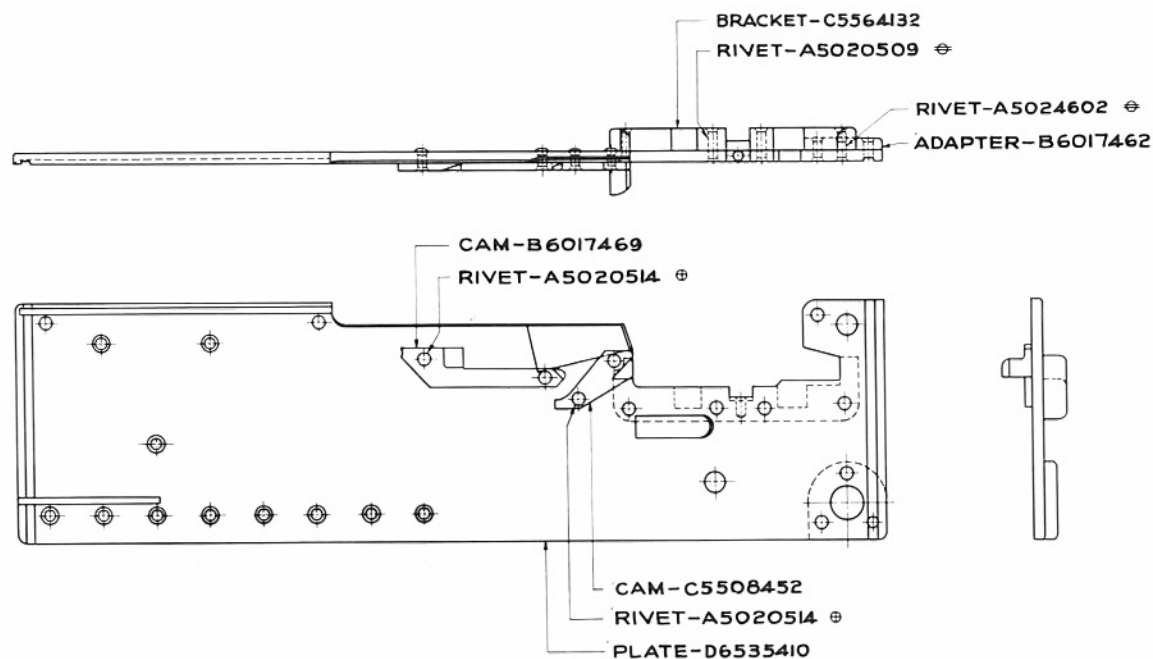


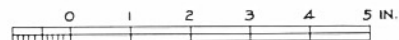
HEAT TREATMENT AND FINAL FINISH



PLATE, SIDE, L.H. ASSEMBLY

5564222

NOTE:  
 ⊕ GRIND FLUSH INSIDE  
 ⊗ GRIND FLUSH INSIDE AND OUTSIDE



WAS C64222

C 5564222

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

DRG. PERTAINS TO

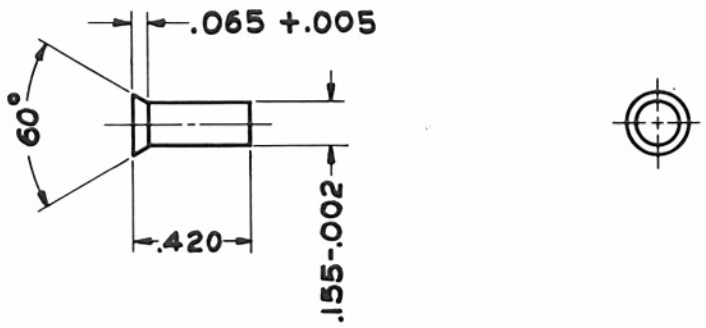


D6535358 .30 BMG M19A4(FXD)-FLEX  
 D6540989 .30 BMG M19A8(FXD)  
 D7114037 .30 BMG M19A6

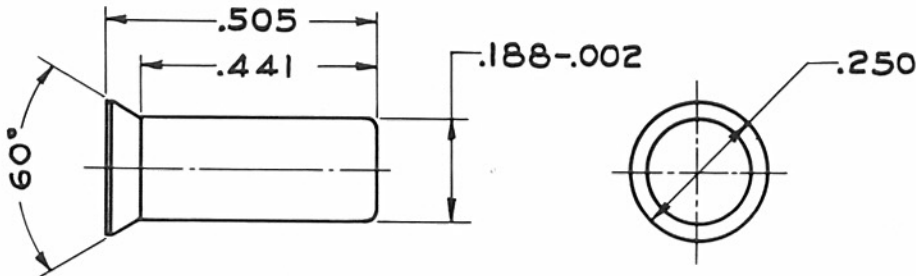
INSCRIBE PART NO.		
DO NOT		
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED		
DECIMAL : —		
FRACTIONAL : —		
ANGULAR : —		
DRAWN BY R.S.B.	CHECKED BY E.B.	DATE 10/10/48
SUBMITTED BY A.H. Roe		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE Walter Wickhaman ORD. DEPT. U. S. A.		
ORDNANCE DEPT., U. S. A.		

MADE AT ROCK ISLAND ARSENAL

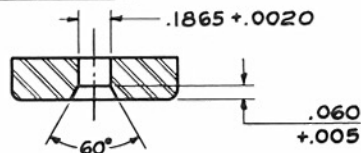
C5564222

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A 5020509 APRIL 4, 1927				
		Y. P.		RED.		SCL.				
		T. S.		BR.						
		EL. 2		ROCK						
<p style="text-align: center;"> <b>RIVET, BELT HOLDING PAWL BRACKET</b>  <b>STEEL FS1035</b>  <b>FINISH 125/</b> </p> <p style="text-align: right;"> <b>5020509</b> </p> <p style="text-align: right;"> <b>SCALE <math>\frac{4}{1}</math> A 5020509</b> </p>							REVISIONS			
							11	5-10-48		
							DRG. PERTAINS TO			
							C5564185	.30 BMG M17A1 (WC)		
							C5564222	.30 BMG M19A4 (FXD)		
