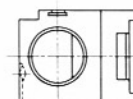
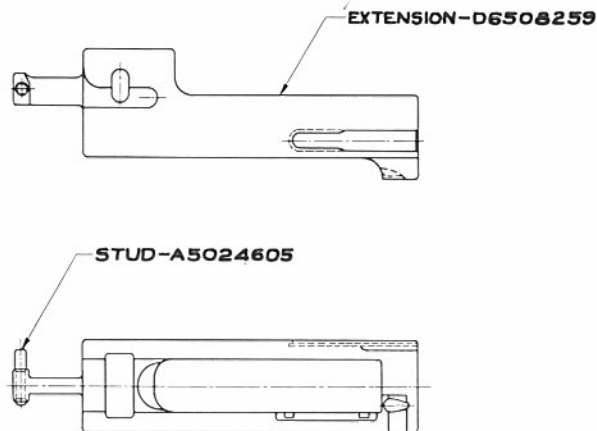
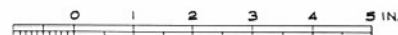


HEAT TREATMENT AND FINAL FINISH
TYPE II FINISH, CLASS B



EXTENSION, BARREL ASSEMBLY C5564139



PHYSICAL PROPERTIES		FEB. 1, 1938	
		REVISIONS	
Y. P.		8	5-10-48
T. S.			
EL. 2			
RED			
BR.			
ROCK.			
SCL.			

DRG. PERTAINS TO

51-10-1	30 BMG M19A1 (W.C.)
51-83-1	30 BMG M19A4 (FXD)
51-84-1	30 BMG M19A5 (FLX)
51-114-1	30 BMG M19A3 (FXD)
51-125-1	30 BMG M19A6

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

DRAWN BY: M. J. E. R. G.
CHECKED BY: [Signature]
CRAFTSMAN: [Signature]

SUBMITTED: [Signature]
ORD. DEPT. U. S. A.

WAS C64139

DO NOT INSCRIBE PART NO.

C5564139

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE

[Signature]
ORD. DEPT. U. S. A.

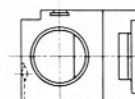
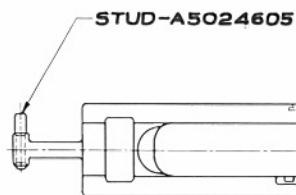
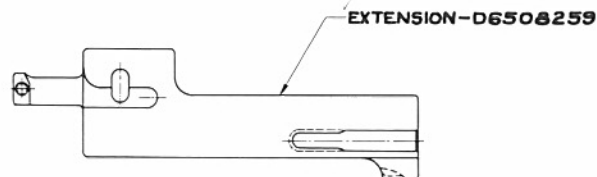
ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL

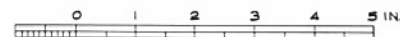
C5564139

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A 5024605 JUNE 1, 1931			
HEAT TREAT	Y. P.	<input checked="" type="checkbox"/>	RED.	<input checked="" type="checkbox"/>	SCL.	REVISIONS			
	T. S.	<input checked="" type="checkbox"/>	BR.	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	11 5-10-48			
	EL. 2	<input checked="" type="checkbox"/>	ROCK	C 30-35					
						DRG. PERTAINS TO			
						C5564139		30BMG M17A1 (WC) M19A4 (FXD) M19A4 (FLEX) M19A5 (FXD) M19A6	
						INSCRIBE PART NO. DO NOT			
						TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL $\pm .005$ FRACTIONAL $\pm 1/64$ ANGULAR $\pm 5^\circ$			
						DRAFTSMAN F.C.L.		TRACER L.R.E.	
CHECKER L.S.C.		CHIEF DRAFTSMAN O.O.							
STUD BARREL PLUNGER STEEL FS 1095 FINISH 125/						5024605 WAS A24605			
SCALE $\frac{4}{1}$						A 5024605			
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.			
ORDANCE DEPT., U. S. A.						ORDANCE DEPT., U. S. A.			

HEAT TREATMENT AND FINAL FINISH
TYPE II FINISH, CLASS B



EXTENSION, BARREL ASSEMBLY C5564139



PHYSICAL PROPERTIES		FEB. 1, 1938	
		REVISIONS	
Y. P.		8	5-10-48
T. S.			
EL. 2			
RED			
BR.			
ROCK.			
SCL.			

DRG. PERTAINS TO

51-10-1	30 BMG M19A1 (W.C.)
51-83-1	30 BMG M19A4 (FXD)
51-84-1	30 BMG M19A5 (FLX)
51-114-1	30 BMG M19A3 (FXD)
51-125-1	30 BMG M19A6

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

DRAWN BY: M. J. E. R. G.
CHECKED BY: [Signature]
CRAFTSMAN: [Signature]

SUBMITTED: [Signature]
ORD. DEPT. U. S. A.

