

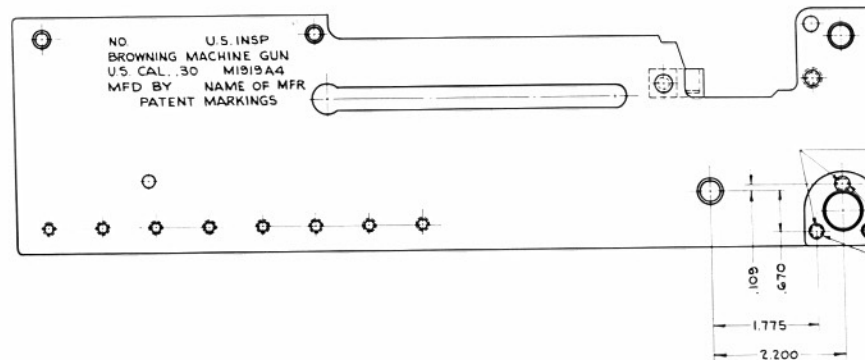
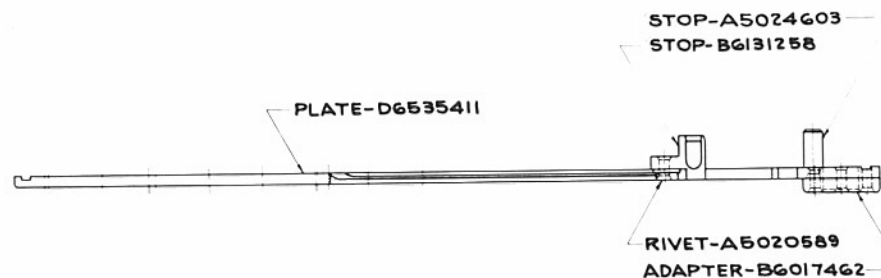
HEAT TREATMENT AND FINAL FINISH

PHYSICAL PROPERTIES		MARCH 10, 1939	
		REVISIONS	
Y. P.		6	5-10-48
T. S.			
EL. 2			
RED			
BR			
ROCK			
SCL			

DRG. PERTAINS TO

06535358 30 6MG  
M19AA (F&D) (FLEX)

C5564224



RIVET-A5024602

PLATE, SIDE, R. H., ASSEMBLY

5564224

NOTE: GRIND ALL RIVETS FLUSH  
OUTSIDE AND INSIDE.

INSCRIBE PART NO.  
DO NOT

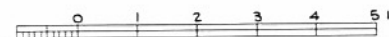
TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED  
DECIMAL : .001  
FRACTIONAL :  
ANGULAR :  
C.F.J.

DEPARTMENT OF THE ARMY  
OFFICE OF THE CHIEF OF ORDNANCE  
WASHINGTON, D. C.

