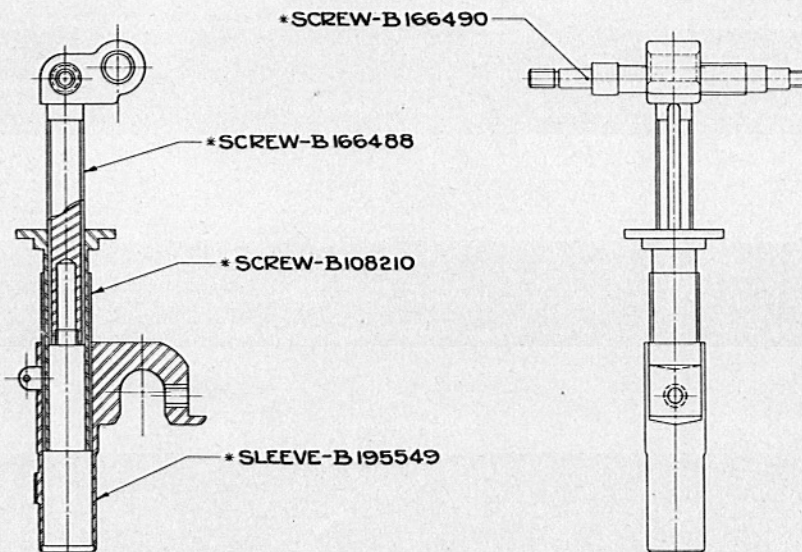


HEAT TREATMENT AND FINAL FINISH

PHYSICAL PROPERTIES		JULY 11, 1942	
		REVISIONS	
Y. P.			
T. S.			
EL. 2			
RED			
BR.			
ROCK.			
SCL.			

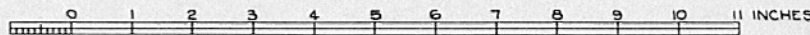
DRG. PERTAINS TO

C74620	MECH. ELEV.
	ASSEMBLY
DT052	MT. TRIPOD, MG
	CAL. .30 M2



**SCREW, ELEVATING, ASSEMBLY**

\* WILL NOT BE ISSUED FOR FIELD MAINTANANCE  
EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.



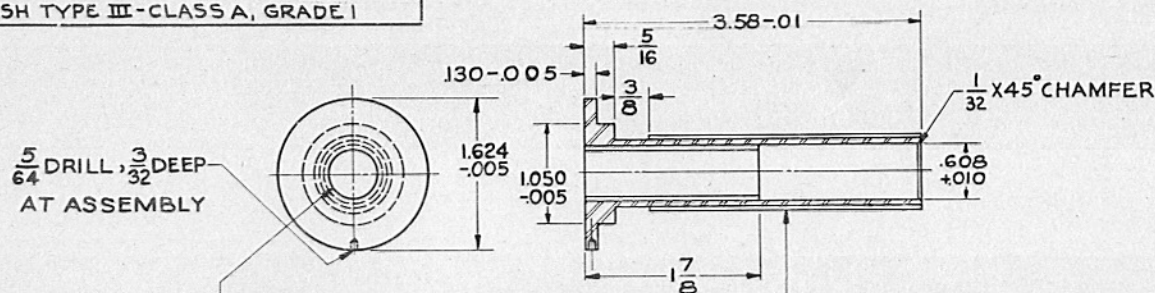
C91827

DESIGNED <i>WJS</i>	DRAWN <i>WJS</i>	CHECKED <i>WJS</i>	IN CHARGE <i>WJS</i>
SUBMITTED: <i>WJS</i>			
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>WJS</i>			
CAPT. ONE DEPT. U. S. A.			
ORDNANCE DEPT. U. S. A.			

