

HEAT TREATMENT AND FINAL FINISH

★POST, FRONT SIGHT, ASSEMBLY - B 7162616
PLUNGER-A5156881

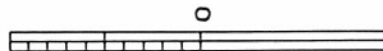
SCREW-A5156884
SPRING-A5156882
⊕ SCREW-A5156883

STAKE
WASHER-A7110440

⊕ NOT REQ'D WHEN
ALTERNATIVE METHOD
OF MANUFACTURE OF
B6144237 IS USED.

SIGHT, BRACKET, GROUP ASSEMBLY ⑦132923

SUPERSEDES B7132923 w/c 5-10-48



PHYSICAL
PROPERTIES

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

FEBRUARY 25, 1947

REVISIONS

1	5-10-48		

DRG. PERTAINS TO

51-83-1 30 BMG
M19A4 (FXD)
51-84-1 30 BMG
M19A4 (FLEX)
51-125-1 30 BMG
M19A6

INSCRIBE PART NO.
DO NOT

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

DRAFTSMAN DER.	TRACER O.K.	L.D.G. DRAFTSMAN
CHECKER R.J.S.	C.O.	CHIEF DRAFTSMAN

SUBMITTED:

A.H. Roe
ORD. DEPT., U. S. A.

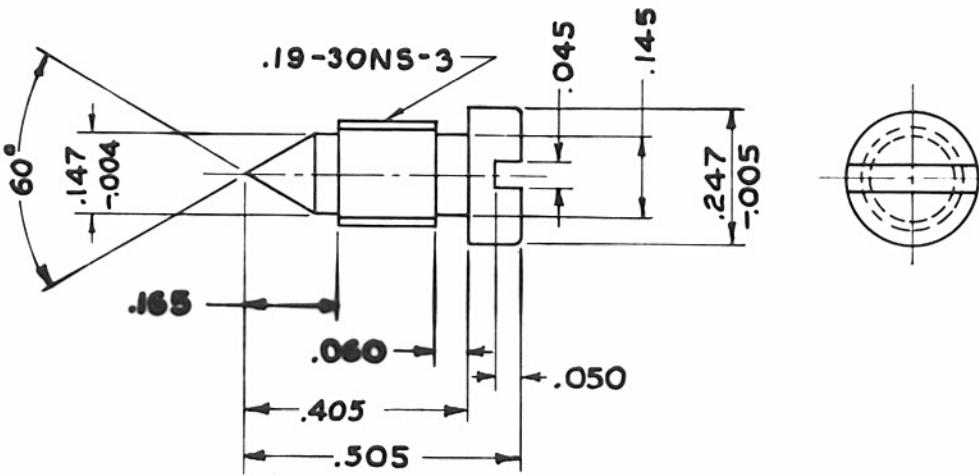
APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:
Walter Schuman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

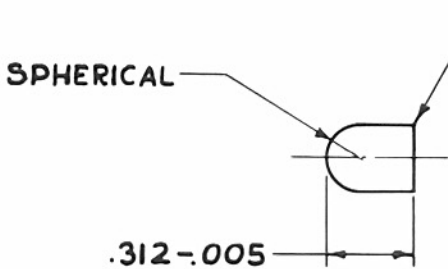
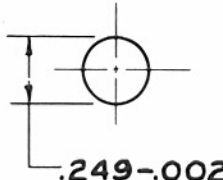
★ FINDING DIAGRAM

