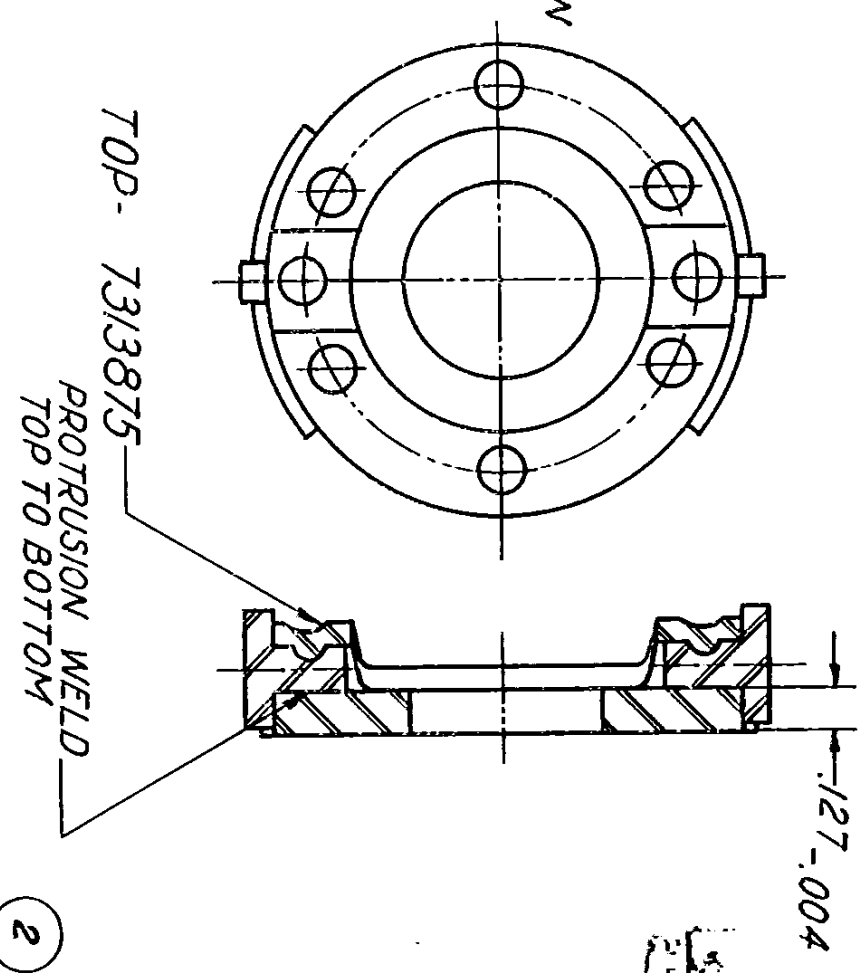
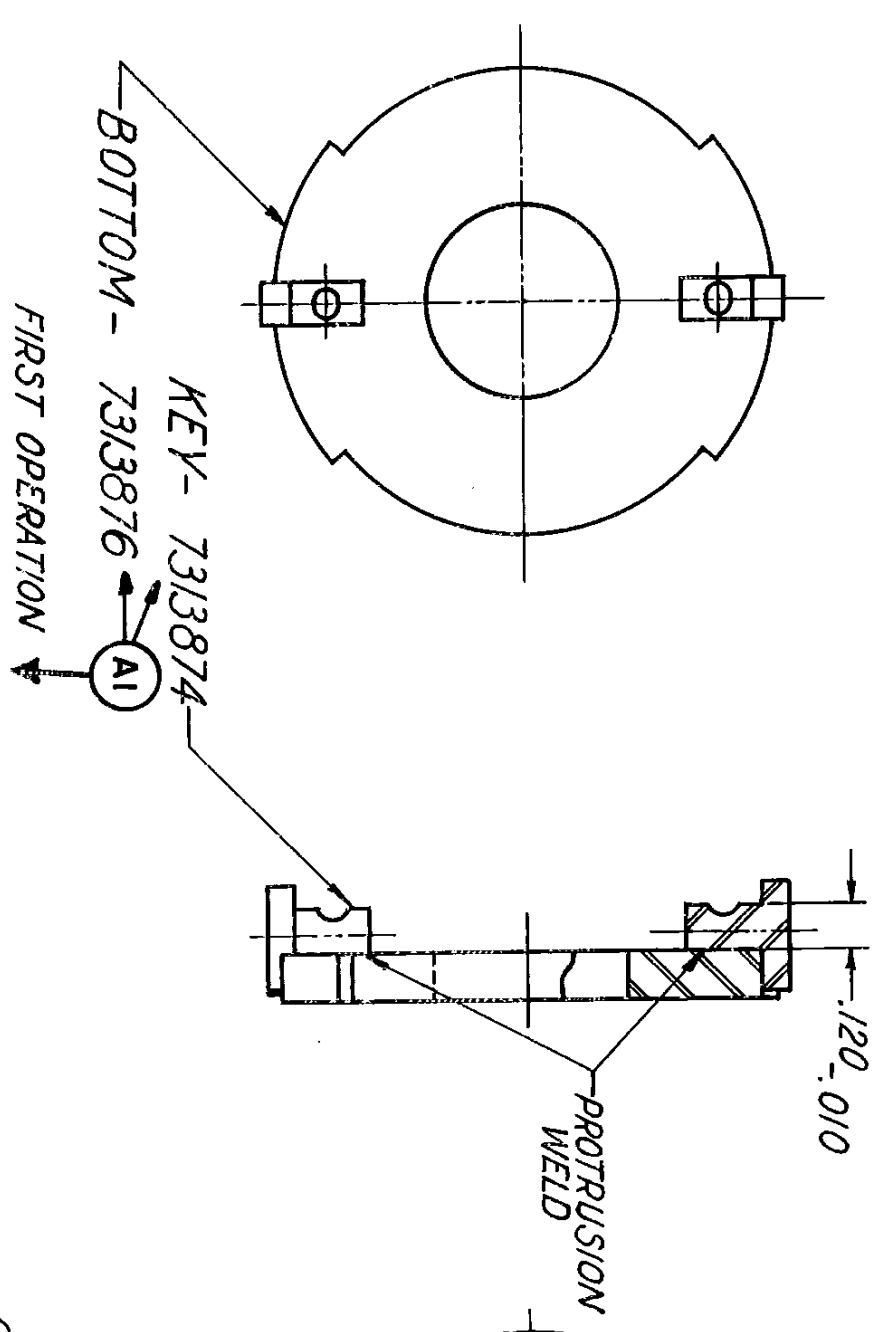