SUBMITTED:  
A.H. Roe

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE  
Halter

ORD. DEPT. U. S. A.  
MADE AT ROCK ISLAND ARSENAL

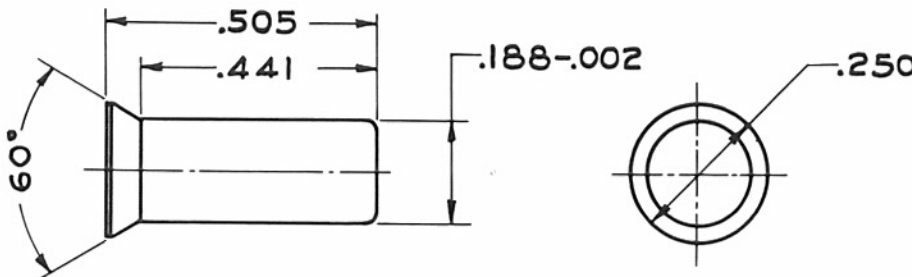


WAS C64224

C5564224

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A 5020589 JUNE 1, 1931													
		Y. P.	RED.	SCL.	<b>REVISIONS</b> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 5%;">8</td> <td style="width: 45%;">5-10-48</td> <td style="width: 50%;"></td> </tr> <tr><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td></tr> </table>			8	5-10-48										
		8	5-10-48																
T. S.	BR.																		
EL. 2	ROCK																		
<p><b>RIVET, REAR CARTRIDGE STOP</b>  <b>STEEL FS1035</b>  <b>FINISH 125/</b></p> <p>SCALE <math>\frac{4}{1}</math>   <b>A 5020589</b></p>		DRG. PERTAINS TO				<p>INSCRIBE PART NO. DO NOT</p> <p>TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED            DECIMAL <math>\pm .005</math>            FRACTIONAL <math>\pm 1/64</math>            ANGULAR <math>\pm 5^\circ</math></p> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">C5564186</td> <td style="width: 50%;">.30 BMG M17A1(WC)</td> </tr> <tr> <td>C5564224</td> <td>.30 BMG 19A4 (FXD) &amp; (FLEX)</td> </tr> <tr> <td>C5590722</td> <td>.30 BMG M19A5(FXD)</td> </tr> <tr> <td>C5594516</td> <td>.30 BMG M19A6</td> </tr> </table>		C5564186	.30 BMG M17A1(WC)	C5564224	.30 BMG 19A4 (FXD) & (FLEX)	C5590722	.30 BMG M19A5(FXD)	C5594516	.30 BMG M19A6				
		C5564186	.30 BMG M17A1(WC)																
		C5564224	.30 BMG 19A4 (FXD) & (FLEX)																
		C5590722	.30 BMG M19A5(FXD)																
		C5594516	.30 BMG M19A6																
SUBMITTED:																			
<p style="text-align: right;">ORD. DEPT., U. S. A.</p>																			
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <p style="text-align: right;">ORD. DEPT., U. S. A.</p>																			
ORDNANCE DEPT., U. S. A.																			

MADE AT ROCK ISLAND ARSENAL

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A5024602 JUNE 1, 1931	
	Y. P.	RED.	SCL.		REVISIONS		
	T. S.	BR.			13	5-10-48	
	EL. 2	ROCK					
					DRG. PERTAINS TO		
					ORDNANCE DIVISIONAL		
					STANDARD		
					DO NOT INSCRIBE PART NO.		
					TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL $\pm .005$ FRACTIONAL $\frac{1}{16}$ ANGULAR $2^\circ$		
DRAFTSMAN E.L.F.		TRACER E.B.		L'D'G DRAFTSMAN			
EVEN		O.O.		CHIEF DRAFTSMAN			
<b>RIVET, MOUNT ADAPTER</b> STEEL FS1035 FINISH $\frac{1}{25}$					(5024602)		
SCALE $\frac{4}{1}$					A 5024602		
WAS A24602					SUBMITTED: <i>A.H. Roe</i>		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>Walter A. Kuman</i>					ORD. DEPT., U. S. A.		
ORDNANCE DEPT., U. S. A.					ORDNANCE DEPT., U. S. A.		

**JUNE 1, 1931**

## PHYSICAL PROPERTIES

**RED.**

BR.

**ROCK**

12	5-10-48
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**C5564186**

.30 BMG  
M17A1 (WC)

C5564224

.30 BMG 19A4  
(FXD) & (FLEX)

**C5590722**

30 BMG  
M19A5 (FXD)  
30 BMG

**C5594516**

.30 BMG	
M19A6	

**TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED**  
DECIMAL  $\pm .005$   
FRACTIONAL  $\pm \frac{1}{64}$   
ANGULAR  $\pm 5^\circ$

