

HEAT TREATMENT AND FINAL FINISH

PHYSICAL PROPERTIES		MARCH 10, 1939	
		REVISIONS	
Y. P.		4	5-10-48
T. S.		5	10-21-48
EL. 2		6	11-15-49
RED			
BR.			
ROCK.			
SCL.			

DRG. PERTAINS TO

C5545964 50 BWA
M194A (FXD)
M194A (FLEX)
M194G

SPRING-A5163397
PLUNGER-A5163398
KNOB-A5152452
PIN-A5013166
PIN-A5013162
SLIDE-C5545961
LEAF-D6535236
SCREW-B6110312

SECTION A-A

HOLE DRILLED IN SCREW FROM KNOB WHEN INDEX LINE ON SLIDE IS ALIGNED WITH MIL GRADUATION 48 AND CLICK IS ENGAGED IN GROOVE OF KNOB.

INSCRIBE PART NUMBER
1/16" HIGH

.0500 ± .0005

RIVET OR STAKE
PIN ON BOTH ENDS

LEAF, REAR SIGHT, ASSEMBLY (5545964

0 1 2 IN.

WAS C45964

C5545964

DO INSCRIBE PART NO.	
DO NOT	
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED	
DECIMAL : ±	
FRACTIONAL : ±	
ANGULAR : ±	
DESIGNED H.M.F.	CHECKED J.H.
DRAWN J.H.	INSP. J.H.
SUBMITTED: A.H. Roe	
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: Walter A. Johnson ORD. DEPT. U. S. A.	
ORDNANCE DEPT., U. S. A.	
MADE AT ROCK ISLAND ARSENAL	

C5545964

HEAT TREATMENT & FINAL FINISH

PROTECTIVE FINISH TYPE II CLASS A OR B

51-88	50 BMG M2 HB (EXD)
C5545964	LEAF, REAR SIGHT, ASM.
51-102	.30 BAR M1918A2
C5564208	LEAF, REAR SIGHT, ASM.
51-113	.30 BAR M1918
51-125	.30 BMG M19A6

19² 4-30-46

20³ 1-28-49
21¹ 3-24-49

PHYSICAL PROPERTIES		MAY 1, 1929			
		REVISIONS			
Y. P.		6	6-15-36	11 ²	6-1-39
T. S.		7	9-30-36	12 ²	5-1-41
EL-2		8 ²	5-2-38	13 ¹	4-16-42
RED.		9 ¹	2-1-39	14 ¹	12-18-42
HT. T.		10 ¹	3-10-39	15 ²	3-23-43
		18 ²	6-14-45	16 ¹	7-27-43
BR.				17 ¹	10-12-43
SCL.					
C. C.					

DRG. PERTAINS TO

C5564061	LEAF, REAR SIGHT, ASM.
C5564037	LEAF, REAR SIGHT, ASM.
C5564054	LEAF, REAR SIGHT, ASM.

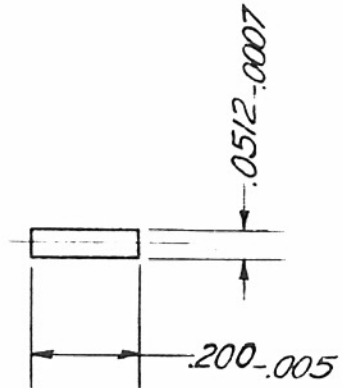
51-78	.30 BMG M2 HB (EXD)
51-79	.30 BMG M2 HB (EXD)
51-80	.30 BMG M2 HB (EXD)
51-81	.30 BMG M2 HB (EXD)
51-82	.30 BMG M2 HB (EXD)
51-83	.30 BMG M2 HB (EXD)
51-84	.30 BMG M2 HB (EXD)
51-85	.30 BMG M2 HB (EXD)
51-86	.30 BMG M2 HB (EXD)
51-87	.30 BMG M2 HB (EXD)
51-88	.30 BMG M2 HB (EXD)
51-89	.30 BMG M2 HB (EXD)
51-90	.30 BMG M2 HB (EXD)
51-91	.30 BMG M2 HB (EXD)
51-92	.30 BMG M2 HB (EXD)
51-93	.30 BMG M2 HB (EXD)
51-94	.30 BMG M2 HB (EXD)
51-95	.30 BMG M2 HB (EXD)
51-96	.30 BMG M2 HB (EXD)
51-97	.30 BMG M2 HB (EXD)
51-98	.30 BMG M2 HB (EXD)
51-99	.30 BMG M2 HB (EXD)
51-100	.30 BMG M2 HB (EXD)

