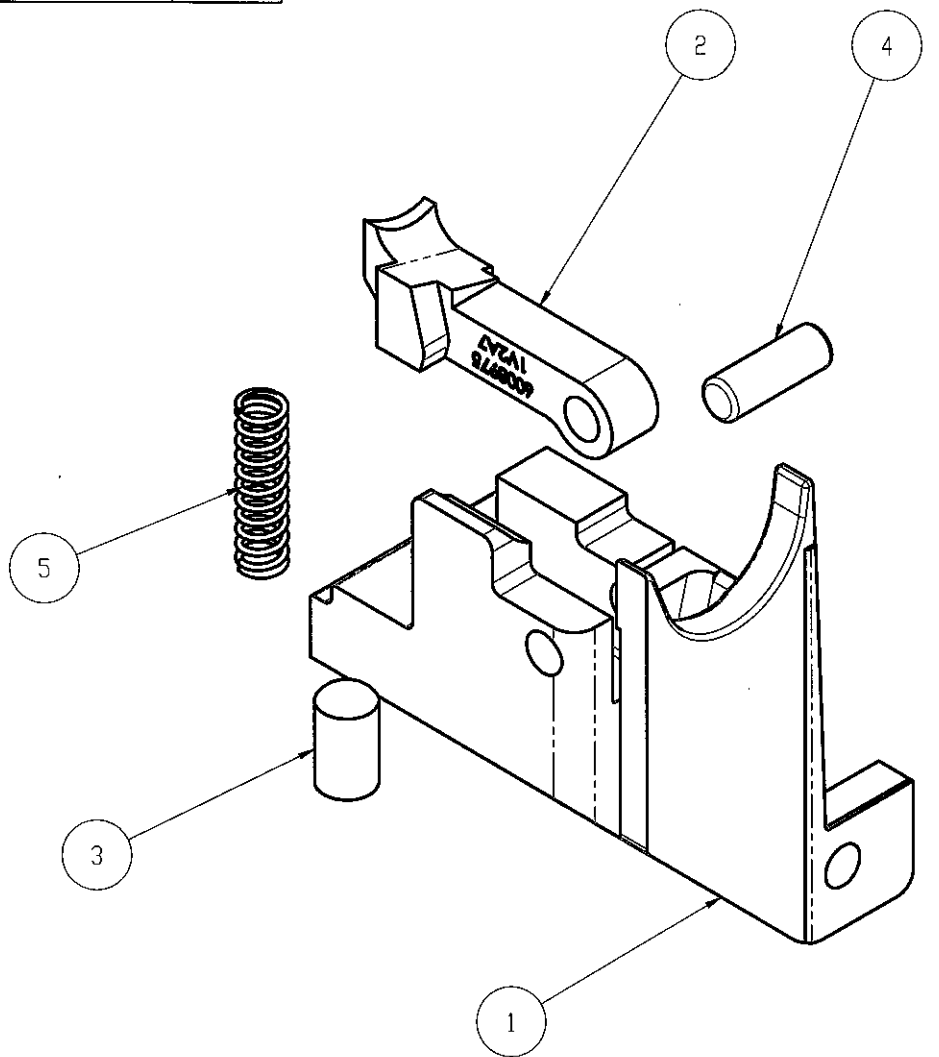


M-1597

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	M-1701 STOP, CARTRIDGE, REAR, RIGHT HAND (5577408)	STOP, CARTRIDGE, REAR, RIGHT HAND, 00W50BMG	1
2	M-1702 PAWL, ALIGNING, CARTRIDGE (6008975)	PAWL, ALIGNING, CARTRIDGE, 00W50BMG	1
3	M-1703 PLUNGER, CARTRIDGE ALIGNING PAWL (5013611)	PLUNGER, CARTRIDGE ALIGNING PAWL, 00W50BMG	1
4	M-1704 PIN, STRIGHT, HEADLESS (5013612)	PIN, STRAIGHT, HEADLESS, 00W50BMG	1
5	M-1705 SPRING, HELICAL COMPRESSION (5013613)	SPRING, HELICAL COMPRESSION, 00W50BMG	1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	CREATE DRAWING	6/1/2015	G. HERSHBERGER

