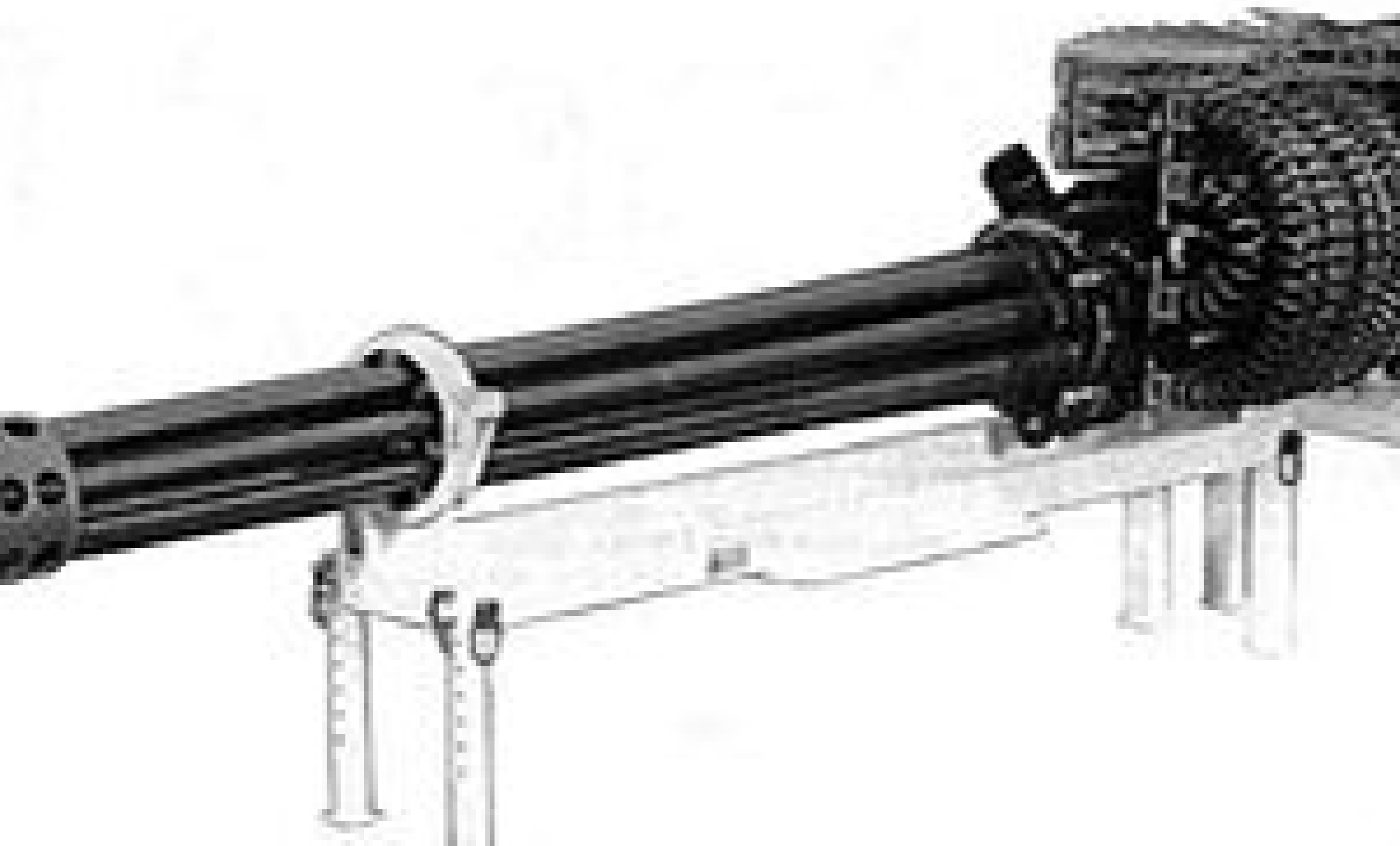
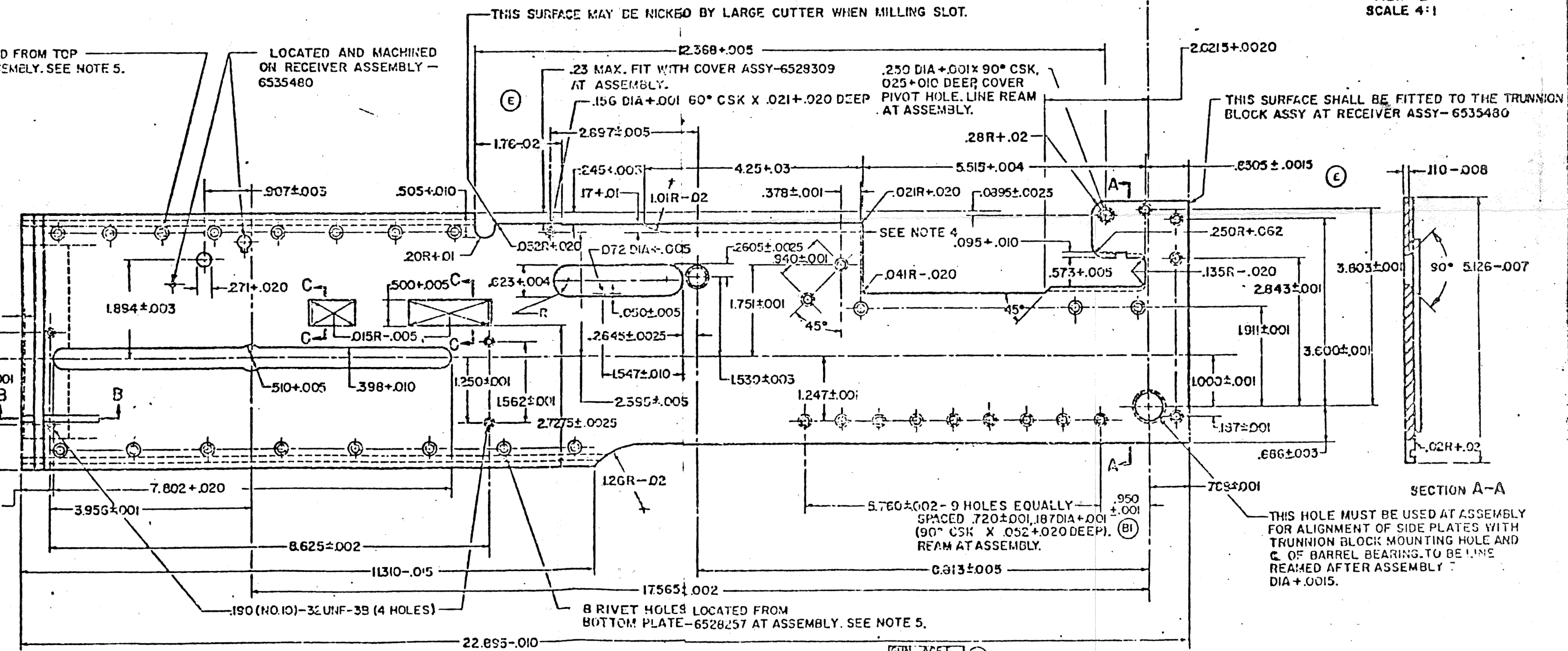
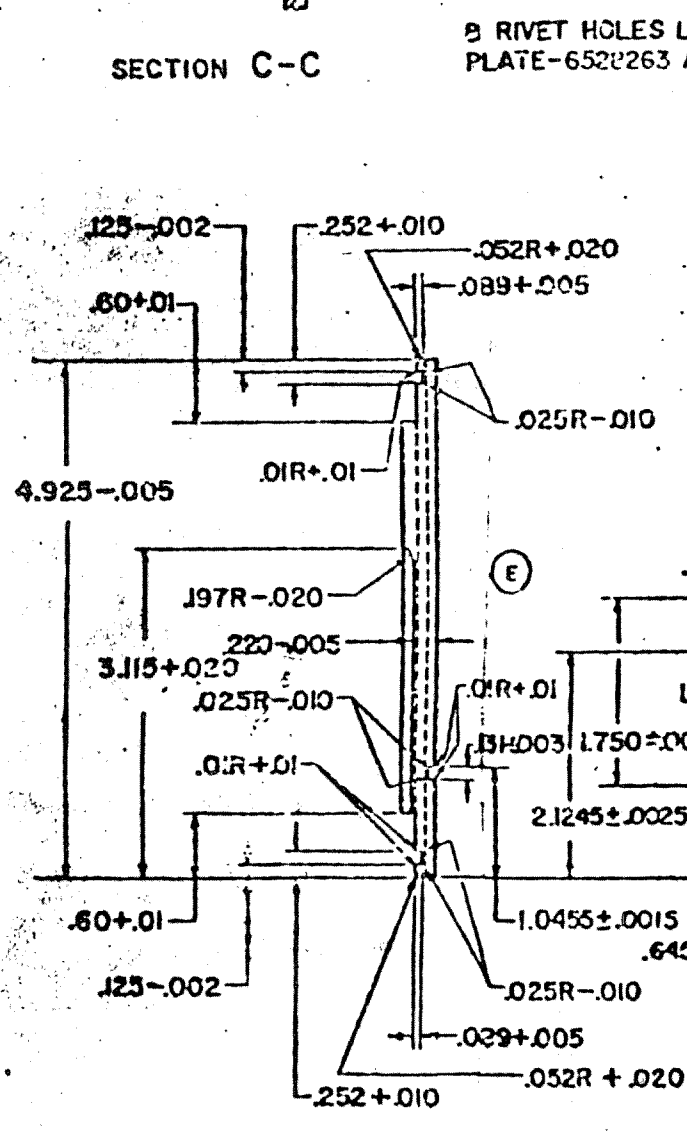
