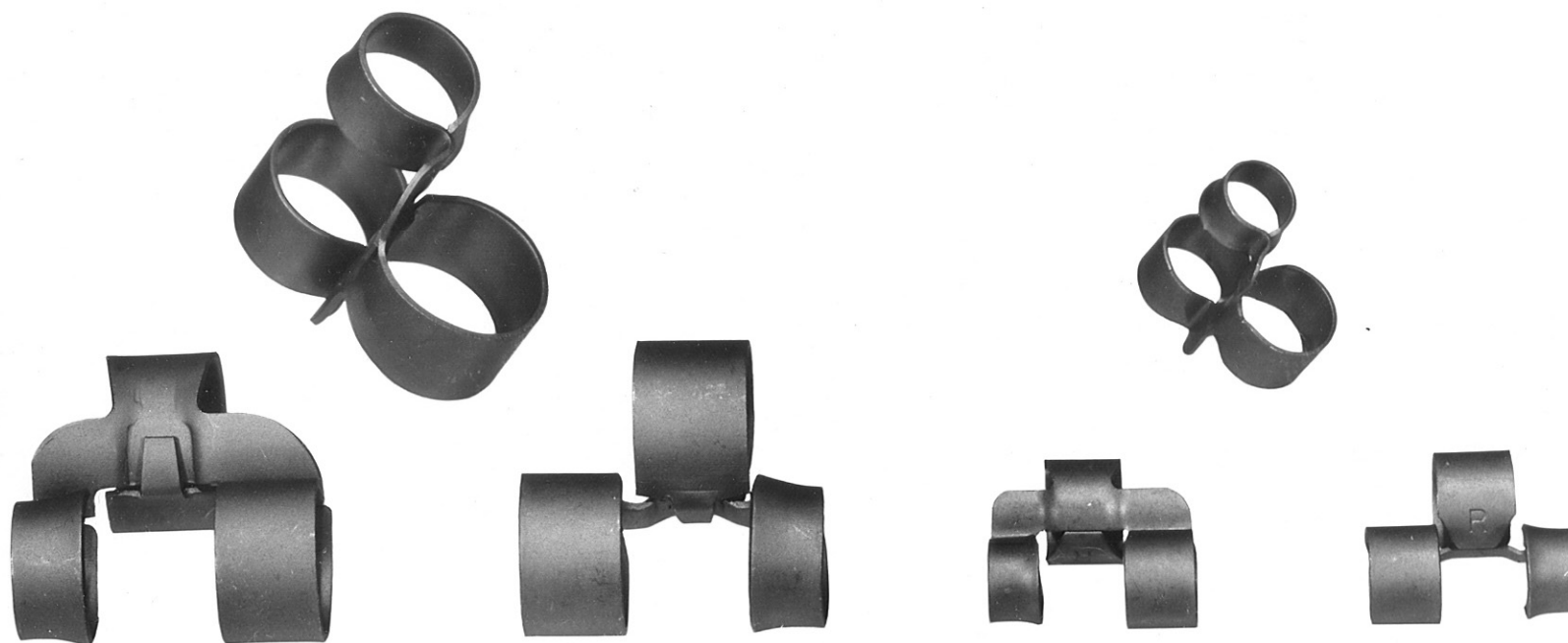


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ROCK ISLAND ARSENAL ORDNANCE DEPARTMENT

September 29, 1952

Link, Metallic Belt, Cal..50, M9. Flexibility of Assembled Belt.



701-43174

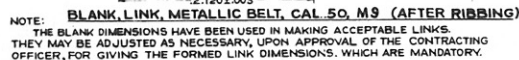
ROCK ISLAND ARSENAL ORDNANCE DEPARTMENT

October 15, 1952

Links, Metallic Belt, Cal..50, M9, Dwg. D7140393 and Cal..30, M1, Dwg. D5559722.



NOTE:- FINISHED LINK MUST FALL FREELY
OF ITS OWN WEIGHT THROUGH APERTURE
OF PROFILE GAGE B57840.



NOTES:
SECTIONS OF LINK MAY BE FOLDED AT "Y" TO CONTACT
OR LEFT WITH GAPS NOT TO EXCEED $\frac{1}{16}$.

WITH CONNECTING AND BODY RINGS TANGENT TO A
FLAT SURFACE, THE EDGES OR WINGS MUST NOT
TOUCH SURFACE.