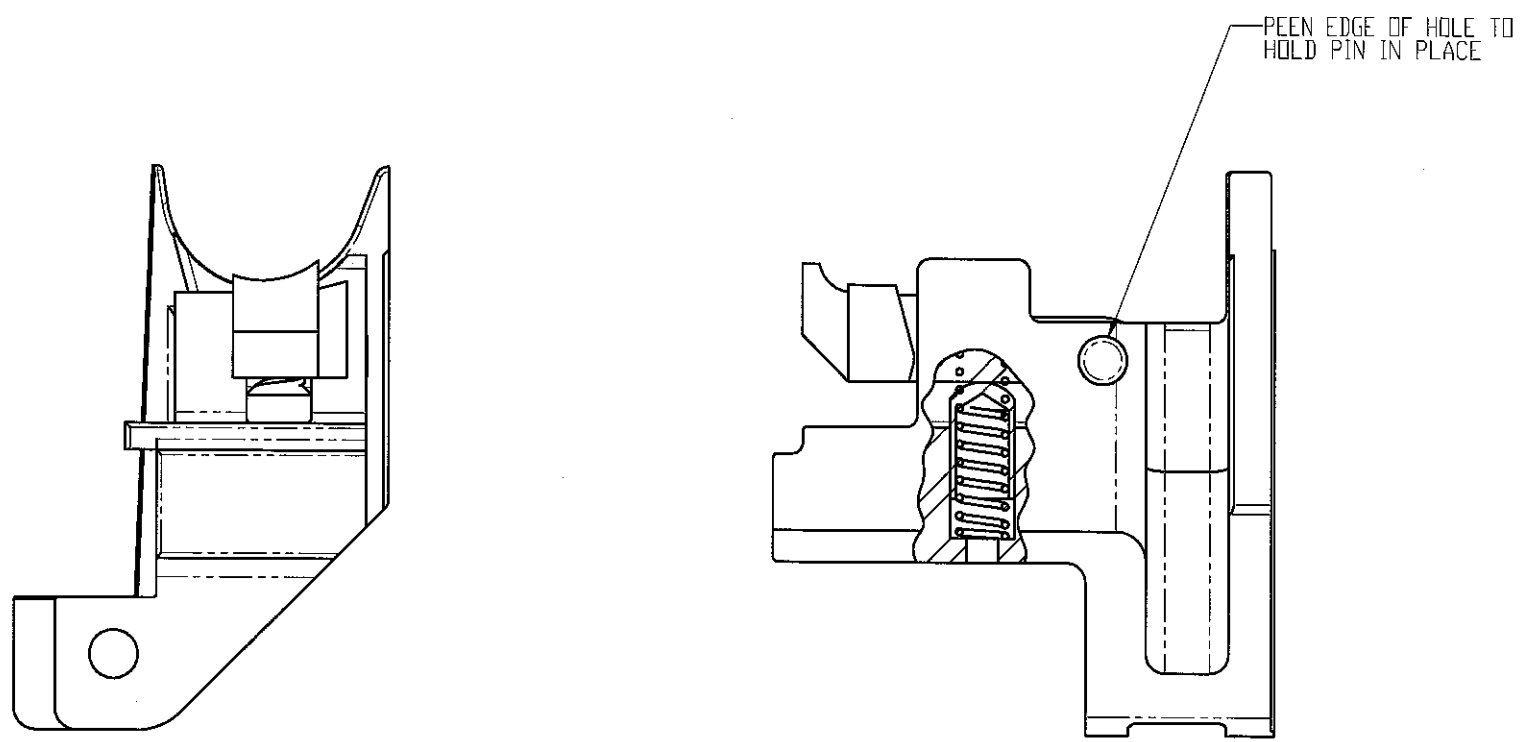


अप्रतिम रूप से मंजूरित
Provisionally Approved
24 AUG 2021
दिनांक
For Cmde (API)

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	DIMENSIONS ARE IN MM/INCHES ALL THREAD DIM ARE IN INCHES	DRAWN	PMD		05/10/15
	TOLERANCES: FRACTIONAL ANGULAR MACH ± BEND TWO PLACE DECIMAL ±0.25 THREE PLACE DECIMAL ±0.127	CHECKED			
	INTERPRET GEOMETRIC TOLERANCING PER MATERIAL	ENG APPR.			
	FINISH	DA.			
	DO NOT SCALE DRAWING	COMMENTS:			
		SIZE	5577409	REV A	
		SCALE: 2:1	WEIGHT:	SHEET 1 OF 2	