SYMBOL

OAP-1396

DITSMAN	TRACER	U.S. DEPT. OF ARMY
E-L-J.	W.C.	
CHECKER	CHIEF DITSMAN	
L.S.C.		

SUBMITTED	
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE	
LT. COL. ORDN. DEPT. U.S.A.	
ORDNANCE DEPT. U.S.A.	



PIN, RETAINER, REAR SIGHT ELEVATING SCREW
STEEL WD 1095
FINISH

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.
SUPERSEDES OLD TRACING A13162
UNDER REVISION DATE OF JUNE 15, 1936

SCALE 4

DO NOT INSCRIBE PART NO.	
A5013162	
A13162	

SUPERSEDES A13162

A5013162

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A5152432 MARCH 10, 1939	
HEAT TREAT TYPE II FINISH, CLASS B		Y. P.		RED.		SCL.	
		T. S.		BR.		C. C.	.010 TO .012 DEEP
		EL. 2		ROCK			
						REVISIONS	
						8	5-10-48
						DRG. PERTAINS TO	
						C5545964	.30 BMG M19A4 (FXD) M19A4 (FLEX) M19AG
						INSCRIBE PART NO. DO NOT	
						TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5^\circ$	
						DRAFTSMAN <i>HDC.</i>	TRACER <i>O.K.</i>
						CHECKED <i>L.S.C.</i>	L'D'G DRAFTSMAN <i>O.O.</i>
						SUBMITTED: <i>A.H. Roe</i> ORD. DEPT., U. S. A.	
						APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>Walter A. Kuma</i> ORD. DEPT., U. S. A.	
						ORDNANCE DEPT., U. S. A.	

KNOB, REAR SIGHT ELEVATING SCREW
 STEEL FSX1020
 FINISH 125/

5152432

SCALE $\frac{4}{1}$

WAS A152432

A 5152432

HEAT TREATMENT & FINAL FINISH
DRAW AT 450 F.
PROTECTIVE FINISH TYPE I CLASS O.S.C.

PROTECTIVE FINISH TYPE I CLASS O.S.C.

~~DO~~ NOT INSCRIBE PART NO

MARCH 10, 1939
REVISIONS

7	8-15-42		
2	10-24-42		

31	10-24-42
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9	7-27-45
10	3 7 11

11-	4-30-46
FBI - NEW YORK	

DBF B

C45964		LEAF BEAR SIGHT
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	ASSEMBLY
--	----------

C64200	LEAF, REAR SIGHT.
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51-83	30 BMG-M19A4 EX
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51-84	30 BAR-M19A4 FLX
51-100	30 BAR-M19A2

51-13	.30 BAR-M10
51-125	30 BAR-M10

--	--

	R.S.	C.C.P.
CHECKED		GROUP

SUBMITTED

Eutoplasma

APPROVED BY ORDER OF
THE CHIEF OF POLICE

COL. ORD. DEPT.

