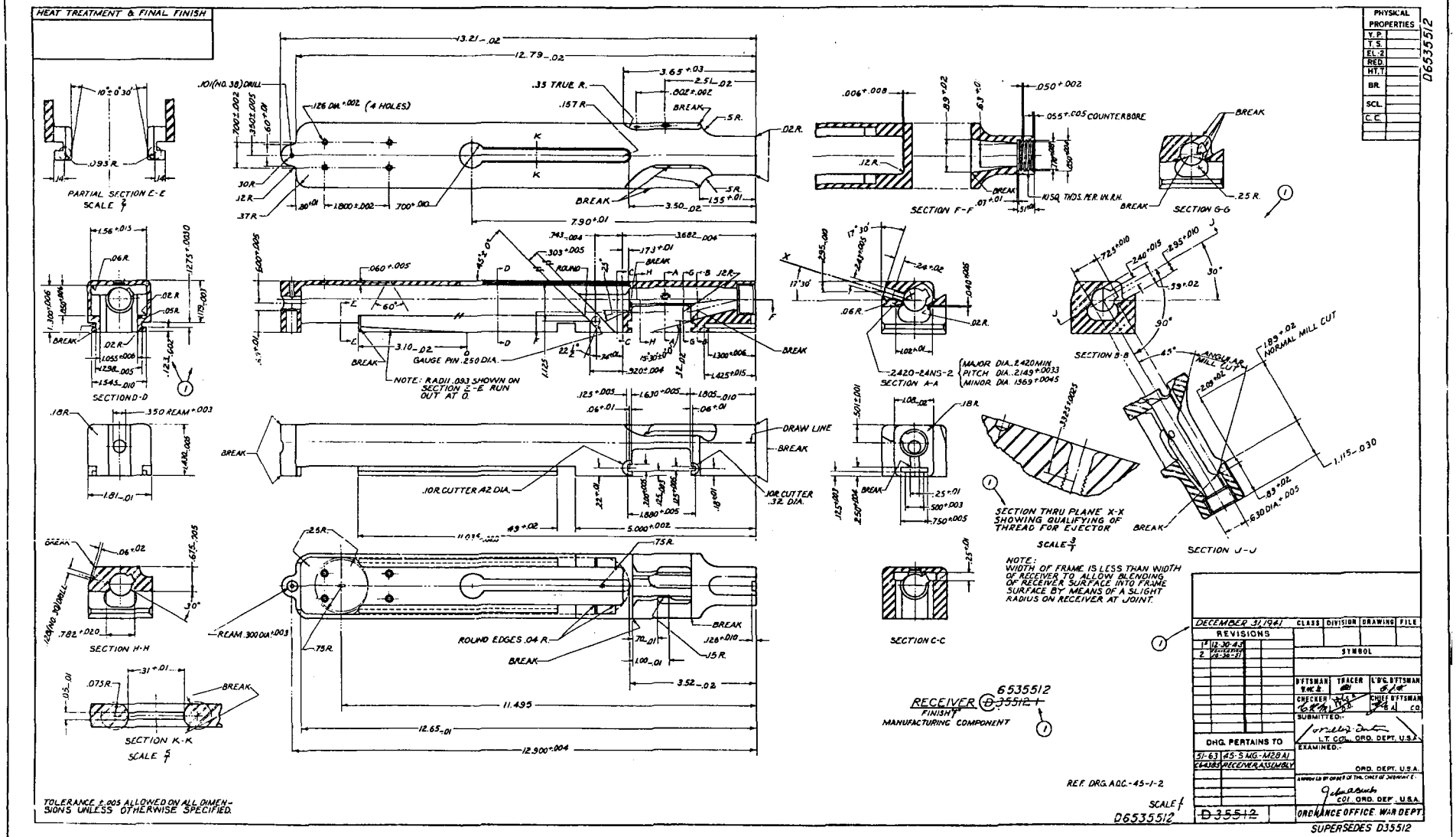
HEAT TREATMENT & FINAL FINISH
PHYSICAL PROPERTIES
Y.P.
T.S.
EL-2
RED.
HT.T.
BR.
SCL.
C.C.
D6535512
PARTIAL SECTION E-E
SCALE 3/1
SECTION D-D
SECTION H-H
SECTION K-K
SCALE 5/1
SECTION F-F
SECTION G-G
SECTION A-A
SECTION B-B
SECTION J-J
SECTION C-C
SECTION THRU PLANE X-X SHOWING QUALIFYING OF THREAD FOR EJECTOR
SCALE 3/1
NOTE: WIDTH OF FRAME IS LESS THAN WIDTH OF RECEIVER TO ALLOW BLENDING OF RECEIVER SURFACE INTO FRAME SURFACE BY MEANS OF A SLIGHT RADIUS ON RECEIVER AT JOINT.
.101 (NO. 38) DRILL
.126 DIA. +.002 (4 HOLES)
.33 TRUE R.
.157 R.
BREAK
.5 R.
.02 R.
.30 R.
.12 R.
.37 R.
.1800 ± .002
.700 ± .010
3.50 -.02
7.90 ± .01
.060 ± .005
GAUGE PIN .250 DIA.
NOTE: RADII .093 SHOWN ON SECTION E-E RUN OUT AT O.
DRAW LINE
.10 R. CUTTER .42 DIA.
.10 R. CUTTER .32 DIA.
5.000 ± .002
11.03 -.020
REAM .300 DIA. +.003
ROUND EDGES .04 R.
.75 R.
.15 R.
3.52 -.02
11.495
12.65 -.01
12.900 ± .004
.006 + .008
.050 + .002
.055 + .005 COUNTERBORE
.10 SQ. THDS. PER VN. R.H.
.24 ± .02
.06 R.
.2420-24NS-2
MAJOR DIA. .2420 MIN.
PITCH DIA. .2149 + .0033
MINOR DIA. .1969 + .0045
.725 ± .010
.240 ± .015
.295 ± .010
.39 ± .02
30°
90°
45°
ANGULAR MILL CUT
1.89 ± .02 NORMAL MILL CUT
2.05 ± .02
1.115 -.030
.630 DIA. ± .005
.350 REAM + .003
1.81 -.01
.675 -.005
.782 + .020
.075 R.
.31 + .01
.05 -.01
RECEIVER D6535512
FINISH
MANUFACTURING COMPONENT
REF. DRG. A.O.C.-45-1-2
SCALE 1/1
D6535512
DECEMBER 31, 1941
REVISIONS
1 12-30-43
2 10-22-51
CLASS
DIVISION
DRAWING
FILE
SYMBOL
D'FTSMAN
TRACER
L'D'G. D'FTSMAN
CHECKER
CHIEF D'FTSMAN
SUBMITTED:-
L.T. COL. ORD. DEPT. U.S.A.
EXAMINED:-
ORD. DEPT. U.S.A.
COL. ORD. DEPT. U.S.A.
DWG. PERTAINS TO
51-63 .45-S MG-M28 A1
E4383 RECEIVER ASSEMBLY
D35512
ORDNANCE OFFICE, WAR DEPT.
SUPERSEDES D35512
TOLERANCE ± .005 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.