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
-	-	See Sheet 1	-	-

M-1100



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	DIMENSIONS ARE IN MM/INCHES ALL THREAD DIM. ARE IN INCHES	DRAWN	PHD		05/10/15
	TOLERANCES: FRACTIONAL	CHECKED			
	ANGULAR MACH ± BEND TWO PLACE DECIMAL ±0.25 THREE PLACE DECIMAL ±0.127	ENG APPR.			
	INTERPRET GEOMETRIC TOLERANCING PER:	Q.A.			
	MATERIAL	COMMENTS:			
	FINISH				
	DO NOT SCALE DRAWING				

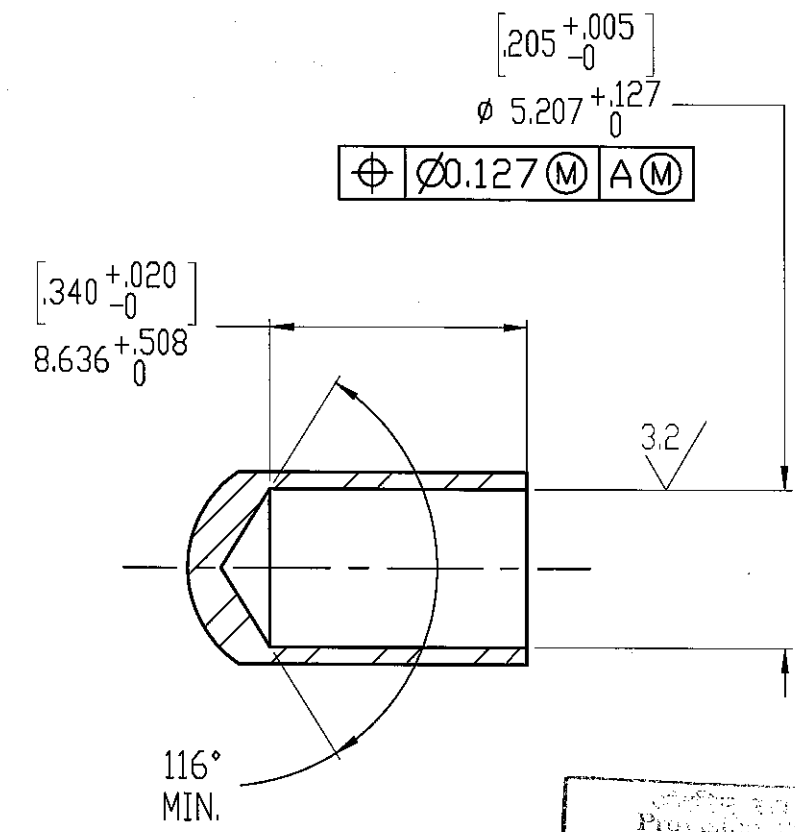
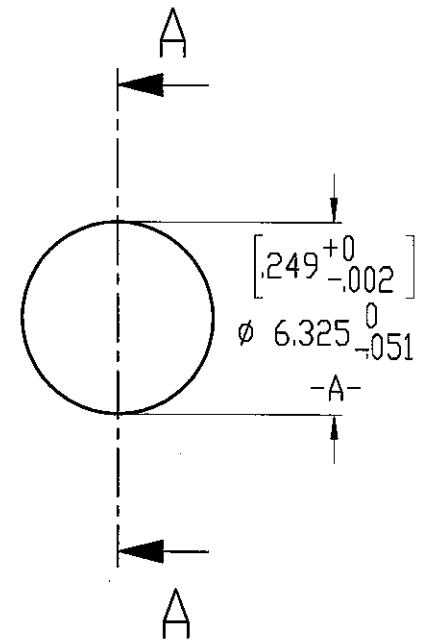
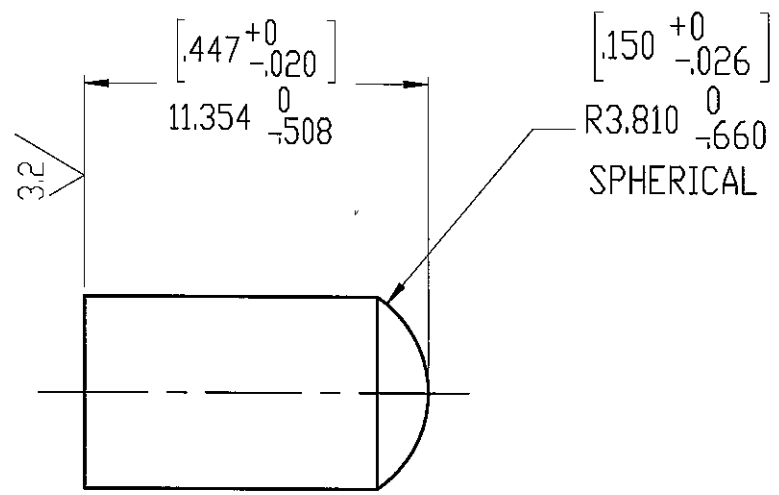
SIZE	REV
C 5577409	A
SCALE: 2:1	WEIGHT:
SHEET 2 OF 2	

