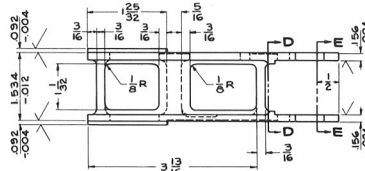
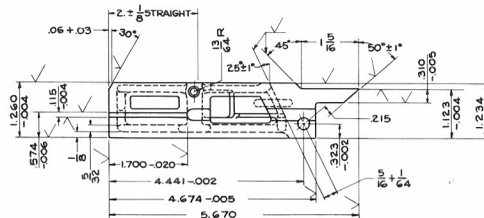
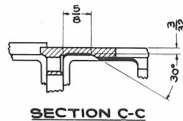
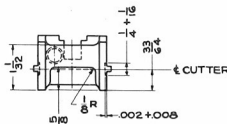
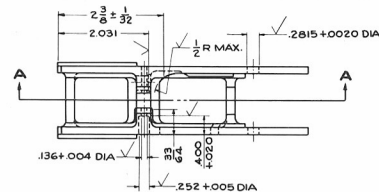


# HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B

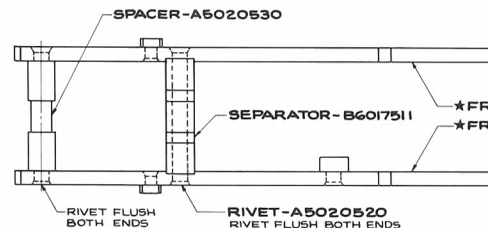
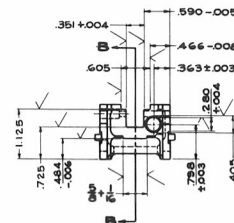


ALTERNATIVE CONSTRUCTION A  
PEARLITIC MALLEABLE IRON-CLASS A  
FINISH  $\sqrt{125}$  TO BE  
SCALE  $\frac{1}{16}$

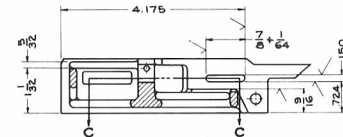
NOTE:  
SECTION D-D:  
HEAT IN NEUTRAL SALT BATH AT 1500°F FOR 10 MINUTES, OIL QUENCH, DRAW AT 950°F FOR 30 MINUTES, AIR COOL.  
SECTION E-E:  
HEAT IN CYANIDE AT 1500°-1550°F FOR 5 MINUTES, OIL QUENCH, DRAW AT APPROX 750° F IN SALT BATH FOR 30 MINUTES, AIR COOL, ROCK. C 47-52

ALL CAST RADII TO BE  $\frac{1}{16}$  UNLESS OTHERWISE SPECIFIED.

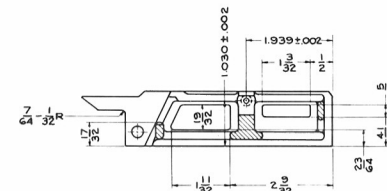
SUPERSEDES C9182 & D7114325 WO/C 5-10-48



FRAME, LOCK, ASSEMBLY 5509182



SECTION A-A



SECTION B-B

★ FINDING DIAGRAM DO NOT INSCRIBE PART NO.

AUGUST 10, 1944		CLASS	DIVISION	DRAWING	FILE
REVISIONS					
15	5-10-48				
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL: .005 FRACTIONAL: $\frac{1}{64}$ ANGULAR: 2°					
DESIGNED	CHECKED	TRACED	BY	DATE	BY
DRG. PERTAINS TO					
51-10	51-83	51-84	51-114-1	51-125-1	
SUBMITTED:					
EXAMINED:					
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:					
ORD. DEPT. U.S.A.					
D/5509182					
ORDNANCE DEPT. U.S.A.					

PHYSICAL PROPERTIES

Y.P.

T.S.

EL. 2

RED

BR

ROCK

SCL

A 5020530

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				APRIL 4, 1927	
		Y. P.		RED.		SCL.	
		T. S.		BR.			
		E. L. 2		ROCK			
						REVISIONS	
						11 5-10-48	
						DRG. PERTAINS TO	
						05509182	
						30 BMG	
						M 17A1 (WC)	
						M 19A4 (FXD)	
						M 19A4 (FLEX)	
						M 19AB (FXD)	
						M 19AG	
						INSCRIBE PART NO.	
						DO NOT	
						TOLERANCE ON DIMENSIONS	
						NOT OTHERWISE SPECIFIED	
						DECIMAL $\pm .005$	
						FRACTIONAL $\pm 1/64$	
						ANGULAR $\pm$ —	
		DRAFTSMAN	TRACER	L'D'G DRAFTSMAN			
		M.F.J.	A.V.C.				
		CHECKER		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.					