B 7132923

B7132923

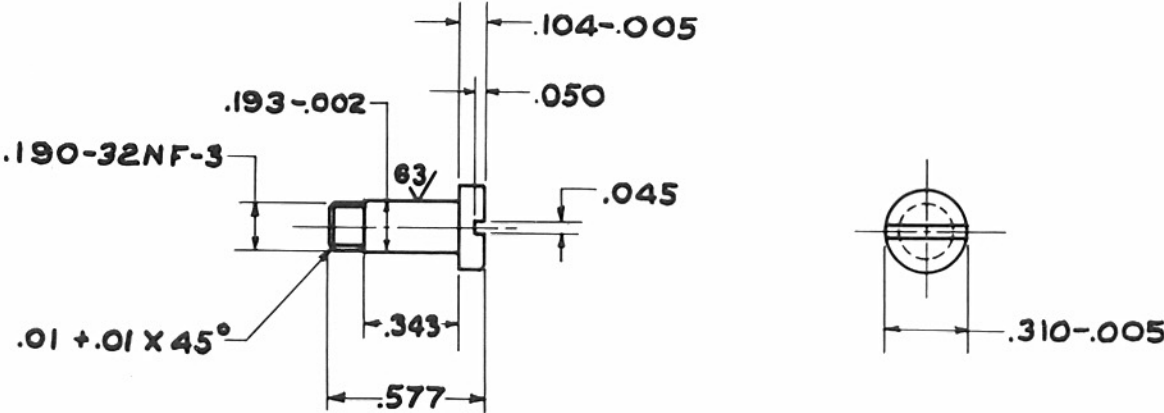
HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES					A5013249		
HEAT TREAT TYPE II FINISH, CLASS B		Y. P.		RED.		SCL.		JUNE 1, 1931	
		T. S.		BR.		C. C.	.003 TO .005 DEEP	REVISIONS	
		EL 2		ROCK				12	5-10-48
		DRG. PERTAINS TO							
		B 144235		.30 BMG M19A4 (FAD)					
		B 7132923		M19A4 (FLEX) M19A6					
<p>SCREW, LOCKING, FRONT SIGHT BRACKET (5013249)</p> <p>STEEL FS X1315</p> <p>FINISH 125/</p>		INSCRIBE PART NO. DO NOT							
		TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL ± .005 FRACTIONAL ± — ANGULAR ± 5°							
		DRAFTSMAN <i>G.L.F.</i>	TRACER O.K.	L'D'G DRAFTSMAN					
		CHECKER <i>E.W.H.</i>	O.O.	CHIEF DRAFTSMAN					
<p>SCALE $\frac{4}{1}$</p> <p>WAS A13249</p> <p>A 5013249</p>		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.							
<p>ORDNANCE DEPT., U. S. A.</p>		ORDNANCE DEPT., U. S. A.							
		ORDNANCE DEPT., U. S. A.							

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A5013258 JUNE 1, 1931	
TYPE II FINISH, CLASS B		Y. P.		RED.		SCL.	
		T. S.		BR.			
		EL 2		ROCK			
		REVISIONS					
		105-10-48					
<p>SCREW, FRONT SIGHT BRACKET (5013258)</p> <p>STEEL FSX1315</p> <p>FINISH 125/</p> <p>SCALE 2/1</p> <p>WAS A13258</p> <p>A 5013258</p>		DRG. PERTAINS TO					
		B 144235		30 BMG			
		B7132923		M19A4 (FXD)			
				M19A4 (FLEX)			
				M19A6			
<p>INSCRIBE PART NO.</p> <p>DO NOT</p> <p>TOLERANCE ON DIMENSIONS</p> <p>NOT OTHERWISE SPECIFIED</p> <p>DECIMAL ± .005</p> <p>FRACTIONAL ± —</p> <p>ANGULAR ± 5°</p>		DRAFTSMAN					
		E.K.		O.K.			
		CHECKER		O.O.			
		E.K.		O.O.			
				O.O.			
<p>SUBMITTED:</p> <p><i>A.H. Roe</i></p> <p>ORD. DEPT., U. S. A.</p> <p>APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:</p> <p><i>Walter Ackerman</i></p> <p>ORD. DEPT., U. S. A.</p> <p>ORDNANCE DEPT., U. S. A.</p>		SUBMITTED:					
		A.H. Roe		O.K.			
		O.O.		O.O.			

