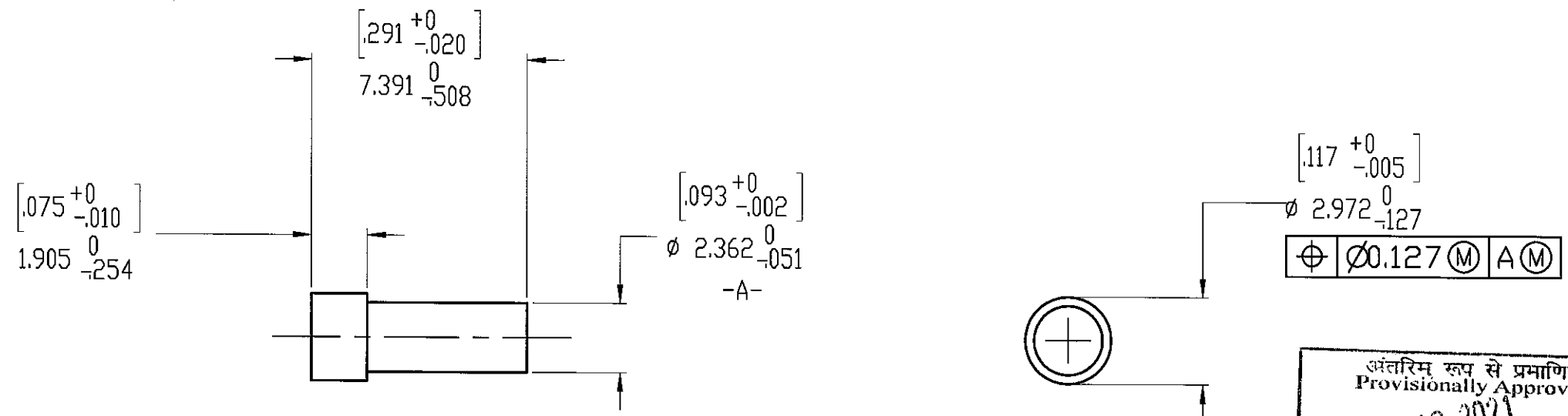


NOTES:

1. FINISH $\sqrt{3.2}$ ALL OVER.
2. BREAK EDGES 0.076 + 0.305 UNLESS OTHERWISE SPECIFIED.
3. MATERIAL: STEEL, ASTM A576: 1095, OR STEEL, ASTM A686, CLASS WI-8 THRU 9, GRADE C.
4. HEAT TREATMENT: HEAT AT 787 TO 816° C. OIL QUENCH. TEMPER ONE HOUR MINIMUM TO HARDNESS SPECIFIED (RH 15N 75-79).
5. OMITTED.
6. FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
7. ASME Y14.5M-1994 APPLIES.

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	CREATE DRAWING	07/13/15	J. HERSHBERGER
	B	UPDATED DRAWING	7/31/2015	G. HERSHBERGER



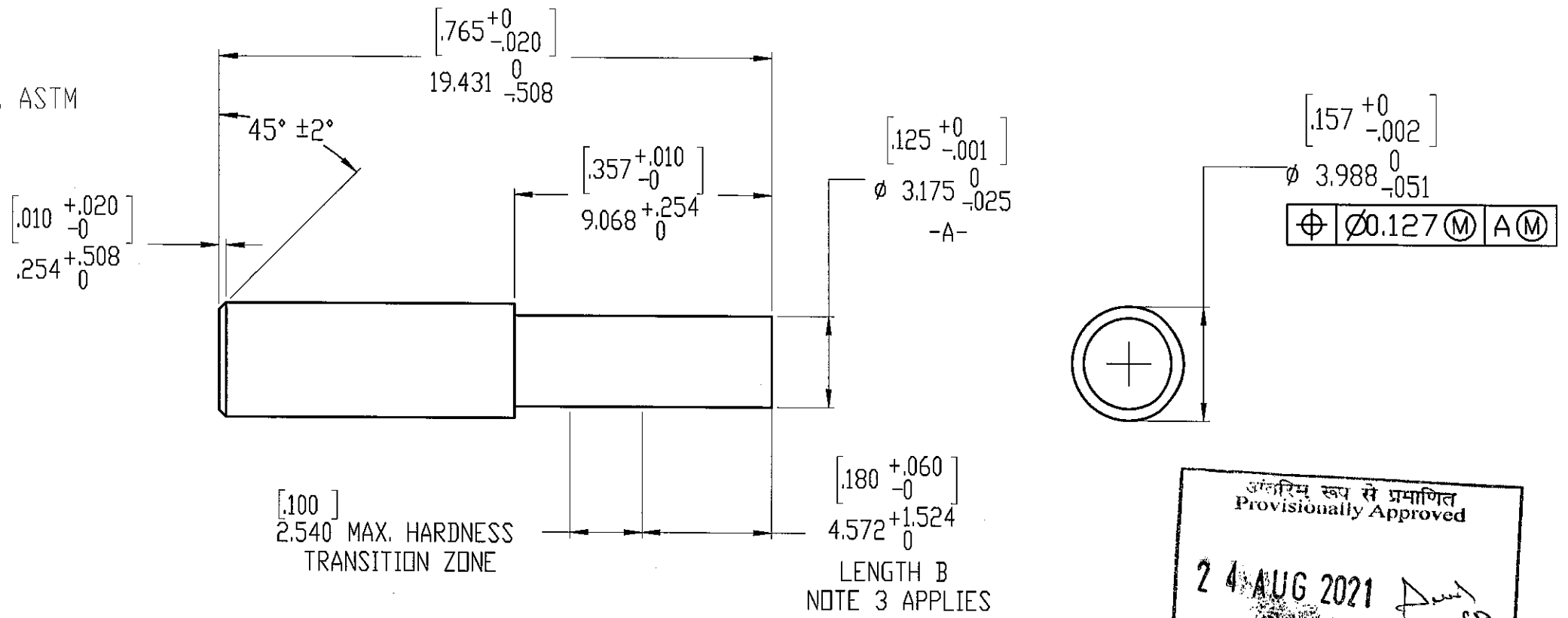
अंतरिम रूप से प्रमाणित
Provisionally Approved
24 AUG 2021
बिनांक
हस्ताक्षर/Sig
Rostmde (AP)