**SPACER, LOCK FRAME**  
**STEEL FSX1020**  
 FINISH 125/

SCALE  $\frac{2}{1}$

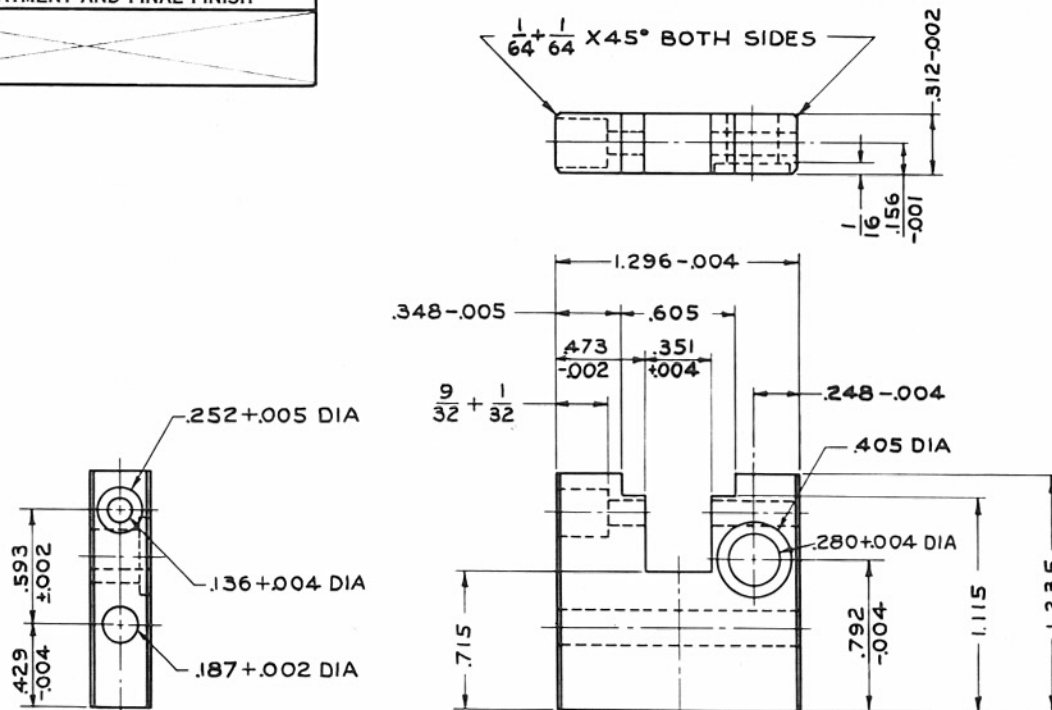
WAS A20530

**A 5020530**

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES						A5020627 FEB. 1, 1927	
		Y. P.	RED.	SCL.				REVISIONS	
		T. S.	BR.				165-10-48		
		EL 2	ROCK						
<p><b>STOP ACCELERATOR</b></p> <p>DRILL ROD</p> <p>FINISH 125/</p>								DRG. PERTAINS TO	
								C5509180	
								30 BMG M 17A1 (WC) M 19A4 (FXD) M 19A4 (FLEX) M 19A5 (FXD) M 19A6	
		INSCRIBE PART NO. DO NOT						TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5^\circ$	
		DRAFTSMAN <i>P. R.</i>		TRACER <i>L. R. E.</i>		L'D'G DRAFTSMAN		SUBMITTED: <i>A. H. Roe</i> ORD. DEPT., U. S. A.	
		CHECKER <i>L. S.</i>		O. O.		CHIEF DRAFTSMAN			
		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>Halter Ackerman</i> ORD. DEPT., U. S. A.		ORDNANCE DEPT., U. S. A.					
		WAS A20627						SCALE $\frac{4}{1}$   A   5020627	

