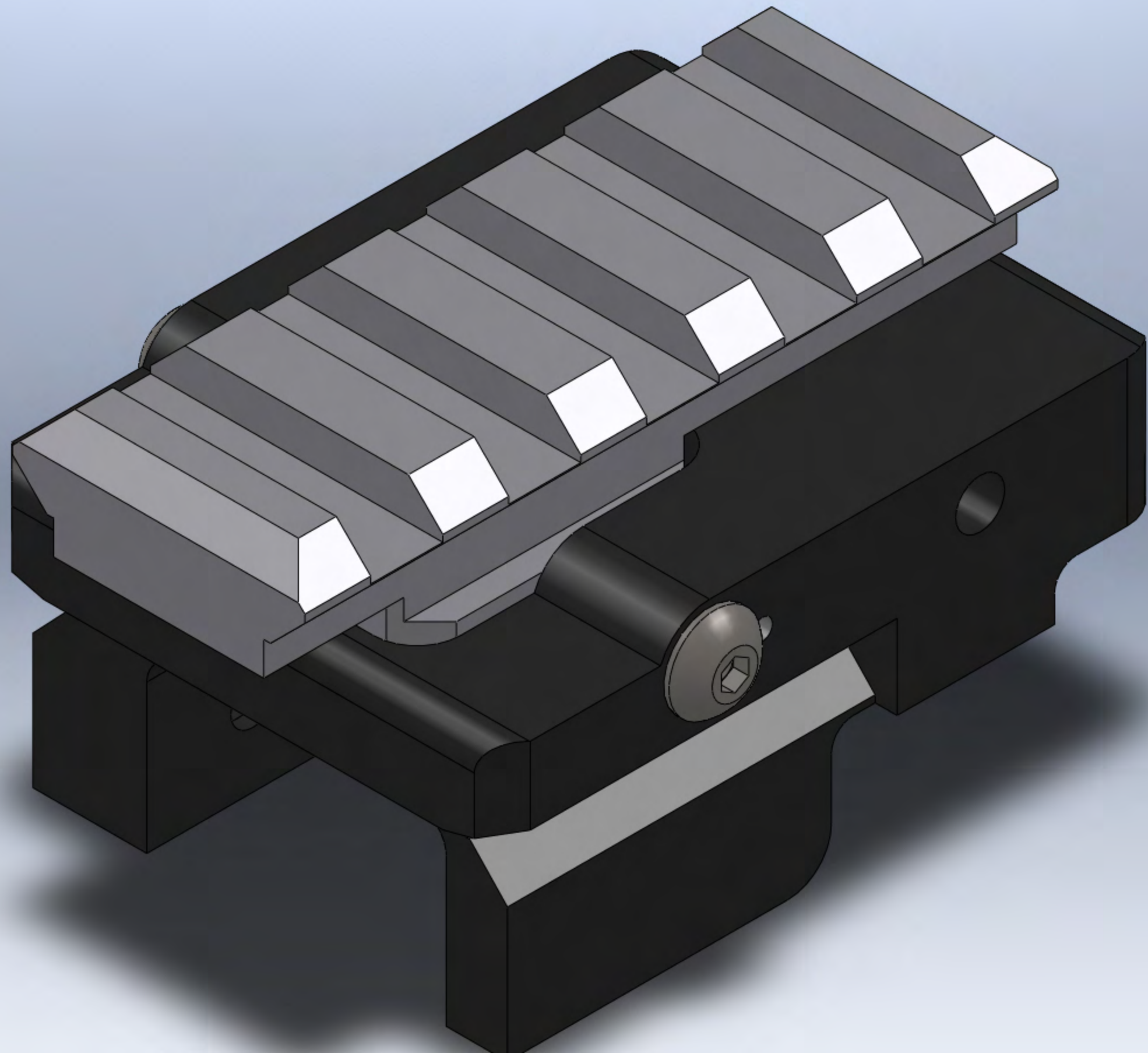
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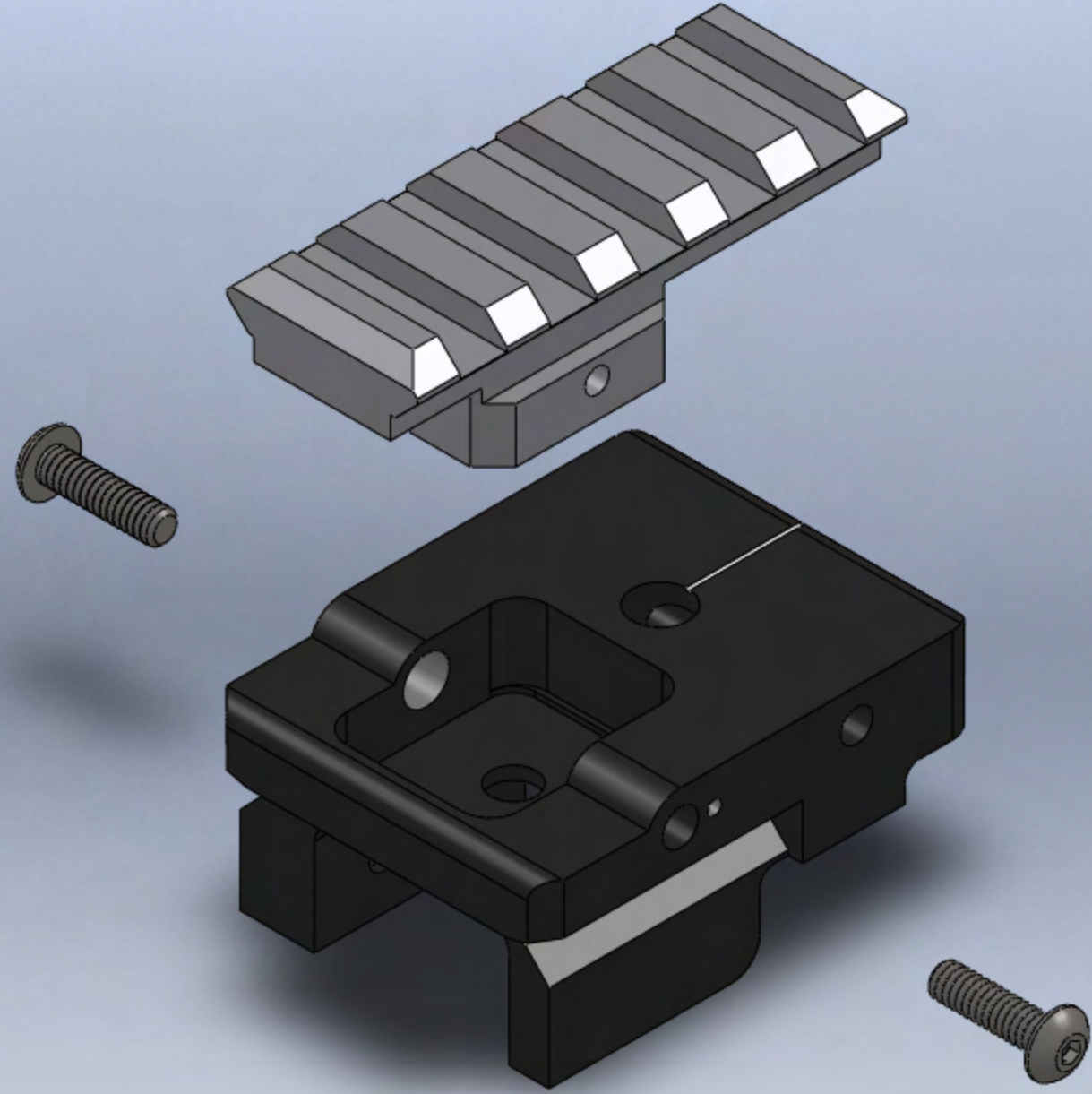
		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES: ANGULAR: $\pm 0^{\circ}03'00''$ TWO PLACE DECIMAL $\pm .01''$ THREE PLACE DECIMAL $\pm .005''$ PARTS SHALL BE FREE OF BURRS BROKEN EDGES $.005''$ MAX R FILLETS $.005''$ MAX R CONCENTRICITY $\pm .003''$ SURFACE ROUGHNESS	DRAWN	NAME	DATE	Saxon Armament Corporation 20719 Golden Hawthorn Ct. Humble, Texas 77346	
			CHECKED			TITLE:	
			ENG APPR.	SCF		STONER 63A BELTFED SCOPE MOUNT	
			MFG APPR.				
			Q.A.			SIZE	DWG. NO.
NEXT ASSY	USED ON	MATERIAL	COMMENTS:		B	SSM-1	A
APPLICATION		PROTECTIVE FINISH	HEAT TREAT		SCALE: 2:1	WEIGHT:	SHEET 1 OF 1