WAS C64139

DO NOT INSCRIBE PART NO.

C5564139

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE

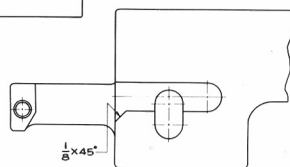
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ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

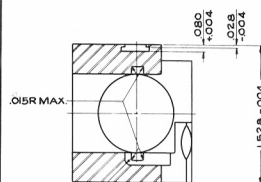
MADE AT ROCK ISLAND ARSENAL

C5564139

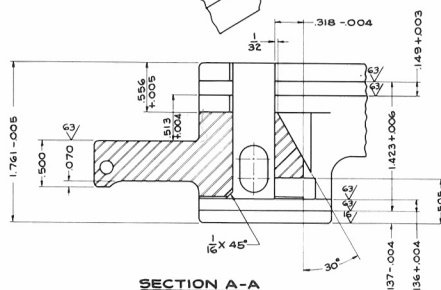
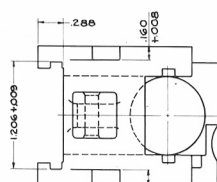
HEAT TREAT



ALTERNATIVE METHOD OF MANUFACTURE

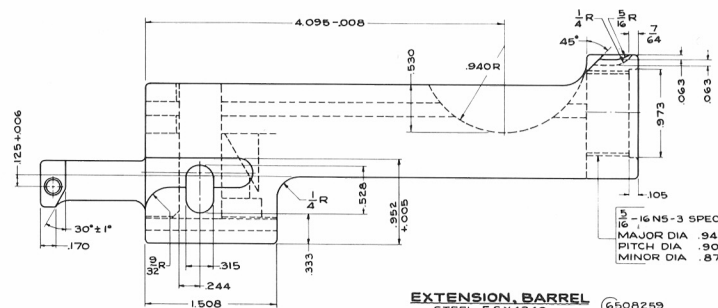
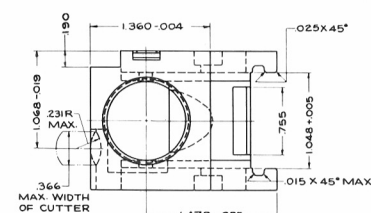
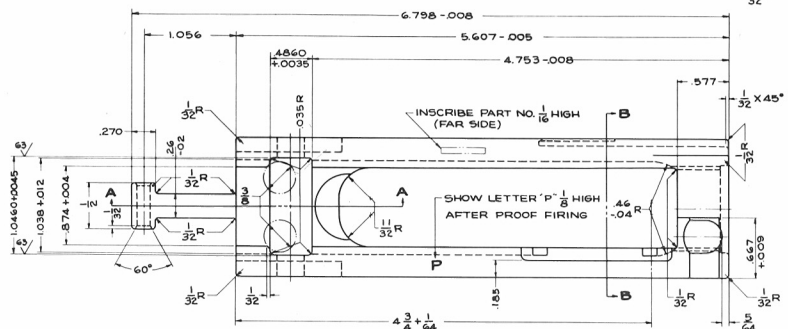
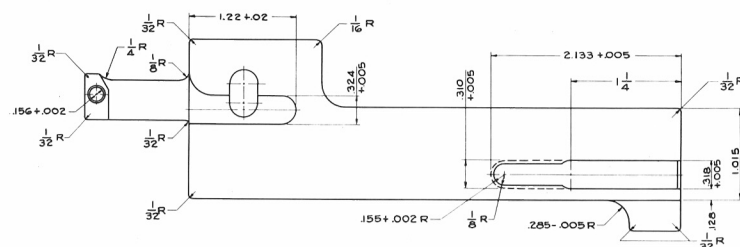


SECTION B-B



SECTION A-A

R.I.A. FORGING SHOWN ON DRG C76070



EXTENSION, BARREL (6508259)
STEEL F 5X4340
 FINISH 125/ OTHER SURFACES, AS SPECIFIED

WAS D8259

SCALE $\frac{2}{1}$

PHYSICAL PROPERTIES	
Y.P.	
T.S.	
EL. 2	
RED	
BR	
ROCK	C-45-52
SCL	

06508259

DO	INSCRIBE PART NO
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APRIL 4, 1927		CLASS	DIVISION	DRAWING	FILE
REVISIONS					
33 510-48		TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL .0008 FRACTIONAL 1/64 ANGULAR 2 W			
DRG. PERTAINS TO C564139		SURFACES M V E D	TOLER Z C	LIVE SHAPED CHAMFERED	
		SUBMITTED: <i>A.H. Roe</i>			
		EXAMINED:			
APPROVED BY ORDER OF THE CHIEF OF DIVISION <i>Walter A. DeLamater</i> CHIEF, DIVISION OF ORDNANCE DEPT. U. S. A.					
D 6508259					