PERSEDES 416 339

Δ	DIAMETER OF WIRE0135
☆	TOTAL NUMBER OF COILS	5
Δ	MINIMUM INSIDE DIAMETER, FREE040
Δ	OUTSIDE DIAMETER, FREE071 ± .003
Δ	MAXIMUM OUTSIDE DIAMETER AT MINIMUM OPERATING HEIGHT075
☆	FREE LENGTH OF SPRING138
Δ	TYPE OF ENDS	PLAIN
☆	WOUND	R.H.
☆	MEAN ASSEMBLED HEIGHT106
Δ	LOAD AT MEAN ASSEMBLED HEIGHT	2 LBS ± 1/2 LB.
☆	MINIMUM OPERATING HEIGHT093
Δ	LOAD AT MINIMUM OPERATING HEIGHT	2.68 LBS. ± 1/2 LB.
☆	LBS. PER INCH OF SPRING DEFLECTION	62 LBS.
Δ	SPRING FUNCTIONS IN HOLE076
☆	SPRING FUNCTIONS OVER ROD038
☆	MAXIMUM SOLID HEIGHT084

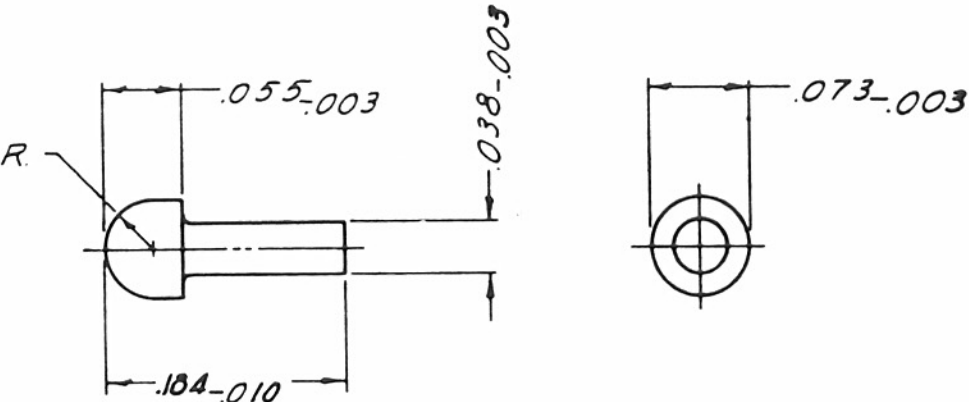
Δ END COILS SHALL BE WITHIN MIN.
INSIDE DIA. AND FREE FROM BURRS.

5163397

A5/63397

A163397

SUPRSEDES A/63397

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				MARCH 10, 1939																							
HEAT TREAT OXIDE BLACK		Y.P.	X	RED.	X	SCL.	<div style="text-align: center;">REVISIONS</div> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%;">1⁴</td> <td style="width: 40%;">2-7-40</td> <td style="width: 10%;">5¹</td> <td style="width: 40%;">6-28-41</td> </tr> <tr> <td>2¹</td> <td>6-25-40</td> <td>6¹</td> <td>4-11-42</td> </tr> <tr> <td>3²</td> <td>9-3-40</td> <td>7²</td> <td>6-18-42</td> </tr> <tr> <td>4²</td> <td>5-1-41</td> <td>8¹</td> <td>10-31-42</td> </tr> <tr> <td>10²</td> <td>CONVERSION 7-28-49</td> <td>9¹</td> <td>7-27-43</td> </tr> </table>			1 ⁴	2-7-40	5 ¹	6-28-41	2 ¹	6-25-40	6 ¹	4-11-42	3 ²	9-3-40	7 ²	6-18-42	4 ²	5-1-41	8 ¹	10-31-42	10 ²	CONVERSION 7-28-49	9 ¹	7-27-43
		1 ⁴	2-7-40	5 ¹	6-28-41																								
		2 ¹	6-25-40	6 ¹	4-11-42																								
3 ²	9-3-40	7 ²	6-18-42																										
4 ²	5-1-41	8 ¹	10-31-42																										
10 ²	CONVERSION 7-28-49	9 ¹	7-27-43																										
T.S.	X	BR.	X	C.C.																									
EL. 2	X	ROCK.	X																										
		DR'G. PERTAINS TO																											
		51-83 30BMG-M19A4 (FXD)																											
		51-84 30BMG-M19A4 (FLEX)																											
		51-102 30BAR-M18A2																											
		C45964 LEAF, REAR SIGHT, ASM.																											
		C64208 LEAF, REAR SIGHT, ASM.																											
		51-13 30BAR-M18																											
		51-125 30 BMG-M19A6																											
		C5564208																											
		SYMBOL																											
DO DO NOT		INSCRIBE PART NO.																											
D'FTSMAN M. J.	TRACER M. J.	L'DR. PFTSMAN G. J. O.																											
CHECKER L. L. C.	TRACER	CHIEF PFTSMAN J. H. O.																											
SUBMITTED:- J. H. O. / W. L. S. / S. L. S.																													
MA J. ORD. DEPT. U. S. A.																													
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:-																													
S. L. S. L.T. COL. ORD. DEPT. U. S. A.																													
ORDNANCE DEPT. U. S. A.																													