**L'D'G DRAFTSMAN**

CHIEF DRAFTSMAN
-----------------

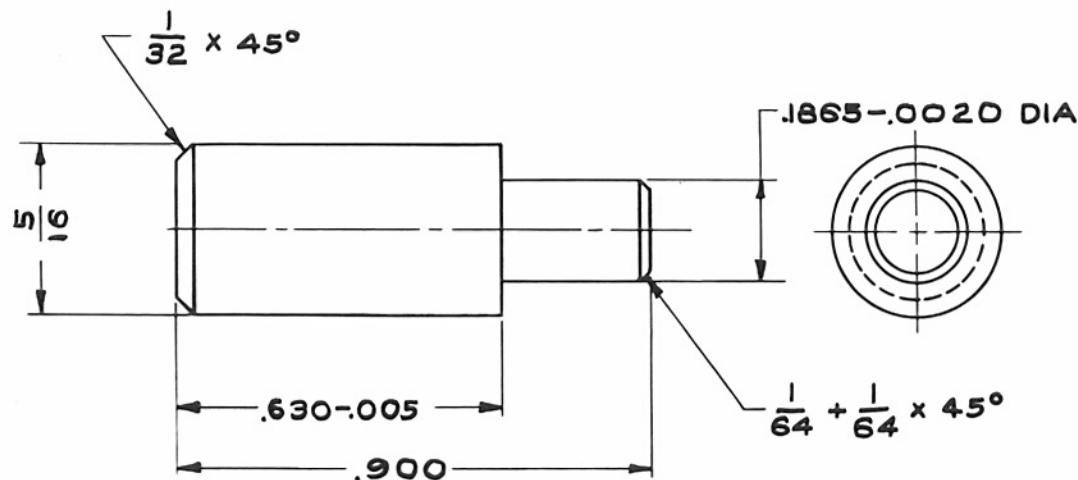
A. H. ROE

ORD. DEPT., U. S. A.

Walter Ackerman  
ORD. DEPT., U. S. A.

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

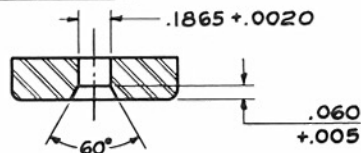


**STOP, CARTRIDGE, FRONT** (5024603)  
**STEEL FSX1335**  
**FINISH 125**

WAS A24603

SCALE  $\frac{4}{1}$  A 5024603

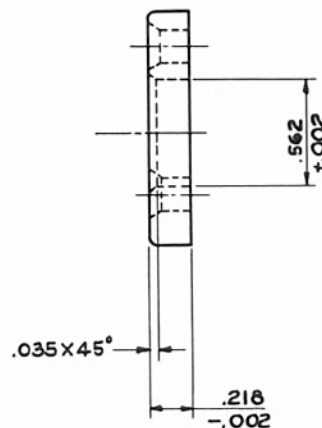
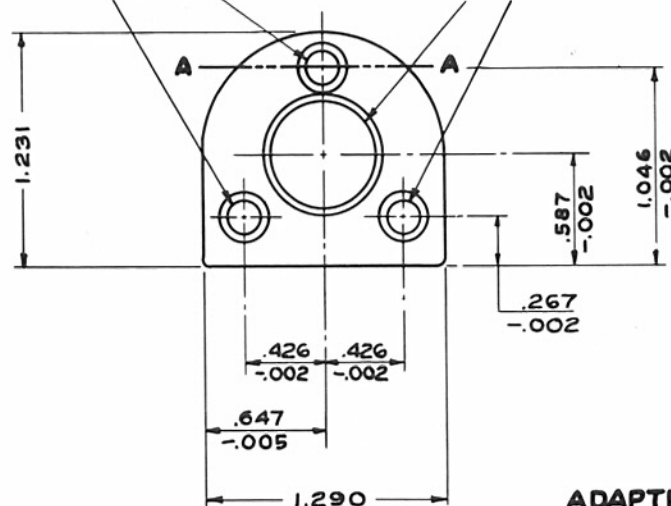
HEAT TREATMENT AND FINAL FINISH