<p>ITAR CONTROLLED</p> <p>THIS DOCUMENT IS CONTROLLED UNDER THE ITAR. IT MAY NOT BE PROVIDED TO A NON-U.S. RESIDENT WITHOUT THE WRITTEN APPROVAL OF THE U.S. GOV'T. VIOLATIONS WILL RESULT IN CIVIL OR CRIMINAL PENALTIES.</p> <p>PROPRIETARY AND CONFIDENTIAL</p> <p>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.</p>	<p>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN MM/(INCHES) ALL THREAD DIM. ARE IN INCHES</p> <p>TOLERANCES:</p> <p>FRACTIONAL</p> <p>ANGULAR: MACH ± BEND</p> <p>TWO PLACE DECIMAL ±0.25</p> <p>THREE PLACE DECIMAL ±0.127</p>	<p>NAME</p> <p>DATE</p>	<p>DHIO ORDNANCE WORKS, INC.</p>	
	<p>INTERPRET GEOMETRIC TOLERANCING PER:</p> <p>MATERIAL</p> <p>FINISH</p> <p>DO NOT SCALE DRAWING</p>	<p>DRAWN</p> <p>CHECKED</p> <p>ENG APPR.</p> <p>MFG APPR.</p> <p>Q.A.</p> <p>COMMENTS:</p>	<p>PMD</p> <p>07/13/15</p>	<p>PIN, SHOULDER, HEADLESS, DDW50BMG</p>
			<p>SIZE</p> <p>B 5152898</p> <p>SCALE: 5:1</p>	<p>REV</p> <p>B</p> <p>WEIGHT:</p> <p>SHEET 1 OF 1</p>

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	CREATE DRAWING	7/22/2015	G. HERSHBERGER

NOTES:

- FINISH $\sqrt{3.2}$ ALL OVER.
- BREAK EDGES 0.076 + 0.305 UNLESS OTHERWISE SPECIFIED.
- HEAT TREATMENT: HARDEN AND TEMPER TO HARDNESS SPECIFIED (RH 15N 76.5-80).
LOCALLY TEMPER LENGTH B TO ROCKWELL 15N 72 MAX.
- ASME Y14.5M-1994 APPLIES.
- FINAL PROTECTIVE FINISH:
A. REPAIR PARTS: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
B. OTHER APPLICATIONS: FINISH AT ASSEMBLY.
- MATERIAL: STEEL, ASTM A576: 1095, OR STEEL, ASTM A686, CLASS W1-8 THRU 9, GRADE C.



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24 AUG 2021
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For Cmd (App)