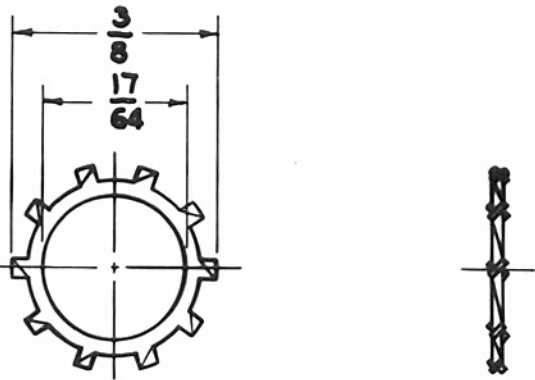
HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A5156881																	
TYPE II FINISH, CLASS B		Y. P.	RED.	SCL.	<div style="text-align: right;">MARCH 10, 1939</div> <div style="text-align: center;">REVISIONS</div> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 5%;">6</td> <td style="width: 45%;">5-10-48</td> <td style="width: 50%;"></td> </tr> <tr><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td></tr> <tr><td> </td><td> </td><td> </td></tr> </table>			6	5-10-48														
		6	5-10-48																				
T. S.	BR.																						
EL 2	ROCK																						
<div style="text-align: right; padding-right: 20px;"> NOTE: A .249-.002 DIA HARDENED AND GROUND STEEL BALL MAY BE USED AS AN ALTERNATIVE METHOD OF MANUFACTURE. </div> <div style="display: flex; justify-content: space-around; align-items: flex-start; margin-top: 20px;"> <div style="text-align: center;"> <p>SPHERICAL</p>  <p>.312-.005</p> </div> <div style="text-align: center;">  <p>.249-.002</p> </div> </div> <div style="text-align: center; margin-top: 30px;"> <p>PLUNGER, FRONT SIGHT</p> <p>STEEL FSX 1020</p> <p>FINISH $\sqrt{63}$</p> </div> <div style="display: flex; justify-content: space-between; align-items: center; margin-top: 20px;"> <div> <p>SCALE $\frac{2}{1}$</p> </div> <div style="border: 1px solid black; padding: 5px;"> <p>WAS A 156881</p> <p style="font-size: 1.5em; font-weight: bold;">A 5156881</p> </div> </div>								<div style="text-align: right;">DRG. PERTAINS TO</div> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">B 144235</td> <td style="width: 50%;">.30 BMG</td> </tr> <tr> <td>B7132923</td> <td>M19A4 (FXD)</td> </tr> <tr> <td> </td> <td>M19A4 (FLEX)</td> </tr> <tr> <td> </td> <td>M19A6</td> </tr> </table> <div style="text-align: center; margin-top: 10px;"> <p>INSCRIBE PART NO.</p> <p>DO NOT</p> </div> <div style="text-align: center; margin-top: 10px;"> <p>TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED</p> <p>DECIMAL \pm —</p> <p>FRACTIONAL \pm —</p> <p>ANGULAR \pm —</p> </div> <table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">DRAFTSMAN <i>H.O.C.</i></td> <td style="width: 33%;">TRACER <i>O.K.</i></td> <td style="width: 33%;">L'D'S DRAFTSMAN</td> </tr> <tr> <td>CHECKER <i>L.S.S. cur</i></td> <td> </td> <td>CHIEF DRAFTSMAN</td> </tr> </table> <div style="margin-top: 10px;"> <p>SUBMITTED:</p> <p style="text-align: right;"><i>A.H. Roe</i></p> <p style="text-align: right; font-size: 0.8em;">ORD. DEPT., U. S. A.</p> </div> <div style="margin-top: 10px;"> <p>APPROVED BY ORDER OF THE CHIEF OF ORDNANCE:</p> <p style="text-align: right;"><i>Walter A. ...</i></p> <p style="text-align: right; font-size: 0.8em;">ORD. DEPT., U. S. A.</p> </div> <div style="text-align: center; margin-top: 10px;"> <p>ORDNANCE DEPT., U. S. A.</p> </div>		B 144235	.30 BMG	B7132923	M19A4 (FXD)		M19A4 (FLEX)		M19A6	DRAFTSMAN <i>H.O.C.</i>	TRACER <i>O.K.</i>	L'D'S DRAFTSMAN	CHECKER <i>L.S.S. cur</i>		CHIEF DRAFTSMAN
B 144235	.30 BMG																						
B7132923	M19A4 (FXD)																						
	M19A4 (FLEX)																						
	M19A6																						
DRAFTSMAN <i>H.O.C.</i>	TRACER <i>O.K.</i>	L'D'S DRAFTSMAN																					
CHECKER <i>L.S.S. cur</i>		CHIEF DRAFTSMAN																					