SECTION A-A

REAM AT ASSEMBLY  
WITH R. & L. SIDE PLATES

REAM AFTER TRUNNION  
BLOCK IS ASSEMBLED



**ADAPTER MOUNT**  
STEEL WD 1035  
FINISH 125/

6017462

SCALE  $\frac{2}{1}$

WAS B 17462

B 6017462

PHYSICAL  
PROPERTIES

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

JUNE 1, 1931

REVISIONS

15	5-10-48		

DRG. PERTAINS TO

C5564185	.30 BMG M17A1 (WC)
C5564186	.30 BMG M17A1 (WC)
C5594516	.30 BMG M19A6
C5590722	.30 BMG M19A5 (FXD)
C5564222	.30 BMG M19A4 (FXD)
	M19A4 (FLEX)
	M19A5 (FXD)
	M19A6
C5564224	.30 BMG M19A4 (FXD)
	M19A4 (FLEX)

INSCRIBE PART NO.  
DO NOT

TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED  
DECIMAL ± .005  
FRACTIONAL ±  
ANGULAR ±

DRAFTSMAN E.S.F.	TRACER O.K.	L.D.'S DRAFTSMAN
CHECKER E.V.H.	CHIEF DRAFTSMAN	

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF  
OF ORDNANCE:

Walter Cushman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

B6017462



HEAT TREATMENT AND FINAL FINISH

PHYSICAL PROPERTIES		MARCH 10, 1939	
		REVISIONS	
Y. P.		6	5-10-48
T. S.			
EL. 2			
RED			
BR			
ROCK			
SCL			

DRG. PERTAINS TO

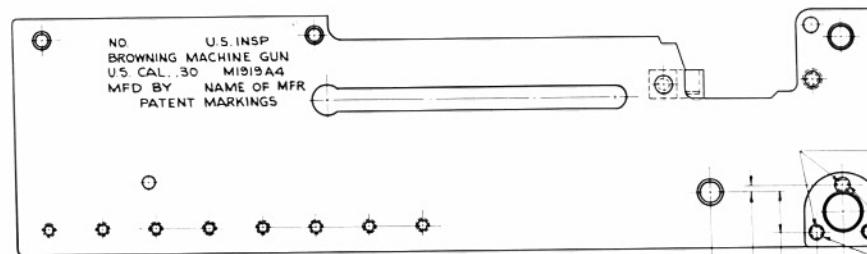
06535358 30 5MG  
M19AA (F&D) (FLEX)

C5564224

STOP-A5024603  
STOP-B6131258

PLATE-D6535411

RIVET-A5020589  
ADAPTER-B6017462



1865 ± .0020

RIVET-A5024602

PLATE, SIDE, R. H., ASSEMBLY

5564224

NOTE: GRIND ALL RIVETS FLUSH  
OUTSIDE AND INSIDE.

INSCRIBE PART NO.  
DO NOT

TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED  
DECIMAL: .001  
FRACTIONAL: 1/16  
ANGULAR: 1/2

DESIGNED BY: C.F.J.  
CHECKED BY: [Signature]  
DRAWN BY: [Signature]

SUBMITTED:

[Signature]

APPROVED BY ORDER OF THE CHIEF  
OF ORDNANCE:

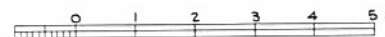
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ORD. DEPT. U. S. A.