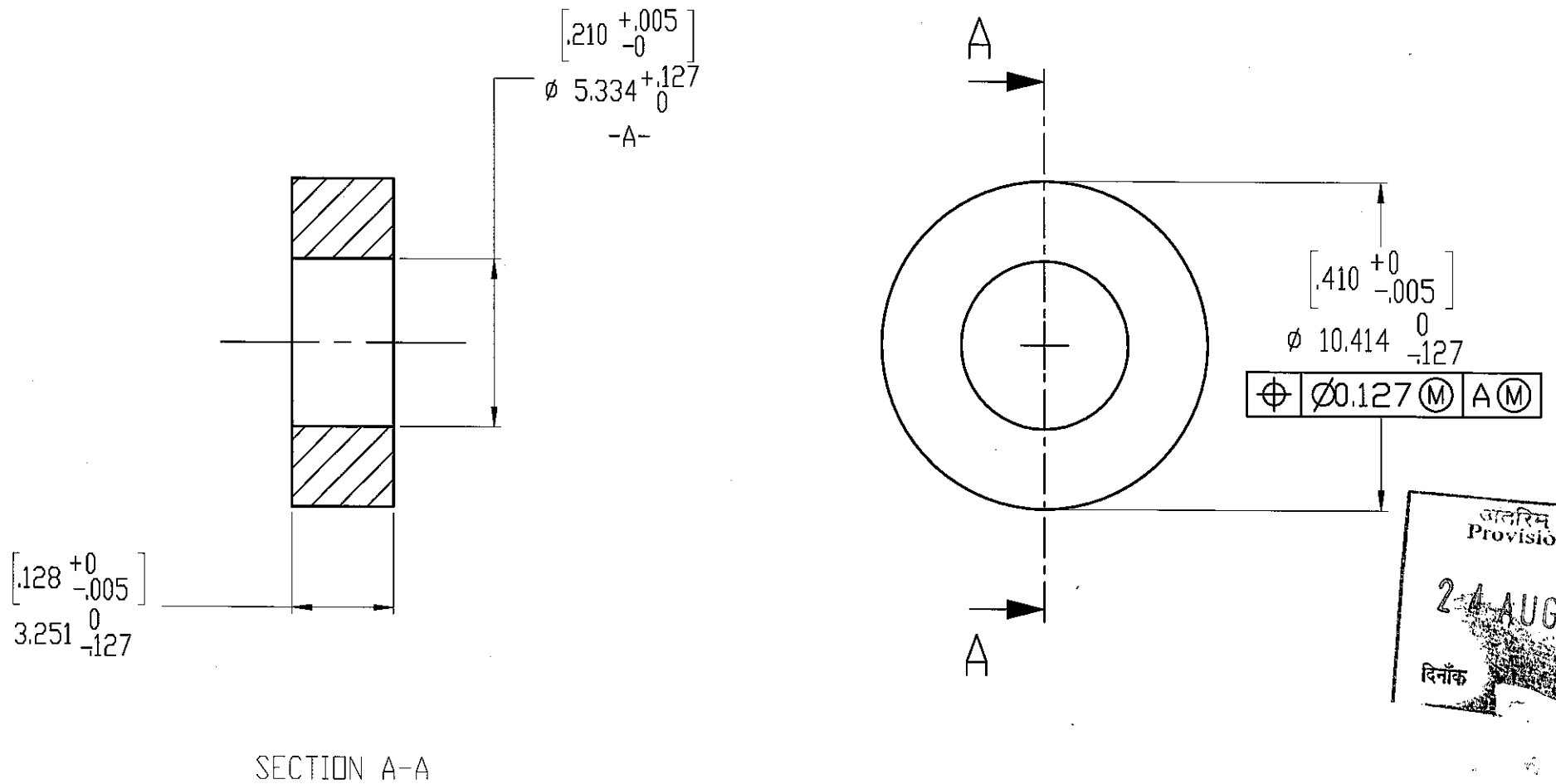
<p>ITAR CONTROLLED</p> <p>THIS DOCUMENT IS CONTROLLED UNDER THE ITAR. IT MAY NOT BE PROVIDED TO A NON-U.S. RESIDENT WITHOUT THE WRITTEN APPROVAL OF THE U.S. GOV'T. VIOLATIONS WILL RESULT IN CIVIL OR CRIMINAL PENALTIES.</p> <p>PROPRIETARY AND CONFIDENTIAL</p> <p>THE INFORMATION CONTAINED IN THIS DRAWING 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.</p>	UNLESS OTHERWISE SPECIFIED	NAME	DATE	<p>OHIO ORDNANCE WORKS, INC.</p> <p>PIN, SHOULDER, HEADLESS, 00W50BMG</p>	
	DIMENSIONS ARE IN MM/(INCHES) ALL THREAD DIM. ARE IN INCHES	DRAWN	PMD		07/13/15
	TOLERANCES: FRACTIONAL: ANGULAR: MACH ± BEND TWO PLACE DECIMAL ±0.25 THREE PLACE DECIMAL ±0.127	CHECKED			
	INTERPRET GEOMETRIC TOLERANCING PER:	ENG APPR.			
	MATERIAL	MFG APPR.			
	FINISH	Q.A.			
	DO NOT SCALE DRAWING	COMMENTS:			
		SCALE: 5:1	WEIGHT:	SHEET 1 OF 1	
		SIZE B	5152899	REV A	

M-7101

NOTES:

1. FINISH $\sqrt{3.2}$ ALL OVER.
2. BREAK EDGES 0.076 + 0.305 UNLESS OTHERWISE SPECIFIED.
3. OMITTED.
4. MATERIAL: STEEL, ASTM A576: 1095 AUSTENITIC GRAIN SIZE 5-8. OR STEEL, ASTM A686, CLASS WI-8 THRU 10, GRADE C
5. HEAT TREATMENT: HEAT AT 787 TO 816° C. OIL QUENCH, TEMPER ONE HOUR MIN. TO HARDNESS SPECIFIED (RH 15N 84-88)
6. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OR 5.3.2.2 OF MIL-STD-171.
7. ASME Y14.5M-1994 APPLIES.

