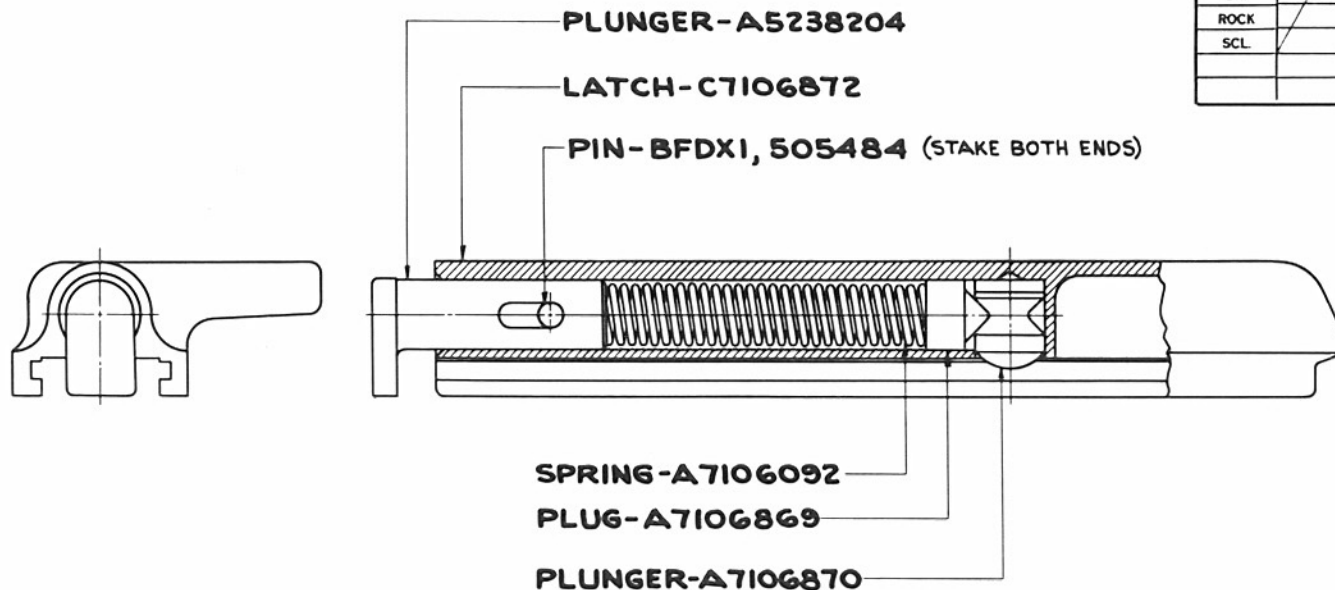


HEAT TREATMENT AND FINAL FINISH  
TYPE II FINISH, CLASS B

PHYSICAL PROPERTIES		OCTOBER 7, 1943	
		REVISIONS	
Y. P.		5	5-10-48
T. S.			
EL. 2			
RED.			
BR.			
ROCK			
SCL.			



LATCH, ASSEMBLY (7106949)

SUPERSEDES B7106949 WO/C 5-10-48



B 7106949

DRG. PERTAINS TO	
51-10-1	.30 BMG M17A1 (WC)
51-83-1	.30 BMG M19A4 (FXD)
51-84-1	.30 BMG M19A4 (FLEX)
51-114-1	.30 BMG M19A5 (FXD)
51-125-1	.30 BMG M19A6

DO  
INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED  
DECIMAL  $\pm$  —  
FRACTIONAL  $\pm$  —  
ANGULAR  $\pm$  —

DRAFTSMAN L.M.D.	TRACER <i>Shw</i>	L'O'G DRAFTSMAN
CHECKER B.J.S.	CHIEF DRAFTSMAN	

SUBMITTED:  
*A.H. Poe*

APPROVED BY ORDER OF THE CHIEF  
OF ORDNANCE:  
*Walter A. Johnson*  
ORD. DEPT., U. S. A.  
ORDNANCE DEPT., U. S. A.

B7106949

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES						A 5238204	
<b>HEAT TREAT</b> <b>TYPE II FINISH, CLASS B</b>		Y. P.	<input checked="" type="checkbox"/>	RED.	<input checked="" type="checkbox"/>	SCL.	<input checked="" type="checkbox"/>	JUNE 3, 1943	
		T. S.	<input checked="" type="checkbox"/>	BR.	<input checked="" type="checkbox"/>	C. C.	<input checked="" type="checkbox"/>	REVISIONS	
		EL 2	<input checked="" type="checkbox"/>	ROCK	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	.005-.010 DEEP	5 5-10-48
								6' 3-7-49	
								DRG. PERTAINS TO	
								B7106949	
								30 BMG M 17A1 (WC) M 19A4 (FXD) M 19A4 (FLEX) M 19A5 (FXD) M 19AG	
								INSCRIBE PART NO.	
								DO NOT	
								TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL $\pm .005$ FRACTIONAL $\pm \frac{1}{64}$ ANGULAR $\pm 5^\circ$	
								DRAFTSMAN H. W. J.	
								TRACER M. C.	
								L'D'G DRAFTSMAN	
								CHECKER H. W. J.	
								CHIEF DRAFTSMAN	
								SUBMITTED:	
								A. H. Roe	
								ORD. DEPT., U. S. A.	
								APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:	
								Walter Ackerman	
								ORD. DEPT., U. S. A.	
								ORDNANCE DEPT., U. S. A.	

