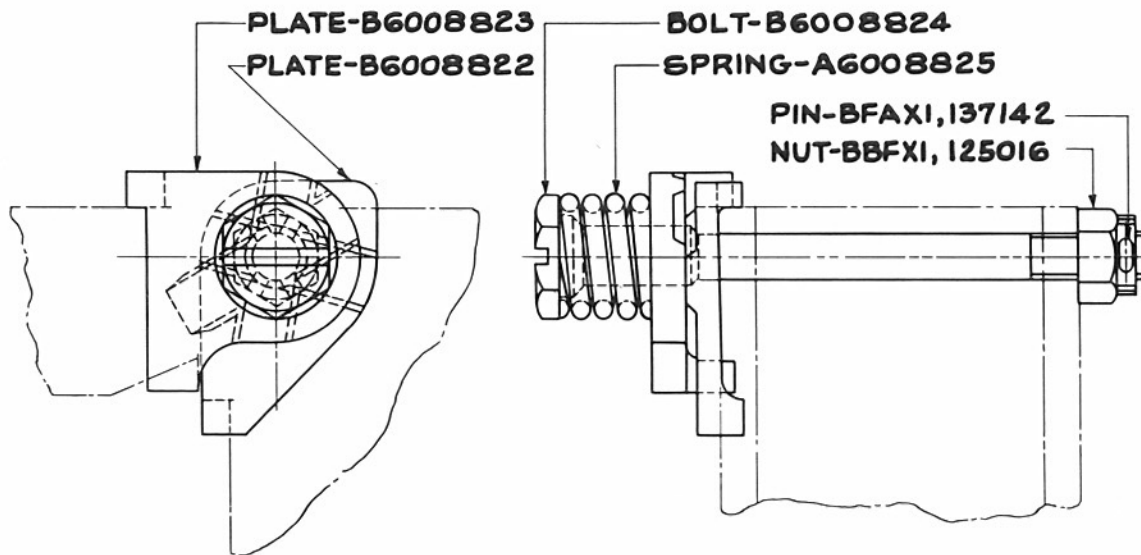
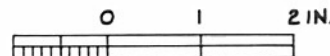


HEAT TREATMENT AND FINAL FINISH



CATCH, COVER (6008757



PHYSICAL PROPERTIES

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

SEPT. 23, 1932

REVISIONS

9	5-10-48		

DRG. PERTAINS TO

51-125-1	30 BMG M19A6
51-84-1	30 BMG M19A4 (FLX)
51-10-1	30 BMG M17A1 (WC)
51-83-1	30 BMG M19A4 (FXD)

INSCRIBE PART NO.
DO NOT

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

DRAFTER	TRACER	L.D.'S DRAFTER
T.J.C.	M.C.	
CHECKER		CHIEF DRAFTER

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

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

ORDNANCE DEPT., U. S. A.