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	CREATE DRAWING	7/22/2015	G. HERSHBERGER



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	DIMENSIONS ARE IN MM/INCHES] ALL THREAD DIM. ARE IN INCHES]	DRAWN	PMD		07/13/15
	TOLERANCES:	CHECKED			
	FRACTIONAL ANGULAR: MACH ± BEND TWO PLACE DECIMAL ±0.25 THREE PLACE DECIMAL ±0.127	ENG APPR.			
INTERPRET GEOMETRIC TOLERANCING PER:	MFG APPR.			<p>COLLAR, DRIVING SPRING ROD, 00W50BMG</p>	
MATERIAL	Q.A.				
FINISH	COMMENTS:			<p>SIZE B</p> <p>5152900</p> <p>REV A</p>	
DO NOT SCALE DRAWING				<p>SCALE: 5:1</p> <p>WEIGHT:</p> <p>SHEET 1 OF 1</p>	

NOTES:

1. MATERIAL: STEEL WIRE, MUSIC SPRING QUALITY, ASTM A228/A228M.
2. LOAD TEST SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED SOLID FIVE (5) TIMES.
3. SQUARED AND GROUND ENDS SHALL BE SQUARE WITH THE SPRING AXIS WITHIN 5°
4. HOLE DIA. INTO WHICH SPRING FITS FREELY - 10.617 MIN.
5. ROD DIA. OVER WHICH SPRING SLIDES FREELY - 7.417 MAX.
6. HEAT TREATMENT: STRESS RELIEVE AT 224° ± 5°C FOR 30 MINUTES AFTER COILING.
7. FINAL PROTECTIVE FINISH: FINISH 5.3.1.1 OF MIL-STD-171 WITH DRY FILM LUBRICANT MIL-PRF-46010 PER FINISH 30.7 OF MIL-STD-171.

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	B	UPDATED DRAWING NOTES, SPECIFIED WIRE DIAMETER TOLERANCE TO BE ±.0004	10/22/2018	T. HARDMAN
C-5	C	CHANGED FINAL FINISH FROM BLACK OXIDE TO MANGANESE PHOSPHATE WITH DRY FILM LUBRICANT.	6/14/2019	B.SUSNIK

WIRE DIAMETER - - - - - 1346 ± 0.01
 COIL DIAMETER (O.D.) - - - - - 10.337 -0.203
 FREE-LENGTH - - - - - 563.88 REF.
 TOTAL COILS - - - - - 144 REF.
 DIRECTION OF HELIX - - - - - L.H.
 LOAD AT COMPRESSED LENGTH OF 382.524 - - - - - 5.942 Kg ±0.590 Kg
 LOAD AT COMPRESSED LENGTH OF 200.66 - - - - - 11.929 Kg ±1.179 Kg
 SPRING RATE - - - - - 0.033 Kg/mm REF.
 SOLID LENGTH - - - - - 198.374 MAX
 TYPE OF ENDS - - - - - CLOSED ENDS GROUND



THREE END COILS CLOSE WOUND AT EACH END

अंतरिम रूप से प्रमाणित
 Provisionally Approved
 24 AUG 2021
 हस्ताक्षर/Sig
 For Arnold (AP)

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	TOLERANCES: FRACTIONAL ANGULAR: MACH ± BEND TWO PLACE DECIMAL ±0.25 THREE PLACE DECIMAL ±0.127	CHECKED	PHD	07/13/15	
	INTERPRET GEOMETRIC TOLERANCING PER:	ENG APPR.			
	MATERIAL	MFG APPR.			
FINISH	G.A.				SIZE
DO NOT SCALE DRAWING	COMMENTS:				B
					6147509
					REV
					C
					SCALE: 1:2
					WEIGHT:
					SHEET 1 OF 1

NOTES:

1. MATERIAL: STEEL WIRE, MUSIC SPRING QUALITY, ASTM A228/A228M.
2. LOAD TEST SHALL APPLY AFTER SPRING HAS BEEN COMPRESSED SOLID FIVE (5) TIMES.
3. SQUARED AND GROUND ENDS SHALL BE SQUARE WITH THE SPRING AXIS WITHIN 5°
4. HOLE DIA. INTO WHICH SPRING FITS FREELY - 7.417 MIN.
5. ROD DIA. OVER WHICH SPRING SLIDES FREELY - 5.232 MAX.
6. HEAT TREATMENT: STRESS RELIEVE AT 224° ±5° C. FOR 30 MINUTES AFTER COILING.
7. FINAL PROTECTIVE FINISH: FINISH 5.3.1.2 OF MIL-STD-171 WITH MIL-PRF-3150 SUPPLEMENTARY OIL. (C)

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	B	UPDATED DRAWING NOTES, SPECIFIED WIRE DIAMETER TOLERANCE TO BE ±.0004	10/22/2018	T. HARDMAN
B3	C	FINAL FINISH CHANGED FROM BLACK OXIDE TO MANGANESE PHOSPHATE W/SUPPLEMENTARY OIL.	6/14/2019	B.SUSNIK

