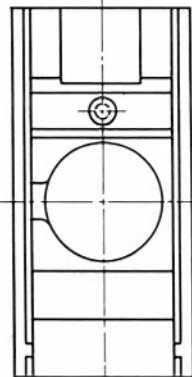


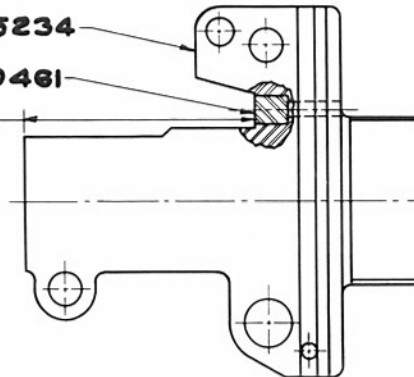
HEAT TREATMENT AND FINAL FINISH



BLOCK-D 6535234

PLATE-A5160461

GRIND FLUSH
TO 2.521 ± .006



BLOCK, TRUNNION, ASSEMBLY (6147093



PHYSICAL
PROPERTIES

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

SEPT. 30, 1936

REVISIONS

7 5-10-48

DRG. PERTAINS TO

D6535358 30 BMG M19A4
(FXD)-(FLEX)
D6540989 30 BMG
M19A5 (FXD)
D7114037 30 BMG
M19A6

INSCRIBE PART NO.
DO NOT

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

DRAFTSMAN P.J.R.	TRACER O.K.	L.D'S DRAFTSMAN
CHECKER L.S.	CHIEF DRAFTSMAN	

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.

WAS B147093

B 6147093

6147093

HEAT TREATMENT & FINAL FINISH		PHYSICAL PROPERTIES				A 5160461 MARCH 10, 1939	
HEAT TREAT		Y. P.		RED.		SCL.	
		T. S.		BR.			
		EL 2		ROCK	C 58-61		
<div style="display: flex; justify-content: space-around; align-items: flex-start;"> <div style="text-align: center;"> </div> <div style="text-align: center;"> </div> </div>							
<div style="display: flex; justify-content: space-between;"> <div> <p>PLATE, BUNTER</p> <p>STEEL FS 1095</p> <p>FINISH 125/</p> </div> <div> <p>5160461</p> </div> </div>							
<div style="display: flex; justify-content: space-between;"> <div> <p>SCALE $\frac{2}{1}$</p> </div> <div> <p>WAS A 160461</p> </div> </div>							

REVISIONS	
6	5-10-48

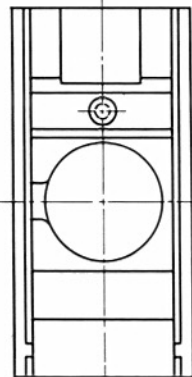
DRG. PERTAINS TO	
86147093	308MG M19A4 (FXD) M19A4 (FLEX) M19A6

INSCRIBE PART NO. DO NOT	
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL ± — FRACTIONAL ± — ANGULAR ± 5°	

DRAFTSMAN	TRACER	L'D'G DRAFTSMAN
M. J.	O. K.	
CHECKED L. S. C.	O. O.	CHIEF DRAFTSMAN

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

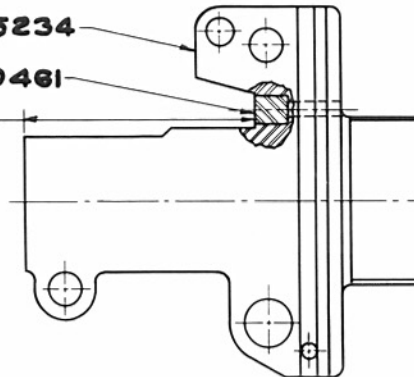
HEAT TREATMENT AND FINAL FINISH



BLOCK-D 6535234

PLATE-A5160461

GRIND FLUSH
TO 2.521 ± .006



BLOCK, TRUNNION, ASSEMBLY (6147093



PHYSICAL
PROPERTIES

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

SEPT. 30, 1936

REVISIONS

7 5-10-48

DRG. PERTAINS TO

D6535358 30 BMG M19A4
(FXD)-(FLEX)
D6540989 30 BMG
M19A5 (FXD)
D7114037 30 BMG
M19A6

INSCRIBE PART NO.
DO NOT

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

DRAFTSMAN P.J.R.	TRACER O.K.	L.D.'S DRAFTSMAN
CHECKER L.S.	CHIEF DRAFTSMAN	

SUBMITTED:

A.H. Roe

ORD. DEPT., U. S. A.