**PLUNGER, LATCH**

**STEEL FSX1020**

FINISH  $\frac{125}{\sqrt{ }}$ , OTHER SURFACES,  
AS SPECIFIED

(5238204)

NOTE: R.I.A. FORGING SHOWN ON DRG. A 7101712

WAS A238204

SCALE  $\frac{2}{1}$

A

**5238204**

**A7106092**

[illegible]

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A7106869 OCTOBER 7, 1943	
HEAT TREAT TYPE II FINISH, CLASS B		Y. P.	<input checked="" type="checkbox"/>	RED.	<input checked="" type="checkbox"/>	SCL.	<input checked="" type="checkbox"/>
		T. S.	<input checked="" type="checkbox"/>	BR.	<input checked="" type="checkbox"/>	C.C.	<input checked="" type="checkbox"/>
		EL. 2	<input checked="" type="checkbox"/>	ROCK	<input checked="" type="checkbox"/>		<input checked="" type="checkbox"/>
						REVISIONS	
						4	5-10-48
						DRG. PERTAINS TO	
						B7106949	.30 BMG M17A1 (WC) M19A4 (FXD) M19A4 (FLEX) M19A5 (FXD) M19A6
						INSCRIBE PART NO. DO NOT	
						TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 1^\circ$	
						DRAFTSMAN H.W.J.	TRACER A.V.C.
						L'D'G DRAFTSMAN	
						CHECKER H.W.J.	CHIEF DRAFTSMAN O.O.
						SUBMITTED: <i>A.H. Roe</i>	
						APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>Walter Ackerman</i> ORD. DEPT., U. S. A.	
						ORDNANCE DEPT., U. S. A.	