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A 5135051 JUNE 1, 1931																															
		Y. P.	RED.	SCL.	<b>REVISIONS</b> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 10%;">12</td> <td style="width: 40%;">5-10-48</td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> <td style="width: 10%;"></td> </tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td><td> </td><td> </td><td> </td></tr> </table>			12	5-10-48																												
		12	5-10-48																																		
T. S.	BR.																																				
EL. 2	ROCK																																				
<p><b>GUIDE, LOCK FRAME</b>  <b>DRILL ROD</b>  <b>FINISH 125/</b></p> <p style="text-align: right;">(5135051)</p> <p style="text-align: right;">WAS A135051</p> <p style="text-align: right;">SCALE <math>\frac{4}{1}</math>   A   5135051</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: 33%;">DRAFTSMAN W.C.O.</td> <td style="width: 33%;">TRACER L.R.E.</td> <td style="width: 33%;">L'D'G DRAFTSMAN</td> </tr> <tr> <td>CHECKER L.R.E.</td> <td>C.O.</td> <td>CHIEF DRAFTSMAN</td> </tr> </table> <p>SUBMITTED:  <i>A.H. Roe</i>            ORD. DEPT., U. S. A.</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>		DRAFTSMAN W.C.O.	TRACER L.R.E.	L'D'G DRAFTSMAN	CHECKER L.R.E.	C.O.	CHIEF DRAFTSMAN																								
		DRAFTSMAN W.C.O.	TRACER L.R.E.	L'D'G DRAFTSMAN																																	
		CHECKER L.R.E.	C.O.	CHIEF DRAFTSMAN																																	
		C5509180 C5509181																																			
		.308 MG M17A1 (WC) M19A4 (FXD) M19A4 (FLEX) M19A5 (FXD) M19A6																																			
.092-.004 .315 .124-.002 7/32																																					

HEAT TREATMENT AND FINAL FINISH



**SEPARATOR, LOCK FRAME**  
**STEEL FSX1020**  
**FINISH  $\frac{125}{V}$**

6017511

SCALE  $\frac{2}{1}$

B 6017511

WAS B17511

PHYSICAL  
PROPERTIES

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

APRIL 4, 1927

REVISIONS

16 5-10-48

DRG. PERTAINS TO

05509182

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

INSCRIBE PART NO.  
DO NOT

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

DRAWN BY  
C.S.S. A.V.C.  
CHECKED BY  
G.D.

SUBMITTED:

A.H. ROE

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF  
OF ORDNANCE:

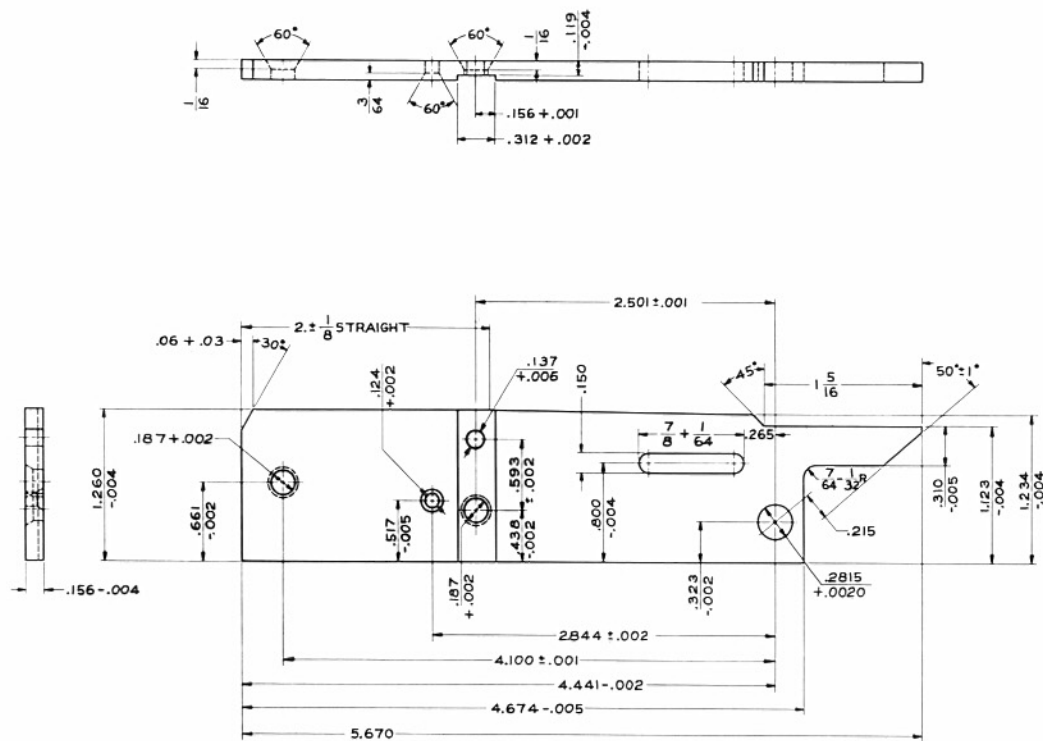
W. A. Ackerman

ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

B6017511

C.C.  $\frac{1}{2}$  INCH ON CAM END .004  
TO .008 DEEP (ROCK A74-78)



FRAME, LOCK, L.H.  
LOW ALLOY STEEL, HIGH TENSILE - GRADE 2  
FINISH 125

5508471

WAS C8471

DO NOT INSCRIBE PART NO.

SCALE  $\frac{2}{1}$  C5508471

PHYSICAL PROPERTIES		APRIL 4, 1927	
		REVISIONS	
Y. P.		19	5-10-48
T. S.			
EL. 2			
RED			
BR			
ROCK.			
SCL			
		DRC. BEYLAWS. 7	

DRG. PERTAINS TO

C5509181	30 BMG M17A1(WC)
	30 BMG M19A4(FXD)
	30 BMG M19A4(FLEX)
	30 BMG M19A5(FXD)
	30 BMG M19A6

TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED  
DECIMAL = .005  
FRACTIONAL = 1/64

DRAFTSMAN B.T.H.	TRACER L.R.E.	U.S.G. DRAFTSMAN
CHIEF C.E.	CHIEF C.E.	CHIEF DRAFTSMAN

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

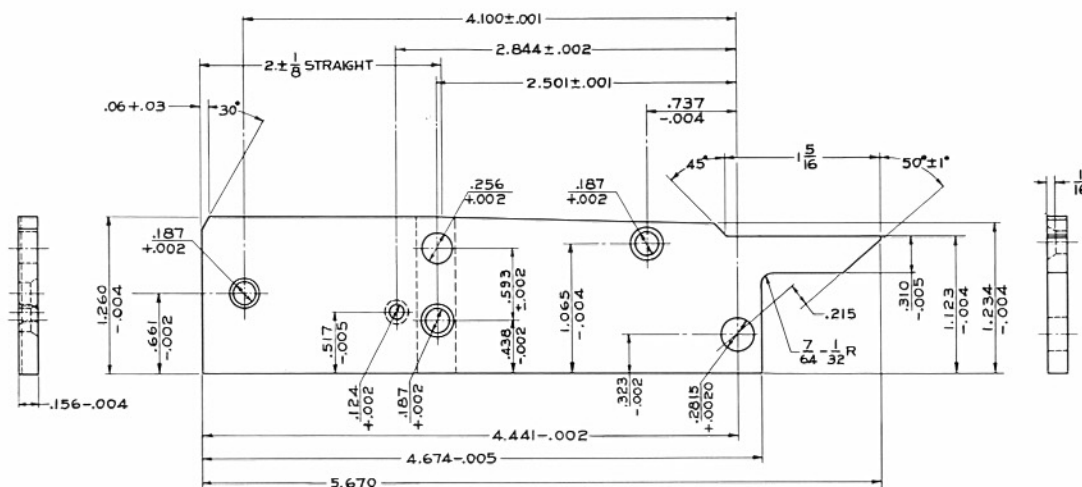
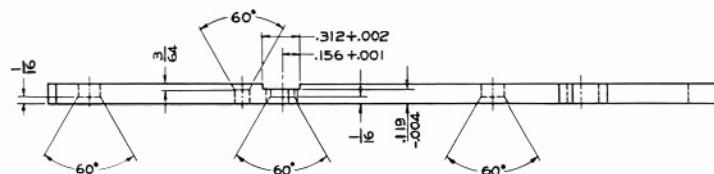
**APPROVED BY ORDER OF THE CHIEF  
OF ORDNANCE:**  
*Walter Ackerman*  
ORD DEPT U.S.A.

