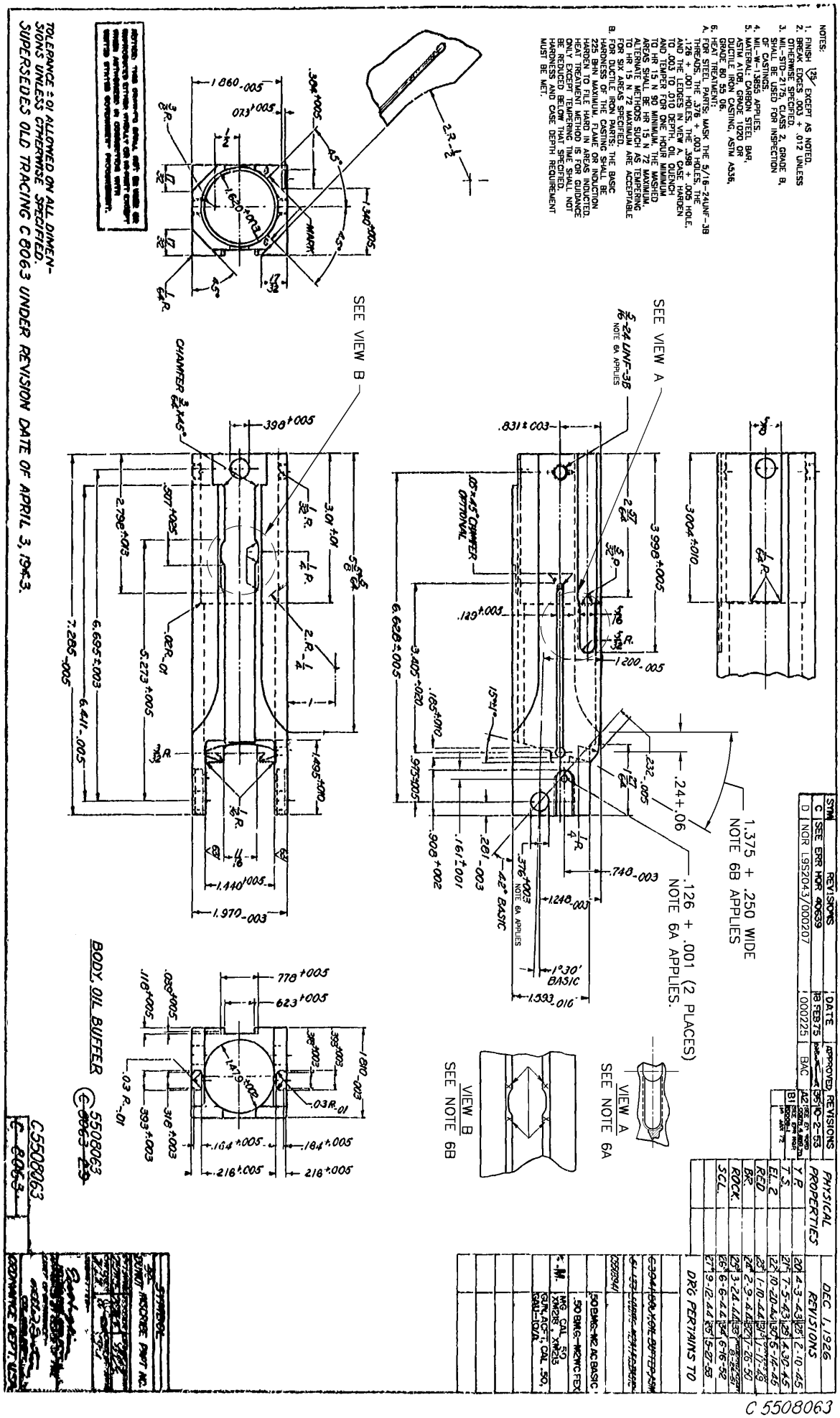
NOTES:
1. FINISH 125 EXCEPT AS NOTED.
2. BREAK EDGES .003 +.012 UNLESS OTHERWISE SPECIFIED.
3. MIL-STD-2175, CLASS 2, GRADE B, SHALL BE USED FOR INSPECTION OF CASTINGS.
4. MIL-W-13855 APPLIES.
5. MATERIAL: CARBON STEEL BAR, ASTM A108, GRADE 1020 OR DUCTILE IRON CASTING, ASTM A536, GRADE 80 55 06.
6. HEAT TREATMENT:
A. FOR STEEL PARTS: MASK THE 5/16-24UNF-3B THREADS, THE .376 +.003 HOLES, THE .128 +.001 HOLES, THE .398 +.005 HOLE, AND THE LEDGES IN VIEW A. CASE HARDEN TO .003 TO .010 DEPTH, OIL QUENCH AND TEMPER FOR ONE HOUR MINIMUM TO HR 15 N 90 MAXIMUM. THE MASKED AREAS SHALL BE HR 15 N 72 MAXIMUM. ALTERNATE METHODS SUCH AS TEMPERING TO HR 15 N 72 MAXIMUM ARE ACCEPTABLE FOR SIX AREAS SPECIFIED.
B. FOR DUCTILE IRON PARTS: THE BASIC PROPERTIES OF THE CASTING SHALL BE 225 BRINELL MINIMUM OR AS NECESSARY TO HARDEN TO FILE HARD IN AREAS INDUCTION HEAT TREATMENT METHOD IS FOR GUIDANCE ONLY EXCEPT TEMPERING TIME SHALL NOT BE REDUCED BELOW THAT SPECIFIED. HARDNESS AND CASE DEPTH REQUIREMENT MUST BE MET.
SEE VIEW A
SEE VIEW B
CHAMFER .398 X 45°
5/16-24 UNF-3B NOTE 6A APPLIES
.831 ±.003
3.998 ±.005
3.004 ±.010
.128 ±.005
1.200 -.005
.185 ±.010
3.405 ±.020
6.628 ±.005
.975 ±.005
.908 ±.002
.161 ±.001
.261 -.003
.376 +.003 NOTE 6A APPLIES
.748 -.003
1.248 -.003
1.393 .016
1°30' BASIC
42° BASIC
.232 -.005
.24 ±.06
1.375 ±.250 WIDE NOTE 6B APPLIES
.126 ±.001 (2 PLACES) NOTE 6A APPLIES.
VIEW A SEE NOTE 6A
VIEW B SEE NOTE 6B
1.860 -.005
.304 +.005
.073 +.005
1.620 +.003
1.340 +.005
MARK
2.R-1/2
3/8 R.
1/64 R.
3.01 ±.01
2.738 ±.003
.907 +.025
.062 R.-.01
5.273 ±.005
6.695 ±.003
6.411 -.005
7.285 -.005
1.495 +.010
1.440 +.005
1.970 -.003
1/16 R.
1/4 R.
2.R.-1/4
1
.778 +.005
.623 +.005
.089 +.005
.116 +.005
.393 +.003
.316 +.003
1.819 +.002
1.810 -.023
.03 R.-.01
.164 +.005
.216 +.005
BODY, OIL BUFFER
5508063
8063-29
C 8063
C5508063
TOLERANCE ± .01 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED.
SUPERSEDES OLD TRACING C 8063 UNDER REVISION DATE OF APRIL 3, 1943.
STM
C SEE ERR HOR 40639
D NOR L9S2043/000207
DATE
18 FEB 75
1 000225
BAC
APPROVED REVISIONS
A2 SEE SHT 2 ADD DIM
B1 ADD DIM
PHYSICAL PROPERTIES
Y.P.
T.S.
EL. 2
RED
BR.
ROCK.
SCL.
DEC. 1, 1926
REVISIONS
DRG PERTAINS TO
.50 BMG-M2 AC BASIC
.50 BMG-M2 MCMC FLEX
M1 CAL .50 M2 CAL .50 M23 CAL .50
SAE-10A
ORDNANCE DEPT. U.S.
C 5508063