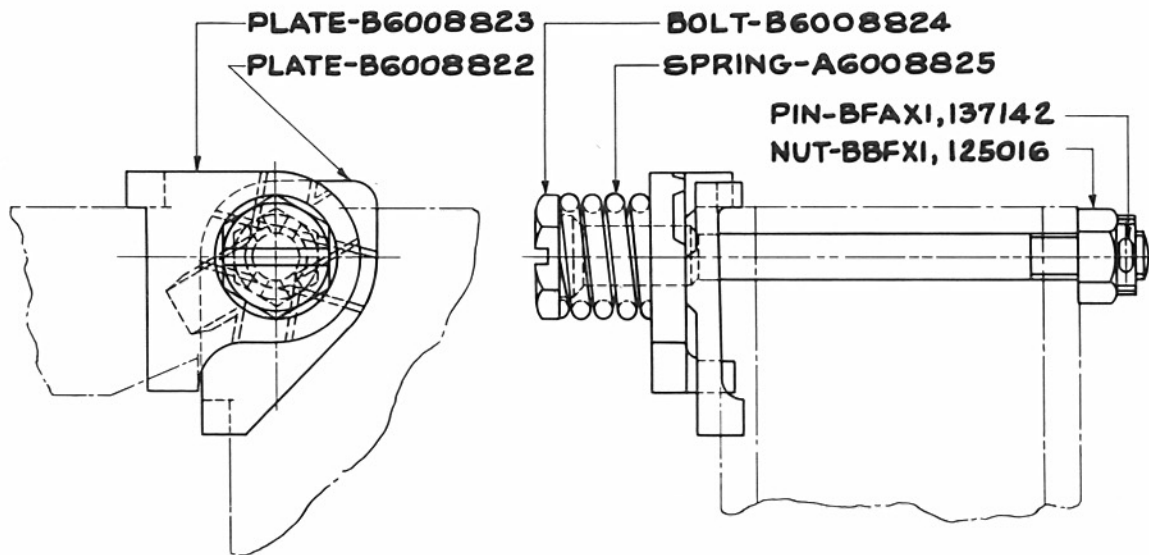
WAS B8757

B 6008757

B6008757

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A 6008825 SEPT. 23, 1932	
HEAT AT 450° F IN OIL FOR 30 MINUTES TYPE II FINISH, CLASS B		Y. P.	RED.	SCL.	REVISIONS <div style="border: 1px solid black; padding: 2px; margin-top: 5px;"> 13 5-10-48 </div>		
		T. S.	BR.				
		EL. 2	ROCK				
<div style="display: flex; justify-content: space-between;"> <div style="width: 60%;"> DIAMETER OF WIRE _____ TOTAL NUMBER OF COILS _____ MINIMUM INSIDE DIAMETER, FREE _____ OUTSIDE DIAMETER, FREE _____ MAX. OUTSIDE DIA AT MIN OPERATING HEIGHT _____ FREE LENGTH _____ TYPE OF ENDS _____ WOUND _____ MEAN ASSEMBLED HEIGHT _____ MIN LOAD AT MEAN ASSEMBLED HEIGHT _____ MIN OPERATING HEIGHT _____ LB PER INCH OF SPRING DEFLECTION _____ SPRING FUNCTIONS OVER ROD _____ CALCULATED MAX. SOLID HEIGHT _____ CAUTION: DO NOT COMPRESS SOLID. </div> <div style="width: 35%; text-align: right;"> .100-.002 4 1/2 .45 .660±.010 .672 2 1/32 ± 1/32 SQ & GD R.H. .450 62. ± 6. LB 7/16 283.1 .440 .415 </div> </div>		DRG. PERTAINS TO <div style="border: 1px solid black; padding: 2px; margin-top: 5px;"> B6008757 308M6-MITAIWC M19A4(FXD) M19A4(FLEX) M19AG </div>					
INSCRIBE PART NO. DO NOT TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL ± — FRACTIONAL ± — ANGULAR ± —							
<div style="text-align: center;"> SPRING COVER CATCH <u>SPRING STEEL WIRE WD1085 SPECIAL-CLASS A</u> </div>		<div style="border: 1px solid black; padding: 2px; margin-top: 5px;"> SUBMITTED: <i>A.H. Roe</i> ORD. DEPT., U. S. A. </div>					
<div style="text-align: center;"> SPRING STEEL WIRE WD1085 SPECIAL-CLASS A </div>		<div style="border: 1px solid black; padding: 2px; margin-top: 5px;"> APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>Walter Ackerman</i> ORD. DEPT., U. S. A. </div>					
<div style="text-align: center;"> WAS 88825 </div>		<div style="border: 1px solid black; padding: 2px; margin-top: 5px;"> ORDNANCE DEPT., U. S. A. </div>					
<div style="text-align: center;"> A 6008825 </div>		<div style="border: 1px solid black; padding: 2px; margin-top: 5px;"> 6008825 </div>					