STONER 63A
BELTFED SCOPE MOUNT

SIZE **B** DWG. NO. SSM-1 REV A

SCALE: 2:1 WEIGHT: SHEET 1 OF 1







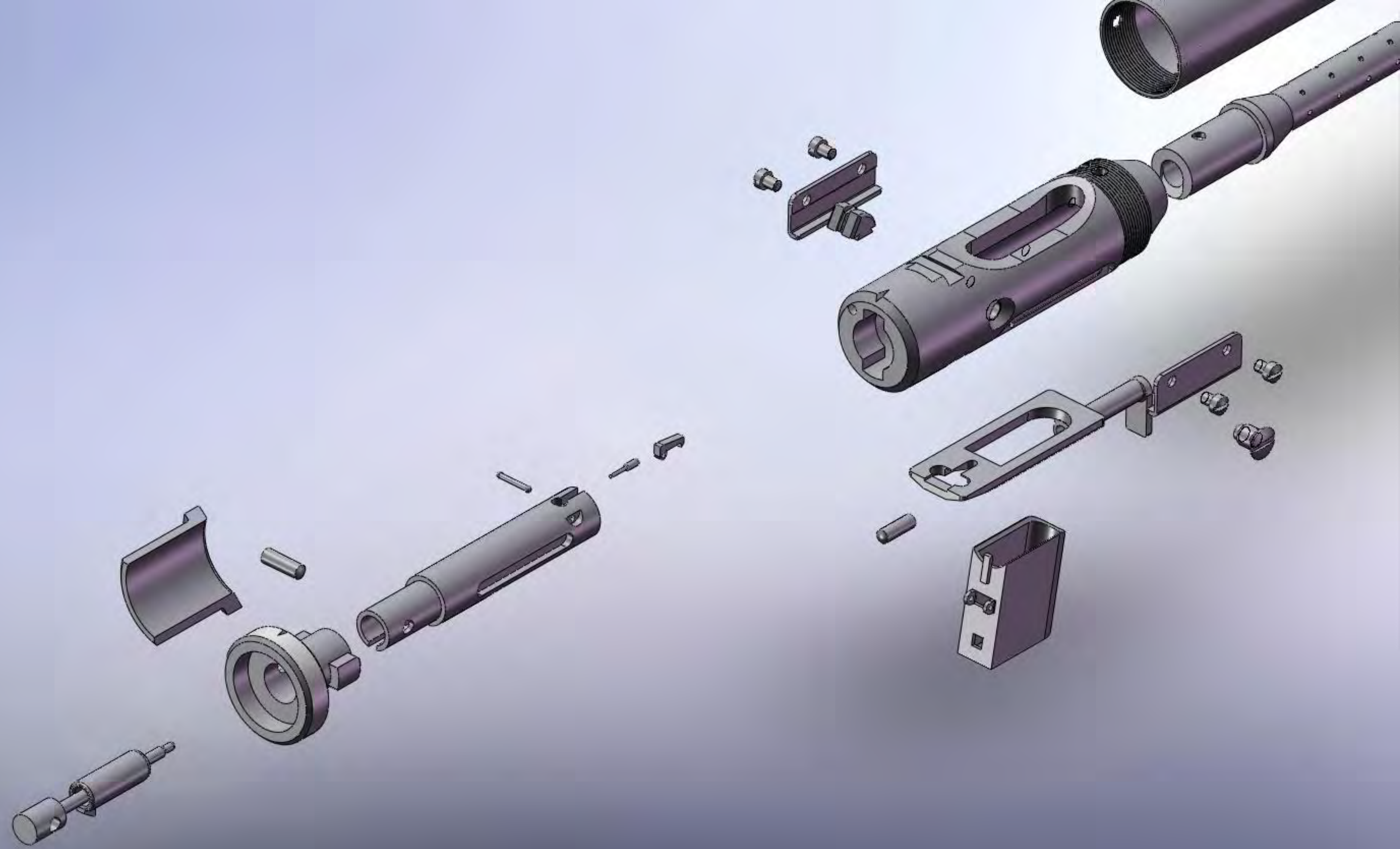


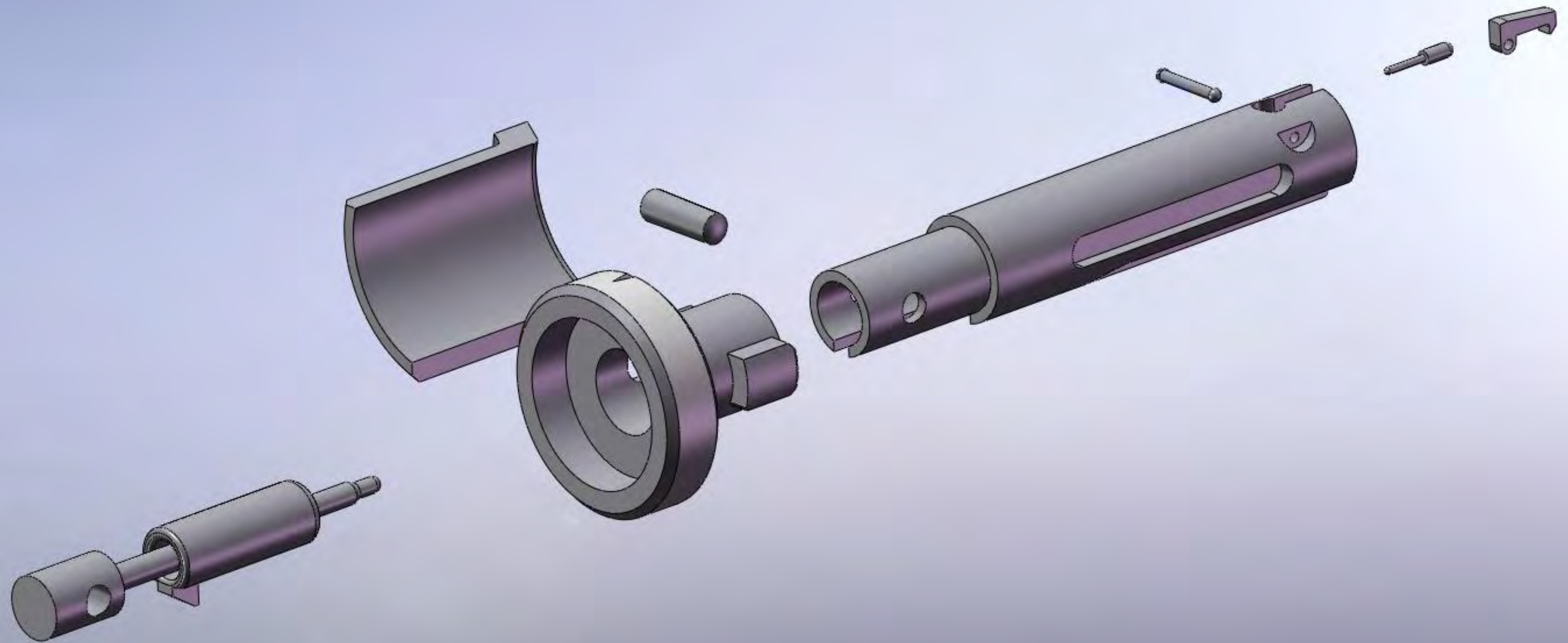


