

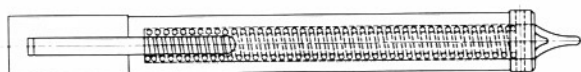
HEAT TREATMENT AND FINAL FINISH

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

DRG. PERTAINS TO

51-10-1	30 BMG
51-83-1	M19A1(WC)
51-84-1	30 BMG
51-114-1	M19A4(FXD)
51-114-1	30 BMG
51-125-1	M19A2(FLX)
51-125-1	30 BMG
51-125-1	M19A8(FXD)
51-125-1	30 BMG
51-125-1	M19A6

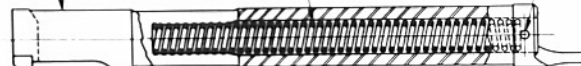
C5509186



PIN-C5508462

SPRING-B6147229

PIN-AZ0498



PIN. FIRING. ASSEMBLY

5509186

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

SOFTENED	TRACES	1/2 D GRATER THAN
C. S. & L. R. E.		
EXCEEDS	1/2 D	1/2 D GRATER THAN

SUBMITTED:

A.H.R.

ORD. DEPT. U. S. A.

WAS C9186

DO NOT INSCRIBE PART NO.

C5509186

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE

Walter A. Dickman

ORD. DEPT. U. S. A.

ORDNANCE DEPT., U. S. A.

MADE AT ROCK ISLAND ARSENAL



HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES						APRIL 4, 1927							
<i>HEAT TREAT</i>		Y.P.		RED.		ROCK.	C44-51	REVISIONS							
		T.S.		BR.				9	11-5-41						
<i>PROTECTIVE FINISH TYPE II CLASS A OR B.</i>		EL.2						10 ^a	7-23-42						
								11'	9-8-42						
		B1472E2	ROD DRIVING SPRING ASM				12'	4-3-45							
		C9186	PIN FIRING ASM				13 ^z	4-30-46							
								14 ^z	1-17-47						
DR'G. PERTAINS TO															
ALL .30 BMG.															
⊕ 51-78 .22 U.S.M.G.-M1															
B8721 PIN FIRING ASM.															
⊕ B131256 ROD DRIVING SPRING ASSEMBLY															
B147356 PIN FIRING ASSEMBLY															
D35485 TRAINER CAL..22,															
MACHINE GUN M3															
D35495 TRAINER CAL..22,															
MACHINE GUN M4															
DFTSMAN D.J.R.	TRACER R.S.D.	L'DG DFTSMAN <i>G.F.V.T.</i>													
CHECKER <i>NWB</i>	<i>[Signature]</i>	CHIEF DFTSMAN A.A.	O.O.												
SUBMITTED.. <i>Rydy / [Signature] mton</i>															
LT.COL. ORD. DEPT., U. S. A.															
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE.. <i>m L [Signature]</i>															
CAPT, ORD. DEPT., U. S. A.															
ORDNANCE DEPT., U. S. A.															

⊕ PIN, DRIVING SPRING ROD
PIN, FIRING PIN SPRING
STEEL W.D.1095
FINISH f
(A) 20498

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.
 SUPERSEDES OLD TRACING A20498 UNDER REVISION DATE OF NOV. 5, 1941

SCALE $\frac{4}{1}$

A 20498

HEAT TREATMENT AND FINAL FINISH
DRAW AT 450°F. TYPE I FINISH, CLASS OSC BAKE ONE HOUR AT 300-350°F.

DIAMETER OF WIRE	.0414
TOTAL NUMBER OF COILS	50.
OUTSIDE DIAMETER, FREE	.259±.003
MAX. OUTSIDE DIA AT MIN OPERATING HEIGHT	.265
FREE LENGTH	4.28±.06
TYPE OF ENDS	SQ & GD
WOUND	R.H.
MEAN ASSEMBLED HEIGHT	2.46
MIN LOAD AT MEAN ASSEMBLED HEIGHT	15.5 LB
MIN OPERATING HEIGHT	2.376
MIN LOAD AT MIN. OPERATING HEIGHT	16.20 LB
LB PER INCH OF SPRING DEFLECTION	8.5
SPRING FUNCTIONS IN HOLE	.270
CALCULATED MAX. SOLID HEIGHT	2.07

CAUTION: DO NOT COMPRESS SOLID

NOTE:

.5% OF SPRINGS WILL BE FATIGUE TESTED
BETWEEN ASSEMBLED HEIGHT AND MINIMUM
OPERATING HEIGHT FOR 50,000 CYCLES. THE
LOAD AT ASSEMBLED HEIGHT, AFTER TESTING,
SHOULD NOT BE LESS THAN 14.5 LB

SPRING FIRING PIN
SPRING STEEL WIRE WD1085 SPECIAL - CLASS A

6147229

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

FEBRUARY 1, 1938

REVISIONS

10	5-10-48		

DRG. PERTAINS TO

B 47556	.22 TRAINER
C5509186	.30 BMG M17A1(WC) M19A4(FXD) M19A4(FLEX) M19A5(FXD) M19A6

INSCRIBE PART NO.
DO NOT

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

W.L.M.	W.L.M.	W.L.M.
W.L.M.	W.L.M.	W.L.M.