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				<div style="text-align: right;">A 5156882</div> MARCH 10, 1939	
DRAW AT 450°F TYPE I FINISH, CLASS OSC BAKE ONE HOUR AT 300-350°F		Y. P.	<input checked="" type="checkbox"/>	RED.	<input checked="" type="checkbox"/>	SCL.	<input checked="" type="checkbox"/>
		T. S.	<input checked="" type="checkbox"/>	BR.	<input checked="" type="checkbox"/>		
		EL 2	<input checked="" type="checkbox"/>	ROCK	<input checked="" type="checkbox"/>		
<div style="display: flex; justify-content: space-between;"> <div style="width: 60%;"> DIAMETER OF WIRE _____ TOTAL NUMBER OF COILS _____ OUTSIDE DIAMETER FREE _____ MAX OUTSIDE DIA AT MIN OPERATING HEIGHT _____ FREE LENGTH _____ TYPE OF ENDS _____ WOUND _____ MEAN ASSEMBLED HEIGHT _____ MIN LOAD AT MEAN ASSEMBLED HEIGHT _____ MINIMUM OPERATING HEIGHT _____ MIN LOAD AT MINIMUM OPERATING HEIGHT _____ LB PER INCH OF SPRING DEFLECTION _____ SPRING FUNCTIONS IN HOLE _____ CALCULATED MAXIMUM SOLID HEIGHT _____ <div style="text-align: center;">CAUTION: DO NOT COMPRESS SOLID.</div> </div> <div style="width: 35%;"> .034 15 .224±.004 .230 1.00±.03 SQ. AND GROUND R.H. .593 9.75 LB .527 11.33 LB 24 .250 .510 </div> </div> <div style="text-align: center; margin-top: 20px;"> SPRING, FRONT SIGHT SPRING STEEL WIRE (WD1085 SPECIAL-CLASS A) </div> <div style="text-align: right; margin-top: 10px;"> WAS A156882 <div style="border: 1px solid black; padding: 5px; display: inline-block;"> A 5156882 </div> </div>		REVISIONS					
		8	5-10-48				
		DRG. PERTAINS TO					
		B 144235 B7132923		.30 SMG M19A4 (FXD) M19A4 (FLEX) M19A6			
		INSCRIBE PART NO. DO NOT					
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL ± — FRACTIONAL ± — ANGULAR ± —							
<small>DRAFTSMAN</small> W.L.M.	<small>TRACER</small> E.B.	<small>L'D'G DRAFTSMAN</small> 					
<small>CHECKER</small> <i>C.H.P.</i>	<small>O.O.</small> 	<small>CHIEF DRAFTSMAN</small> 					
SUBMITTED: <i>A.H. Roe</i>							
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE: <i>Walter Asherman</i> <small>ORD. DEPT., U. S. A.</small>							
ORDNANCE DEPT., U. S. A.							