**ORDNANCE DEPT., U. S. A.**

MADE AT BUCK ISLAND ARSENAL

C5508471

HEAT TREATMENT AND FINAL FINISH  
C.C.  $\frac{1}{2}$  INCH ON CAM END .004 TO .008 DEEP  
(ROCK. A 74-78)



FRAME, LOCK, R.H.  
LOW ALLOY STEEL, HIGH TENSILE - GRADE 2  
FINISH  $\sqrt{125}$

5508472

PHYSICAL PROPERTIES		APRIL 4, 1927 REVISIONS	
Y. P.		19	5-10-48
T. S.			
EL. 2			
RED			
BR.			
ROCK.			
SCL.			

DRG. PERTAINS TO

C5509180  
30 BMO  
M17A1 (WC)  
30 BMO  
M19A4 (FXD)  
30 BMO  
M19A4 (FLEX)  
30 BMO  
M19A5 (FXD)  
30 BMO  
M19A5

TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED  
DECIMAL - .005  
FRACTIONAL -  $\frac{1}{16}$   
ANGULAR - 5°

DRAWN BY B.T.M. CHECKED BY E.B. DESIGNED BY J.D. DRAFTSMAN

SUBMITTED: *A.H. Roe*

WAS C8472

DO NOT INSCRIBE PART NO.

SCALE  $\frac{2}{1}$

C5508472

APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:  
*Wm. C. Anderson*  
ORD. DEPT. U. S. A.  
MADE AT ROCK ISLAND ARSENAL

C5508472

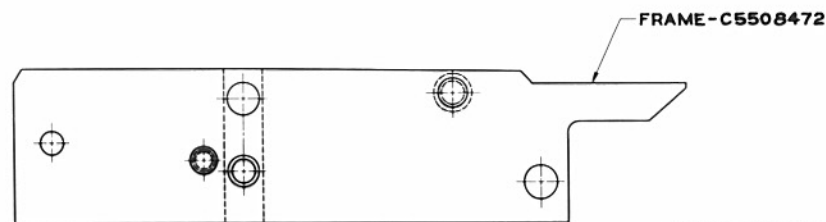
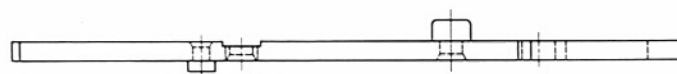
HEAT TREATMENT AND FINAL FINISH

PHYSICAL PROPERTIES		JUNE 1, 1931	
		REVISIONS	
Y. P.		11	5-10-48
T. S.			
EL. 2			
RED			
BR.			
ROCK.			
SCL.			

DRG. PERTAINS TO

D5509182 30 B.M.G.  
M17A1(WC)  
30 B.M.G.  
M19A4(FXD)  
30 B.M.G.  
M19A4(FLEX)  
30 B.M.G.  
M19A5(FXD)  
30 B.M.G.  
M19A6

C5509180



STOP-A5020627

GUIDE-A5135051

FRAME, LOCK, R.H. ASSEMBLY

5509180

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

DEVELOPER	TRACER	U.S. & DEPT.
C.S.S.	L.R.E.	
CHIEF	CHIEF	DEVELOPER

SUBMITTED:

*HRP*

ORD. DEPT. U. S. A.

WAS C9180

DO NOT INSCRIBE PART NO.

C5509180

APPROVED BY ORDER OF THE CHIEF  
OF ORDNANCE:

*Walter C. ...*

ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL





HEAT TREATMENT AND FINAL FINISH	

PHYSICAL PROPERTIES		JUNE 1, 1931	
		REVISIONS	
Y. P.		11	5-10-48
T. S.			
EL. 2			
RED			
BR.			
ROCK.			
SCL			
		DRG. PERTAINS TO	

DRG. PERTAINS TO

[illegible]

FRAME-C5508471

-GUIDE-A5135051

### FRAME, LOCK, L.H., ASSEMBLY

5509(8)

TOLERANCE ON DIMENSIONS  
NOT OTHERWISE SPECIFIED

DECIMAL  $\pm$  —  
FRACTIONAL  $\pm$  —  
ANGULAR  $\pm$  —

DRAFTSMAN <b>M.E.B.</b>	TRACER <b>M.C.</b>	L.O. DRAFTSMAN
CHECKER <i>[Signature]</i>	<i>[Signature]</i>	CHIEF DRAFTSMAN
<b>SUBMITTED:</b>		

SUBMITTED:

WAS C9181

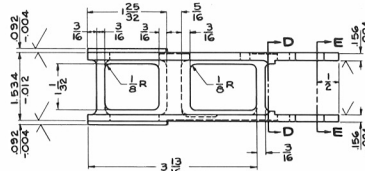
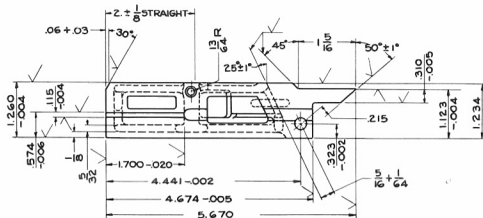
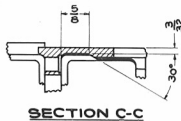
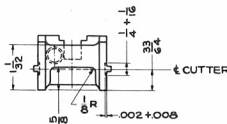
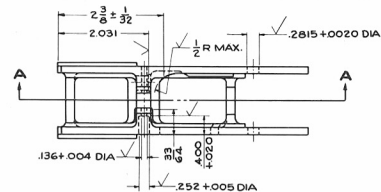
DO NOT INSCRIBE PART NO.

C	5509181
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APPROVED BY ORDER OF THE CHIEF  
OF ORDNANCE:  
*Walter Cushman*  
ORD. DEPT. U. S. A.  
ORDNANCE DEPT., U. S. A.  
MADE AT ROCK ISLAND ARSENAL

# HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B

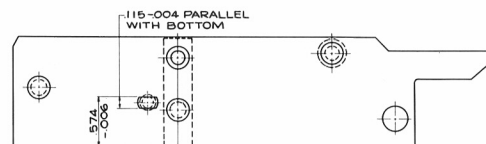
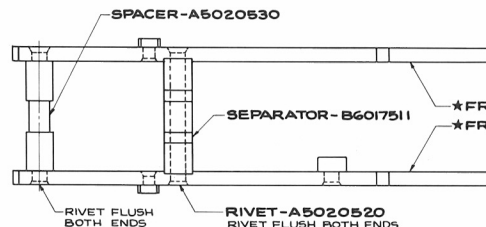
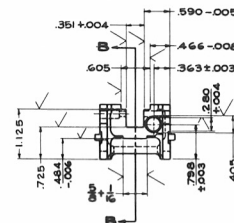


ALTERNATIVE CONSTRUCTION A  
PEARLITIC MALLEABLE IRON-CLASS A  
FINISH  $\sqrt{125}$  TO BE  
SCALE  $\frac{1}{16}$

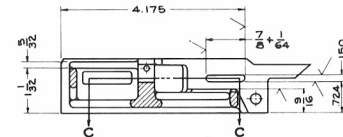
NOTE:  
SECTION D-D:  
HEAT IN NEUTRAL SALT BATH AT 1500°F FOR 10 MINUTES, OIL QUENCH, DRAW AT 950°F FOR 30 MINUTES, AIR COOL.  
SECTION E-E:  
HEAT IN CYANIDE AT 1500°-1550°F FOR 5 MINUTES, OIL QUENCH, DRAW AT APPROX 750° F IN SALT BATH FOR 30 MINUTES, AIR COOL, ROCK. C 47-52

ALL CAST RADII TO BE  $\frac{1}{16}$  UNLESS OTHERWISE SPECIFIED.

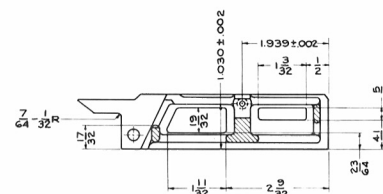
SUPERSEDES C9182 & D7114325 WO/C 5-10-48



FRAME, LOCK, ASSEMBLY 5509182



SECTION A-A



SECTION B-B

★ FINDING DIAGRAM DO NOT INSCRIBE PART NO.

AUGUST 10, 1944		CLASS	DIVISION	DRAWING	FILE
REVISIONS					
15	5-10-48				
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL: .005 FRACTIONAL: 1/64 ANGULAR: 2°					
DESIGNED	CHECKED	TRACED	BY	DATE	BY
DRG. PERTAINS TO					
51-10	50 BANG WIPING				
51-83	50 BANG WIPING				
51-84	50 BANG WIPING				
51-114-1	50 BANG WIPING				
51-125-1	50 BANG WIPING				
SUBMITTED: A.H. Roe					
EXAMINED: Walter Ackerman					
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: Walter Ackerman					
D/5509182					
ORDNANCE DEPT. U.S.A.					

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

D509182