5508146 - Tube, Oil Buffer.c4

C5508146

HEAT TREATMENT & FINAL FINISH

1. HEAT TREATMENT: WITH TEMPORARY SCREWS IN HOLES, CARBURIZE AT 1550–1600°F TO A CASE DEPTH OF .003–.010. OIL QUENCH. TEMPER 1 HOUR MINIMUM TO A HARDNESS OF HRA 79–82.

(27) (38) (A1)

SYM	REVISION	DATE	APPROVED
C	SEE ERR HQR 40639	18 FEB 75	
D	NOR L1S2092/010514	010606	HJS
E	NOR L2S2137 030210	030415	TPT
F	NOR L3S3100/030425	030513	HJS

38 A4 B1 — MATERIAL CHANGED 10-26-81 — REF. FOR NOR 2000 B-1

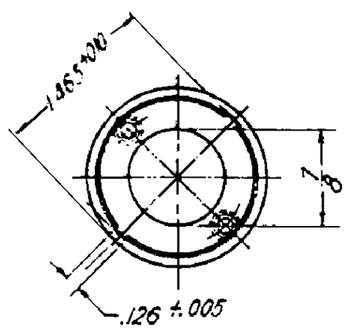
PHYSICAL PROPERTIES		DEC. 1, 1926 REVISIONS			
Y.P.		22	6-26-42	30A	2-18-44
T.S.		23A	9-3-42	31A	4-17-44
EL.2		24A	9-25-42	32A	5-3-44
RED.		25A	7-6-43	33A	9-5-44
BR.		26A	11-16-43	34A	4-20-45
		27A	12-18-43	35A	6-14-45
ROCK.		28A	1-15-44	36A	4-12-46
HARDNESS	FILE HARD	29A	2-1-44	37A	7-12-46

DRG. PERTAINS TO

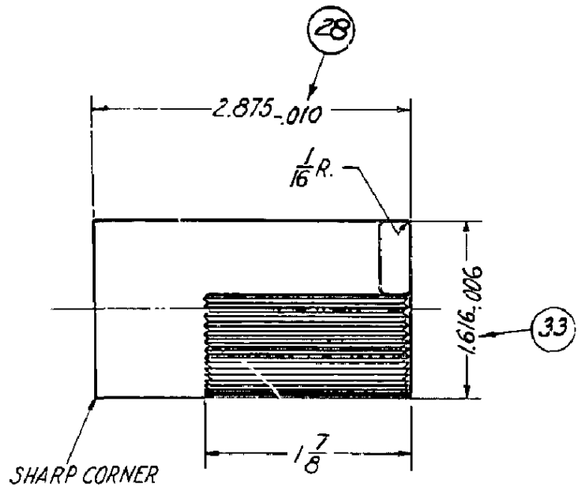
MG CAL .30 XM218, XM213
GUN, ACFT, CAL .50 GAU-8/A

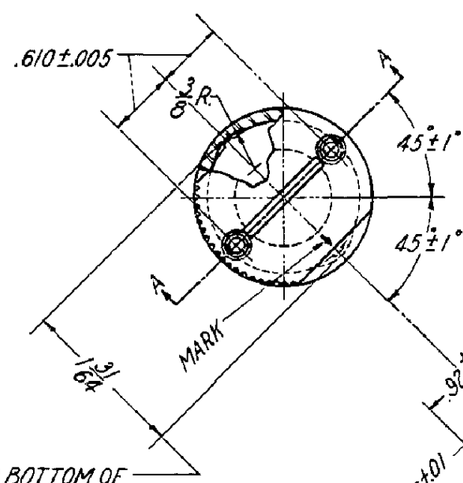
51-60	.50 BMG-M2 WC (FLEX)
05504077	
51-82	.50 BMG-M2 AC BASIC
51-88	.50 BMG-M2 AC (FLEX)
C4077	BUFFED OIL GROUND