HEAT TREATMENT AND FINAL FINISH



CATCH, COVER (6008757



PHYSICAL PROPERTIES

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

SEPT. 23, 1932

REVISIONS

9	5-10-48		

DRG. PERTAINS TO

51-125-1	30 BMG M19A6
51-84-1	30 BMG M19A4 (FLX)
51-10-1	30 BMG M17A1 (WC)
51-83-1	30 BMG M19A4 (FXD)

INSCRIBE PART NO.
DO NOT

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

DRAWN	TRACER	L.D.'S DRAFTER
T.J.C.	M.C.	
CHECKED		CHIEF DRAFTER

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

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

ORDNANCE DEPT., U. S. A.

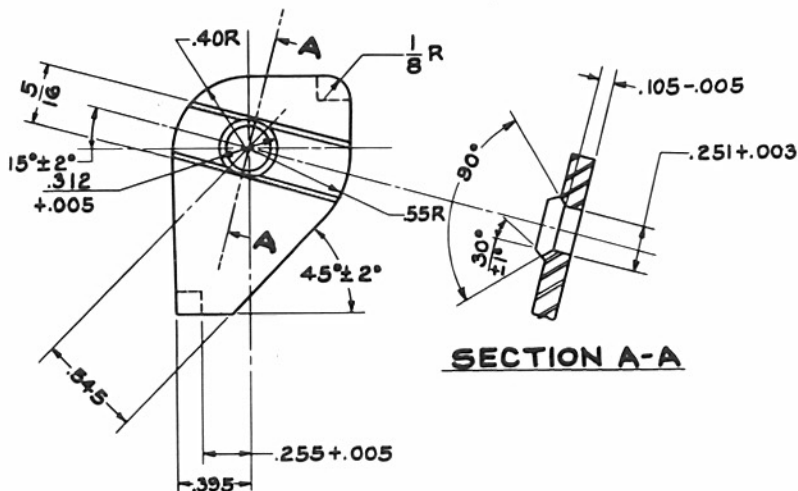
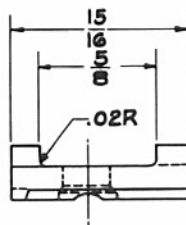
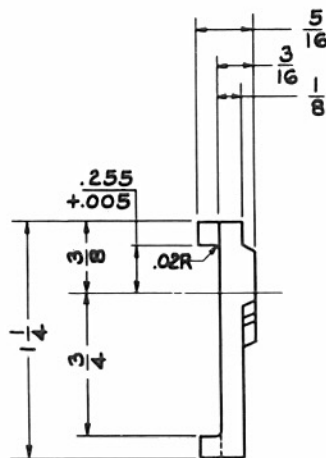
WAS B8757

B 6008757

B6008757

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS B



SECTION A-A

PLATE, FIXED
STEEL FS4615
FINISH $\sqrt{125}$

6008822

PHYSICAL PROPERTIES

Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	A78-B3
SCL.	
C.C.	.015 TO .020

SEPT. 23, 1932

REVISIONS

14	5-10-48		

DRG. PERTAINS TO

86008757 .30 BMG
M17A1(WC)
M19A4(FXD)
M19A4(FLEX)
M19A6

INSCRIBE PART NO.
DO NOT

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

DRAFTER	TRACER	L'D'S DRAFTER
F.J.C.	M.C.	
CHECKER	C.S.	CHIEF DRAFTER

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

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

ORDNANCE DEPT., U. S. A.