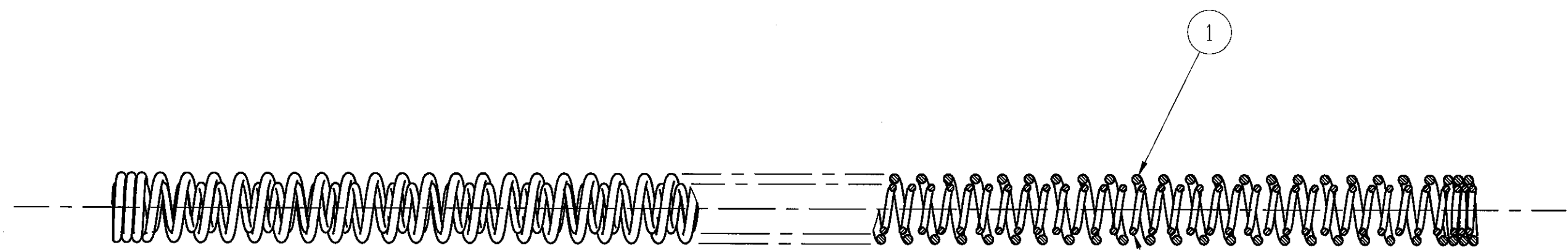
WIRE DIAMETER - - - - - 0.991 ±0.01
 COIL DIAMETER (O.D.) - - - - - 7.366 -0.127
 FREE-LENGTH - - - - - 553.72 REF.
 TOTAL COILS - - - - - 197 REF.
 DIRECTION OF HELIX - - - - - R.H.
 LOAD AT COMPRESSED LENGTH OF 381.508 - - - - - 3.492 Kg ±0.453 Kg
 LOAD AT COMPRESSED LENGTH OF 203.2 - - - - - 7.076 Kg±0.725 Kg
 SPRING RATE - - - - - 0.02 Kg/mm REF.
 SOLID LENGTH - - - - - 198.12 MAX
 TYPE OF ENDS - - - - - CLOSED ENDS GROUND



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 Provisionally Approved
 24 AUG 2021
 दिनांक
 हस्ताक्षर/Sig
 For Amde (AP)

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	DIMENSIONS ARE IN MM/(INCHES) ALL THREAD DIM. ARE IN INCHES	DRAWN	PMD		07/13/15
	TOLERANCES: FRACTIONAL ANGULAR: MACH ± BEND TWO PLACE DECIMAL ±0.25 THREE PLACE DECIMAL ±0.127	CHECKED			
	INTERPRET GEOMETRIC TOLERANCING PER:	ENG APPR.			
MATERIAL	FINISH	MFG APPR.			
DO NOT SCALE DRAWING		Q.A.			
		COMMENTS:			
		SIZE	REV		
		B	C	6147510	
		SCALE: 1:2	WEIGHT:	SHEET 1 OF 1	

ITEM NO.	PART NUMBER	DESCRIPTION	FINAL ASSEMBLY/QTY.	REVISIONS				
				ZONE	REV.	DESCRIPTION	DATE	APPROVED
1	M-7121 SPRING, HELICAL COMPRESSION (6147509)	SPRING, HELICAL COMPRESSION, 00W50BMG	1		A	CREATE DRAWING	6/20/2018	T. HARDMAN
2	M-7122 SPRING, HELICAL COMPRESSION (6147510)	SPRING, HELICAL COMPRESSION, 00W50BMG	1					



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Provisionally Approved

24 AUG 2021

हस्ताक्षर/Sig
For Control (APD)

NOTES:

1. DRIVING SPRING ASSEMBLY P/N 7312243 IS USED WITH GUIDE ROD ASSEMBLY P/N 7313289 TO COMPLETE DRIVING SPRING ROD ASSEMBLY P/N 5564305.

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	DIMENSIONS ARE IN MM/(INCHES) ALL THREAD DIM. ARE IN INCHES	DRAWN	TMB/20/1806/08/2020		
	TOLERANCES: FRACTIONAL ANGULAR: MACH ± BEND TWO PLACE DECIMAL ± THREE PLACE DECIMAL ±	CHECKED			
	INTERPRET GEOMETRIC TOLERANCING PER:	ENG APPR.			
MATERIAL	MFG APPR.			SIZE B	
FINISH	Q.A.				7312243
DO NOT SCALE DRAWING	COMMENTS:			REV A	
		SCALE: 1:2	WEIGHT:	SHEET 1 OF 1	

