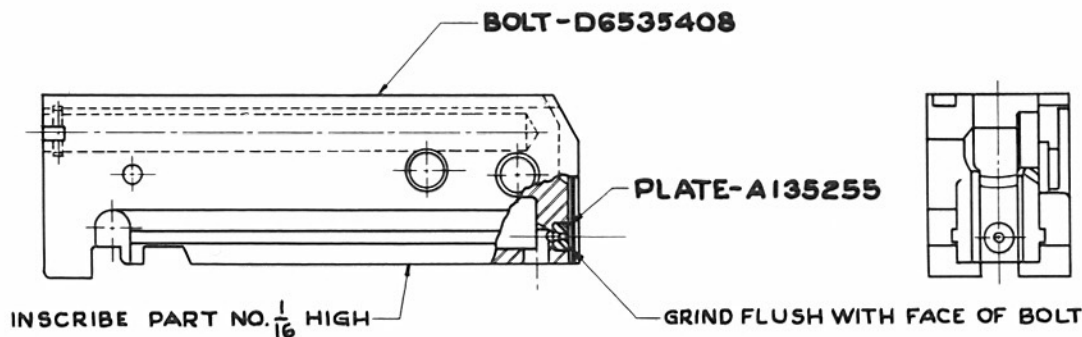
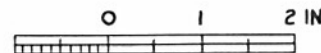


HEAT TREATMENT AND FINAL FINISH  
TYPE II FINISH, CLASS B

PHYSICAL PROPERTIES		FEB. 1, 1938	
		REVISIONS	
Y. P.		9	5-10-48
T. S.			
EL. 2			
RED.			
BR.			
ROCK			
SCL.			



**BOLT, ASSEMBLY** (6)47299



WAS B147299

**B6147299**

DO  
INSCRIBE PART NO.

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

DRAFTSMAN G.A.F.	TRACER O.K.	L'D'G DRAFTSMAN
CHECKER L.S.	CHIEF DRAFTSMAN	

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

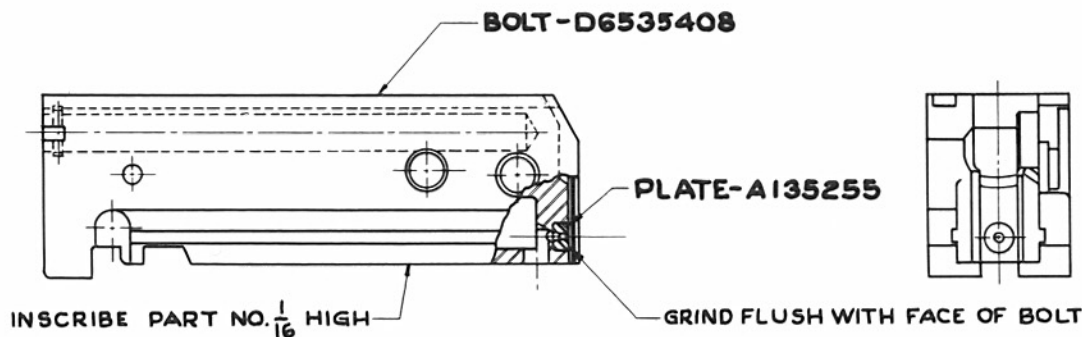
APPROVED BY ORDER OF THE CHIEF  
OF ORDNANCE:  
*Walter Askeham*  
ORD. DEPT., U. S. A.  
ORDNANCE DEPT., U. S. A.

B6147299

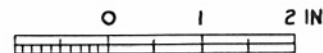


HEAT TREATMENT AND FINAL FINISH  
TYPE II FINISH, CLASS B

PHYSICAL PROPERTIES		FEB. 1, 1938	
		REVISIONS	
Y. P.		9	5-10-48
T. S.			
EL. 2			
RED.			
BR.			
ROCK			
SCL.			



**BOLT, ASSEMBLY** (6)47299



WAS B147299

**B6147299**

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

DO  
INSCRIBE PART NO.

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

DRAFTSMAN G.A.F.	TRACER O.K.	L'D'G DRAFTSMAN
CHECKER L.S.	CHIEF DRAFTSMAN	

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

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

B6147299

HEAT TREAT



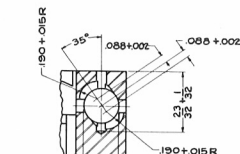
SECTION C-C



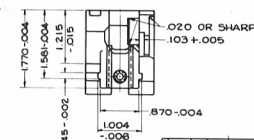
**SECTION A-A**



VIEWS SHOWING ALTERNATIVE  
METHOD OF MANUFACTURE FOR 35° CLEARANCE CUT



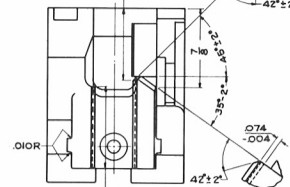
**SECTION B-B**  
**SCALE 2**

SCALE  $\frac{4}{1}$ 

**SECTION F-F**  
SCALE  $\frac{3}{8}$



SCALE :



**ENLARGED VIEWS OF  
FACE OF BOLT**  
SCALE 7

$\frac{1}{8} R$  (CYLINDRICAL)  
 $.175 - .020 R$  (AT TOP OF CONE)

DO NOT INSCRIBE PART NO.