								M19A4 (FLEX)		
								M19A5 (FXD)		
								M19A6		
							INSCRIBE PART NO. DO NOT			
							TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL $\pm .005$ FRACTIONAL $\pm$ — ANGULAR $\pm 5^\circ$			
		DRAFTSMAN <b>W.C.O.</b>	TRACER <b>L.R.E.</b>	L'D'G DRAFTSMAN						
		CHECKER <i>W.C.O.</i>	<i>W.C.O.</i>	CHIEF DRAFTSMAN						
							SUBMITTED: <i>A.H. Roe</i> ORD. DEPT., U. S. A.			
							APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>Walter A. Kuman</i> ORD. DEPT., U. S. A.			
							ORDNANCE DEPT., U. S. A.			

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A 5020514 APRIL 4, 1927	
		Y. P.	RED.	SCL.	REVISIONS		
		T. S.	BR.		11	5-10-48	
		EL. 2	ROCK				
<p><b>RIVET</b>  <b>STEEL FSX1315</b>  <b>FINISH 125/</b></p> <p style="text-align: right;">(5020514)</p> <p style="text-align: right;">SCALE <math>\frac{2}{1}</math> A <b>5020514</b></p>						DRG. PERTAINS TO	
						C5564185	.30 BMG M17A1 (WC)
						C5564222	.30 BMG M19A4 (FXD) M19A4 (FLEX) M19A5 (FXD) M19A6
INSCRIBE PART NO. DO NOT						TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL $\pm .005$ FRACTIONAL $\pm \frac{\quad}{\quad}$ ANGULAR $\pm 5^\circ$	
DRAFTSMAN J.J.V.		TRACER L.R.E.		L'D'G DRAFTSMAN		SUBMITTED:  ORD. DEPT., U. S. A.	
CHECKER L.R.E.		O.O.		CHIEF DRAFTSMAN			
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:  ORD. DEPT., U. S. A.						ORDNANCE DEPT., U. S. A.	
WAS A20514							

