

HEAT TREATMENT AND FINAL FINISH  
FINISH TYPE II, CLASS B

PHYSICAL PROPERTIES		JUNE 1, 1931	
		REVISIONS	
Y. P.		15	5-10-40
T. S.		16	6-21-49
EL. 2			
RED			
BR.			
ROCK.			
SCL.			

DRG. PERTAINS TO

C5564056  
M14AA (FXD)  
M14AA (FLX)  
M14AS (FXD)  
M14AS

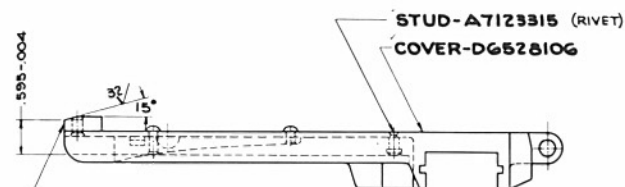
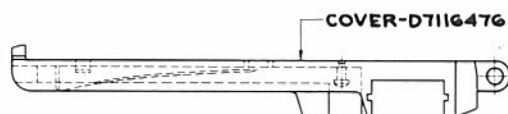
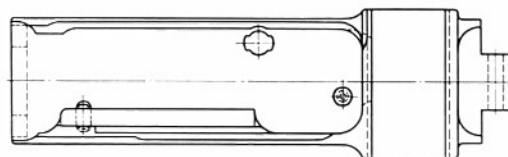


PLATE-A 5020505  
RIVET-A 5020513



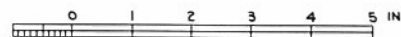
RIVET AND  
FILE FLUSH

RIVET-A 7133165 (RIVET AND FILE FLUSH)  
CAM-B6017494  
RIVET-A 7133164 (RIVET AND FILE FLUSH)

ALTERNATIVE A

COVER, ASSEMBLY

5509801



WAS C9801

C5509801

INSCRIBE PART NO.  
DO NOT

TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED

DECIMAL: —  
FRACTIONAL: 1/16  
ANGULAR: 0° 30'

DRAWN BY W.B.H. CHECKED BY W.B.H. DESIGNED BY W.B.H. APPROVED BY W.B.H.

SUBMITTED: A.H. Roe

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

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL

C5509801

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A5020503 APRIL 4, 1927	
HEAT TREAT TYPE II FINISH, CLASS B		Y. P.	RED.	SCL.	REVISIONS		
		T. S.	BR.				
		EL. 2	ROCK	C43-49			
		DRG. PERTAINS TO					
		51-114-5	.30 BMG M19A5(FXD)				
		51-125-5	.30 BMG M19A6				
		51-10-45	.30 BMG M17A1(WC)				
		51-83-5	.30 BMG M19A4(FXD)				
		51-84-5	.30 BMG M19A4(FLEX)				
		INSCRIBE PART NO. DO NOT					
		TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL ± — FRACTIONAL : 1/64 ANGULAR : 5°					
		DRAFTSMAN M.E.B.	TRACER A.V.C.	L'D'G DRAFTSMAN			
		CHECKER L.S.C.	O.O.	CHIEF DRAFTSMAN			
SUBMITTED: <i>A.W. Roe</i> ORD. DEPT., U. S. A.							
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>Walter Ackerman</i> ORD. DEPT., U. S. A.							
ORDNANCE DEPT., U. S. A.							

**PIN, TRIGGER**

STEEL FS4140

FINISH 125/

5020503

SCALE  $\frac{2}{1}$

WAS A20503

A 5020503

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A5020513 APRIL 4, 1927	
		Y. P.	RED.	SCL.	REVISIONS		
		T. S.	BR.		11	5-10-48	
		EL. 2	ROCK				
		<p>DRG. PERTAINS TO ORDNANCE DIVISIONAL STANDARD</p>					
		<p>INSCRIBE PART NO. DO NOT</p>					
		<p>TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL <math>\pm .005</math> FRACTIONAL <math>\pm</math> ANGULAR <math>\pm 5^\circ</math></p>					
		DRAFTSMAN W.C.O.		TRACER E.B.		L'D'G DRAFTSMAN	
		CHECKER <i>[Signature]</i>		O.O.		CHIEF DRAFTSMAN	
		<p>SUBMITTED: <i>A.H. Roe</i></p>					
		<p>APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>Walter Ackerman</i> ORD. DEPT., U. S. A.</p>					
		<p>ORDNANCE DEPT., U. S. A.</p>					