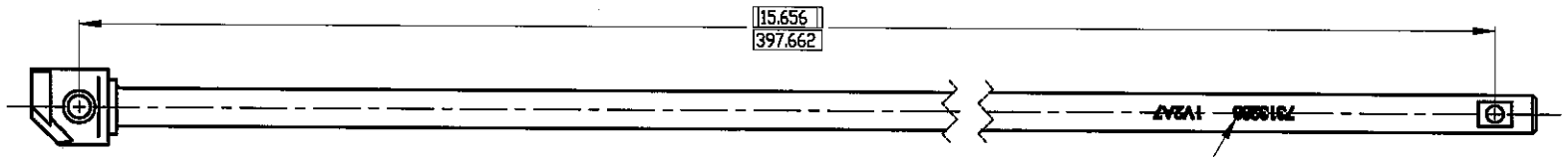
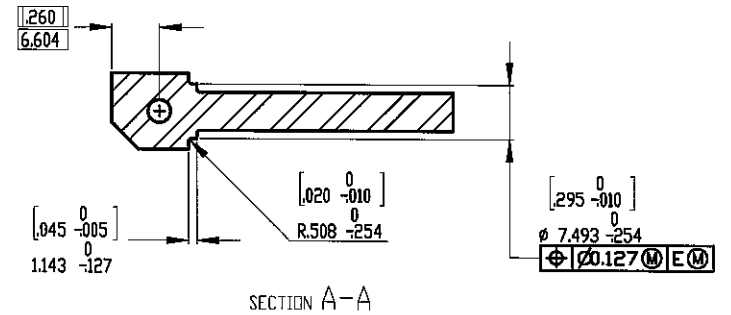
- NOTES:
- FINISH $\sqrt{32}$ ALL OVER.
 - BREAK ALL EDGES 0.076 +0.305 UNLESS OTHERWISE SPECIFIED.
 - HEAT TREATMENT:
HARDEN BOTH ENDS FOR DISTANCE INDICATED.
OIL QUENCH AND TEMPER ONE HOUR MINIMUM TO HARDNESS SPECIFIED (RH 15N 84.5-87.5).
 - ASME Y14.5M-1994 APPLIES.
 - MATERIAL:
ALLOY STEEL BARS, HOT WROUGHT, ASTM A322, GRADES 4140, 4142, 4340, ALLOY STEEL BARS, COLD FINISHED, ASTM A331, GRADES 4140, 4142, 4340, STEEL BARS, CARBON, HOT WROUGHT, ASTM A576, GRADE 1095.

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	CREATE DRAWING	7/27/2015	G. HERSHBERGER