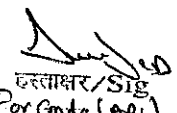
M-1000

NOTES:

1. FINISH $\sqrt{1.6}$ EXCEPT AS NOTED.
2. BREAK EDGES 0.076 + 0.127 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT: HEAT AT 87°C. QUENCH IN OIL. TEMPER 1 HOUR MINIMUM TO HARDNESS SPECIFIED (RH C55-60).
4. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
5. ASME Y14.5M-1994 APPLIES.
6. MATERIAL: TOOL STEEL, ASTM A681: TYPE S1 THRU S7 OR TYPE O1 THRU O7.

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	CREATE DRAWING	6/1/2015	G. HERSHBERGER




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 दिनांक: _____
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 For Gndr (AP1)

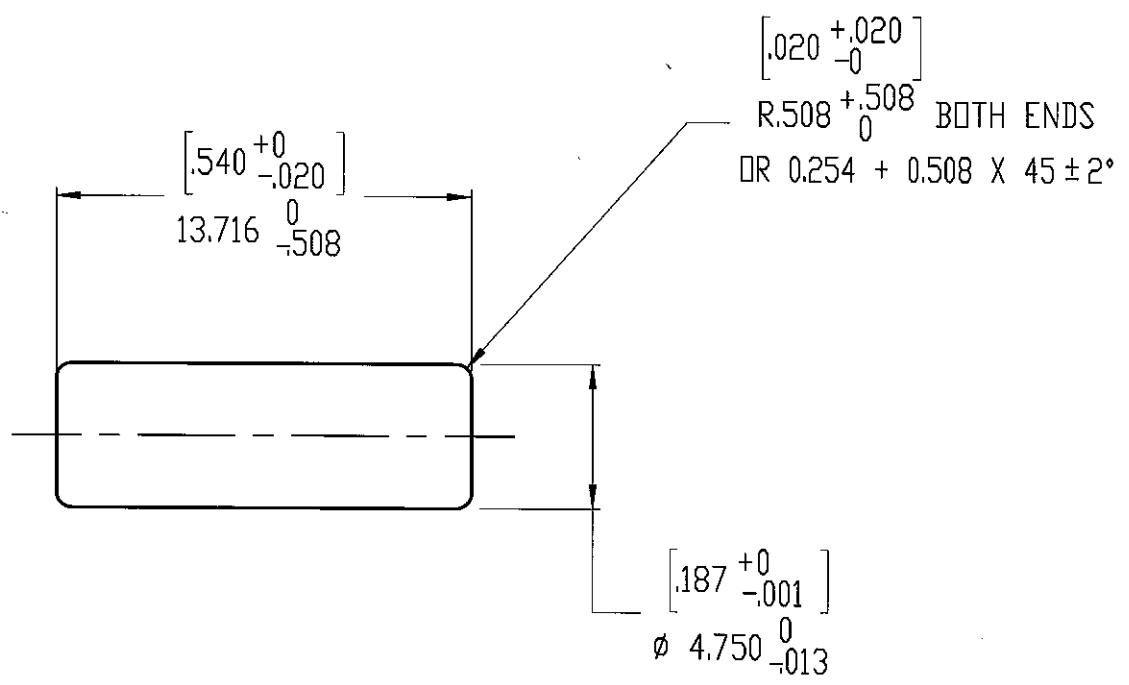
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	INTERPRET GEOMETRIC TOLERANCING PER:	DRAWN: PMD CHECKED: ENG APPR.: MFG APPR.:		SIZE: B REV: A
	MATERIAL: FINISH:	Q.A.: COMMENTS:		SCALE: 4:1 WEIGHT:
	DO NOT SCALE DRAWING	SHEET 1 OF 1		