MADE AT ROCK ISLAND ARSENAL

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A5156884	
TYPE II FINISH, CLASS B		Y. P.	<div style="border: 1px solid black; width: 20px; height: 20px; transform: rotate(45deg);"></div>	RED.	<div style="border: 1px solid black; width: 20px; height: 20px; transform: rotate(45deg);"></div>	SCL.	--
		T. S.	<div style="border: 1px solid black; width: 20px; height: 20px; transform: rotate(45deg);"></div>	BR.	<div style="border: 1px solid black; width: 20px; height: 20px; transform: rotate(45deg);"></div>		
		EL 2	<div style="border: 1px solid black; width: 20px; height: 20px; transform: rotate(45deg);"></div>	ROCK	<div style="border: 1px solid black; width: 20px; height: 20px; transform: rotate(45deg);"></div>		
		MARCH 10, 1939		REVISIONS			
		7 5-10-48					
		DRG. PERTAINS TO					
		B 144235		.30 BMG		M19A4 (FXD)	
		B7132923		M19A4 (FLEX)		M19AG	
INSCRIBE PART NO. DO NOT		TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL $\pm .005$ FRACTIONAL $\pm \frac{1}{16}$ ANGULAR $\pm 5^\circ$					
		DRAFTSMAN H.D.C.		TRACER O.K.		L'D'G DRAFTSMAN	
		CHECKED L.S. <i>EvR</i>		O.O.		CHIEF DRAFTSMAN	
SCALE $\frac{2}{1}$		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.					
WAS A 156884		ORDNANCE DEPT., U. S. A.					
		A 5156884					

SCREW BEARING, FRONT SIGHT (5156884)
STEEL FSX 1315
 FINISH $\frac{125}{1}$ OTHER SURFACES, AS SPECIFIED

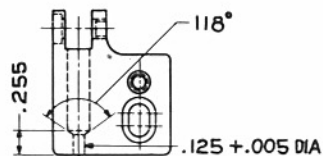
HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A7110440 JANUARY 31, 1944					
TYPE II FINISH, CLASS B		Y. P.	RED.	SCL.	REVISIONS 3 5-10-48						
		T. S.	BR.	ROCK							
		EL 2	ROCK								
						DRG. PERTAINS TO					
						B 144235		30 BMG			
						B 7132923		M19A4 (FXD) M19A4 (FLEX) M19A6			
						INSCRIBE PART NO. DO NOT					
						TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL ± — FRACTIONAL ± — ANGULAR ± —					
						DRAFTSMAN <i>W. G. 20</i>		TRACER <i>O.K.</i>		L'D'G DRAFTSMAN	
						CHECKER <i>H.W.J.</i>		O.O.		CHIEF DRAFTSMAN	
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ORDNANCE DEPT., U. S. A.						ORDNANCE DEPT., U. S. A.					