SCALE $\frac{2}{1}$

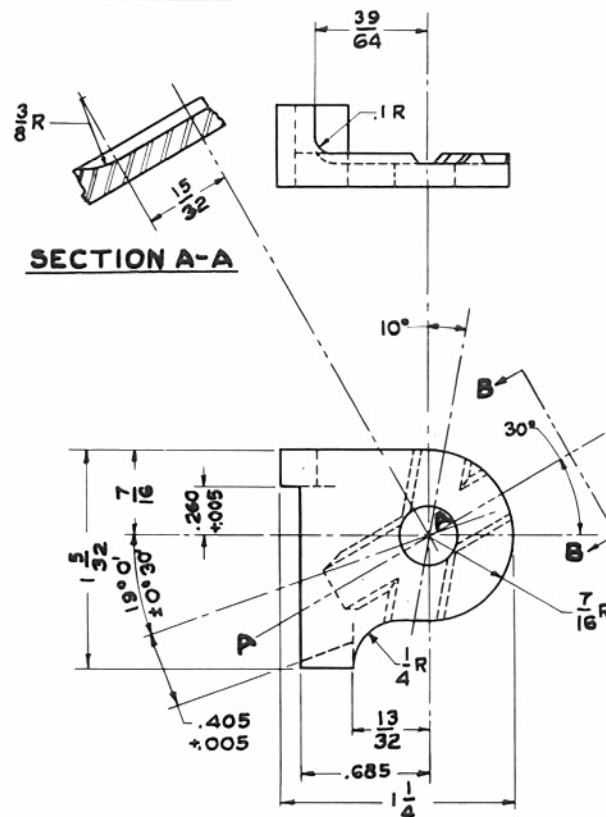
WAS B5822

B 6008822

2888008822

HEAT TREATMENT AND FINAL FINISH

HEAT TREAT
TYPE II FINISH, CLASS B



PLATE, MOVABLE 6008823
STEEL FS 4615
FINISH 125

R.I.A. FORGING SHOWN ON A7101648

WAS B8823

SCALE $\frac{2}{1}$

B 6008823

PHYSICAL
PROPERTIES

Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	A78-83
SCL.	
C. C.	.018 TO .020 DEEP

SEPT. 23, 1932

REVISIONS

15	5-10-48		

DRG. PERTAINS TO

B6008751 .30 BMG
M17A1(WC)
M19A4(FXD)
M19A4(FLEX)
M19AG

INSCRIBE PART NO.
DO NOT

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL: ± .005
FRACTIONAL: 1/64
ANGULAR: 2°

DRAWN T.C.	TRACED O.K.	L.D.G. DRAFTER
CHECKED M.E.	APPROVED A.H. Roe	CHIEF DRAFTER

SUBMITTED:

ORD. DEPT., U. S. A.

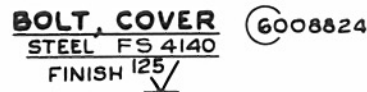
APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

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

ORDNANCE DEPT., U. S. A.

B6008823

HEAT TREAT
TYPE II FINISH, CLASS B



SCALE $\frac{2}{1}$

B	600 8824
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Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	C40-45
SCL.	

[illegible]

B6008757	.30 BMG M17A1 (WC) M19A4 (FXD) M19A4 (FLEX) M19A6
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TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$
ANGULAR $\pm 5^\circ$

DRAFTSMAN T.J.C.	TRACER O.K.	L'D-G DRAFTSMAN
CHECKED MET	Q.O.	CHIEF DRAFTSMAN

A.H. Roe

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:-

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

B6008824

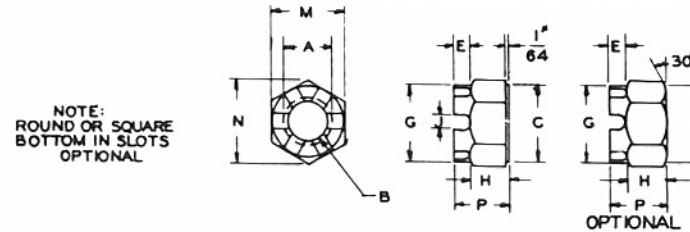
SUPERSEDES BBFX1 WITH CHANGE 10-18-45

NUT, CASTLE, NF, SEMI-FINISHED, LIGHT

BBFX1

ORDNANCE DEPT. STANDARDS (COMMERCIAL)