APPROVED BY ORDER OF THE CHIEF
OF ORDNANCE:

Walter Ackerman
ORD. DEPT., U. S. A.

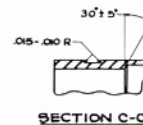
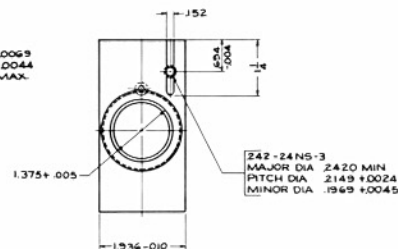
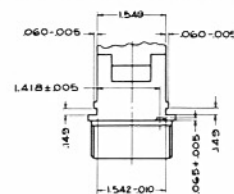
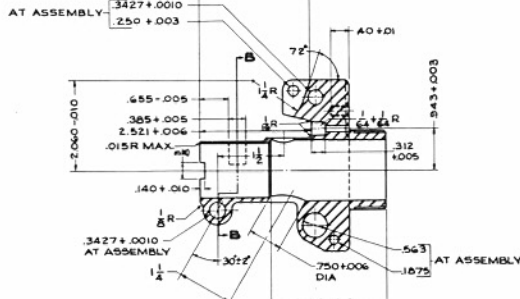
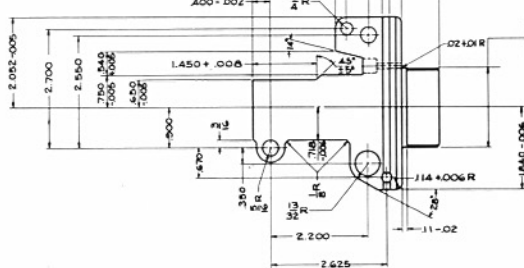
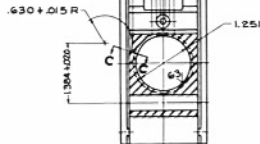
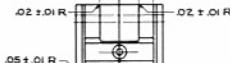
ORDNANCE DEPT., U. S. A.

WAS B147093

B 6147093

6147093

06535234



RIA FORGING SHOWN ON DRG C72853

NOTE: WHEN USING MALLEABLE IRON SPECIAL-CLASS B,
BUNTER PLATE A5160461 AND MACHINING FOR SAME
MAY BE OMITTED AND FRONT SURFACE OF FEEDWAY
FLAME HARDENED TO A MINIMUM HARDNESS OF ROCK C 35

BLOCK, TRUNNION (6535234)
STEEL F51050
FINISH 125/ OTHER SURFACES, AS SPECIFIED

WAS 035234

SCALE $\frac{1}{4}$

					INSURE PART NO.	
					DO NOT	
<div></div>						
SEPTEMBER 30, 1956						
REVISIONS						
Z-8-10-A-B						
<div></div>						
TOLERANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED FRACTIONS .004" DECIMALS .005" ANGULAR 2° FINISH "BEST"						
QUANTITY		Z.C.		TYPE REQUIRED		
G S T		Z.C.		"A"		
SPECIFICATION		"G"		OTHER REQUIREMENTS		
<div></div>						
SUBMITTER:						
A.H.Roe						
EXAMINED:						
<div></div>						
APPROVED BY ORDER OF THE CHIEF OF BUREAU						
Felix Williams						
ORD. DEPT., U.S.A.						
FORM NO. 10-56						
D 6535234						