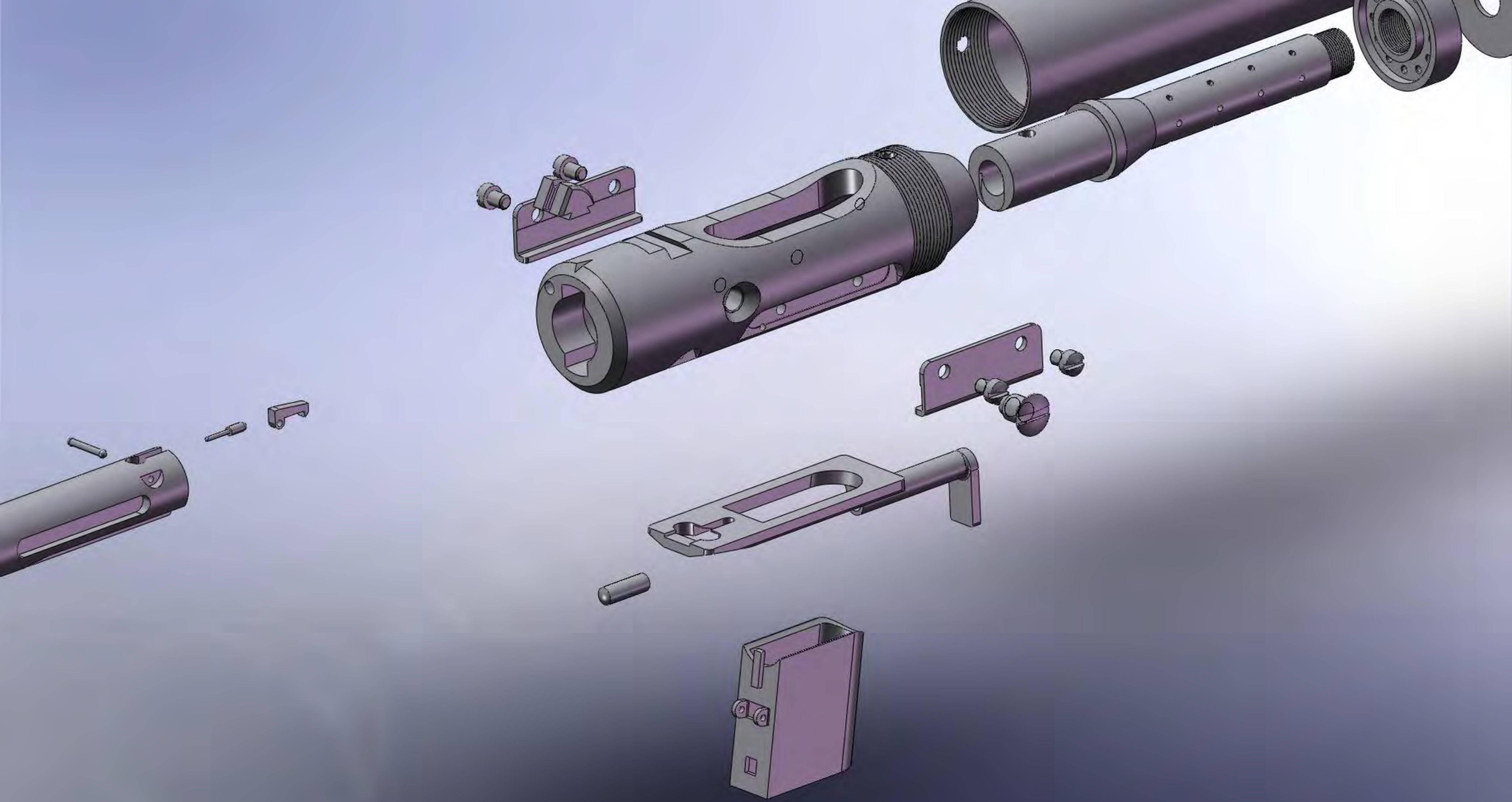


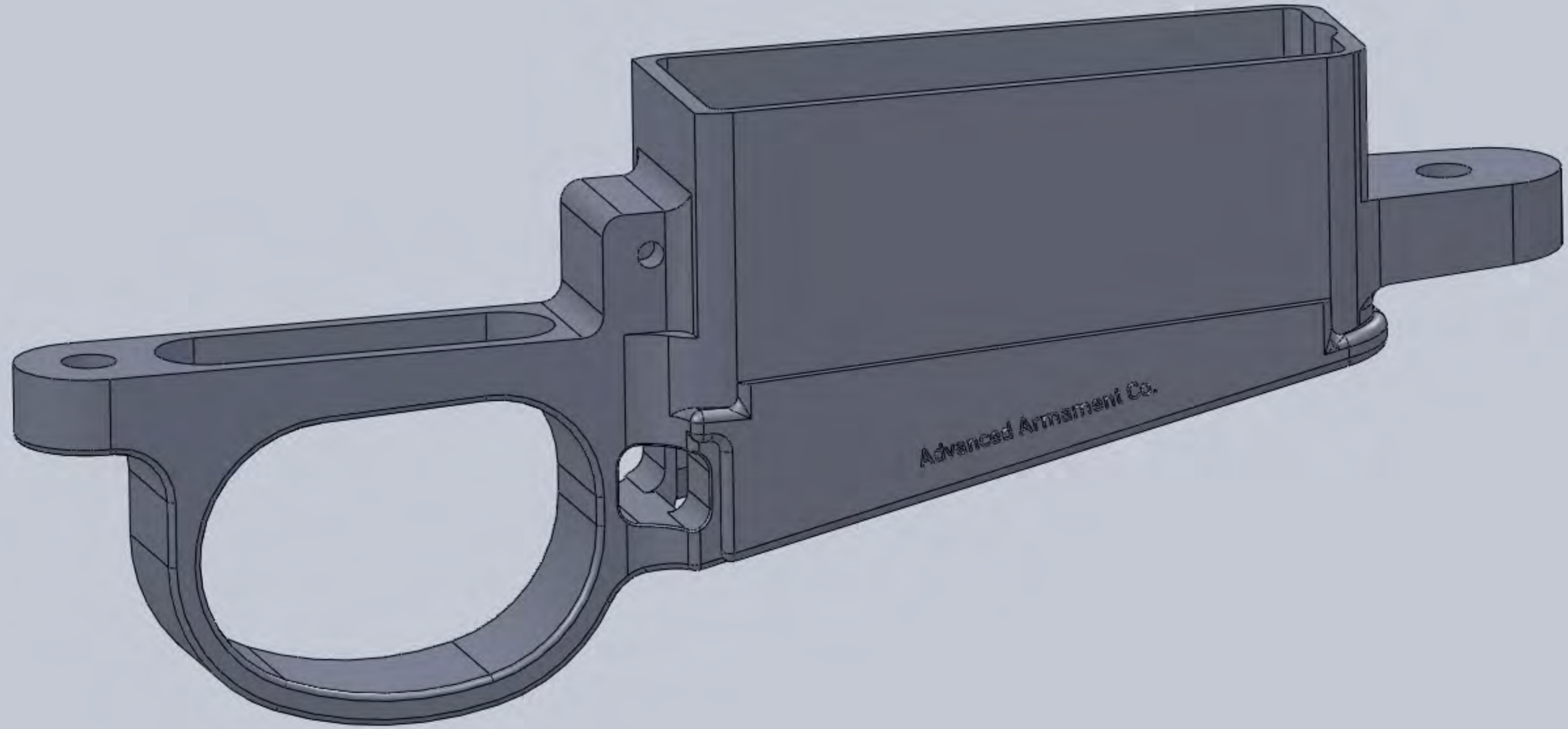








