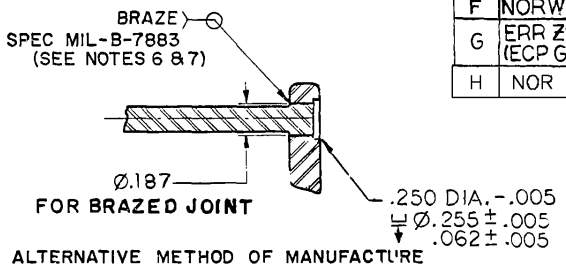
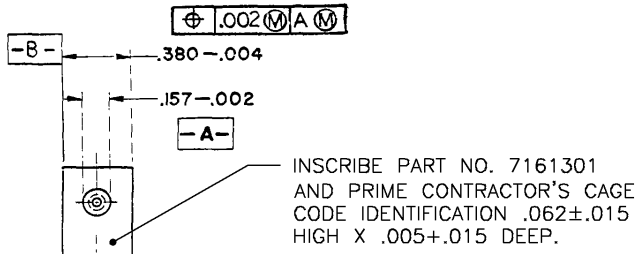
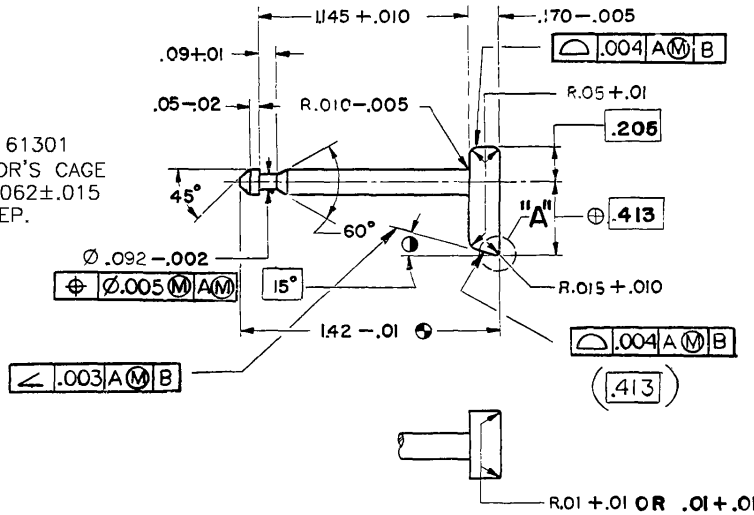
NOTES:
1. FINISH 125 ALL OVER.
2. BREAK EDGES .003+.007 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, ASTM A322 OR A331: 6150, 8645 OR 8650.
4. HEAT TREATMENT: HEAT AT 1550° TO 1600°F. OIL QUENCH. TEMPER 1 HOUR MINIMUM TO HARDNESS SPECIFIED.
5. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
6. BRAZING MATERIAL: BRAZING ALLOY SPEC QQ-B-650; CMPSN BCu-1.
7. BRAZED JOINT SHALL WITHSTAND A GRADUALLY APPLIED AXIAL LOAD OF 1000 POUNDS WITHOUT FAILURE.
8. MIL-W-13855 AND ANSI Y14.5M-1982 APPLIES.

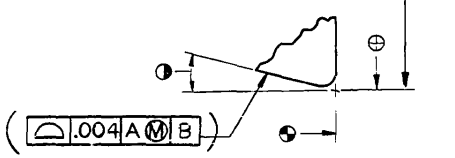
REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
A	REDRAWN WITH CHANGE SEE EO SA 29355	17 FEB 67	
B	SEE EO HQRD 00175	4 AUG 70	
C	(1) SEE ERR HQR 20008-1	14 JAN 72	
D	(4) SEE ERR HQR 40639	18 FEB 75	
E	(2) SEE ERR HQR 50655	1 OCT 75	
F	NORW8S3015 79-05-01	79-11-22	
G	ERR Z9Z1171P (ECP G8S2061/890419)	891010	
H	NOR L1S2100 011116	011212	RLV



ALTERNATIVE METHOD OF MANUFACTURE
ALL OTHER DIMENSIONS SAME AS BASIC DESIGN







VIEW AT "A"
SCALE 10/1

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

PART NO. 7161301

	GUN, ACFT,
	CAL .50,
	GAU-10/A
	MG CAL. 50:
	M2 HB FLEX,
	FXD, TT,
	MG CAL.50
D6528322	XM218,XM213

NEXT ASSY	USED ON
APPLICATION	
~~APPLY PART NO.~~	

MECHANICAL PROPERTIES	
YP	
TS	
EL 2	
RA	
BH	
RH	A 73.5-77.0

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON FRACTIONS ± DECIMALS ± ANGLES ± 1°
MATERIAL: SEE NOTES 3 & 6
HEAT TREATMENT: SEE NOTE 4
FINAL PROTECTIVE FINISH: SEE NOTE 5

ORIGINAL DATE OF DRAWING 1 JUN 44
DRAFTSMAN RZE CHECKER EK
TRACER RZE CHECKER EK
ENGINEER ENGINEER CB
SUBMITTED P.E.SULLIVAN
APPROVED V.A.LEWKKONEN

SPRINGFIELD ARMORY,
SPRINGFIELD, MA

STOP, ACCELERATOR

DWG SIZE	CODE IDENT NO.	
C	19205	7161301

SCALE 2:1 | UNIT WT | SHEET 1 OF 1

SWESP FORM NO. 1177-1
20 MAR 64 REV.

SCANNED DUPLICATE ORIGINAL

Accelerator Stop.c4