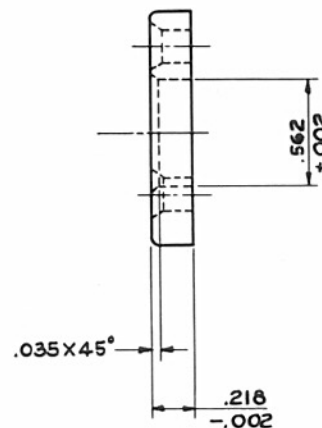
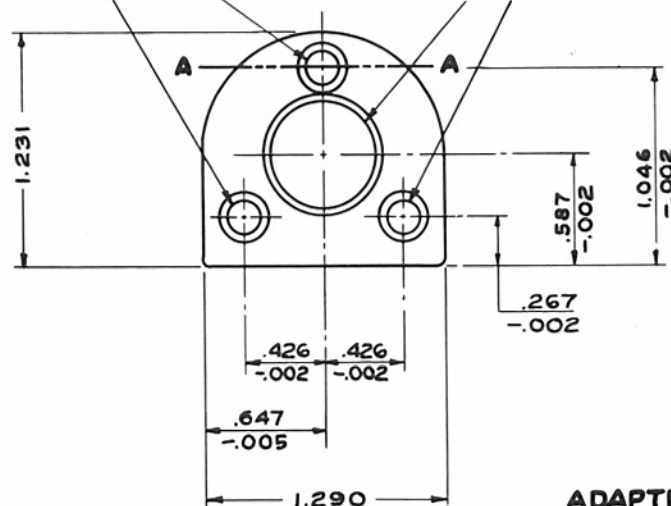
HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A5024602 JUNE 1, 1931	
	Y. P.	RED.	SCL.		REVISIONS		
	T. S.	BR.			13	5-10-48	
	EL. 2	ROCK					
					DRG. PERTAINS TO		
					ORDNANCE DIVISIONAL		
					STANDARD		
					DO NOT INSCRIBE PART NO.		
					TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED 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.		

HEAT TREATMENT AND FINAL FINISH



REAM AT ASSEMBLY  
WITH R. & L. SIDE PLATES

REAM AFTER TRUNNION  
BLOCK IS ASSEMBLED



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

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  $\pm .005$   
FRACTIONAL  $\pm$   
ANGULAR  $\pm$

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:

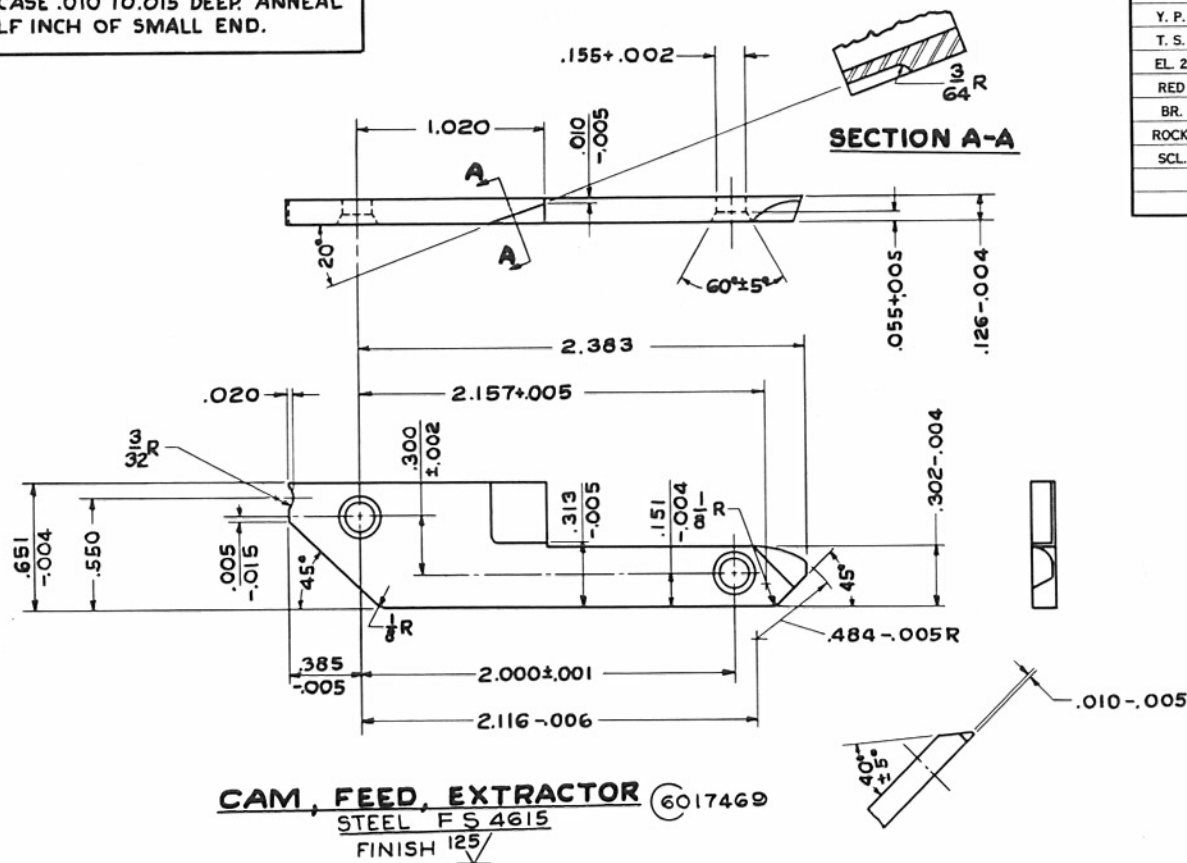
Walter Cushman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