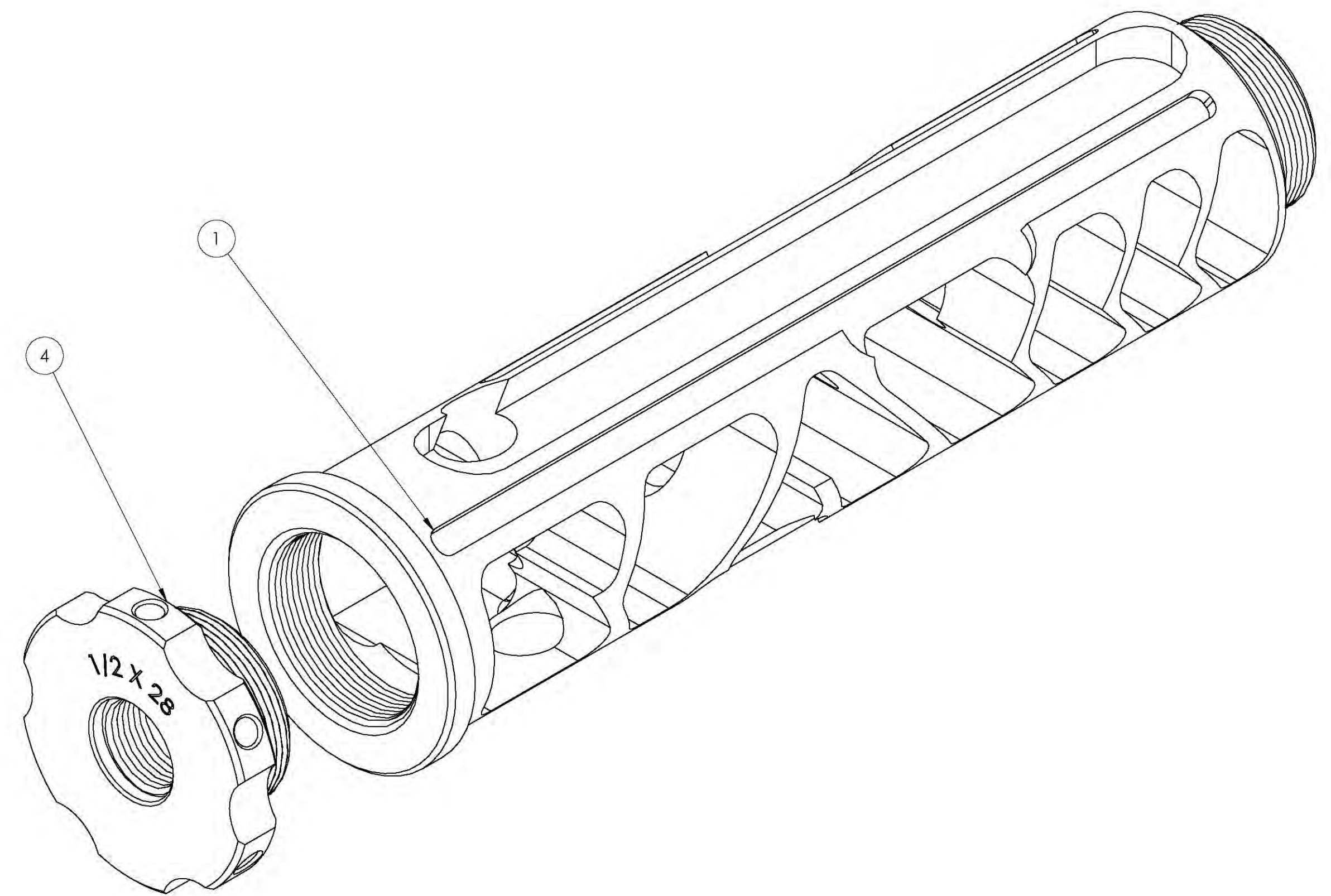
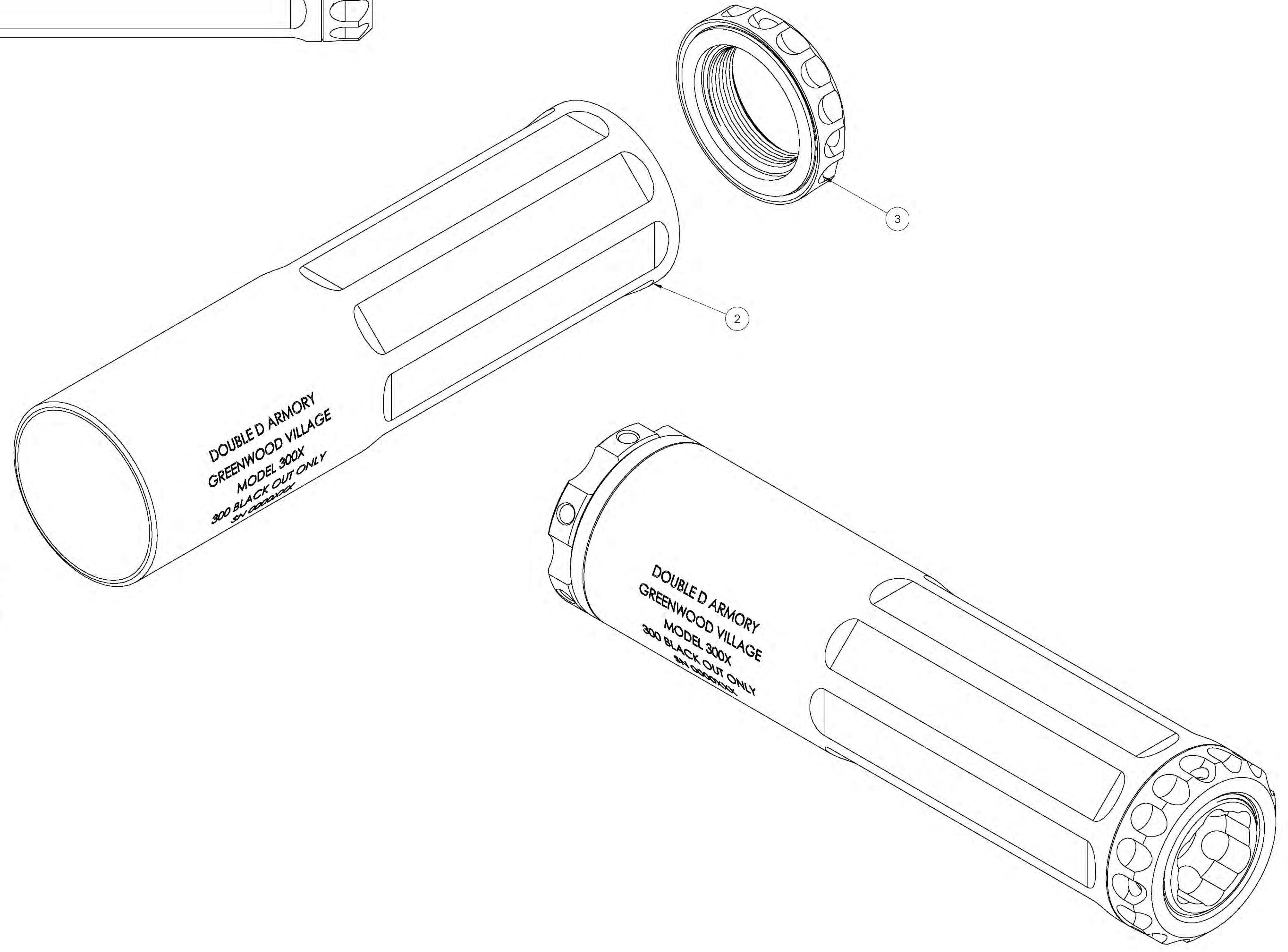