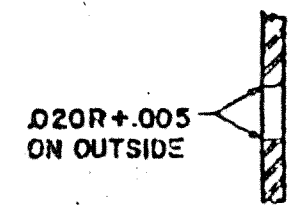
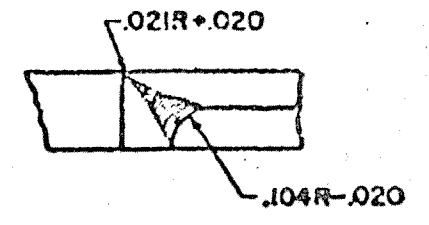
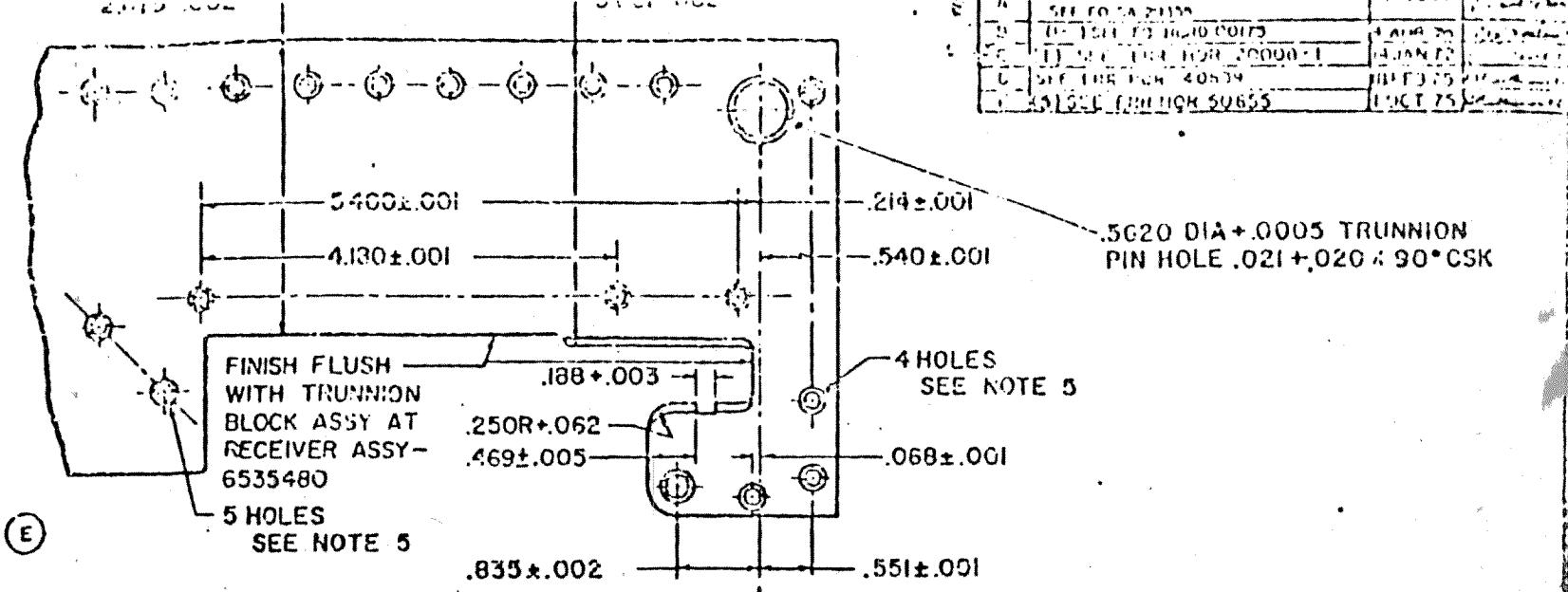
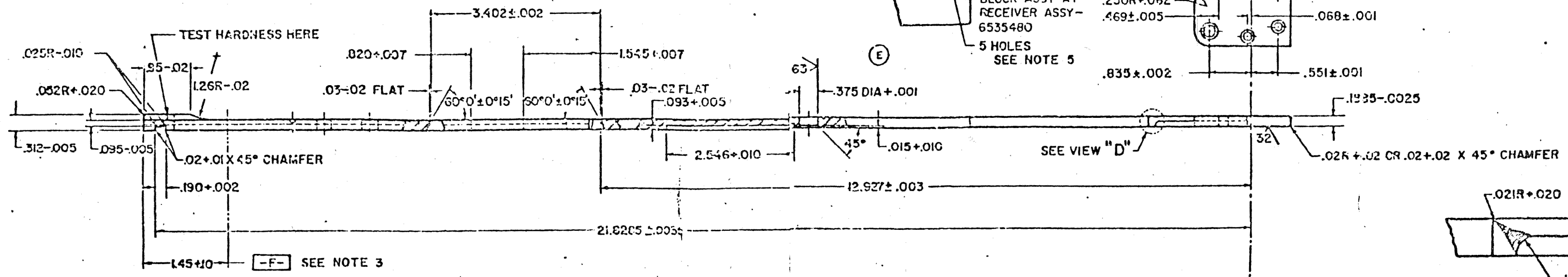
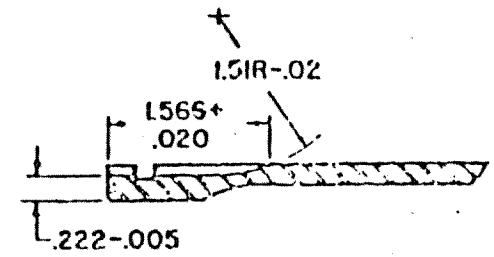