B6017462

HEAT TREATMENT AND FINAL FINISH  
CARBON CASE .010 TO .015 DEEP. ANNEAL  
ONE HALF INCH OF SMALL END.



SECTION A-A

PHYSICAL  
PROPERTIES

Y. P.	
T. S.	
EL. 2	
RED	
BR.	
ROCK.	A78-83
SCL.	

JUNE 1, 1931

REVISIONS

11	5-10-48		

DRG. PERTAINS TO

C5564185	.30 BMG M19A1 (WC)
C5564222	.30 BMG M19A4 (FXD) M19A4 (FLEX) M19A5 (FXD) M19A6

INSCRIBE PART NO.  
DO NOT

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

DRAFTSMAN	TRACER	L'D'S DRAFTSMAN
C.S.S. O.K.		
CHECKER	C.D.	CHIEF DRAFTSMAN
L.S.		

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 817469

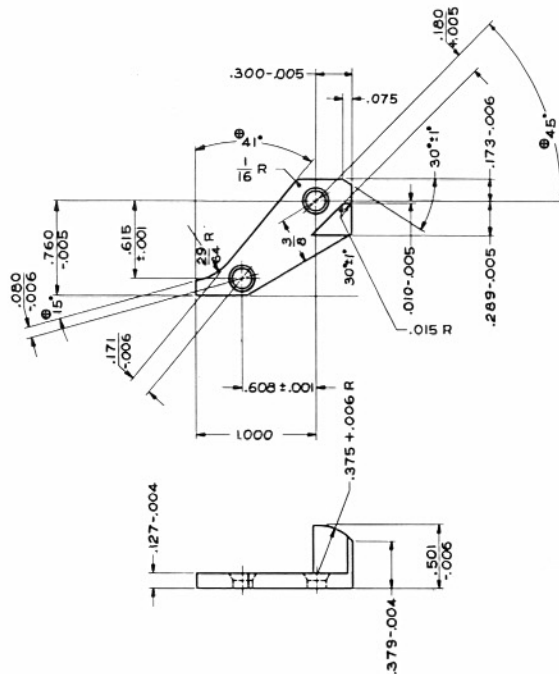
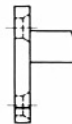
SCALE  $\frac{2}{1}$

B 6017469

B6017469

# HEAT TREATMENT AND FINAL FINISH

CARBON CASE .010 TO .015 DEEP.  
ANNEAL  $\frac{1}{2}$  INCH OF SMALL END.



**CAM EXTRACTOR**  
STEEL FS 4615  
FINISH  $\frac{125}{1}$

5508452

● PERMISSIBLE ANGLE TOLERANCES NOT SPECIFIED, MUST BE WITHIN LIMITS PRESCRIBED BY LOCATING DIMENSIONS.

PHYSICAL PROPERTIES		JUNE 1, 1931 REVISIONS	
Y. P.		15	5-10-48
T. S.			
EL. 2			
RED			
BR.			
ROCK.	A78-83		
SCL.			