M-1504

NOTES:

1. FINISH $\sqrt{3.2}$ ALL OVER.
2. HEAT TREATMENT: SPEC MIL-H-6875. QUENCH AND TEMPER 1 HOUR MINIMUM TO HARDNESS SPECIFIED (RH 15N 82-86).
3. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
4. OMITTED.
5. MATERIAL: STEEL, ASTM A576: 1095 OR STEEL, ASTM A686: CLASS W1-8 THRU 10. GRADE C

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	CREATE DRAWING	6/1/2015	G. HERSHBERGER



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	INTERPRET GEOMETRIC TOLERANCING PER:	DRAWN:		SIZE: B
	MATERIAL:	CHECKED:		REV: A
	FINISH:	ENG APPR.:		SCALE: 4:1 WEIGHT: SHEET 1 OF 1

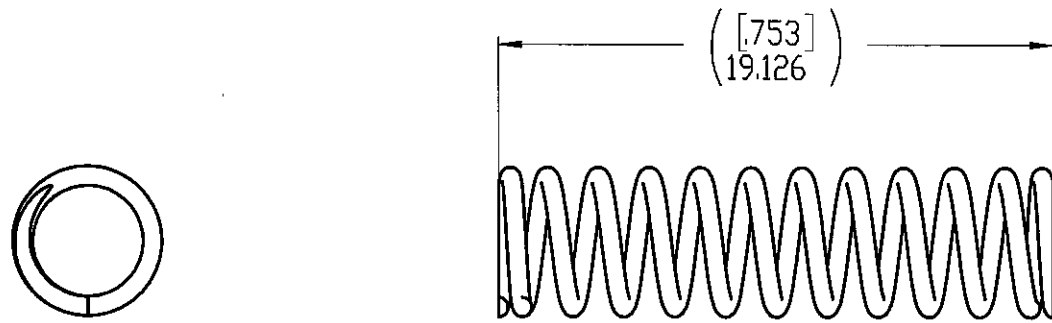
M-1000

NOTES:

1. HOLE DIA. INTO WHICH SPRING FITS FREELY - 5.207 MIN.
2. MANUFACTURE IN ACCORDANCE WITH MIL-S-13572, TYPE 1, GRADE A, EXCEPT THAT:
 - A. PARA 4.4.4.1 (PROCEDURE FOR REMOVING SET) SHALL NOT APPLY. PARA 4.4.4 (LOAD TEST) SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED SOLID FIVE (5) TIMES.
 - B. PARA 3.5.5 (SQUARENESS OF ENDS) SHALL NOT APPLY. SQUARED AND GROUND ENDS SHALL BE SQUARE WITH THE SPRING AXIS WITHIN ± 3
3. HEAT TREATMENT: STRESS RELIEVE AT $224^{\circ} \pm 5^{\circ}C$. FOR 30 MINUTES AFTER COILING.
4. FINAL PROTECTIVE FINISH: FINISH 3.3.1 OF MIL-STD-171 WITH MIL-PRF-3150 SUPPLEMENTARY OIL TREATMENT.
5. MATERIAL: WIRE, MUSIC, STEEL, ASTM A228.

