

HEAT TREATMENT AND FINAL FINISH

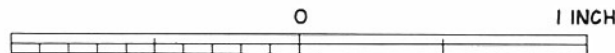
SPRING-A5020615  
PIN-A5020562

EDGE OF SLOT TO BE PEENED  
OVER TO RETAIN SPRING



PIN ASSEMBLY

6131253



PHYSICAL  
PROPERTIES

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

JUNE 1, 1931

REVISIONS

8 5-10-48  
9 11-15-49

DRG. PERTAINS TO

51-10-41 .30 BMG M17A1 (WC)  
51-83-1 .30 BMG M19A4 (FXD)  
51-84-1 .30 BMG M19A4 (FLEX)  
51-114-1 .30 BMG M19A5 (FXD)  
51-125-1 .30 BMG M19A6

~~DO~~ INSCRIBE PART NO.  
DO NOT

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

DRAFTSMAN S.C.F.	TRACER L.R.E.	CHECKER S.C.F.	CHIEF DRAFTSMAN O.D.
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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 ROCK ISLAND ARSENAL

WAS B131253

B 6131253

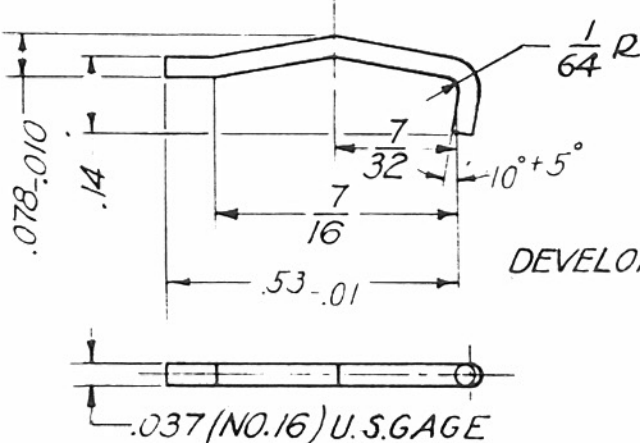
B6131253

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A 5020562 FEB. 1, 1927					
HEAT TREAT TYPE II FINISH, CLASS B		Y. P.	RED.		SCL.	REVISIONS					
		T. S.	BR.								
		EL. 2	ROCK	C38-43							
<p style="text-align: center;">PIN DRILL ROD FINISH 125/</p>		DRG. PERTAINS TO		<p>50 BMB M 17A1 (WC) M 19A4 (FXD) M 19A4 (FLEX) M 19A5 (FXD) M 19A6</p> <p style="text-align: center;">INSCRIBE PART NO. DO NOT</p> <p style="text-align: center;">TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL ± .005 FRACTIONAL ± 1/64 ANGULAR ± —</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 J.E.</td> <td></td> <td>CHIEF DRAFTSMAN</td> </tr> </table> <p style="text-align: center;">SUBMITTED: <i>A.H. Poe</i> ORD. DEPT., U. S. A.</p> <p style="text-align: center;">APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>Walter Ackerman</i> ORD. DEPT., U. S. A.</p> <p style="text-align: center;">ORDNANCE DEPT., U. S. A.</p>		DRAFTSMAN W.C.O.	TRACER L.R.E.	L'D'G DRAFTSMAN	CHECKER J.E.		CHIEF DRAFTSMAN
		DRAFTSMAN W.C.O.	TRACER L.R.E.			L'D'G DRAFTSMAN					
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ORDNANCE DEPT., U. S. A.											

SCALE  $\frac{2}{1}$  A 5020562

WAS A20562

5020562

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				APRIL 4, 1927				
AFTER BENDING HEAT AT 450°-470°F FOR 15 MINUTES PROTECTIVE FINISH TYPE I CLASS 0.S.C.		Y.P.		RED.		ROCK.		REVISIONS		
		T.S.		BR.				9	11-5-41	15 <sup>4</sup> 1-9-46
		EL 2						10	7-23-42	16 <sup>2</sup> 4-30-48
								11 <sup>2</sup> 7-30-42	17 <sup>2</sup> CONVERSION 11-23-48	
								12 <sup>2</sup> 3-13-43	18 <sup>2</sup> 2-15-49	
								13 <sup>1</sup> 2-7-44		
								14 <sup>1</sup> 2-10-45		
		DO NOT INSCRIBE PART NO.								
		DRG. PERTAINS TO CONT.								
		50MG-M3 AC. BASIC								
		ALL .50BMG-M2								
		DEVELOPED LENGTH .68-.04								
<ul style="list-style-type: none"> <li>⊕ SPRING, COCKING LEVER PIN</li> <li>⊕ SPRING, ACCELERATOR PIN</li> <li>⊕ SPRING, BELT FEED PAWL PIN</li> <li>⊕ SPRING, BREECH LOCK PIN</li> <li>⊕ SPRING, LOWER GRIP PIN</li> </ul>		DRG. PERTAINS TO								
		ALL .30 BMG								
		51-78 .22 USMG MH								
		⊕ A5013440 PIN, ACCELERATOR ASM.								
		⊕ A13440 PIN, BREECH LOCK ASM.								
		⊕ A5013441 PIN, BELT FEED PAWL ASM.								
		⊕ A22914 PIN, LOWER GRIP ASM.								
		⊕ B6131253 PIN, ACCELERATOR ASM.								
		⊕ B31253 PIN, BREECH LOCK ASM.								
		⊕ B6131255 PIN, BELT FEED PAWL ASM.								
		ALL 50 CAL. MG.								
		B6147762 PIN, COCKING LEVER ASM.								
		B7131745 PIN, COCKING LEVER ASM.								
		<div style="display: flex; justify-content: space-between;"> <div>             1<sup>ST</sup> MAN FE           </div> <div>             TRACER NLE           </div> <div>             LDC DFTSMAN B.P.O.           </div> </div>								
		<div style="display: flex; justify-content: space-between;"> <div>             CHIEF DFTSMAN 154           </div> <div>             00           </div> </div>								
		SUBMITTED								
		LT. COL. ORD. DEPT., U. S.								
		APPROVED BY ORDER OF THE CHIEF OF ORDNANCE								
		CAPT. ORD. DEPT., U. S. A.								
		ORDNANCE DEPT., U. S. A.								

TOLERANCE  $\pm .01$  ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.  
 SUPERSEDES OLD TRACING A20615  
 UNDER REVISION DATE OF NOV. 5, 1941

SCALE  $\frac{4}{1}$

A5020615

A20615

SUPERSEDES A 20615

A5020615

HEAT TREATMENT AND FINAL FINISH

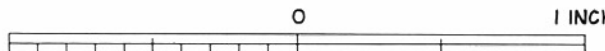
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