MADE AT ROCK ISLAND ARSENAL

HEAT TREATMENT & FINAL FINISH

HEAT TREAT  
FINISH TYPE III-CLASS A, GRADE I

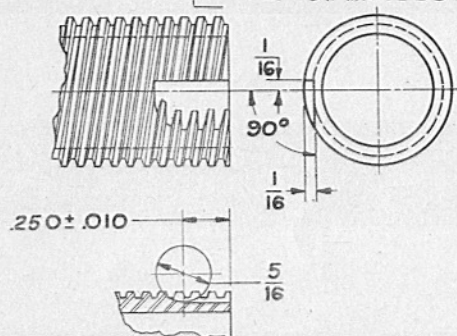


.6000-.0896P-.2688L.-N.A.-3 SPEC.  
MAJOR DIAM. .6030+.0050  
PITCH DIAM. .5552+.0124  
MINOR DIAM. .5103+.0050  
LEAD ERROR ±.0003 PER INCH; INDEXING  
ERROR ±.0002 BETWEEN ANY TWO THREADS

ALTERNATIVE METHOD OF MFG.:  
DATA SAME AS ACME THREAD, EXCEPT  
.6000 D.-.0896P.-.2688L.-60°NS-SPEC.  
PITCH DIAM. .5552+.0055

.8125-.0896P-.2688L.-L.H.-N.A.-3 SPEC.  
MAJOR DIAM. .8125-.0050  
MINOR DIAM. .7213-.0050  
LEAD ERROR ±.0003 PER INCH; INDEXING  
ERROR ±.0002 BETWEEN ANY TWO THREADS.  
PITCH DIAM. .7677(REF)-FIT TO GIVE .000 TO  
.002 END PLAY AT 1 IN. ENGAGEMENT  
WITH MATING PART

ALTERNATIVE METHOD OF MFG.:  
DATA SAME AS ACME THREAD EXCEPT  
.8125 D.-.0896P.-.2688L.-L.H.-60°NS-SPEC.



SCREW, ELEVATING, LOWER

STEEL WDX1335

FINISH

MANUFACTURING COMPONENT

NOTE:  
FOR ALT. CONSTRUCTION  
SEE BIO8210A

NOTE:  
THIS PART AND MATING  
PARTS MUST HAVE SAME  
TYPE OF THREADS

PHYSICAL PROPERTIES		JUNE 1, 1934			
		REVISIONS			
Y. P.		16	10-21-42		
T. S.		17	12-28-42		
EL. 2		18	4-19-43		
RED.		19	5-3-43		
BR.		20	10-9-44		
ROCK	C. 25-30				
SCL.					

DRG. PERTAINS TO

C91827 SCREW, ELEV.  
ASSEMBLY  
D7052 MOUNT, TRIPOD  
MACHINE GUN,  
CAL. .30, M2

TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED  
DECIMAL ± .01  
FRACTIONAL ± —  
ANGULAR ± —

DRAFTSMAN	CHIEF	L.D.G. DRAFTSMAN
H.A.C.	C.L.A.	A.H.R.
CHECKED	CO.	CHIEF DRAFTSMAN
C.A.	DF.	

SUBMITTED:

A.H.R.

APPROVED BY ORDER OF THE CHIEF  
OF ORDNANCE:

Capt. W. S. S. A.

ORDNANCE DEPT., U. S. A.

SUPERSEDES OLD TRACING BIO8210, UNDER REVISION DATE OF 10-21-42 SCALE 1/2" = 1" BIO8210

MADE AT ROCK ISLAND ARSENAL





OXIDE BLACK

## REVISIONS

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7'	3-8-42		
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CAL. 30, M2.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL



HEAT TREAT  
OXIDE BLACK AFTER ASSEMBLY

FEBRUARY 16, 1942

Y. P.		1'	3-25-42
T. S.		2'	4-4-42
EL. 2		3	7-11-42
RED		4*	9-29-42
BR.		5'	4-19-43
ROCK.	C 30-34	6'	6-13-44
SCL			

C91827	SCREW, ELEV.
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	ASSEMBLY
--	----------

D 7052	MT. TRIP. M.G.
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CAL..30 M2

**SECTION A-A**  
SCALE  $\frac{1}{4}$

ALTERNATIVE METHOD OF MANUFACTURE OF SECTION "A-A"

SCALE 4

**SECTION B-B**  
**SCALE  $\frac{4}{1}$**

TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED  
DECIMAL  $\pm$  —  
FRACTIONAL  $\pm \frac{1}{64}$   
ANGULAR  $\pm 0^{\circ}30'$

NOTE: THIS PART AND MATING PARTS MUST HAVE SAME TYPE OF THREADS

### SLEEVE, ELEVATING MECHANISM

STEEL WDX 1335  
MANUFACTURING COMPONENT  
NOTE: FOR ALT. CONSTRUCTION  
ADS SEE B195549A&B

NOTE:  
ALL CORNER RADII AND FILLETS  
TO BE  $\frac{3}{32}$ " R. UNLESS OTHERWISE  
SPECIFIED.