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	CREATE DRAWING	6/1/2015	G. HERSHBERGER

WIRE DIAMETER - - - - - 0.660 \pm 0.01
 COIL DIAMETER (O.D.) - - - - - 5.131 - 0.152
 FREE-LENGTH - - - - - 19.126 REF.
 TOTAL COILS - - - - - 12 REF.
 DIRECTION OF HELIX - - - - - R.H.
 LOAD AT COMPRESSED LENGTH OF 15.748 - - - - - 0.771 Kg \pm 0.09 Kg
 LOAD AT COMPRESSED LENGTH OF 11.760 - - - - - 1.678 Kg \pm 0.181 Kg
 SPRING RATE - - - - - 0.228 Kg/mm REF.
 SOLID LENGTH - - - - - 8.026 MAX
 TYPE OF ENDS - - - - - CLOSED ENDS GROUND



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	DIMENSIONS ARE IN MM/(INCHES) ALL THREAD DIM. ARE IN INCHES	DRAWN	PMD		05/10/15
	TOLERANCES: FRACTIONAL ANGULAR: MACH \pm BEND TWO PLACE DECIMAL ± 0.25 THREE PLACE DECIMAL ± 0.127	CHECKED			
	INTERPRET GEOMETRIC TOLERANCING PER:	ENG APPR.			
	MATERIAL	MFG APPR.			
	FINISH	G.A.			
	DO NOT SCALE DRAWING	COMMENTS:			
		SIZE			
		B	5013613	REV A	
		SCALE: 4:1	WEIGHT:	SHEET 1 OF 1	

M-1601

NOTES:

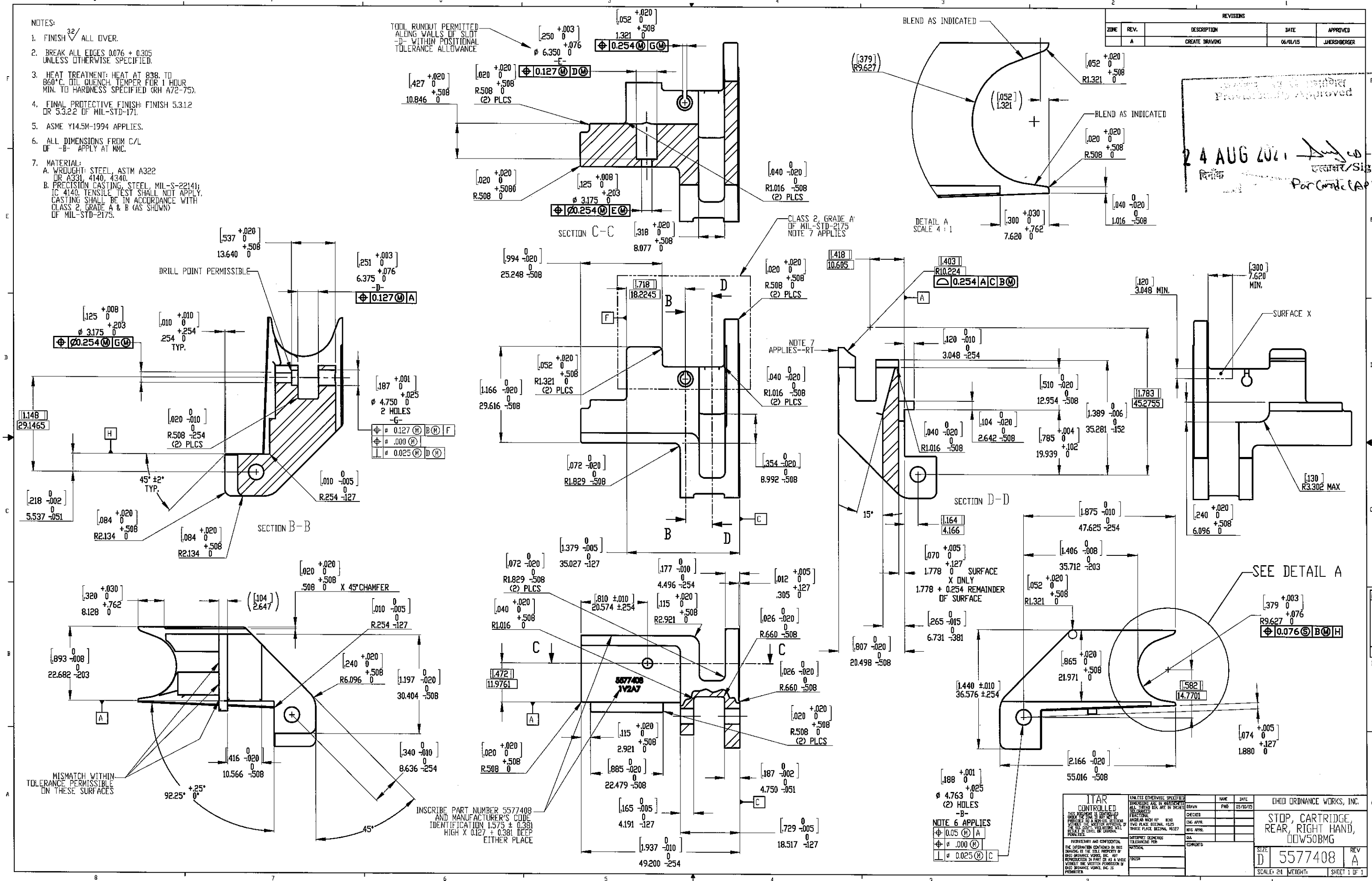
- FINISH $\sqrt{32}$ ALL OVER.
- BREAK ALL EDGES 0.076 + 0.305 UNLESS OTHERWISE SPECIFIED.
- HEAT TREATMENT: HEAT AT 838 TO 860°C, OIL QUENCH, TEMPER FOR 1 HOUR MIN. TO HARDNESS SPECIFIED (RH A72-75).
- FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
- ASME Y14.5M-1994 APPLIES.
- ALL DIMENSIONS FROM C/L OF -B- APPLY AT MMC.
- MATERIAL:
 - A. WROUGHT STEEL, ASTM A322 OR A331, 4140, 4340.
 - B. PRECISION CASTING, STEEL, MIL-S-22141, IC 4140. TENSILE TEST SHALL NOT APPLY. CASTING SHALL BE IN ACCORDANCE WITH CLASS 2, GRADE A & B (AS SHOWN) OF MIL-STD-2175.