FORM NO. SPOBD-441
20 JUNE 45 E



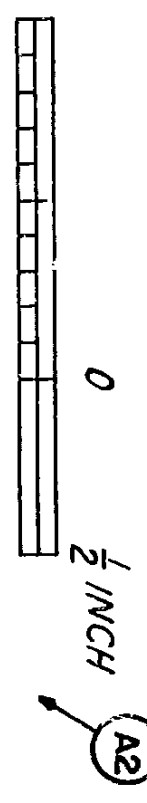
COPPER BRAZE TOP TO BOTTOM AFTER PROTRUSION WELD. IF BRAZING FURNACE IS NOT CONTROLLED TO PREVENT DECARBURIZING, THE KEYS SHOULD BE COPPER PLATED .0003 TO .0005 THICK

LIST OF COMPONENTS			
1	2	3	4
LINE NUMBER	DRAWING NUMBER OR PIECE MARK	NAME OF COMPONENT	NO. REQUIRED PER UNIT ASM.
1	B 7313877	VALVE, OIL-BUFFER PISTON, ASM (2ND. ALTERNATIVE)	1
2	B 7313876	COMPOSED OF:- 1-BOTTOM, OIL BUFFER PISTON VALVE	
3	A 7313874	2-KEY, OIL BUFFER PISTON VALVE	
4	B 7313875	1-TOP, OIL BUFFER PISTON VALVE	

FOR LIST OF PARTS, SEE EPL 7313877
WITH A 7313874, B 7313875 AND B 7313876 SUPERSEDES C113713 AND WITH B 8969
SUPERSEDES B 8969 WITHOUT CHANGE MARCH 15, 1946.

VALVE, OIL BUFFER PISTON, ASSEMBLY 7313877

2ND. ALTERNATIVE DESIGN
FOR STANDARD DESIGN SEE B6008969



INVENTOR: [Signature]

B 7313877
MARCH 15, 1946

NO.	DATE	REVISIONS	NO.	DATE
1	1-14-49			
2	8-23-49			
A2	SEE E67 HORD			
B1	DOUGLAS 4 AUG 50			
C	SEE ERR HOR 40639			

MAINT. 18 FEB 75

HEAT TREATMENT & PROTECTIVE FINISH	
HEAT AT 1500°F IN SALT OR CONTROLLED ATMOSPHERE. OIL QUENCH. TEMPER 20 TO 30 MINUTES AT APPROX 800°F. HARDNESS OF KEY - ROCKWELL D 54-60. PROTECTIVE FINISH 581.2.5.2.2 OF MIL-STD-171	
PHYSICAL PROPERTIES	MAJOR ITEM
V.P.	51-68 50B MG-M210000
T.S.	51-82 50B MG-M210000
EL. 2	64077 GUN ACFT, CAL 50
RED	03504077 GAU-107A
BR.	M6 CR. 50, JMB
DO NOT INSCRIBE PART NO.	XM213
SCALE	CHECKED [Signature]
TOLERANCES & DIMENSIONS EXCEPT AS NOTED	TRACED [Signature]
FROM PIN SURFACES	ENGINEER [Signature]
DECIMAL	1/16
FRACTIONAL	1/32
ANGULAR	30°
FROM LIFTING SURFACES	
FRACTIONAL	
ANGULAR	
APPROVED BY ORDER OF THE CHIEF OF ORDNANCE	[Signature]
SHARP CORNERS AND EDGES BROKEN TO APPROX.	
APPROX.	
B 7313877	ORDNANCE DEPT. U.S.A.

MADE AT SPRINGFIELD ARMORY