H-3H 7-14-31
APPROVED DATE



DIAMETER, NOMINAL	#10	1/4	5/16	3/8	7/16	1/2		
A MAJOR THD. DIAM.	.1900	.2500	.3125	.3750	.4375	.5000		
B THREADS PER INCH	32	28	24	24	20	20		
WIDTH	{							
M ACROSS	NOM. 3/8	7/16	1/2	9/16	5/8	3/4		
FLATS	MAX. .3750	.4375	.5000	.5625	.6250	.7500		
N ACROSS CORNERS	MIN. .365	.428	.489	.551	.612	.736		
	MIN. .416	.488	.557	.628	.698	.840		
P THICKNESS	{							
	NOM. 1/4	9/32	21/64	13/32	29/64	9/16		
	MAX. .266	.288	.336	.415	.463	.573		
	MIN. .234	.274	.320	.398	.444	.552		
H HEIGHT OF FLATS	NOM. .110	3/16	15/64	9/32	19/64	13/32		
J WIDTH OF SLOT	5/64	5/64	3/32	1/8	1/8	5/32		
E DEPTH OF SLOT	3/32	3/32	3/32	1/8	5/32	5/32		
G DIAMETER OF CYLINDRICAL PART	{							
	MAX. .231	.4375	.5000	.5625	.6250	.7500		
	MIN. .211	.371	.425	.478	.531	.637		
MATERIAL AND FINISH	ORDNANCE PART NUMBER, NF-2							
STEEL, COMMERCIAL								
PLAIN FINISH		103043	103044	103045	103046	103047		
CADMIUM OR ZINC PLATED		125013	125020	125027	125035	125043		
PHOSPHATE COATED		125016	125024	131807	131802	131803		
STEEL, ALLOY								
PLAIN FINISH		218595	218596	218597	218598	218599		
CADMIUM OR ZINC PLATED		432697	432709	432711	432744			
PHOSPHATE COATED		571221	571222	571223	571224	571225		
MATERIAL AND FINISH	ORDNANCE PART NUMBER, NF-3							
STEEL, COMMERCIAL								
PLAIN FINISH	503204							
CADMIUM OR ZINC PLATED		122498	122515	122531				
PHOSPHATE COATED								

MATERIAL:

STEEL, COMMERCIAL, MIN. ROCKWELL HARDNESS B-78.
STEEL, ALLOY - MIN. YIELD STRENGTH 130,000 P.S.I.

EXAMPLE FOR ORDERING: NUT, CASTLE, S-FIN., S., LIGHT, 1/2"-20NF-2, DRG. BBFX1, PART NO. 103047, PLAIN.

NOTE: ALLOY STEEL NUTS SHALL BE STAMPED WITH THE LETTER H ON ONE SIDE OF THE HEXAGON.

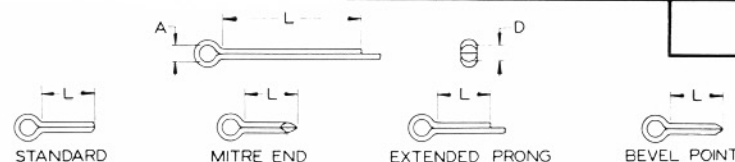
NOTE: DIAMETER OF WASHER FACE C = M MAX. -5%. DIAMETER OF BOTTOM CIRCLE D = M MAX. -15%.

REFERENCE: A.S.A. B18.2-1941.

DIMENSIONS IN INCHES.