TOOL ROUNDT PERMITTED ALONG WALLS OF SLOT -D- WITHIN POSITIONAL TOLERANCE ALLOWANCE

BLEND AS INDICATED

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
A		CREATE DRAWING	06/01/15	JHRSBERGER

24 AUG 2011
 24 AUG 2011
 24 AUG 2011
 24 AUG 2011
 24 AUG 2011

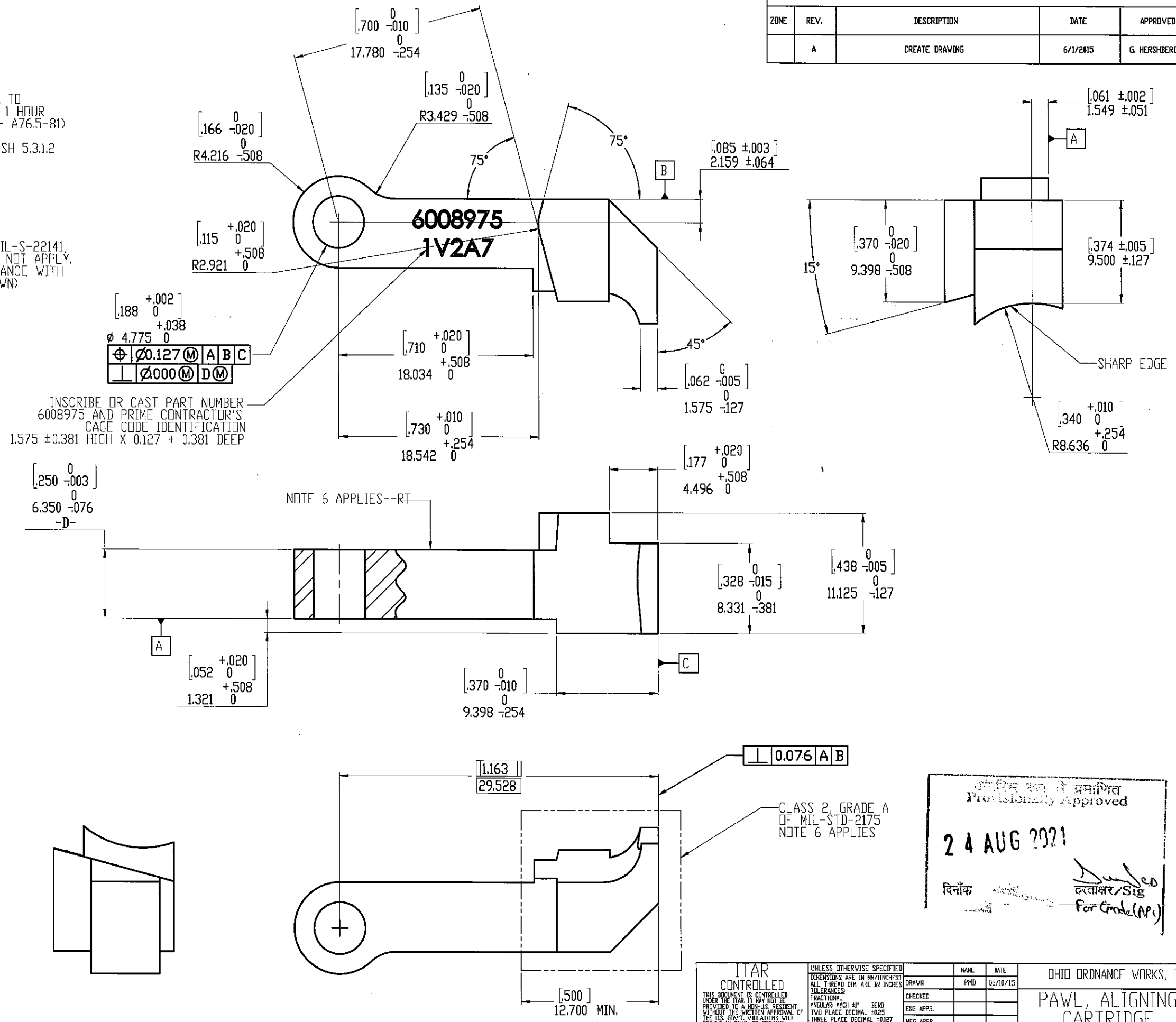


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	APPROVED FOR RELEASE	DATE	DATE	
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	CHECKED	DATE	DATE	
PROPERTY AND CONFIDENTIAL. THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF OHIO ORDNANCE WORKS, INC. ANY REPRODUCTION IN PART OR AS A WHOLE WITHOUT THE WRITTEN PERMISSION OF OHIO ORDNANCE WORKS, INC. IS PROHIBITED.	ENG. APPR.	DATE	DATE	SIZE
	MFG. APPR.	DATE	DATE	D 5577408
	DATE	DATE	DATE	SCALE: 2:1
	DATE	DATE	DATE	WEIGHT:
	DATE	DATE	DATE	SHEET 1 OF 1

NOTES:

1. FINISH $\sqrt{32}$ ALL OVER.