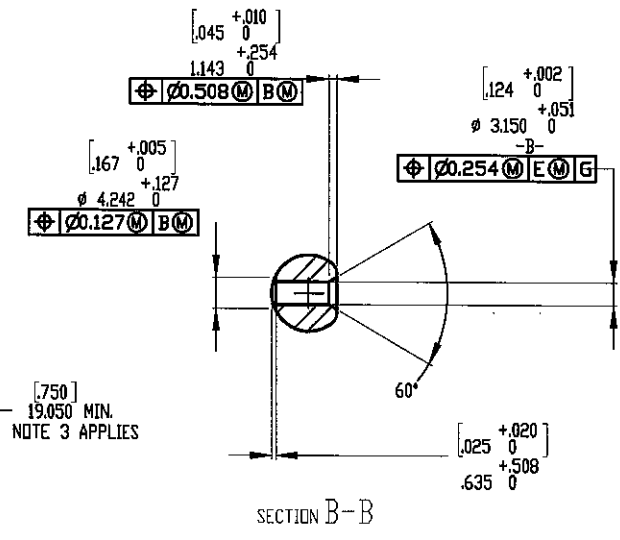
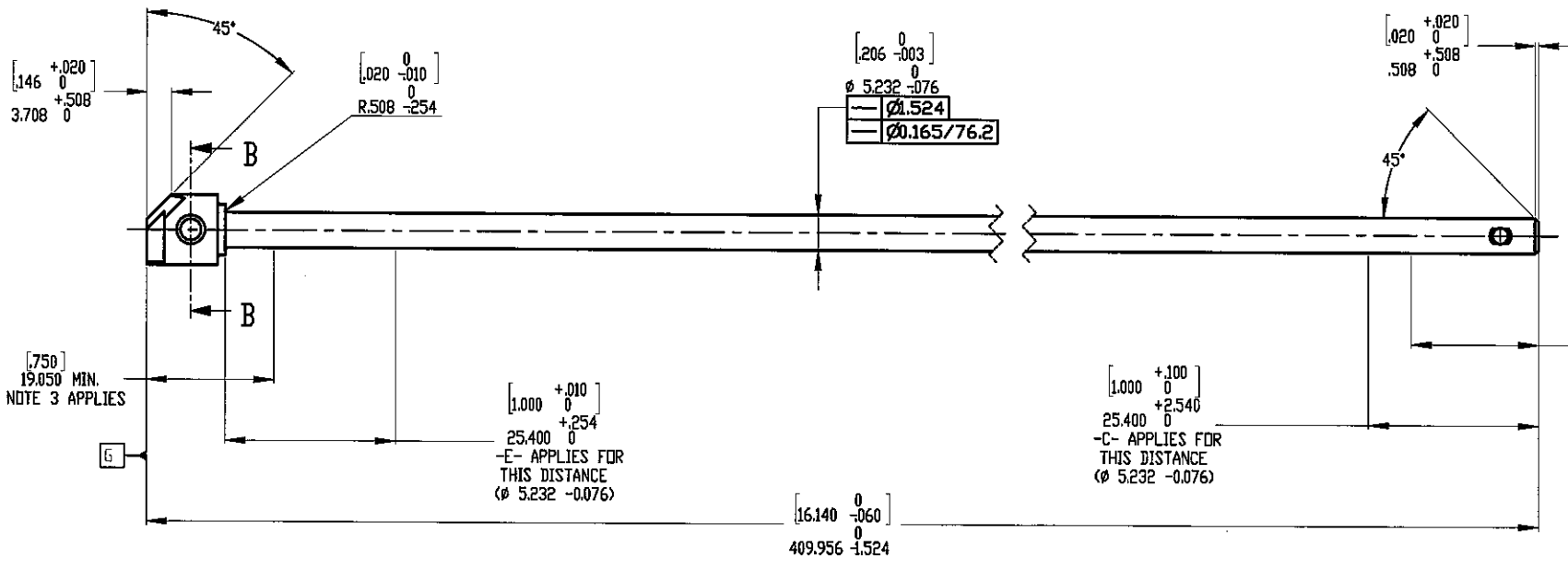
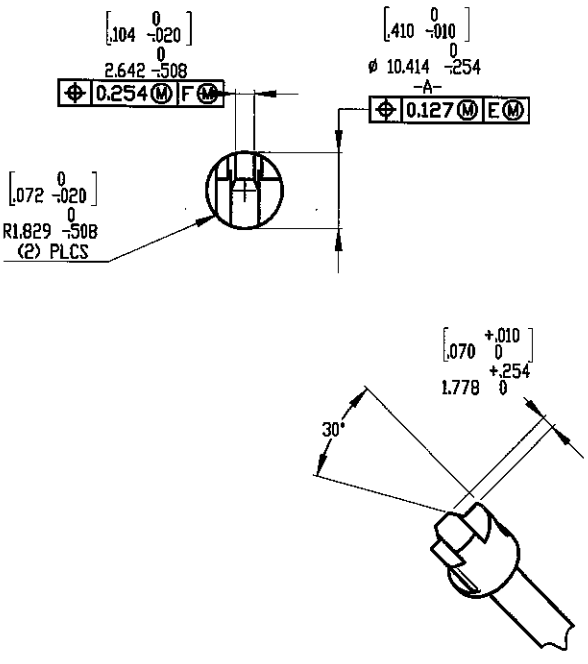
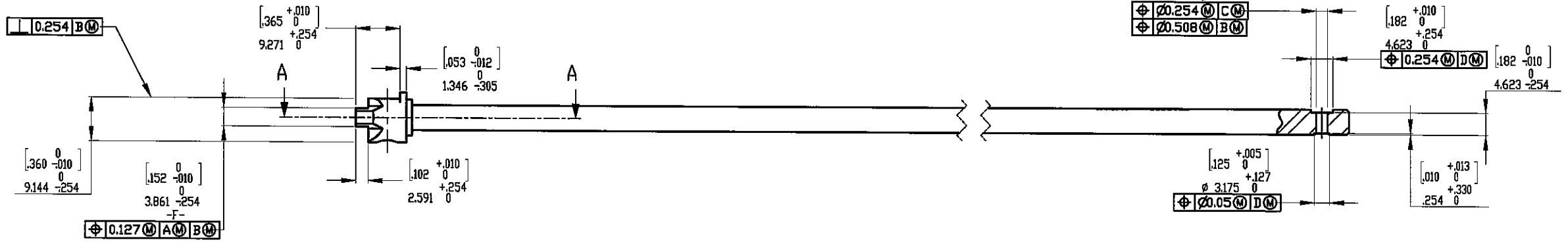
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Provisionally Approved

24 AUG 2015

दिनांक हस्ताक्षर/Sig
For (Mudappa)



INSCRIBE PART NUMBER 7313288 AND "1V2A7" CAGE CODE IDENTIFICATION, 1.575 ± 0.381 HIGH X 0.127 +0.381 DEEP.