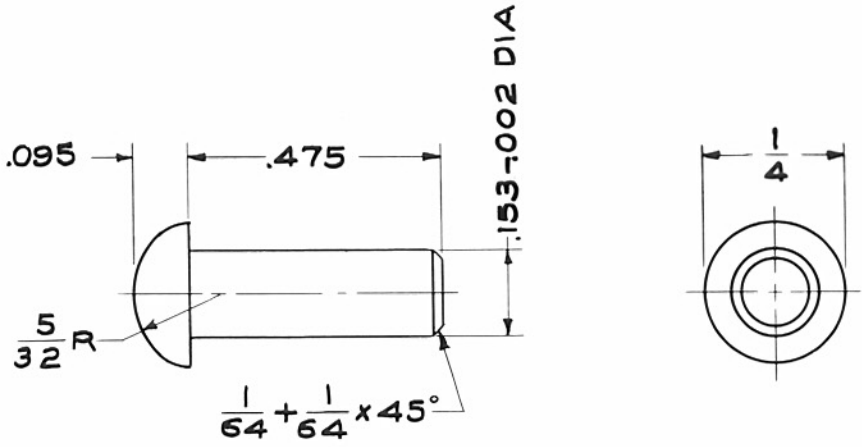
**RIVET**  
**STEEL FS 1035**  
**FINISH 125/**

5020513

WAS A20513

SCALE  $\frac{4}{1}$  A 5020513

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A7123315 MAY 25, 1945		
		Y. P.	RED.	SCL.	REVISIONS			
		T. S.	BR.		1	5-10-48		
		E. L. 2	ROCK					
<p><b>STUD, COVER EXTRACTOR SPRING</b></p> <p><b>STEEL FS1115</b></p> <p><b>FINISH 125/</b></p>						DRG. PERTAINS TO		
		C5509814		30 B.M.G. M17A1 (WC)				
		C5509801		30 B.M.G. M19A4 (FXD) M19A4 (FLEX) M19A5 (FXD) M19A6				
						INSCRIBE PART NO. DO NOT		
						TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL ± .005 FRACTIONAL ± 1/64 ANGULAR ± 8°		
DRAFTSMAN W.O.F.		TRACER A.V.C.		L'D'G DRAFTSMAN				
CHECKER H.W.J.		0.0.		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.		
SUPERSEDES A7123315 WO/C 5-10-48		SCALE 4/1		A 7123315		ORDNANCE DEPT., U. S. A.		

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				<b>A7133164</b> <b>MAY 10, 1948</b>	
		Y. P.		RED.		SCL.	
		T. S.		BR.			
		EL. 2		ROCK			
<div style="display: flex; justify-content: space-around; align-items: center;">  </div>							
<b>RIVET COVER EXTRACTOR CAM, LONG</b> <b>STEEL FS1035</b> <b>FINISH 125/</b>							
<b>7133164</b>							
<b>SUPERSEDES A20511A WO/C 5-10-48</b>							
<b>SCALE 4/1</b>							
<b>A 7133164</b>							

REVISIONS			

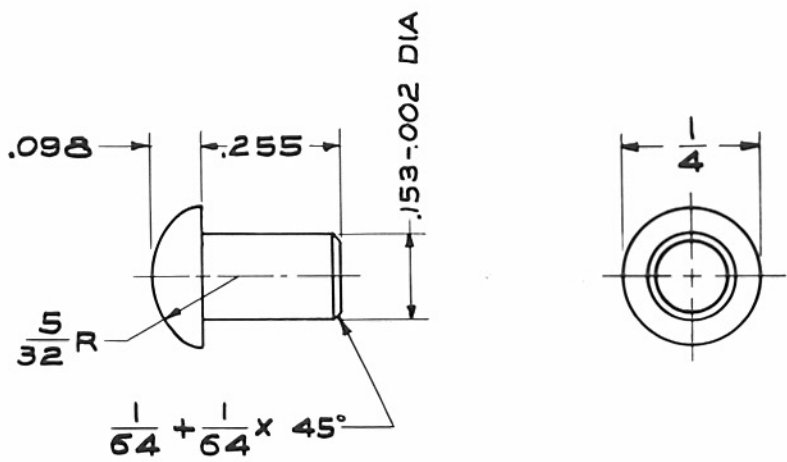
DRG. PERTAINS TO	
<b>C5509801</b>	<b>130BMGM19A4</b> <b>(FXD) &amp; (FLEX.)</b> <b>M19A5 (FXD)</b> <b>M19A6</b>

INSCRIBE PART NO. DO NOT	
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL ± .005 FRACTIONAL ± 1/64 ANGULAR ± 5°	

DRAFTSMAN <b>A.P.R.</b>	TRACER <b>E.R.G.</b>	L'D'G DRAFTSMAN
CHECKER <i>H.W.S.</i>	0.0	CHIEF DRAFTSMAN

SUBMITTED: <i>A.H. Roe</i> ORD. DEPT., U. S. A.	
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>Walter Ackerman</i> ORD. DEPT., U. S. A.	
ORDNANCE DEPT., U. S. A.	