FEBRUARY 1, 1936 REVISIONS 37 5-10-46	CLARE TOLRANCE ON DIMENSIONS NOT OTHERWISE SPECIFIED DECIMAL FRACTIONS .005 ANGULAR 2° 1/4	DRAWING TOLER. Z. C. 1/8" MAXIMUM 1/16" MINIMUM 1/32" MINIMUM 1/64" MINIMUM 1/128" MINIMUM 1/256" MINIMUM 1/512" MINIMUM 1/1024" MINIMUM 1/2048" MINIMUM 1/4096" MINIMUM 1/8192" MINIMUM 1/16384" MINIMUM 1/32768" MINIMUM 1/65536" MINIMUM 1/131072" MINIMUM 1/262144" MINIMUM 1/524288" MINIMUM 1/1048576" MINIMUM 1/2097152" MINIMUM 1/4194304" MINIMUM 1/8388608" MINIMUM 1/16777216" MINIMUM 1/33554432" MINIMUM 1/67108864" MINIMUM 1/134217728" MINIMUM 1/268435456" MINIMUM 1/536870912" MINIMUM 1/1073741824" MINIMUM 1/2147483648" MINIMUM 1/4294967296" MINIMUM 1/8589934592" MINIMUM 1/17179869184" MINIMUM 1/34359738368" MINIMUM 1/68719476736" MINIMUM 1/137438953472" MINIMUM 1/274877906944" MINIMUM 1/549755813888" MINIMUM 1/1099511627776" MINIMUM 1/2199023255552" MINIMUM 1/4398046511104" MINIMUM 1/8796093022208" MINIMUM 1/17592186044416" MINIMUM 1/35184372088832" MINIMUM 1/70368744177664" MINIMUM 1/140737488355328" MINIMUM 1/281474976710656" MINIMUM 1/562949953421312" MINIMUM 1/1125899906842624" MINIMUM 1/2251799813685248" MINIMUM 1/4503599627370496" MINIMUM 1/9007199254740992" MINIMUM 1/18014398509481984" MINIMUM 1/36028797018963968" MINIMUM 1/72057594037927936" MINIMUM 1/144115188075855872" MINIMUM 1/288230376151711744" MINIMUM 1/576460752303423488" MINIMUM 1/1152921504606846976" MINIMUM 1/2305843009213693952" MINIMUM 1/4611686018427387904" MINIMUM 1/9223372036854775808" MINIMUM 1/18446744073709551616" MINIMUM 1/36893488147419103232" MINIMUM 1/73786976294838206464" MINIMUM 1/147573952589676412928" MINIMUM 1/295147905179352825856" MINIMUM 1/590295810358705651712" MINIMUM 1/1180591620717411303424" MINIMUM 1/2361183241434822606848" MINIMUM 1/4722366482869645213696" MINIMUM 1/9444732965739290427392" MINIMUM 1/18889465931478580854784" MINIMUM 1/37778931862957161709568" MINIMUM 1/75557863725914323419136" MINIMUM 1/151115727451828646838272" MINIMUM 1/302231454903657293676544" MINIMUM 1/604462909807314587353088" MINIMUM 1/1208925819614629174706176" MINIMUM 1/2417851639229258349412352" MINIMUM 1/4835703278458516698824704" MINIMUM 1/9671406556917033397649408" MINIMUM 1/19342813113834066795298816" MINIMUM 1/38685626227668133590597632" MINIMUM 1/77371252455336267181195264" MINIMUM 1/154742504910672534362390528" MINIMUM 1/309485009821345068724781056" MINIMUM 1/618970019642690137449562112" MINIMUM 1/1237940039285380274899124224" MINIMUM 1/2475880078570760549798248448" MINIMUM 1/4951760157141521099596496896" MINIMUM 1/9903520314283042199192993792" MINIMUM 1/19807040628566084398385987584" MINIMUM 1/39614081257132168796771975168" MINIMUM 1/79228162514264337593543950336" MINIMUM 1/158456325028528675187087900672" MINIMUM 1/316912650057057350374175801344" MINIMUM 1/633825300114114700748351602688" MINIMUM 1/1267650600228229401496703205376" MINIMUM 1/2535301200456458802993406410752" MINIMUM 1/5070602400912917605986812821504" MINIMUM 1/10141204801825835211973625643008" MINIMUM 1/20282409603651670423947251286016" MINIMUM 1/40564819207303340847894502572032" MINIMUM 1/81129638414606681695789005144064" MINIMUM 1/162259276829213363291578010288128" MINIMUM 1/324518553658426726583156020576256" MINIMUM 1/649037107316853453166312041152512" MINIMUM 1/1298074214633706906332624082305024" MINIMUM 1/2596148429267413812665248164610048" MINIMUM 1/5192296858534827625330496329220096" MINIMUM 1/10384593717069655250660992658440192" MINIMUM 1/20769187434139310501321985316880384" MINIMUM 1/41538374868278621002643970633760768" MINIMUM 1/83076749736557242005287941267521536" MINIMUM 1/16615349947311448401057588253504288" MINIMUM 1/33230699894622896802115176507008576" MINIMUM 1/66461399789245793604230353014017152" MINIMUM 1/132922799578491587208460706028034304" MINIMUM 1/265845599156983174416921412056068608" MINIMUM 1/531691198313966348833842824112137216" MINIMUM 1/1063382396627932697667685648224274432" MINIMUM 1/2126764793255865395335371296448548864" MINIMUM 1/4253529586511730790670742592897097728" MINIMUM 1/8507059173023461581341485185794195456" MINIMUM 1/17014118346046923162682970371588390912" MINIMUM 1/34028236692093846325365940743176781824" MINIMUM 1/68056473384187692650731881486353563648" MINIMUM 1/136112946768375385301463762972707127296" MINIMUM 1/272225893536750770602927525945414254592" MINIMUM 1/54445178707350154
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PHYSICAL	
PROPERTY	
Y.P.	
T.S.	
EL.2	
RED	
HT.T	
BR	
ROCK	C-47-5
SCL.	

06535408