WASHER, LOCK
.022 STEEL - COMMERCIAL (7110440)
 SHAKEPROOF EXTERNAL TOOTH LOCK WASHER NO. 1114-05 OR EQUAL

SUPERSEDES A7110440 WO/C 5-10-48 SCALE $\frac{4}{1}$ A 7110440

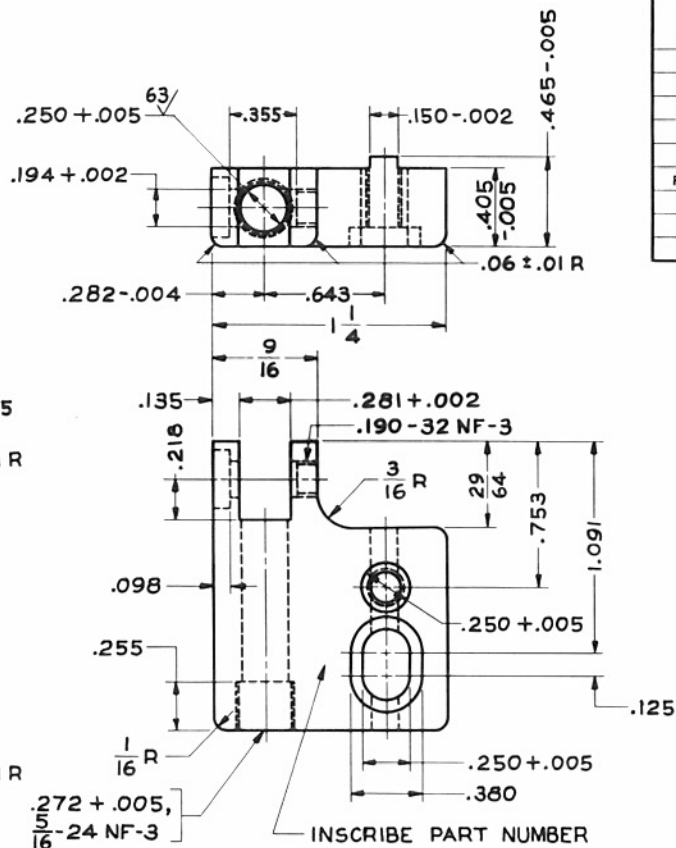
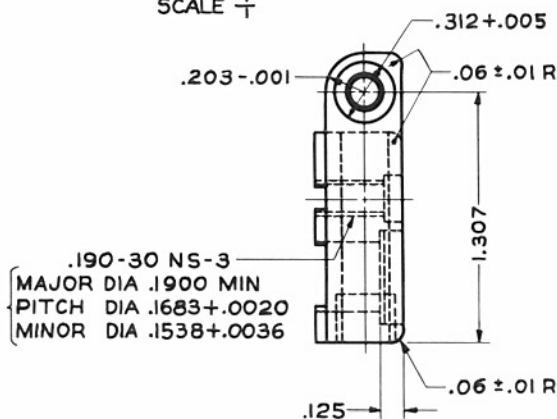
HEAT TREATMENT AND FINAL FINISH

TYPE II FINISH, CLASS B



**VIEW SHOWING ALTERNATIVE
METHOD OF MANUFACTURE**

SCALE $\frac{1}{16}$



BODY, FRONT SIGHT

STEEL FSX1020

FINISH $\frac{125}{16}$, OTHER SURFACES
AS SPECIFIED

6144237

SCALE $\frac{2}{1}$

WAS B144237

B 6144237

PHYSICAL
PROPERTIES

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

MARCH 10, 1939

REVISIONS

11	5-10-48		

DRG. PERTAINS TO

B 144235 30B MG M19A4
(FXD) & (FLEX)
B 7132923 30B MG M19A4
(FXD) & (FLEX)

DO INSCRIBE PART NO.

TOLERANCE ON DIMENSIONS
NOT OTHERWISE SPECIFIED
DECIMAL $\pm .005$
FRACTIONAL $\pm \frac{1}{64}$
ANGULAR: 5'

DRAFTER H.D.C.	TRACER L.R.E.	L/O D DRAFTER CHIEF DRAFTER
5/10/39		

SUBMITTED:

W. 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.

B6144237

HEAT TREATMENT AND FINAL FINISH

★POST, FRONT SIGHT, ASSEMBLY - B 7162616
PLUNGER-A5156881

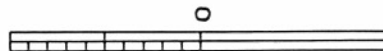
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ALTERNATIVE METHOD
OF MANUFACTURE OF
B6144237 IS USED.

SIGHT, BRACKET, GROUP ASSEMBLY ⑦132923

SUPERSEDES B7132923 w/c 5-10-48



PHYSICAL
PROPERTIES

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

FEBRUARY 25, 1947

REVISIONS

1	5-10-48		

DRG. PERTAINS TO

51-83-1 30 BMG M19A4 (FXD)
51-84-1 30 BMG M19A4 (FLEX)
51-125-1 30 BMG M19A6

INSCRIBE PART NO.
DO NOT

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

DRAFTSMAN DER.	TRACER O.K.	L'D G DRAFTSMAN
CHECKER R.J.S.	C.O.	CHIEF DRAFTSMAN

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

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:
Walter Schuman
ORD. DEPT., U. S. A.

ORDNANCE DEPT., U. S. A.

★ FINDING DIAGRAM

B 7132923

B7132923