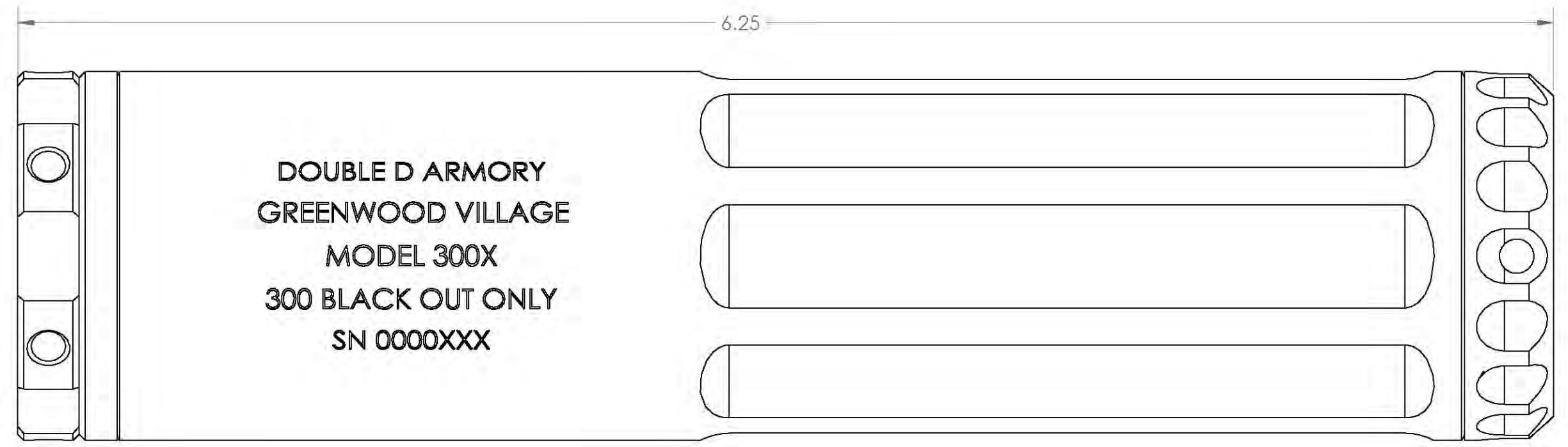
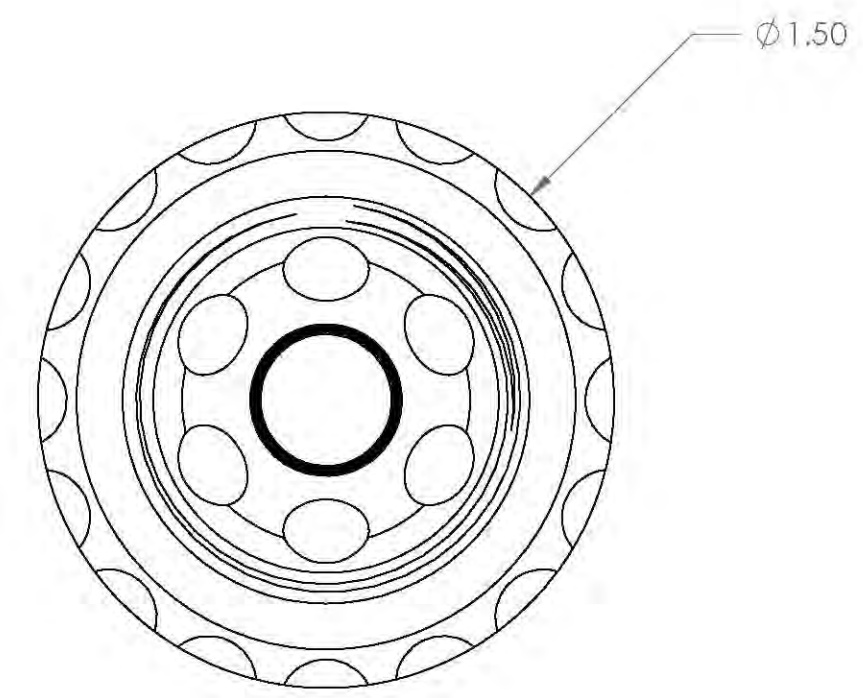