8125-.0896P-.2688L:LH:NA-3SPEC.  
MAJ. DIAM. .8150+.0050  
PITCH DIAM. .7677+.0124  
MINOR DIAM. .7228+.0050  
LEFT HAND ACME 29°  
LEAD ERROR ±.0003 PER INCH  
INDEXING ERROR ±.0002 BETWEEN  
ANY TWO THREADS  
[ALTERNATIVE METHOD OF MFR:  
DATA SAME AS ACME THREAD EXCEPT  
8125D-.0896P-.2688L-LH:60°NS-SPEC.  
PITCH DIAM. .7677+.0055

SCALE  $\frac{1}{4}$  | B195549

DRAFTSMAN <i>RKB</i>	TRACER <i>RKB</i>	L'D'G. DRAFTSMAN <i>A.M.R.</i>
CHECKER <i>RKB</i>	<i>oo</i>	CHIEF DRAFTSMAN <i>W.R.</i>

SUBMITTED:-  
2003 *Geo. L. Kuhn*  
U.S. DEPT. OF JUSTICE

C. APPROVED BY ORDER OF THE CHIEF  
OF ORDNANCE: *[Signature]*

LT. COL. ORDN. DEPT., U. S. A.  
ORDNANCE DEPT., U. S. A.

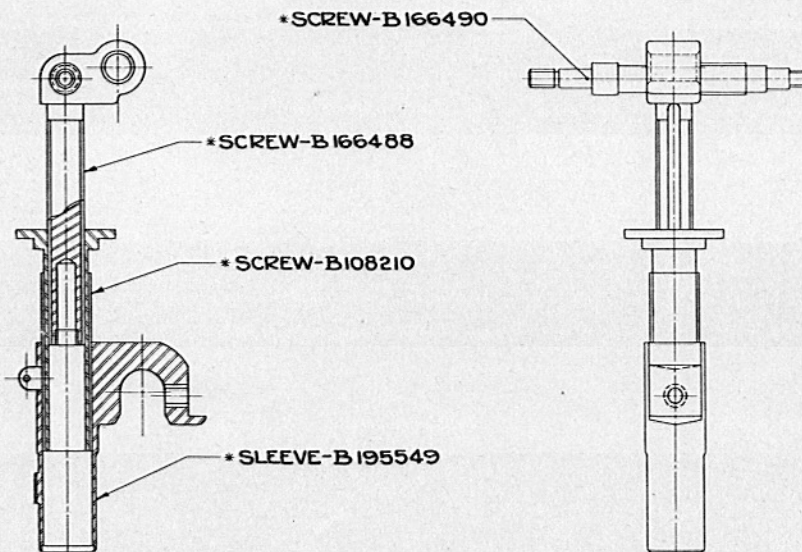
MADE AT ROCK ISLAND ARSENAL

HEAT TREATMENT AND FINAL FINISH

PHYSICAL PROPERTIES		JULY 11, 1942 REVISIONS	
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BR.			
ROCK.			
SCL.			

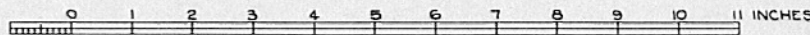
DRG. PERTAINS TO

C74620	MECH. ELEV.
	ASSEMBLY
DT052	MT. TRIPOD, MG
	CAL. .30 M2



**SCREW, ELEVATING, ASSEMBLY**

\* WILL NOT BE ISSUED FOR FIELD MAINTANANCE EXCEPT AS COMPONENTS OF AUTHORIZED ASSEMBLIES.



C91827

DESIGNED <i>WJS</i>	DRAWN <i>WJS</i>	CHECKED <i>WJS</i>	IN CHARGE <i>WJS</i>
SUBMITTED: <i>WJS</i>			
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>WJS</i>			
CAPT. ONE DEPT. U. S. A.			

MADE AT ROCK ISLAND ARSENAL