2. BREAK ALL EDGES 0.076 + 0.305 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT: HEAT AT 843 TO 871°C. OIL QUENCH. TEMPER FOR 1 HOUR MIN. TO HARDNESS SPECIFIED (RH A76.5-81).
4. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
5. ASME Y14.5M-1994 APPLIES.
6. MATERIAL:
 - A. WROUGHT: STEEL, ASTM A322 OR A331, 6150, 5160.
 - B. PRECISION CASTING, STEEL, MIL-S-22141; IC 6150. TENSILE TEST SHALL NOT APPLY. CASTING SHALL BE IN ACCORDANCE WITH CLASS 2, GRADE A & B (AS SHOWN) OF MIL-STD-2175.

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	CREATE DRAWING	6/1/2015	G. HERSHBERGER



INSCRIBE OR CAST PART NUMBER 6008975 AND PRIME CONTRACTOR'S CAGE CODE IDENTIFICATION 1.575 ±0.381 HIGH X 0.127 + 0.381 DEEP

NOTE 6 APPLIES--RT

CLASS 2, GRADE A OF MIL-STD-2175 NOTE 6 APPLIES

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	INTERPRET GEOMETRIC TOLERANCING PER: [] MATERIAL: [] FINISH: [] DO NOT SCALE DRAWING	CHECKED: [] ENG APPR: [] MFG APPR: [] D.A. COMMENTS: []		REV: A
	COMMENTS: []			REV: A
	COMMENTS: []			REV: A