DRG. PERTAINS TO	
C5564185	30 BMG M17A1 (WC)
C5564222	30 BMG M19A4 (F&D)
	30 BMG M19A4 (FLEX)
	30 BMG M19A5 (F&D)
	30 BMG M19A5

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

DRAWN	CS.S.	RECEIVED	L.R.E.	U.S. DEPT. OF ARMY
CHECKED		U.S. DEPT. OF ARMY		

SUBMITTED: *A.H. Roe*

WAS C8452

DO NOT INSCRIBE PART NO.

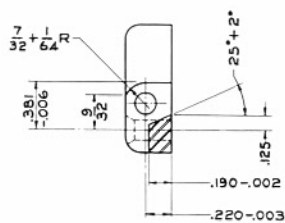
SCALE  $\frac{2}{1}$

5508452

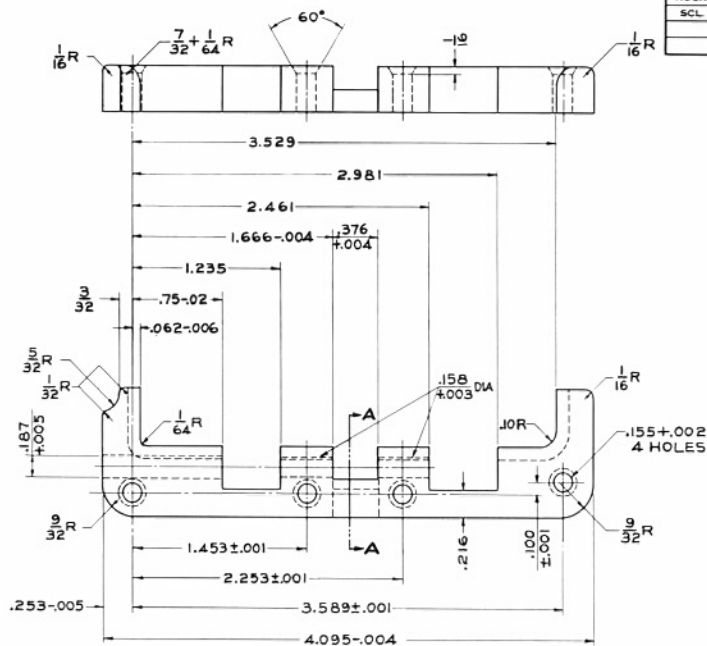
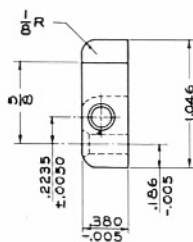
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE.  
*Walter R. Robinson*  
U.S. DEPT. OF ARMY  
ORDNANCE DEPT., U. S. A.  
MADE AT ROCK ISLAND ARSENAL

C5508452

HEAT TREATMENT AND FINAL FINISH



SECTION A-A



BRACKET, BELT HOLDING PAWL  
STEEL FSX1020  
FINISH 125

5564132

PHYSICAL PROPERTIES		FEBRUARY 1, 1938	
		REVISIONS	
Y. P.		13	5-10-48
T. S.			
EL. 2			
RED			
BR.			
ROCK.			
SCL.			

DRG. PERTAINS TO

05564185 30 BMG  
MITA(WC)  
05564222 30 BMG  
M19A4(FXD)  
30 BMG  
M19A4(FLEX)  
30 BMG  
M19A5(FXD)  
30 BMG  
M19A6

TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED  
DECIMAL : .003  
FRACTIONAL : 1/64  
ANGULAR : 5°

DRAWN BY J. U. E. B. CHECKED BY J. U. E. B. C.D. DRAFTSMAN

SUBMITTED: A.M. Roe

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: Walter C. Bowman

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL

WAS 64132

DO NOT INSCRIBE PART NO.