REVISION 7 10-18-45 8 12-10-46

BFAXI



OPTIONAL DESIGNS

D	COTTER PIN DIAMETER	NOM. MAX. MIN.	1/16 .063 .055	3/32 .092 .084	7/64 .108 .100	1/8 .121 .113	5/32 .152 .144	
A	EYE DIAMETER		1/16	3/32	7/64	1/8	5/32	
L	LENGTH	ORDNANCE PART NUMBER, STEEL, PLAIN FINISH						
5/16	137124							
3/8	112526	112527			112528	112529		
7/16	137130							
1/2	103361	103372	192422	103383	103394			
5/8	107761	107762	192473	107763	107764			
3/4	103362	103373	141405	103384	103395			
7/8	100620	100629	141406	100630	100631			
1	103363	103374	121673	103385	103396			
1-1/8	108634	108636		108637	108638			
1-1/4	103364	103375		103386	103397			
1-3/8	100640	100645		100641	100643			
1-1/2	103365	103376	143222	103387	103398			
1-5/8	119207	119208		119209	119210			
1-3/4	106366	103377		103388	103399			
1-7/8	119176	119177		119178	119179			
2	103367	103378		103389	103400			
2-1/8	119215	119216	119457	119217	119218			
2-1/4	103368	103379		103390	103401			
2-1/2	103369	103380		103391	103402			
2-3/4	103370	103381		103392	103403			
3	103371	103382		103393	103404			
3-1/4		431014		120466	431624			
3-1/2				121221				
3-3/4					107319			
4					500747			
L	LENGTH	ORDNANCE PART NUMBER, STEEL, PLATED*						
5/16	137127				427300	107609		
3/8	119481							
7/16	137133							
1/2	112726	119117			137946			
5/8	137141	137159			426663			
3/4	121223	121222			177523			
7/8	137150	137168			137160			
1	17552	121224			137185	120169		
1-1/8	107943	137175			137190			
1-1/4		119120			120123	137218		
1-3/8					137195	137223		
1-1/2	107357				137204	137226		
1-5/8					137209	137233		
1-3/4		150777			137214	137238		
2					125637	137243		
2-1/4						137248		
3-1/4					192659			
L	LENGTH	ORDNANCE PART NUMBER, STEEL, OXIDE BLACK ***						
5/8	544141							
L	LENGTH	ORDNANCE PART NUMBER, COR-RES-STEEL ****						
3/4	108736	220257			107352			
3/8	193003							
1/2	190432	432254						
1-1/4	192742				190381			
1-3/4								
1		503168						

SPECIFICATION: COTTER PINS SHALL BE IN ACCORDANCE WITH FED. SPEC. FF-P-386 OF LATEST REVISION.
FINISH: *PLATED COTTER PINS MAY BE CADMIUM, ZINC OR BRIGHT NICKEL PLATED.
 **PHOSPHATE COATING SHALL BE IN ACCORDANCE WITH TYPE II, CLASS B OF SPEC 57-0-2 OF LATEST REVISION.
 ***OXIDE COATING SHALL BE IN ACCORDANCE WITH TYPE III, CLASS A, GRADE I OF SPEC 57-0-2 OF LATEST REVISION.
 ****CORROSION RESISTING STEEL SHALL BE IN ACCORDANCE WITH TYPE U OF FED. SPEC. FF-P-386
NOMENCLATURE PATTERN: PIN, COTTER, SPLIT, 1/16 x 7/16, STEEL, PLAIN FINISH, DWG. BFAXI, PART NO. 137130.

REVISIONS				ORIGINAL DATE OF DRAWING SEP 5, 1928		ORDNANCE ENGINEERING STANDARDS (COMMERCIAL)		ORDNANCE DEPT DEPT OF THE ARMY	
SYM	DESCRIPTION	DATE	APPD	DRAFTSMAN	CHECKER			ENGINEERING & INSPECTION SECTION - ORDIP	
17		5-23-49	W.C.R.	TYPST B.L.	CHECKER O.M.H.	PIN, COTTER, SPLIT		PREPARED BY ROCK ISLAND ARSENAL	
18		10-14-49		ENGINEER W.E. Rogers	ENGINEER			BFAXI	
				SUBMITTED O'Connell	APPROVED G.S. Stump				
				MATERIAL					
				COMMERCIAL AS SPECIFIED					
						SCALE		DIMENSIONS IN INCHES	