PLUNGER, CLICK, REAR SIGHT ELEVATING SCREW KNOB
STEEL - W D 1020 COLD DRAWN
FINISH f

TOLERANCE $\pm .01$ ALLOWED ON ALL DIMEN-
 SIONS UNLESS OTHERWISE SPECIFIED SCALE $\frac{1}{4}$

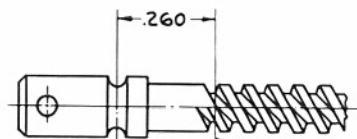
5163398

A163398

SUPERSEDES A163398

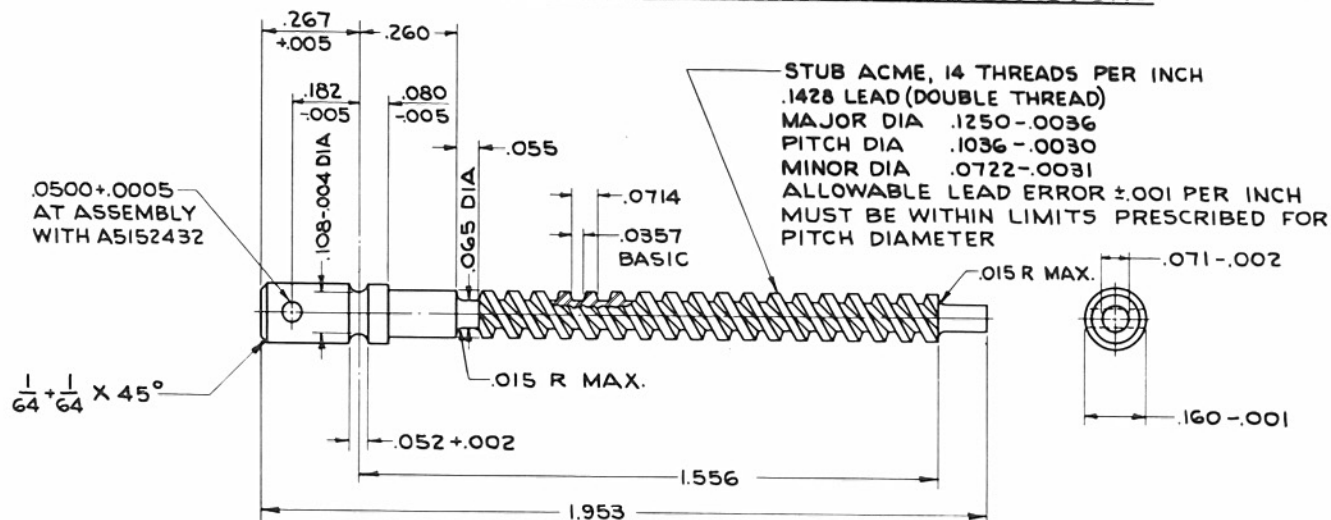
A 5163398

HEAT TREATMENT AND FINAL FINISH
TYPE II FINISH, CLASS B



FULL THREAD DEPTH
TO THIS POINT

ALTERNATE METHOD OF MANUFACTURE



SCREW, ELEVATING, REAR SIGHT

STEEL FSX1315

FINISH $\frac{63}{\sqrt{}}$

G110312

SCALE $\frac{4}{1}$

WAS B110312

B G110312

PHYSICAL
PROPERTIES

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

MARCH 10, 1939

REVISIONS

8 5-10-48

DRG. PERTAINS TO

C55459G4 .30 BMSM19A4
(FIX) & (FLX)

INSCRIBE PART NO.

