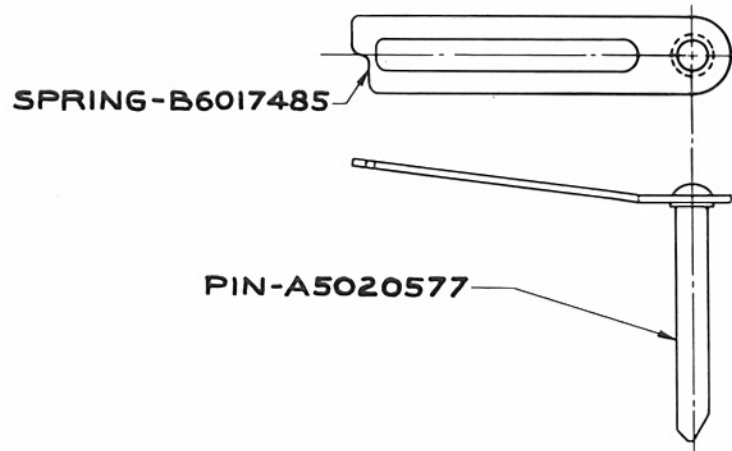


HEAT TREATMENT AND FINAL FINISH
TYPE II FINISH, CLASS B



PIN-A5020577

SPRING, SEAR, ASSEMBLY

6131265



PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	
SCL.	

JUNE 1, 1931

REVISIONS

11	5-10-48		

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

INSCRIBE PART NO.
DO NOT

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

DRAFTSMAN E.C.P.	TRACER A.V.C.	L.D.G. DRAFTSMAN
CHECKER V. G.	CHECKER G.S.	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.

WAS B131265
B 6131265

B6131265

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A 5020577 JUNE 1, 1931	
HEAT TREAT $\frac{1}{2}$ INCH OF BEVELED END		Y. P.		RED.		SCL.	
		T. S.		BR.			
		EL. 2		ROCK	C 55-60		
PIN, SEAR SPRING DRILL ROD FINISH $\frac{125}{\nabla}$		(5020577)				ALTERNATIVE METHOD OF MANUFACTURE	
SCALE $\frac{2}{1}$		A 5020577		WAS A20577		ORDNANCE DEPT., U. S. A.	

DRG. PERTAINS TO	
B6131265	30 BMG M17A1 (WC) M19A4 (FXD) M19A4 (FLEX) M19A5 (FXD) M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL .005
FRACTIONAL $\frac{1}{64}$
ANGULAR 2°

DRAFTSMAN W.C.O.	TRACER L.R.E.	L D G DRAFTSMAN
CHECKER L.S.C.	0°	CHIEF DRAFTSMAN

SUBMITTED:
A.N. Roe
ORD. DEPT., U. S. A.

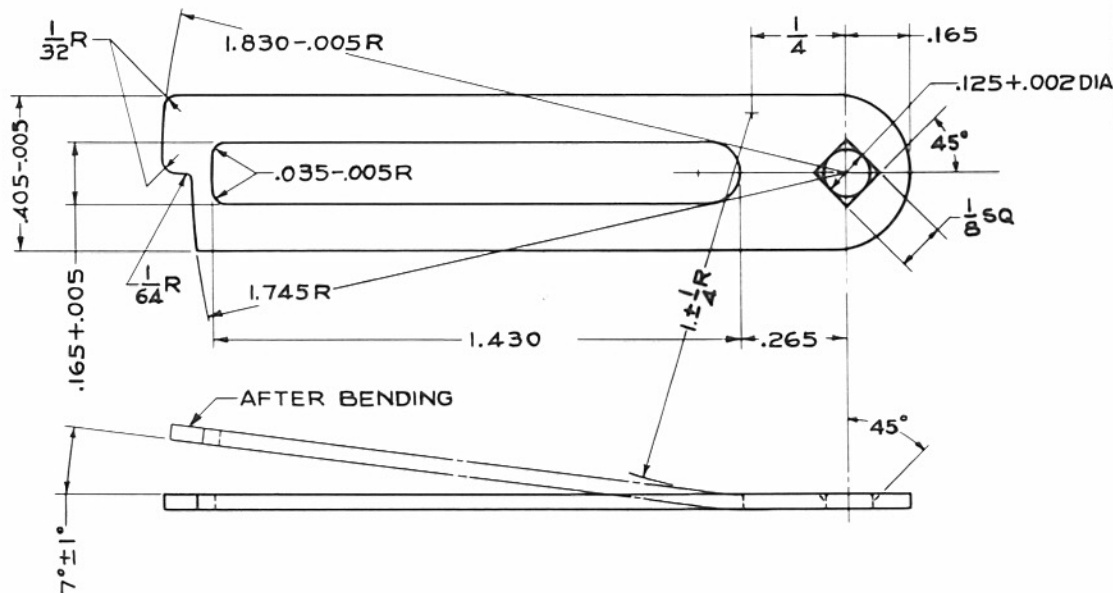
APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:
Walter Ackerman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL

HEAT TREATMENT AND FINAL FINISH
HEAT TREAT

NOTE:
THE $\frac{1}{8}$ SQ X 45° CHAMFER ON UPPER EDGE OF HOLE
MAY BE OMITTED WHEN ALTERNATIVE METHOD OF
MANUFACTURE FOR A5020577 IS USED.



SPRING SEAR
 SPRING STEEL WDI095
 NO. 19 (.0418) U.S. GAGE THICK
 FINISH $\frac{125}{V}$

6017485

SCALE $\frac{4}{1}$ B WAS B17485
 6017485

PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	A73-77
SCL	

JUNE 1, 1931	
REVISIONS	
13	5-10-48

DRG. PERTAINS TO	
B6131265	.30 BMG M17A1 (WC) M19A4 (FXD) M19A4 (FLEX) M19A5 (FXD) M19A6

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: .005
FRACTIONAL: $\frac{1}{64}$
ANGULAR: 5°

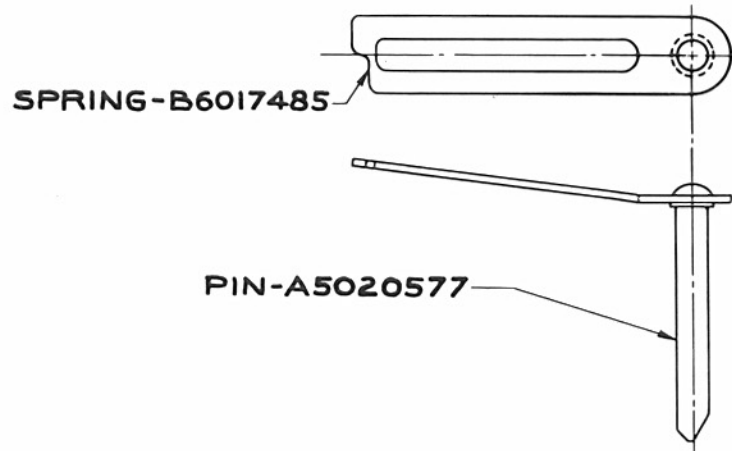
DRAFTSMAN	TRACER	L.D.'S DRAFTSMAN
C.S.S.	E.B.	
CHIEF DRAFTSMAN		

SUBMITTED:
A.W. Roe

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

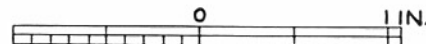
B6017485

HEAT TREATMENT AND FINAL FINISH
TYPE II FINISH, CLASS B



SPRING, SEAR, ASSEMBLY

6131265



PHYSICAL PROPERTIES	
Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	
SCL.	

JUNE 1, 1931

REVISIONS

11	5-10-48				

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

INSCRIBE PART NO.
DO NOT

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

DRAFTSMAN E.C.P.	TRACER A.V.C.	L.D.G. DRAFTSMAN
CHECKER V. G.	CHECKER G.S.	CHIEF DRAFTSMAN

SUBMITTED:
A.H. Roe
ORD. DEPT., U. S. A.

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

ORDNANCE DEPT., U. S. A.

WAS B131265
B 6131265

B6131265