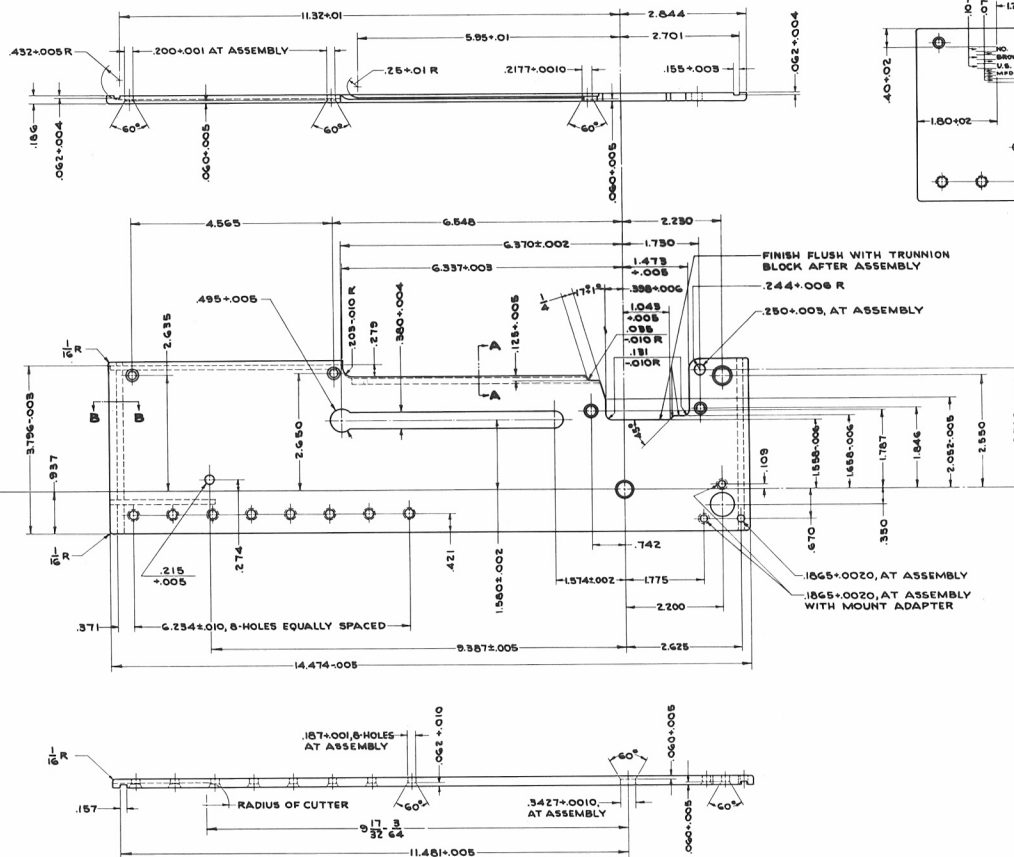
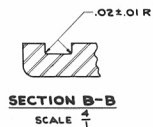
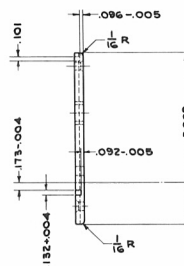
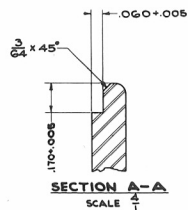
MADE AT ROCK ISLAND ARSENAL

WAS C64224

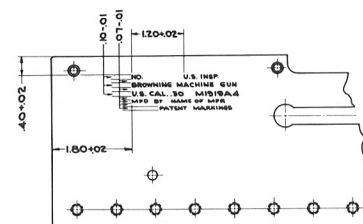
C5564224



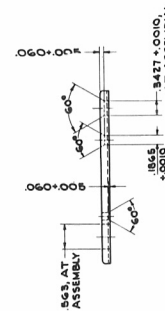
HEAT TREATMENT & FINAL FINISH  
HEAT TREAT REAR END FOR ONE  
INCH, ROCK. C48-49, ANNEAL AROUND  
TWO HOLES.



PLATE, SIDE, R.H. ©535411  
STEEL F43640  
FINISH 12/64



MARKINGS



FEBRUARY 1, 1956		CLASS	DIVISION	DRAWING	FILE
REVISIONS					
15	5-10-48				
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMALS ± .005 FRACTIONS ± 1/16 ± .005 ANGULAR ± 5°					
TOLERANCES R.S.B. <i>[Signature]</i> TOLERANCES <i>[Signature]</i> TOLERANCES <i>[Signature]</i>					
DRG. PERTAINS TO C5564224 M1944 (P.10) M1945 (P.15)					
SUBMITTED: <i>[Signature]</i>					
EXAMINED: <i>[Signature]</i>					
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE <i>[Signature]</i>					
ORD. DEPT. U.S.A.					
ORD. DEPT. U.S.A.					
ORD. DEPT. U.S.A.					
MADE AT ROCK ISLAND ARSENAL					

SCALE 1/1  
WAS D35411

D6535411

D6535411