DO NOT

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

DRAFTERMAN C. P. L. *Edw* L. O. G. DRAFTERMAN
CHECKER *S. G. Galt* CHIEF DRAFTERMAN

SUBMITTED:

A. H. Poe

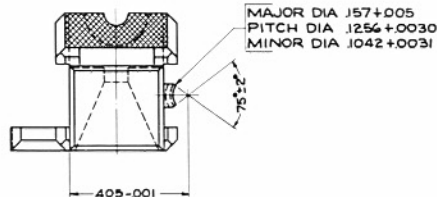
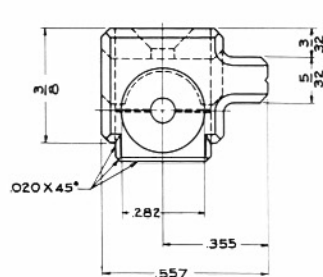
APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

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

ORDNANCE DEPT., U. S. A.

B6110312

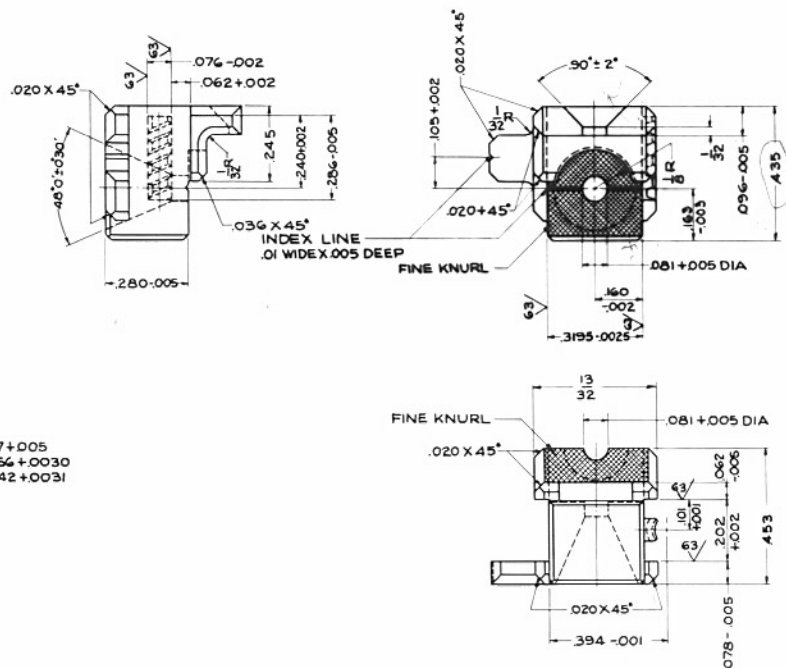
TYPE II FINISH, CLASS B



ALTERNATIVE MANUFACTURE OF STUB ACME THREAD

SAME AS STANDARD THREAD
EXCEPT AS NOTED

NOTE :
INDEX LINES TO BE FILLED
WITH WHITE ENAMEL



SLIDE, REAR SIGHT
STEEL FSX1020

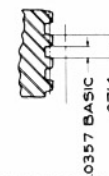
5545961

FINISH $\frac{125}{\sqrt{}}$ OTHER SURFACES, AS SPECIFIED

PHYSICAL PROPERTIES		MARCH 10, 1939	
		REVISONS	
Y. P.	X	11	5-10-48
T. S.			
EL. 2			
RED			
BR.			
ROCK.			
SCL.			
		DRC. PERTAINS TO	