Advanced Armament Co.

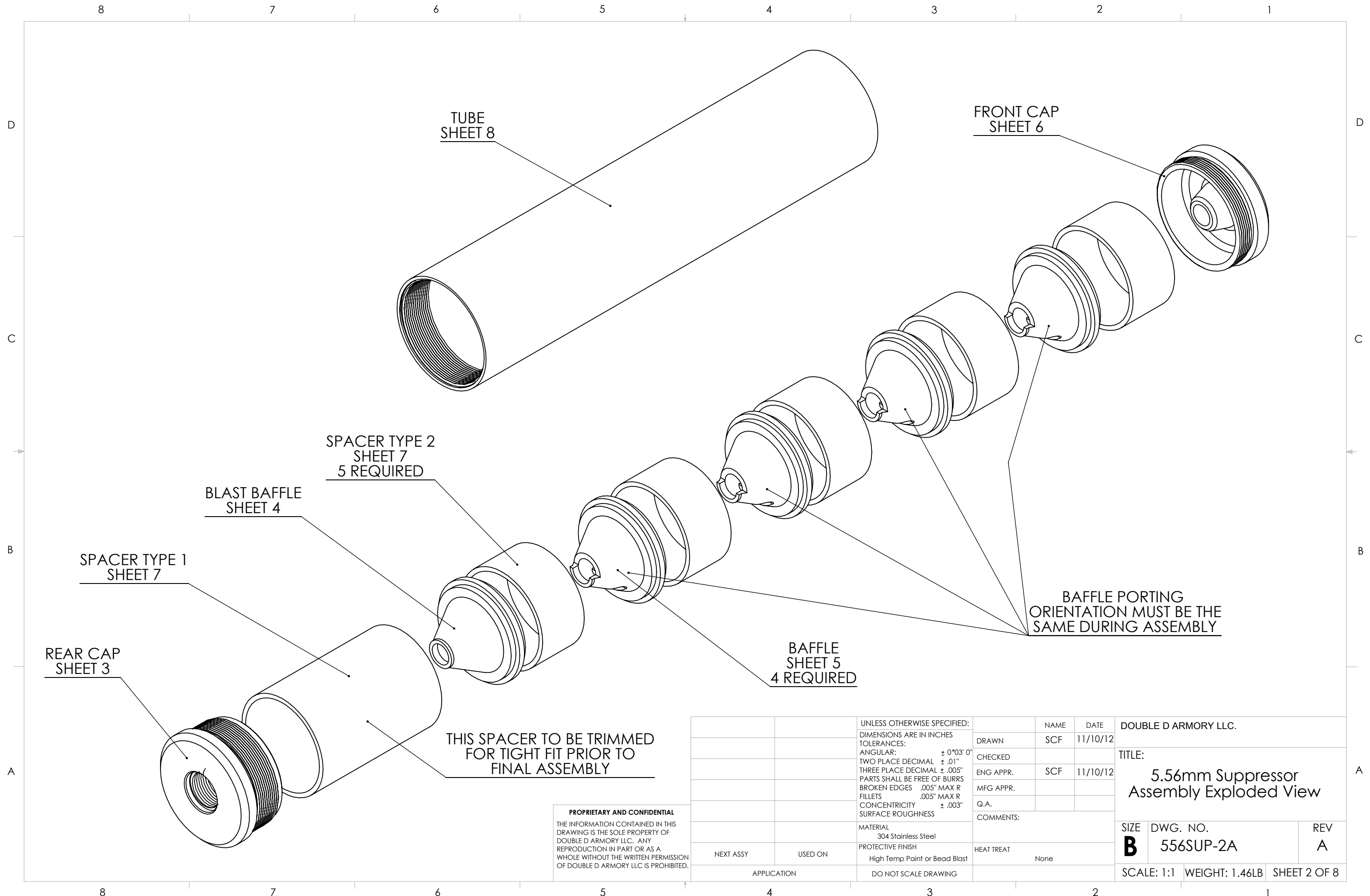


REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	ISSUED FOR PROTOTYPING	4/30/2014	SCF



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UNLESS OTHERWISE SPECIFIED:		NAME	DATE	DOUBLE D ARMORY LTD.
DIMENSIONS ARE IN INCHES		SCF	4/30/14	
TOLERANCES:		CHECKED		TITLE: MONOLITHIC SUPPRESSOR SYSTEM
ANGULAR MATCH: 1°		ENG APPR.	SCF	4/30/14
TWO PLACE DECIMAL ± 0.01		MFG APPR.		
THREE PLACE DECIMAL ± 0.005		DIA.		
	INTERPRET GEOMETRIC TOLERANCING PER:	COMMENTS:		
	MATERIAL 304 or 316 SS			
	FINISH None			
NEXT ASSY	USED ON			SIZE DWG. NO. REV
APPLICATION				D MONSUPP-1 A
				SCALE: 2:1 WEIGHT: 19.7oz SHEET 1 OF 9