WEIGHT OF 100 LINKS 4 LBS
WEIGHT OF 100 CARTRIDGES IN LINKS 29 LBS 14 OZ

LINE NO	LIST OF DRAWINGS	DRAWING NUMBER	LINE NO	LIST OF SPECIFICATIONS	SPEC NUMBER
1	LINK, METALLIC BELT, CAL. 50, M9	DT140393	1	LINKS, METALLIC BELT, FOR SMALL ARMS AMM.	MIL-L-3077
2	CASE, CARTRIDGE, CAL. 50, M1	C26-46	2	METALS; GENERAL SPECIFICATION FOR INSPECTION OF	QQ-M-151
3	CARTON, METALLIC BELT LINK, CAL. 50, M2 OR M9	D5576365	3	MANUFACTURE AND INSPECTION OF SMALL ARMS	
4	MARK, MANUFACTURER'S IDENTIFICATION	C5593317	4	WEAPONS AND ACCESSORIES	52-0-1
5			5	STEEL STRIP FOR METALLIC BELT LINKS @	57-16-1
6	ORDNANCE PACKAGING INSTRUCTIONS FOR LINKS,		6	STANDARD SPECIFICATIONS FOR MARKING	
7	METALLIC BELT, CAL. 50, M2 OR M9	PS-127	7	SHIPMENT	100-2
8	ORDNANCE PACKAGING INSTRUCTIONS FOR LINKS,		8	FINISHES, PROTECTIVE, FOR IRON AND STEEL PARTS	57-0-2
9	METALLIC BELT, CAL. 50, M2 OR M9	PS-82	9		

⊕ THIS SPECIFICATION IS NOT MANDATORY -
SEE SPEC MIL-L-3077 OF LATEST REVISION

NOTES:
FLEXIBILITY & WALK-OFF DATA IS
FOR INFORMATIONAL PURPOSES
ONLY

STRAINED FLEXIBILITY:
TWISTING TEST (FANWISE)—A BELT OF 22 ROUNDS, THE FIRST ROUND OF WHICH IS LOADED IN DOUBLE LOOP AND IS NORMAL TO THE AXIS OF A 6-INCH DIAMETER CYLINDER SHALL BE PULLED ON A POLISHED METAL OR GLASS SURFACE AND DRAWN AROUND THE CYLINDER BY A PULL OF 5 POUNDS; THIS PULL TO BE APPLIED AT THE CENTER OF THE DOUBLE LOOP OF THE END ROUND, ON THE SAME SIDE OF THE CYLINDER AS THE FIRST CARTRIDGE AND PERPENDICULAR TO THE AXIS OF THE CARTRIDGE, WITH THE POINT OF THE FIRST CARTRIDGE AGAINST THE CYLINDER THIS FORCE SHALL BE SUFFICIENT TO PULL THE POINTS OF ALL THE OTHER CARTRIDGES TO WITHIN 1/32 INCH OF THE CYLINDER.

2 TWISTING TEST-(HELICAL)-A BELT OF 12 ROUNDS, WHEN HUNG VERTICALLY AND STRETCHED BY A 5-POUND WEIGHT, SHALL BE CAPABLE OF BEING TWISTED (LOWER 4 ROUNDS RESTRAINED FROM ROTATION) 110 DEGREES BY A TORQUE OF 15 INCH-POUNDS. THIS FLEXIBILITY MUST BE ATTAINED BOTH RIGHT HAND AND LEFT HAND.

WALK-OFF TEST:- WITH THE APPARATUS FOR THE HELICAL TWISTING TEST, THE BELT MUST BE CAPABLE OF WITHSTANDING 100 TWISTS OF 120 DEGREES WITHOUT ANY CARTRIDGE WALKING-OFF ITS LINK MORE THAN .050 INCH. THIS TEST MUST BE NET BOTH RIGHT AND LEFT HAND.

EXTRACTOR PULL OF 10 TO 25 POUNDS
ON A BUFFED STEEL PLUG OF
MINIMUM CARTRIDGE DIMENSIONS
CONTROLS LIMITS OF THIS DIAMETER
AND ALIGNMENT OF LOOPS. FOR
DETAIL OF BUFFED STEEL PLUG,
SEE DWG. D16242.

— REMOVE BURRS AND SHARP EDGE BY COINING, CHAMFERING, ROLLING, OR OTHER MEANS ACCEPTABLE TO CONTRACTING OFFICER.

ORIGINAL DATE OF RECORD OCTOBER 21, 1944

REVISIONS			
NO.	DATE	REVISION	BY
1	11-9-49	WAS 495	C.D.P.
2	5-8-50	TEST DATA REVISION	C.D.P.
3	3-5-51	D-48 WAS 008, 030 WAS 030, 075 WAS 081	C.D.P.
4	3-30-51	GENERAL REVISION	R.D.C.
5	5-18-51	GENERAL REVISION	P.D.C.
6	8-27-51	GENERAL REVISION	R.D.C.

CLASS	DIVISION	NUMBER
HEAT TREATMENT & PROTECTIVE FINISH		
TYPE II CLASS B, SPEC 57-0-2		

NATIONAL IDENTIFICATION NUMBER		SHOWED PRINTING TO DATE REC		PRINTED DATE	
1	2	3	4	5	6
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