DRG. PERTAINS TO

C5545964	.30 BMG
	M19A4 (FXD)
	M19A4 (FLEX)
	M19A6



SECTION A-A

MAJOR DIA .135+0.05
PITCH DIA .1036+0.030
MINOR DIA .0822+0.031
ALLOWABLE LEAD ERROR ± 0.01
PER INCH AND INCLUDES
INDEXING ERROR, ALL OF
WHICH MUST BE WITHIN
LIMITS PRESCRIBED FOR
PITCH DIAMETER

STUB ACME (DOUBLE THREAD)
14 THREADS PER INCH
LEAD = .1428
FINISH $\sqrt{63}$

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED

DECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$
ANGULAR $\pm 5^\circ$

GRADUATE	TEACHER	C. G. GRADUATE
C. P. L.	Z. C.	

SUBMITTED:

A. M. Roe

WAS C45961

INSCRIBE PART NO.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE.

9/10/11/12/13/14/15/16/17/18/19/20/21/22/23/24/25/26/27/28/29/30/31/32/33/34/35/36/37/38/39/40/41/42/43/44/45/46/47/48/49/50/51/52/53/54/55/56/57/58/59/60/61/62/63/64/65/66/67/68/69/70/71/72/73/74/75/76/77/78/79/80/81/82/83/84/85/86/87/88/89/90/91/92/93/94/95/96/97/98/99/100/101/102/103/104/105/106/107/108/109/110/111/112/113/114/115/116/117/118/119/120/121/122/123/124/125/126/127/128/129/130/131/132/133/134/135/136/137/138/139/140/141/142/143/144/145/146/147/148/149/150/151/152/153/154/155/156/157/158/159/160/161/162/163/164/165/166/167/168/169/170/171/172/173/174/175/176/177/178/179/180/181/182/183/184/185/186/187/188/189/190/191/192/193/194/195/196/197/198/199/200/201/202/203/204/205/206/207/208/209/210/211/212/213/214/215/216/217/218/219/220/221/222/223/224/225/226/227/228/229/230/231/232/233/234/235/236/237/238/239/240/241/242/243/244/245/246/247/248/249/250/251/252/253/254/255/256/257/258/259/260/261/262/263/264/265/266/267/268/269/270/271/272/273/274/275/276/277/278/279/280/281/282/283/284/285/286/287/288/289/290/291/292/293/294/295/296/297/298/299/300/301/302/303/304/305/306/307/308/309/310/311/312/313/314/315/316/317/318/319/320/321/322/323/324/325/326/327/328/329/330/331/332/333/334/335/336/337/338/339/340/341/342/343/344/345/346/347/348/349/350/351/352/353/354/355/356/357/358/359/360/361/362/363/364/365/366/367/368/369/370/371/372/373/374/375/376/377/378/379/380/381/382/383/384/385/386/387/388/389/390/391/392/393/394/395/396/397/398/399/400/401/402/403/404/405/406/407/408/409/410/411/412/413/414/415/416/417/418/419/420/421/422/423/424/425/426/427/428/429/430/431/432/433/434/435/436/437/438/439/440/441/442/443/444/445/446/447/448/449/450/451/452/453/454/455/456/457/458/459/460/461/462/463/464/465/466/467/468/469/470/471/472/473/474/475/476/477/478/479/480/481/482/483/484/485/486/487/488/489/490/491/492/493/494/495/496/497/498/499/500/501/502/503/504/505/506/507/508/509/510/511/512/513/514/515/516/517/518/519/520/521/522/523/524/525/526/527/528/529/530/531/532/533/534/535/536/537/538/539/540/541/542/543/544/545/546/547/548/549/550/551/552/553/554/555/556/557/558/559/560/561/562/563/564/565/566/567/568/569/570/571/572/573/574/575/576/577/578/579/580/581/582/583/584/585/586/587/588/589/590/591/592/593/594/595/596/597/598/599/600/601/602/603/604/605/606/607/608/609/610/611/612/613/614/615/616/617/618/619/620/621/622/623/624/625/626/627/628/629/630/631/632/633/634/635/636/637/638/639/640/641/642/643/644/645/646/647/648/649/650/651/652/653/654/655/656/657/658/659/660/661/662/663/664/665/666/667/668/669/670/671/672/673/674/675/676/677/678/679/680/681/682/683/684/685/686/687/688/689/690/691/692/693/694/695/696/697/698/699/700/701/702/703/704/705/706/707/708/709/710/711/712/713/714/715/716/717/718/719/720/721/722/723/724/725/726/727/728/729/730/731/732/733/734/735/736/737/738/739/740/741/742/743/744/745/746/747/748/749/750/751/752/753/754/755/756/757/758/759/760/761/762/763/764/765/766/767/768/769/770/771/772/773/774/775/776/777/778/779/780/781/782/783/784/785/786/787/788/789/790/791/792/793/794/795/796/797/798/799/800/801/802/803/804/805/806/807/808/809/810/811/812/813/814/815/816/817/818/819/820/821/822/823/824/825/826/827/828/829/830/831/832/833/834/835/836/837/838/839/840/841/842/843/844/845/846/847/848/849/850/851/852/853/854/855/856/857/858/859/860/861/862/863/864/865/866/867/868/869/870/871/872/873/874/875/876/877/878/879/880/881/882/883/884/885/886/887/888/889/890/891/892/893/894/895/896/897/898/899/900/901/902/903/904/905/906/907/908/909/910/911/912/913/914/915/916/917/918/919/920/921/922/923/924/925/926/927/928/929/930/931/932/933/934/935/936/937/938/939/940/941/942/943/944/945/946/947/948/949/950/951/952/953/954/955/956/957/958/959/960/961/962/963/964/965/966/967/968/969/970/971/972/973/974/975/976/977/978/979/980/981/982/983/984/985/986/987/988/989/990/991/992/993/994/995/996/997/998/999/1000/1001/1002/1003/1004/1005/1006/1007/1008/1009/1010/1011/1012/1013/1014/1015/1016/1017/1018/1019/1020/1021/1022/1023/1024/1025/1026/1027/1028/1029/1030/1031/1032/1033/1034/1035/1036/1037/1038/1039/1040/1041/1042/1043/10