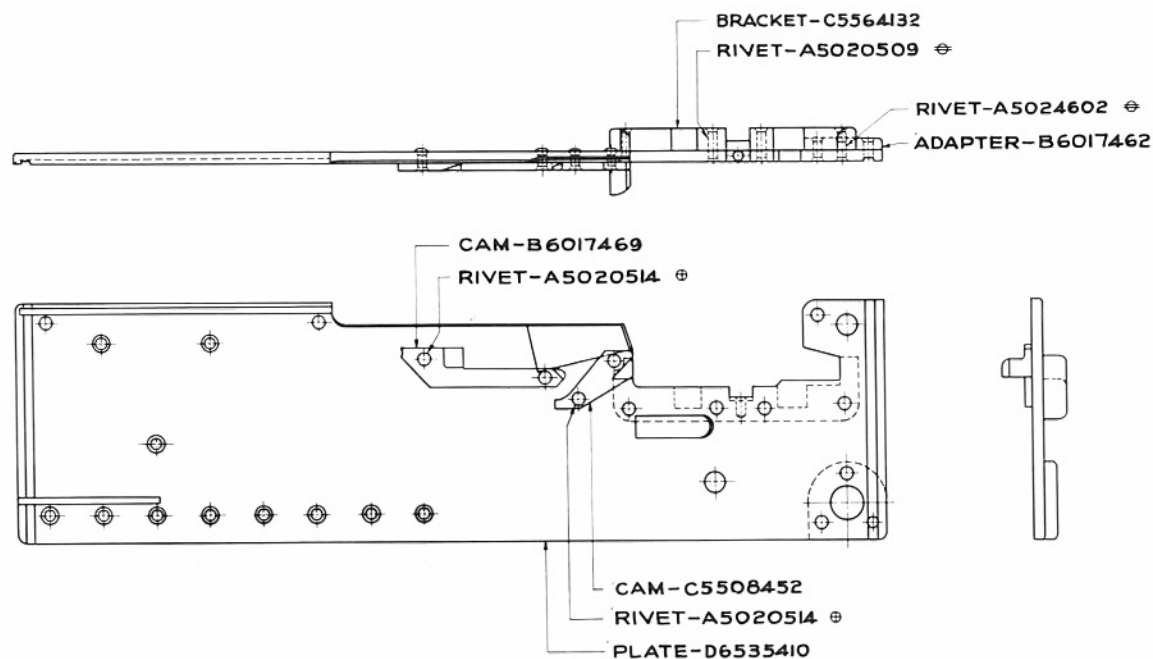
SCALE 2

5564132

C5564132



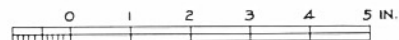
HEAT TREATMENT AND FINAL FINISH



PLATE, SIDE, L.H. ASSEMBLY

5564222

NOTE:  
 ⊕ GRIND FLUSH INSIDE  
 ⊗ GRIND FLUSH INSIDE AND OUTSIDE



WAS C64222

C 5564222

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

DRG. PERTAINS TO

D6535358 .30 BMG M19A4(FXD)-FLEX  
 D6540989 .30 BMG M19A8(FXD)  
 D7114037 .30 BMG M19A6

INSCRIBE PART NO.		
DO NOT		
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED		
DECIMAL : —		
FRACTIONAL : —		
ANGULAR : —		
DRAWN BY R.S.B.	CHECKED BY E.B.	DATE 10/10/39
SUBMITTED BY A.H. Roe		
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE Walter Wickham ORD. DEPT. U. S. A.		
ORDNANCE DEPT., U. S. A.		

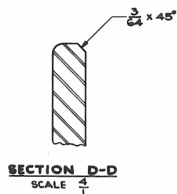
MADE AT ROCK ISLAND ARSENAL

C5564222

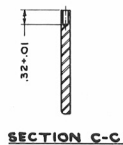
HEAT TREAT REAR END FOR ONE INCH, ROCK. C43-49. ANNEAL AROUND TWO HOLES.

PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL-2	
RED.	
HT.T.	
BR.	
SCL.	
C.C.	