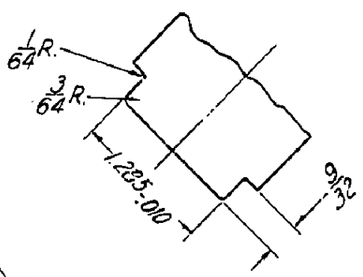
(38) (B1) (C) (37) (27) (36) (35) (34) (27)

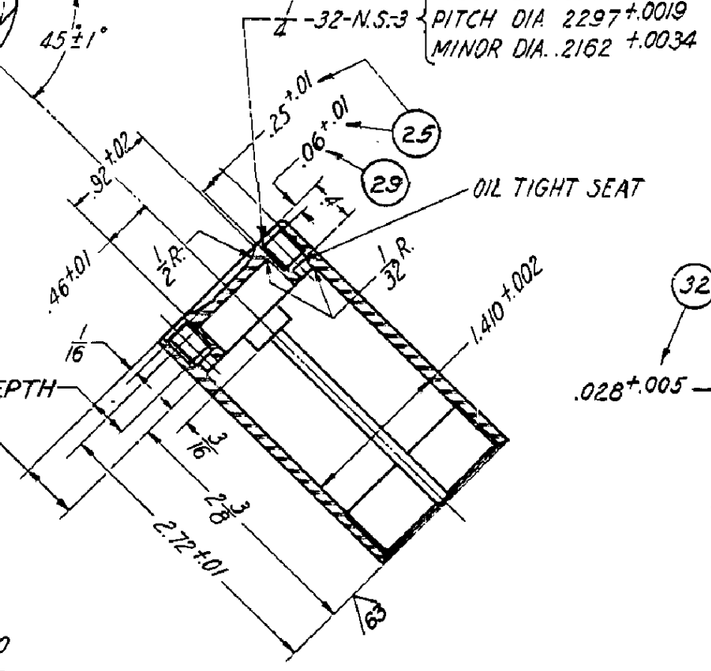


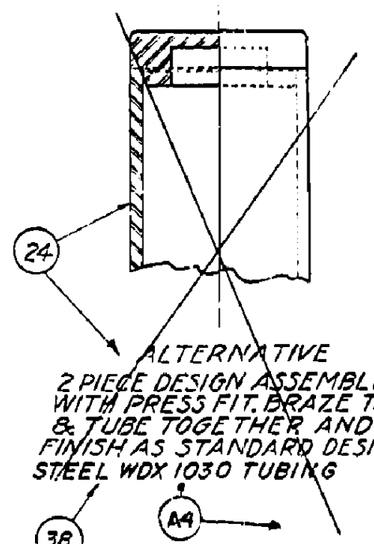
(28)