SARACE, A.E., MICHON, L.M., & DODD, A. (1986) A.

SCALE $\frac{5}{1}$

C 554596

C5545961

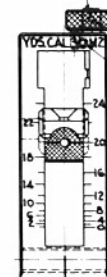
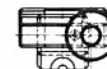
HEAT TREATMENT AND FINAL FINISH

SPRING-A5163397
 PLUNGER-A5163398
 KNOB-A5152452
 PIN-A5013166
 PIN-A5013162
 SLIDE-C5545961
 LEAF-D6535236
 SCREW-BG110312

SECTION A-A

HOLE DRILLED IN SCREW FROM KNOB WHEN INDEX LINE ON SLIDE IS ALIGNED WITH MIL GRADUATION 48 AND CLICK IS ENGAGED IN GROOVE OF KNOB.

INSCRIBE PART NUMBER
1/16" HIGH



.0500+.0005
 RIVET OR STAKE
 PIN ON BOTH ENDS

LEAF, REAR SIGHT, ASSEMBLY (5545964



WAS C45964

C5545964

PHYSICAL PROPERTIES		MARCH 10, 1939 REVISIONS	
Y. P.		4	5-10-48
T. S.		5	10-21-48
EL. 2		6	11-15-49
RED			
BR.			
ROCK.			
SCL.			

DRG. PERTAINS TO

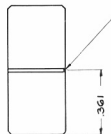
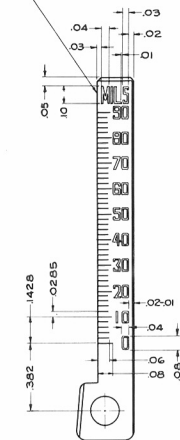
C5545964
 50 BWA
 M194A (FXD)
 M194A (FLX)
 M194G