TUBE SHEET 8

FRONT CAP SHEET 6

SPACER TYPE 2 SHEET 7 5 REQUIRED

BLAST BAFFLE SHEET 4

SPACER TYPE 1 SHEET 7

REAR CAP SHEET 3

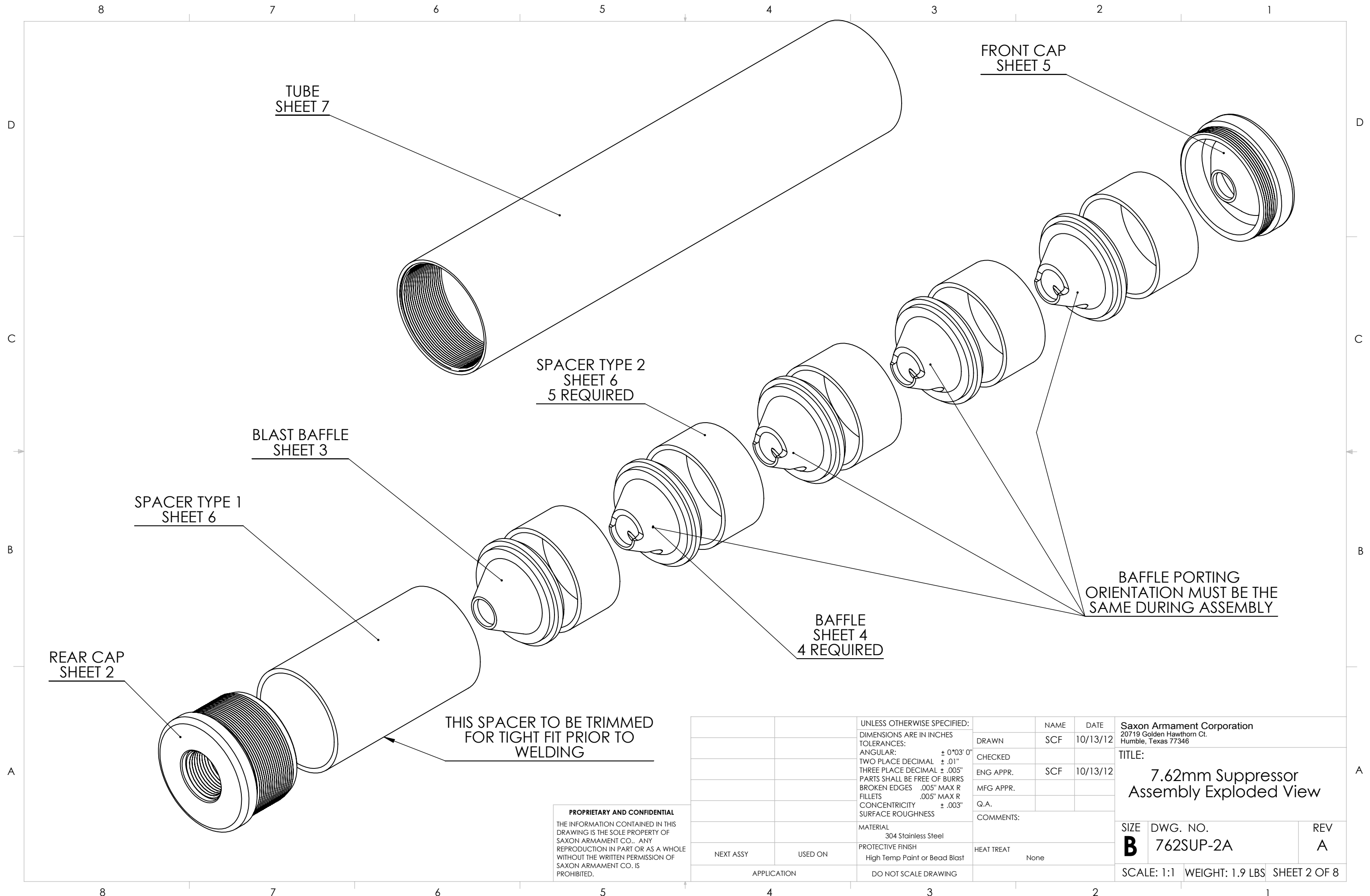
BAFFLE SHEET 5 4 REQUIRED

THIS SPACER TO BE TRIMMED FOR TIGHT FIT PRIOR TO FINAL ASSEMBLY

BAFFLE PORTING ORIENTATION MUST BE THE SAME DURING ASSEMBLY

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		UNLESS OTHERWISE SPECIFIED:				DOUBLE D ARMORY LLC.	
		DIMENSIONS ARE IN INCHES		DRAWN		NAME SCF	
		TOLERANCES:		CHECKED		DATE 11/10/12	
		ANGULAR: ± 0°03' 0"		ENG APPR.		SCF	
		TWO PLACE DECIMAL ± .01"		MFG APPR.		DATE 11/10/12	
		THREE PLACE DECIMAL ± .005"		Q.A.			
		PARTS SHALL BE FREE OF BURRS		COMMENTS:			
		BROKEN EDGES .005" MAX R		HEAT TREAT		None	
		FILLET .005" MAX R		CONCENTRICITY		± .003"	
		SURFACE ROUGHNESS		MATERIAL		304 Stainless Steel	
NEXT ASSY		USED ON		PROTECTIVE FINISH		High Temp Paint or Bead Blast	
APPLICATION		DO NOT SCALE DRAWING		TITLE:		5.56mm Suppressor Assembly Exploded View	
SIZE		DWG. NO.		REV		A	
B		556SUP-2A		SCALE: 1:1		WEIGHT: 1.46LB	
						SHEET 2 OF 8	



TUBE
SHEET 7

FRONT CAP
SHEET 5

SPACER TYPE 2
SHEET 6
5 REQUIRED

BLAST BAFFLE
SHEET 3

SPACER TYPE 1
SHEET 6

BAFFLE PORTING
ORIENTATION MUST BE THE
SAME DURING ASSEMBLY

BAFFLE
SHEET 4
4 REQUIRED

REAR CAP
SHEET 2

THIS SPACER TO BE TRIMMED
FOR TIGHT FIT PRIOR TO
WELDING

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PROHIBITED.

		UNLESS OTHERWISE SPECIFIED:		NAME	DATE	Saxon Armament Corporation 20719 Golden Hawthorn Ct. Humble, Texas 77346	
		DIMENSIONS ARE IN INCHES		DRAWN	SCF	10/13/12	TITLE: 7.62mm Suppressor Assembly Exploded View
		TOLERANCES:		CHECKED			
		ANGULAR: ± 0°03' 0"		ENG APPR.	SCF	10/13/12	
		TWO PLACE DECIMAL ± .01"		MFG APPR.			
		THREE PLACE DECIMAL ± .005"		Q.A.			SIZE DWG. NO. REV B 762SUP-2A A
		PARTS SHALL BE FREE OF BURRS		COMMENTS:			
		BROKEN EDGES .005" MAX R		HEAT TREAT	None		SCALE: 1:1 WEIGHT: 1.9 LBS SHEET 2 OF 8
		FILLETS .005" MAX R					
		CONCENTRICITY ± .003"					
		SURFACE ROUGHNESS					
		MATERIAL					
		304 Stainless Steel					
		PROTECTIVE FINISH					
		High Temp Paint or Bead Blast					
NEXT ASSY	USED ON	APPLICATION					
		DO NOT SCALE DRAWING					