MADE AT ROCK ISLAND ARSENAL

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				<div style="text-align: right;">A7133165</div> <div style="text-align: center;">MAY 10, 1948</div>	
		Y. P.		RED.		SCL.	
		T. S.		BR.			
		EL. 2		ROCK			
							
<b>RIVET, COVER EXTRACTOR CAM, SHORT</b> <u>STEEL FS 1035</u> FINISH 125/							
(7133165)							
SCALE $\frac{4}{1}$   A   7133165							

A7133165

MAY 10, 1948

REVISIONS


DRG. PERTAINS TO

C5509801	30BMG M19A4 (FXD) & (FLEX.) M19A5 (FXD) M19A6

DO NOT INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS  
 NOT OTHERWISE SPECIFIED  
 DECIMAL : .005  
 FRACTIONAL : 1/64  
 ANGULAR : 5°

DRAFTSMAN A.P.R.	TRACER E.R.G.	L'D'G DRAFTSMAN
CHECKER H.W.J.	0.0	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.

SUPERSEDES A20512A WO/C 5-10-48

MADE AT ROCK ISLAND ARSENAL

CARBON CASE .010 TO .015 DEEP.  
ANNEAL ONE HALF INCH OF SMALL END.

## REVISIONS

**SCL.**

16	5-10-48
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C5509814

C5509801

.30 BMG M17A1(WC)	
.30 BMG M19A4(FXD) M19A4(FLEX) M19A5(FXD) M19A6	

TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED  
DECIMAL ± —  
FRACTIONAL ± 1/64  
ANGULAR ± 5°

DRAFTSMAN 22.8	TRACER L.R.E.	L'D-G DRAFTSMAN
CHECKER 1.95		CHIEF DRAFTSMAN

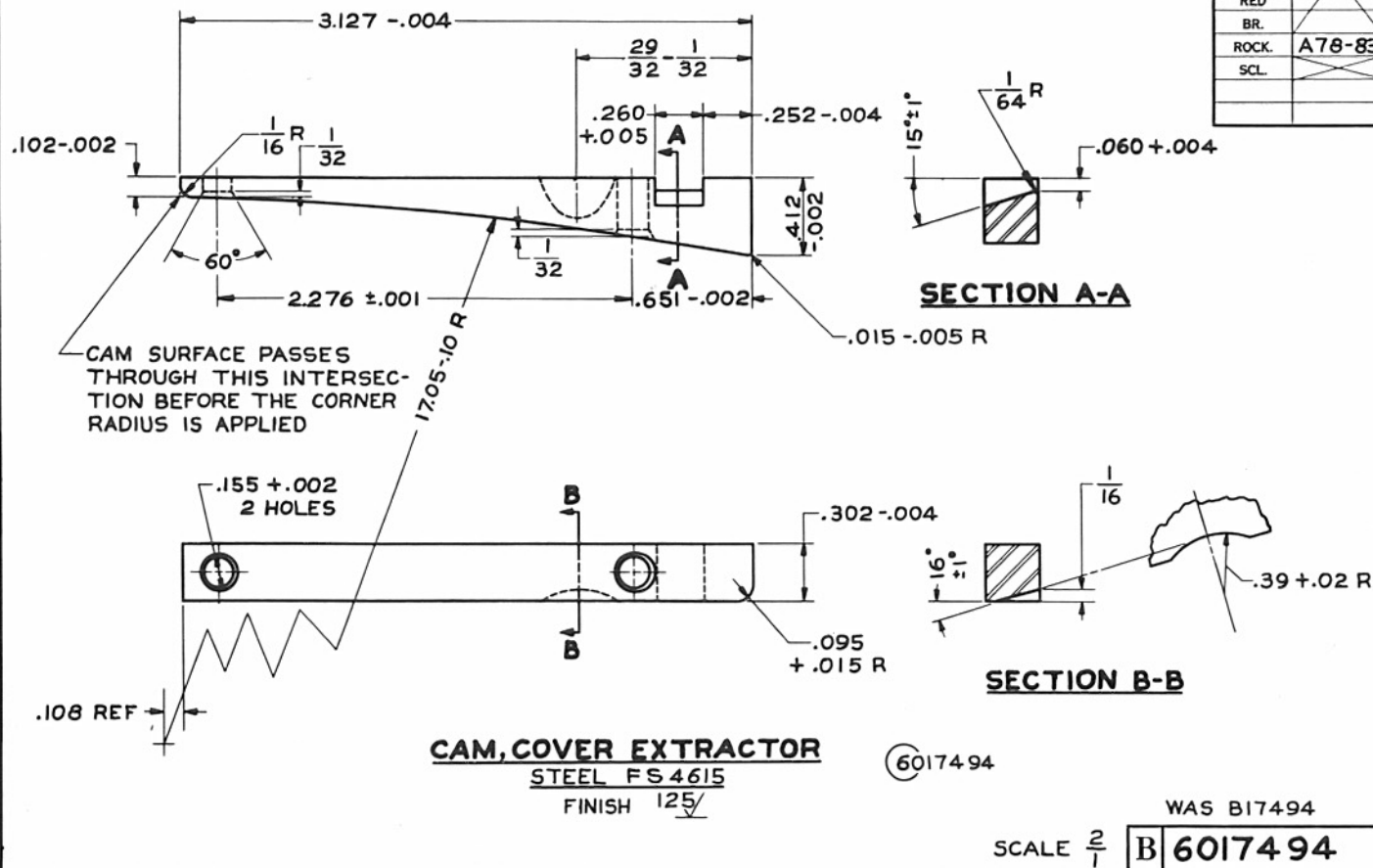
SUBMITTED:

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.



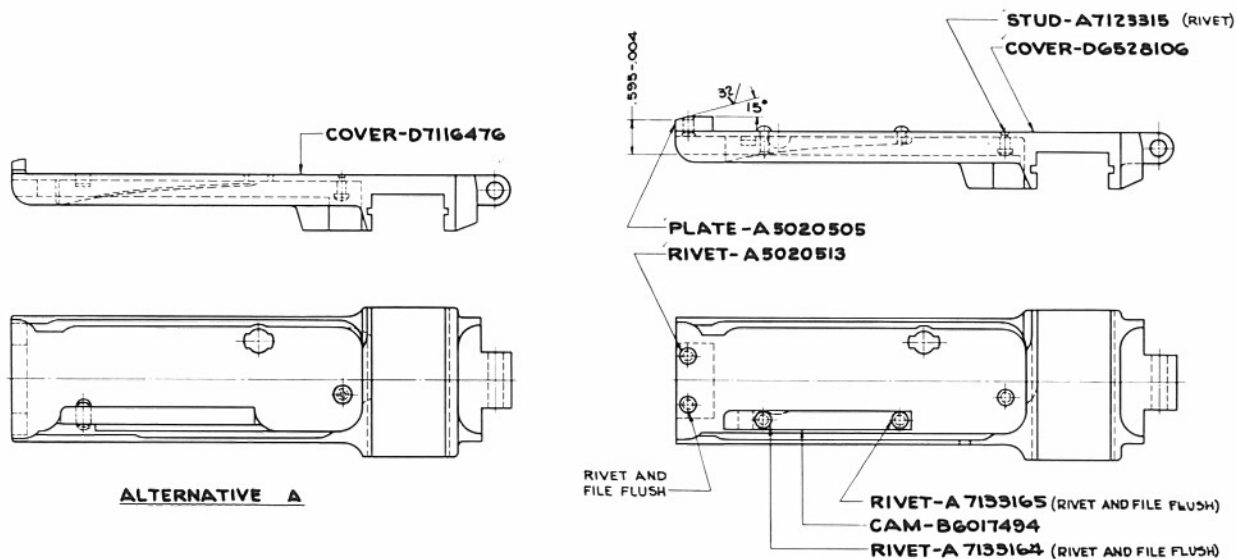
HEAT TREATMENT AND FINAL FINISH  
FINISH TYPE II, CLASS B

PHYSICAL PROPERTIES		JUNE 1, 1931	
		REVISIONS	
Y. P.		15	5-10-40
T. S.		16	2-1-49
EL. 2			
RED			
BR.			
ROCK.			
SCL.			

DRG. PERTAINS TO

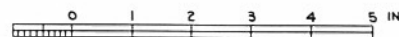
C5564056  
M14AA (FXD)  
M14AA (FLX)  
M14AS (FXD)  
M14AS

C5509801



COVER, ASSEMBLY

5509801



WAS C9801

C5509801

INSCRIBE PART NO.  
DO NOT

TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED

DECIMAL : —  
FRACTIONAL : —  
ANGULAR : 0° 30'

DRAWN BY W.B.H. CHECKED BY W.B.H. DESIGNED BY W.B.H. APPROVED BY W.B.H.

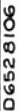
SUBMITTED: A.H. Roe

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

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL





Drawing # D7116476 is missing from  
the government files and was replaced  
by drawing D6528106