DO	INSCRIBE PART NO.
DO NOT	
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED	
DECIMAL : =	
FRACTIONAL : =	
ANGULAR : =	
DESIGNED BY	CHECKED BY
DRAWN BY	INSP. BY
SUBMITTED:	
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:	
ORD. DEPT. U. S. A.	
MADE AT ROCK ISLAND ARSENAL	

C5545964

TYPE II FINISH, CLASS B

STAMP SR = 13.96
FIGURES .10 HIGH ON BACK OF LEAF

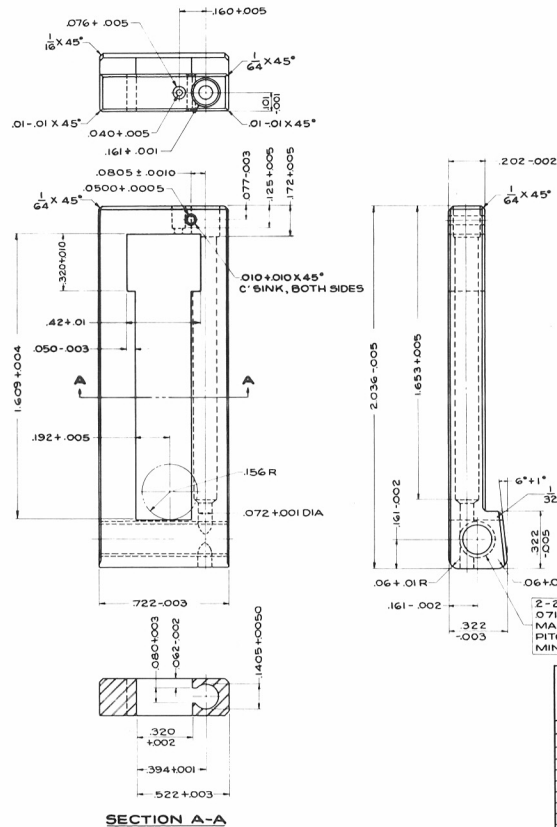


NOTE:
GRADUATIONS .01 WIDE X .005 DEEP
GRADUATIONS AND FIGURES TO BE
FILLED WITH WHITE ENAMEL
TOLERANCES ON LOCATION OF GRADUATIONS $\pm .003$

NOTE: SIZE OF FIGURES ON FACE OF LEAF
1 TO 8 INCLUSIVE .045 X .06 WIDE
10 TO 12 INCLUSIVE .06 X .06 WIDE
14 TO 18 INCLUSIVE .08 X .06 WIDE
20 TO 24 INCLUSIVE .08 X .05 WIDE

DATA USED IN CALCULATIONS	
SIGHT RADIUS -----	13.957
¢ OF BORE TO TIP OF FRONT SIGHT -----	3.446
¢ OF BORE TO AXIS OF LEAF JOINT PIN -----	3.169
CONSTANT (SIGHT ABOVE JOINT PIN AXIS) -----	.277
GRADUATIONS COMPUTED FROM FIRE CONTROL TABLE	0.30-C-3
PREPARED BY ORDNANCE DEPT DATED APRIL, 1934	
CALCULATIONS FOR GRADUATIONS BASED ON	14.28 SR

LEAF, REAR SIGHT (6535236)
STEEL FSX1020
FINISH 125



WAS D35236

SCALE

MARCH 10, 1939		CLASS	DIVISION	DRAWING	FILE
REVISIONS					
12	5-10-40				
13	10-21-40				
TOLERANCE OR DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL 1/32 FRACTIONAL 1/16 ANGULAR 2°					
DRAFTSMAN		CHECKER		TYPE INSPECTOR	
C. L.		Z. C.		C. H.	
DATE		SUBMITTED		TIME	
ORG. PERTAINS TO		APPROVED BY			
C5545964 30BWMG M184A (FX) M184A (FLX) M184B		H. R. P.			
EXAMINED:		ORD. DEPT. U. S. A.			
APPROVED BY ORDER OF THE CHIEF OF ORIGINATING OFFICE		H. R. P.			
ORD. DEPT. U. S. A.		ORD. DEPT. U. S. A.			

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

2000