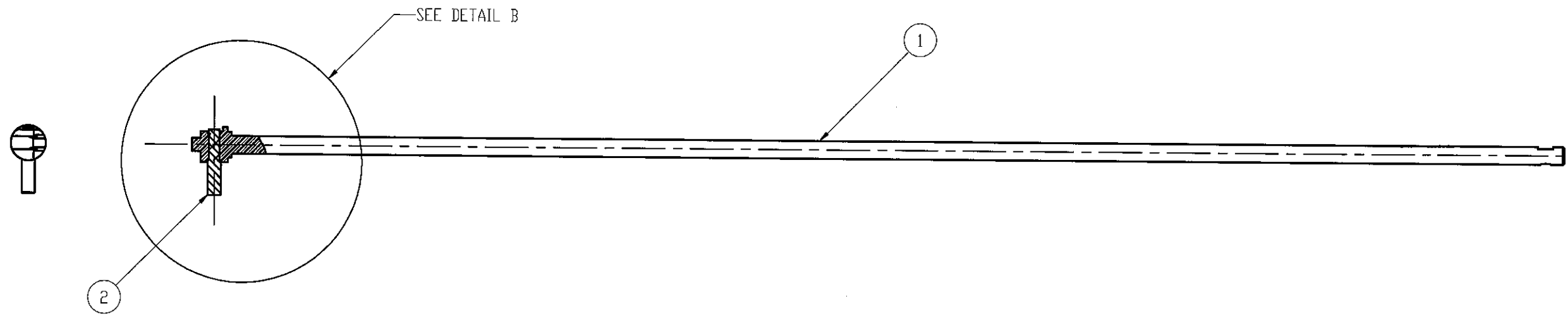


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	<p>DRAWN</p> <p>CHKD</p> <p>ENG APPR</p> <p>REV APPR</p> <p>QA</p> <p>ISSUED</p>	<p>NAME</p> <p>FWO</p>	<p>REV</p> <p>A</p>	<p>ROD, GUIDE, ODW50BMG</p>
	<p>MATERIAL</p> <p>FINISH</p> <p>HT</p> <p>HT</p> <p>HT</p>	<p>DATE</p> <p>7/27/2015</p>	<p>SCALE: 2:1</p>	<p>WEIGHT:</p>
	<p>SIZE</p> <p>D</p>	<p>7313288</p>	<p>SHEET 1 OF 1</p>	

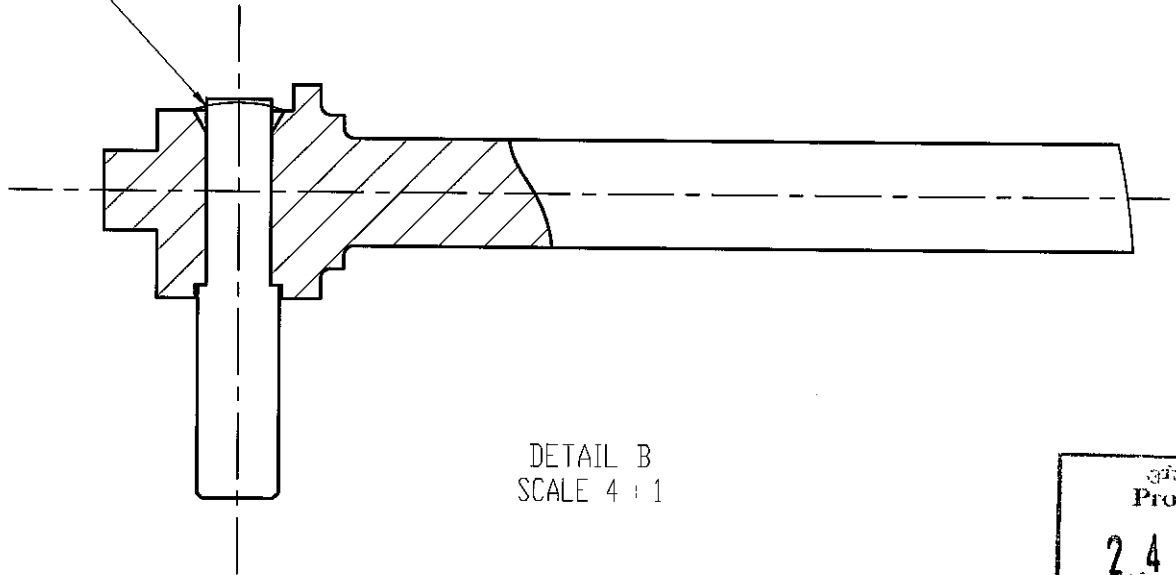
ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	M-71112 ROD, GUIDE (7313288)	ROD, GUIDE, 00W50BMG	1
2	M-7111 PIN, SHOULDER, HEADLESS (5152899)	HEADLESS SHOULDER PIN, 00W50BMG	1

REVISIONS				
ZONE	REV.	DESCRIPTION	DATE	APPROVED
	A	CREATE DRAWING	6/21/2018	T. HARDMAN

M
7116



RIVET - FINISH FLUSH TO 0.254 PROTRUSION



DETAIL B
SCALE 4:1

अप्रमाणित रूप से प्रमाणित
Provisionally Approved
24 AUG 2021
दिनांक
हस्ताक्षर/Sig
For Cmde(PP)

NOTES:

- GUIDE ROD ASSEMBLY P/N 7313289 IS USED WITH DRIVING SPRING ASSEMBLY P/N 7312243 TO COMPLETE DRIVING SPRING ROD ASSEMBLY P/N 5564305.
- FINAL PROTECTIVE FINISH: FINISH 5.31.2 OR 5.32.2 OF MIL-STD-171.

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	DIMENSIONS ARE IN MM/(INCHES) ALL THREAD DIM. ARE IN INCHES	DRAWN	TMH		6/21/18
	TOLERANCES: FRACTIONAL ANGULAR MACH & BEND TWO PLACE DECIMAL ± THREE PLACE DECIMAL ±	CHECKED			
	INTERPRET GEOMETRIC TOLERANCING PER MATERIAL	ENG APPR.			
FINISH	MFG APPR.			ROD ASSEMBLY, GUIDE, 00W50BMG	
DO NOT SCALE DRAWING	QA				
	COMMENTS:				
	SIZE	7313289	REV	A	
	SCALE: 1:1	WEIGHT:		SHEET 1 OF 1	