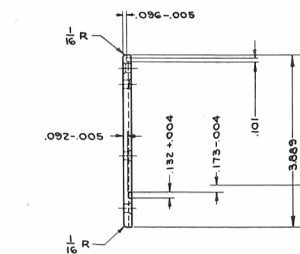
D6535410



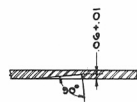
**SECTION D-D**  
SCALE  $\frac{4}{1}$



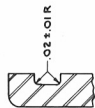
**SECTION C-C**



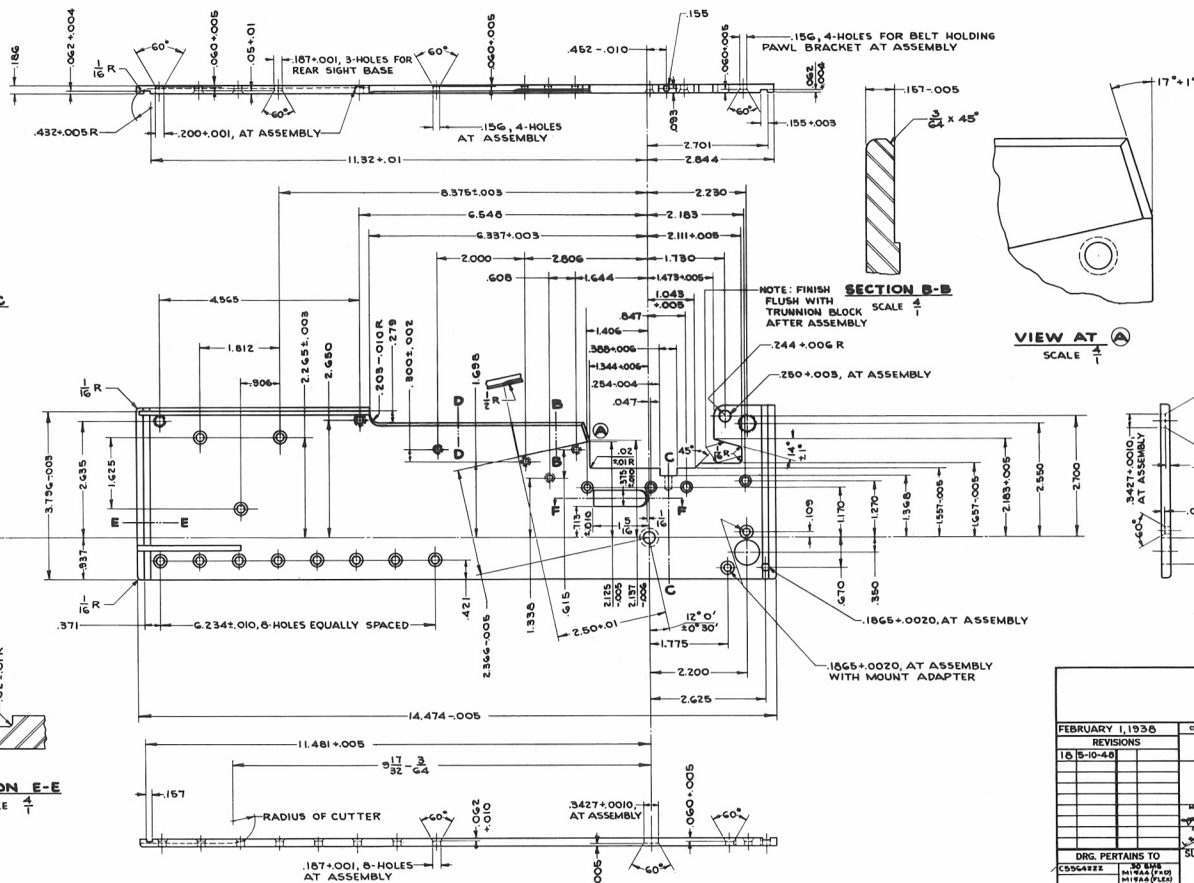
**SECTION F-F**



**SECTION F-F**



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



PLATE, SIDE, L.H. (G535410)  
STEEL FS4G40  
FINISH 125

SCALE  $\frac{1}{1}$   
WAS D35410

FEBRUARY 1, 1956		CLASS		DIVISION		DRAWINGS		FILES	
REVISIONS									
10 15-10-49									
		TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL 1: .001 FRACTIONAL 5/16 & 3/8 ANGULAR ± 3° FINISH: <i>Relief</i>							
		APPROVED <i>[Signature]</i> CHECKED <i>[Signature]</i>		REVIEWED <i>[Signature]</i> CRIP REVIEWED <i>[Signature]</i>					
DRG. PERTAINS TO C564422		TO BLUE M (144) M (144) (P) (L) M (144) (P) (D) M (144)		SUBMITTED: <i>THP</i>					
D 6535410				EXAMINED:  APPROVED BY CHIEF OF BUREAU <i>[Signature]</i> ORDNANCE DEPT., U.S.A. ORDNANCE DEPT., U.S.A.					