SUBMITTED:

A.H. Roe

ORD. DEPT. U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter A. ...
ORD. DEPT. U. S. A.

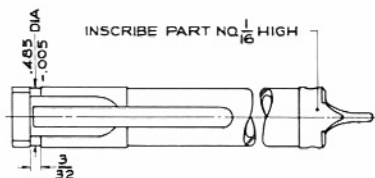
ORDNANCE DEPT., U. S. A.

WAS B147229

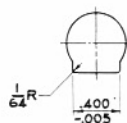
B 6147229

B6147229

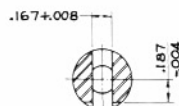
HEAT TREAT
TYPE II FINISH, CLASS B



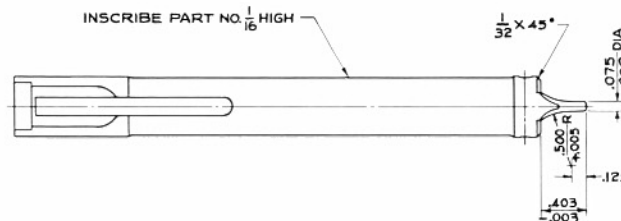
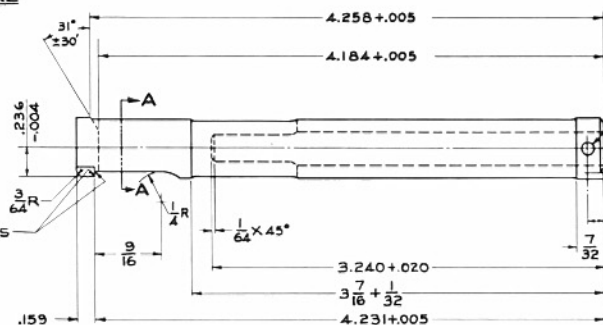
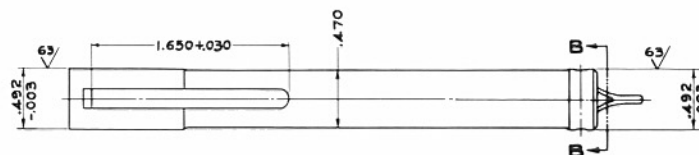
ALTERNATIVE METHOD OF MANUFACTURE



THESE CORNERS
TO BE SHARP



SECTION A-A



PIN, FIRING
STEEL FS4140
FINISH ¹²⁵/

(5508462)



SECTION B-B
SCALE $\frac{4}{1}$

SCALE $\frac{10}{1}$

SCALE $\frac{2}{1}$

PHYSICAL PROPERTIES		JUNE 1, 1931 REVISIONS	
Y. P.		235-10-48	
T. S.			
EL. 2			
RED			
BR.			
ROCK.	C48-53		
SCL.			

DRG. PERTAINS TO	
------------------	--

C5509186

30 BMG
M12A1(WC)
30 BMG
M19A4(FXD)
30 BMG
M19A4(FLEX)
30 BMG
M19A5(FXD)
30 BMG
M19A6

TOLERANCE ON DIMENSION
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\pm 1/64$

GRAFTMAN J. J. V.	TRACER E. B.	L. O. & Graftman
55	55	Chief Graftman

SUBMITTED:

WAS C8462

INSCRIBE PART NO.

C 5508462

ORDNANCE DEPT., U. S. A.

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C5508462

HEAT TREATMENT AND FINAL FINISH

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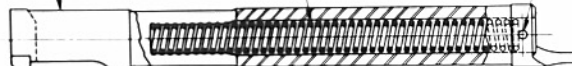
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SPRING-B6147229

PIN-AZ0498



PIN. FIRING. ASSEMBLY

5509186

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

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C. S. & S.	L. R. E.	OF THE ARMY
COPIES	TRACES	U.S. DEPARTMENT
COPIES	TRACES	OF THE ARMY

SUBMITTED:

A. H. R.

ORD. DEPT. U. S. A.

WAS C9186

DO NOT INSCRIBE PART NO.

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