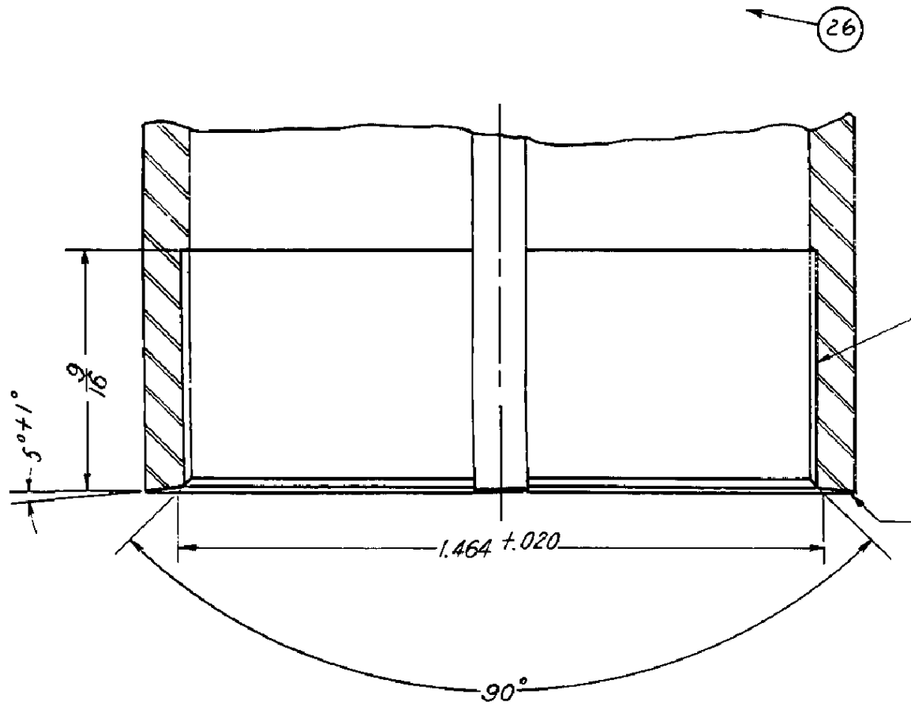


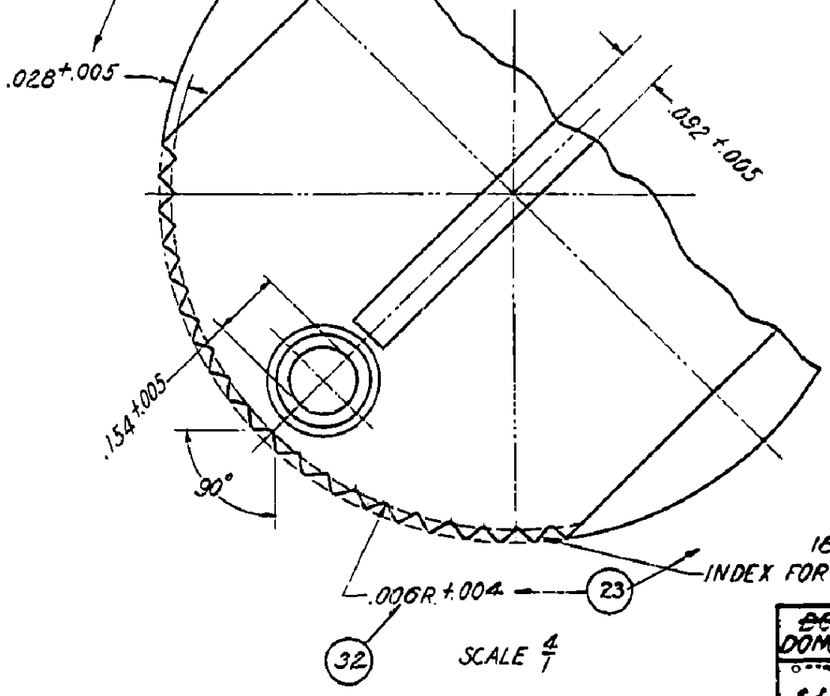












1.44-32-N.S. { MAJOR DIA. 1.4400 MIN. / PITCH DIA. 1.4197 +.0040 / MINOR DIA. 1.4130 +.0030 } (24)

THIS SURFACE TO BE FINISHED AFTER HEAT TREATING LOCATING FROM THE 1.44-32 THREAD. (26) (27)

TUBE, OIL BUFFER (37) 5508146 ~~C 8146-33~~

(27) (A2) (24) (23) (25) (28) (29) (30) (31) (32) (33) (37)

ALLOY STEEL BAR, ASTM A108 OR ASTM A576, GRADE 1018 OR 1020.
FINISH 125/ OTHER SURFACES AS SPECIFIED (38)

TOLERANCE ±.01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.
SUPERSEDES OLD TRACING C 8146 UNDER REVISION DATE OF JUNE 26, 1942.

NOTICE: THIS DRAWING SHALL NOT BE USED OR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

CURRENT DESIGN ACTIVITY CAGE CODE 19200
U.S. ARMY
ARMAMENT RESEARCH, DEVELOPMENT AND ENGINEERING CENTER
PICATINNY ARSENAL, NEW JERSEY 07806-5000

(38) (A3) SCALE 1/1 (37) C 5508146 ~~C 8146~~

DO NOT INSCRIBE PART NO.

ORDNANCE DEPT U.S.A.