BREAK CORNER .010

**PLUG, RETAINING**

**STEEL FS1020**

FINISH  $\frac{63}{\sqrt{}}$ , OTHER SURFACES, AS SPECIFIED

7106869

SUPERSEDES A7106869 WO/C 5-10-48

SCALE  $\frac{2}{1}$

A
7106869

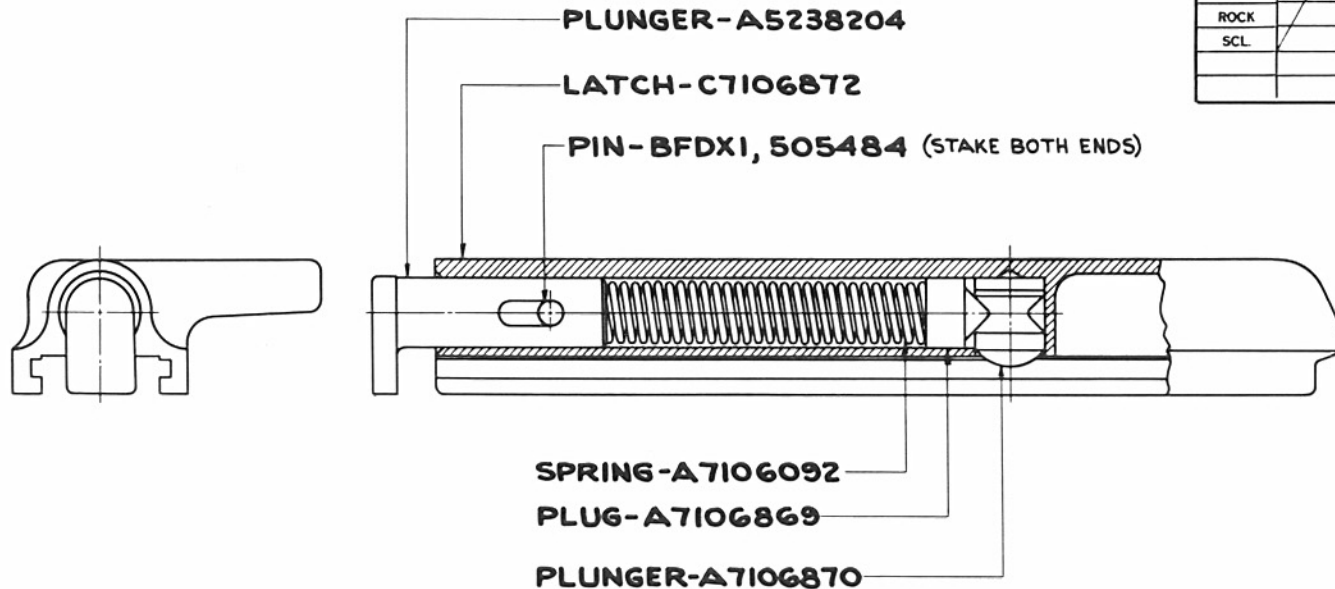
A 7106870

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES						OCTOBER 7, 1943			
HEAT TREAT TYPE II FINISH, CLASS B		Y. P.	<input checked="" type="checkbox"/>	RED.	<input checked="" type="checkbox"/>	SCL.	<input checked="" type="checkbox"/>	REVISIONS			
		T. S.	<input checked="" type="checkbox"/>	BR.	<input checked="" type="checkbox"/>	C. C.	.005-.010 DEEP	4	5-10-48		
		E. L. 2	<input checked="" type="checkbox"/>	ROCK	<input checked="" type="checkbox"/>						
<p align="center"><b>PLUNGER, FRICTION</b></p> <p align="center"><u>STEEL FS 1020</u> (7106870)</p> <p>FINISH <math>\frac{63}{\sqrt{V}}</math>, OTHER SURFACES AS SPECIFIED</p>											
<p>SUPERSEDES A 7106870 WO/C 5-10-48 SCALE <math>\frac{2}{1}</math> <b>A 7106870</b></p>											

DRG. PERTAINS TO		
B7106949	.30 BMG M 17A1 (WC) M 19A4 (FXD) M 19A4 (FLEX) M 19A5 (FXD) M 19A6	
INSCRIBE PART NO. DO NOT		
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 1^\circ$		
DRAFTSMAN H.W.J.	TRACER A.V.C.	L'D'G DRAFTSMAN
CHECKER H.W.J.	CHIEF DRAFTSMAN	
SUBMITTED: <i>A.H. Roe</i>		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE <i>Walter Ackerman</i> ORD. DEPT., U. S. A.		
ORDNANCE DEPT., U. S. A.		

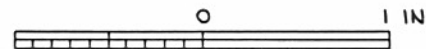
HEAT TREATMENT AND FINAL FINISH  
TYPE II FINISH, CLASS B

PHYSICAL PROPERTIES		OCTOBER 7, 1943	
		REVISIONS	
Y. P.		5	5-10-48
T. S.			
EL. 2			
RED.			
BR.			
ROCK			
SCL.			



LATCH, ASSEMBLY (7106949)

SUPERSEDES B7106949 WO/C 5-10-48



B 7106949

DRG. PERTAINS TO	
51-10-1	.30 BMG M17A1 (WC)
51-83-1	.30 BMG M19A4 (FXD)
51-84-1	.30 BMG M19A4 (FLEX)
51-114-1	.30 BMG M19A5 (FXD)
51-125-1	.30 BMG M19A6

DO  
INSCRIBE PART NO.

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

DRAFTSMAN L.M.D.	TRACER <i>Shw</i>	L'O'G DRAFTSMAN
CHECKER <i>B.J.S.</i>	CHIEF DRAFTSMAN	

SUBMITTED:  
*A.H. Poe*

APPROVED BY ORDER OF THE CHIEF  
OF ORDNANCE:  
*Walter A. Johnson*  
ORD. DEPT., U. S. A.  
ORDNANCE DEPT., U. S. A.

B7106949

SUPERSEDES BFDXI WITH CHANGE 2-24-47

PIN, STRAIGHT, STEEL CHAMFERED						BFDXI	
ORDNANCE DEPT STANDARDS (ORDNANCE DESIGN)						<div style="display: flex; justify-content: space-between;"> <span>APPROVED <u>WGR</u></span> <span>1-31-34 DATE</span> </div>	
D OF PIN B CHAMFER	{ NOM. MAX. MIN.	1/16 .0630 .0620 .010	3/32 .0942 .0932 .010	1/8 .1255 .1245 .010	5/32 .1567 .1557 1/64	3/16 .1880 .1870 1/64	
L LENGTH		ORDNANCE PART NUMBER - PLAIN FINISH					
1/8		505461	544188				
3/16		505462	544072	544019			
1/4		505463	505470				
5/16		505464	505471	544029			
3/8		505465	505472	505481			
7/16		505466	505473	505482	544020	544055	
1/2		505467	505474	505483	505494		
9/16		505468	505475	505484	505495	544028	
5/8		505469	505476	505485	505496	505506	
11/16			505477	505486	505497	505508	
3/4			505478	505487	505498	505509	
13/16		544070	505479	505488	505499	505510	
7/8			505480	505489	505500	505511	
15/16				505491	505501	505512	
1				505492	505502	505513	
1-1/8				505493	505503	505514	
1-1/4					505504	505515	
1-3/8					505505	505516	
1-1/2		426778				505517	
1-5/8			544075			505518	
1-3/4						505519	
L LENGTH		ORDNANCE PART NUMBER - PHOSPHATE (OILED) FINISH					
5/8						505507	
7/8						582953	
1-1/8				505490			
1-3/8				544179			
						582954	
<b>MATERIAL:</b> DRILL ROD, COMMERCIAL. TOLERANCE ON DRILL ROD $\pm .0005"$ . DIMENSIONS IN INCHES. <b>NOMENCLATURE PATTERN:</b> PIN, STRAIGHT, DRILL ROD, 1/8" x 1/2", PLAIN, DRG. BFDXI, PART NUMBER 505483. <b>NOTE:</b> PINS SHOULD BE .0005" TO .001" DRIVE FIT.							

