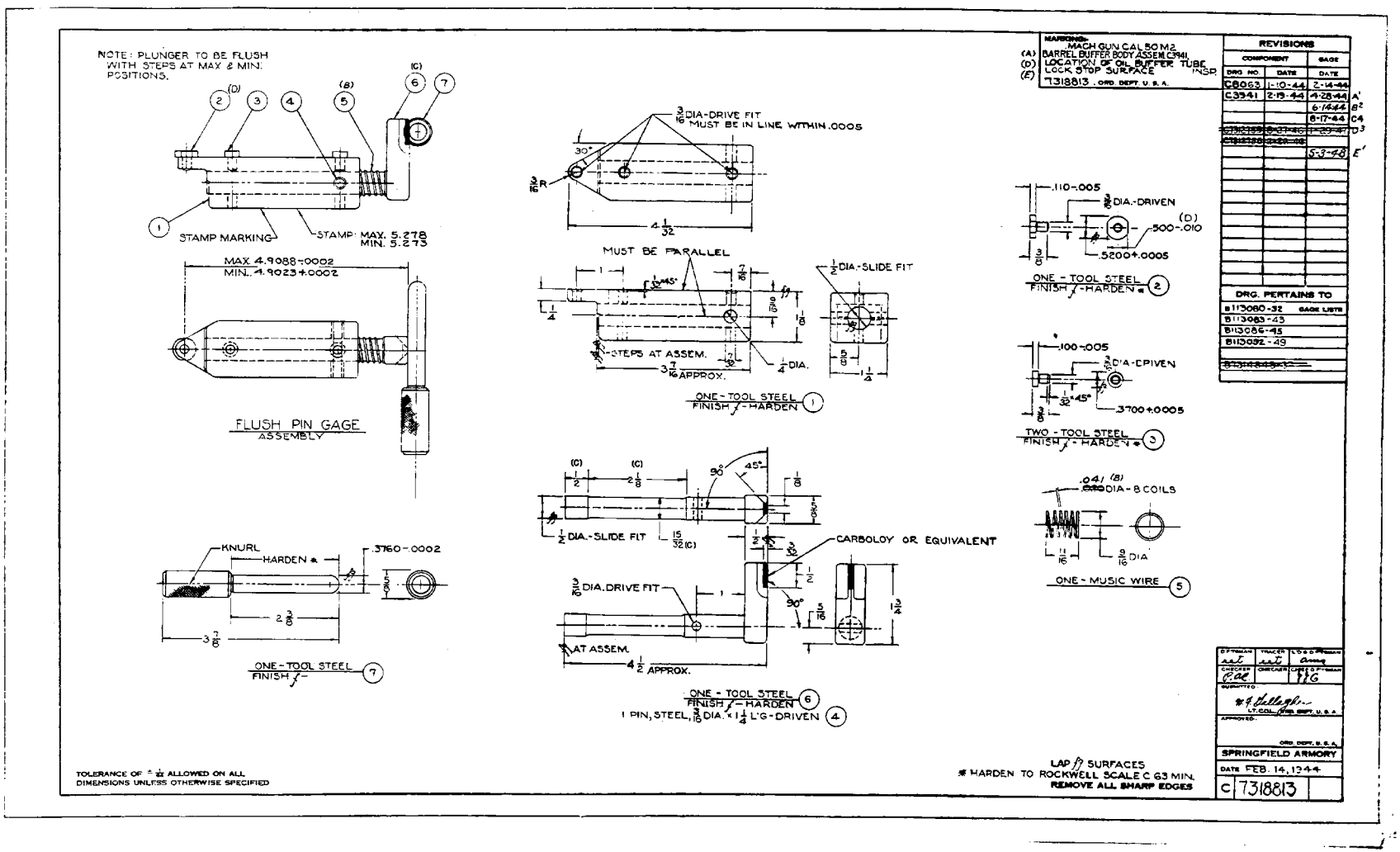
NOTE: PLUNGER TO BE FLUSH WITH STEPS AT MAX & MIN. POSITIONS.
STAMP MARKING
STAMP: MAX. 5.278 MIN. 5.273
MAX 4.9088-.0002
MIN. 4.9023+.0002
FLUSH PIN GAGE
ASSEMBLY
KNURL
HARDEN *
.3760-.0002
ONE-TOOL STEEL
FINISH f
3/16 DIA-DRIVE FIT
MUST BE IN LINE WITHIN .0005
MUST BE PARALLEL
1/2 DIA.-SLIDE FIT
STEPS AT ASSEM.
3 7/16 APPROX.
1/4 DIA.
ONE-TOOL STEEL
FINISH f-HARDEN
1/2 DIA.-SLIDE FIT
CARBOLOY OR EQUIVALENT
3/16 DIA. DRIVE FIT
AT ASSEM.
4 1/2 APPROX.
ONE-TOOL STEEL
FINISH f-HARDEN
1 PIN, STEEL, 3/16 DIA. x 1 1/4 L'G-DRIVEN
.110-.005
3/16 DIA.-DRIVEN
.500-.010
.5200+.0005
ONE-TOOL STEEL
FINISH f-HARDEN *
.100-.005
3/16 DIA-DRIVEN
.3700+.0005
TWO-TOOL STEEL
FINISH f-HARDEN *
.041 (B)
DIA-8 COILS
9/16 DIA
ONE-MUSIC WIRE
MARKING:
MACH GUN CAL 50 M2
(A) BARREL BUFFER BODY ASSEM. C3941
(D) LOCATION OF OIL BUFFER TUBE
(E) LOCK STOP SURFACE INSP.
7318813 . ORD. DEPT. U. S. A.
REVISIONS
COMPONENT
GAGE
DRG. NO.
DATE
DATE
C8063 1-10-44 2-14-44
C3941 2-19-44 4-28-44 A'
6-14-44 B2
8-17-44 C4
5-3-48 E'
DRG. PERTAINS TO
B113080-32 GAGE LISTS
B113083-43
B113086-45
B113092-49
SPRINGFIELD ARMORY
DATE FEB. 14, 1944
C 7318813
TOLERANCE OF ± 1/64 ALLOWED ON ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED
LAP f SURFACES
* HARDEN TO ROCKWELL SCALE C 63 MIN.
REMOVE ALL SHARP EDGES

gages.c4