GAU Machine Cannon



1. FINISH 125 EXCEPT AS NOTED.
2. BREAK EDGES .003 ± .012 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT: HEAT LENGTH TO 1480° - 1500°F OIL QUENCH. TEMPER AT APPROX. 800° TO HARDNESS SPECIFIED.
4. THE CLEARANCE CUT CONTROLLED BY DIMENSIONS 4.25 ± .03 LENGTH, .17 ± .01 DEPTH, AND 1.01R - .02 IS OPTIONAL WITH MANUFACTURER TO MAKE THE LEFT & RIGHT HAND SIDE PLATES ALIKE AS TO THIS CUT.
5. ALL RIVET HOLES ARE .187 DIA. ± .001 (60° - 1° CSK X .052 ± .020 DEEP), REAM AT ASSEMBLY UNLESS OTHERWISE SPECIFIED.
6. MIL-W-13855 APPLIES.



VIEW D
SCALE 4:1

SECTION C-C

8 RIVET HOLES LOCATED FROM TOP PLATE - 652263 AT ASSEMBLY. SEE NOTE 5.

LOCATED AND MACHINED ON RECEIVER ASSEMBLY - 6535480

THIS SURFACE MAY BE NICKED BY LARGE CUTTER WHEN MILLING SLOT.

THIS SURFACE SHALL BE FITTED TO THE TRUNNION BLOCK ASSY AT RECEIVER ASSY - 6535480

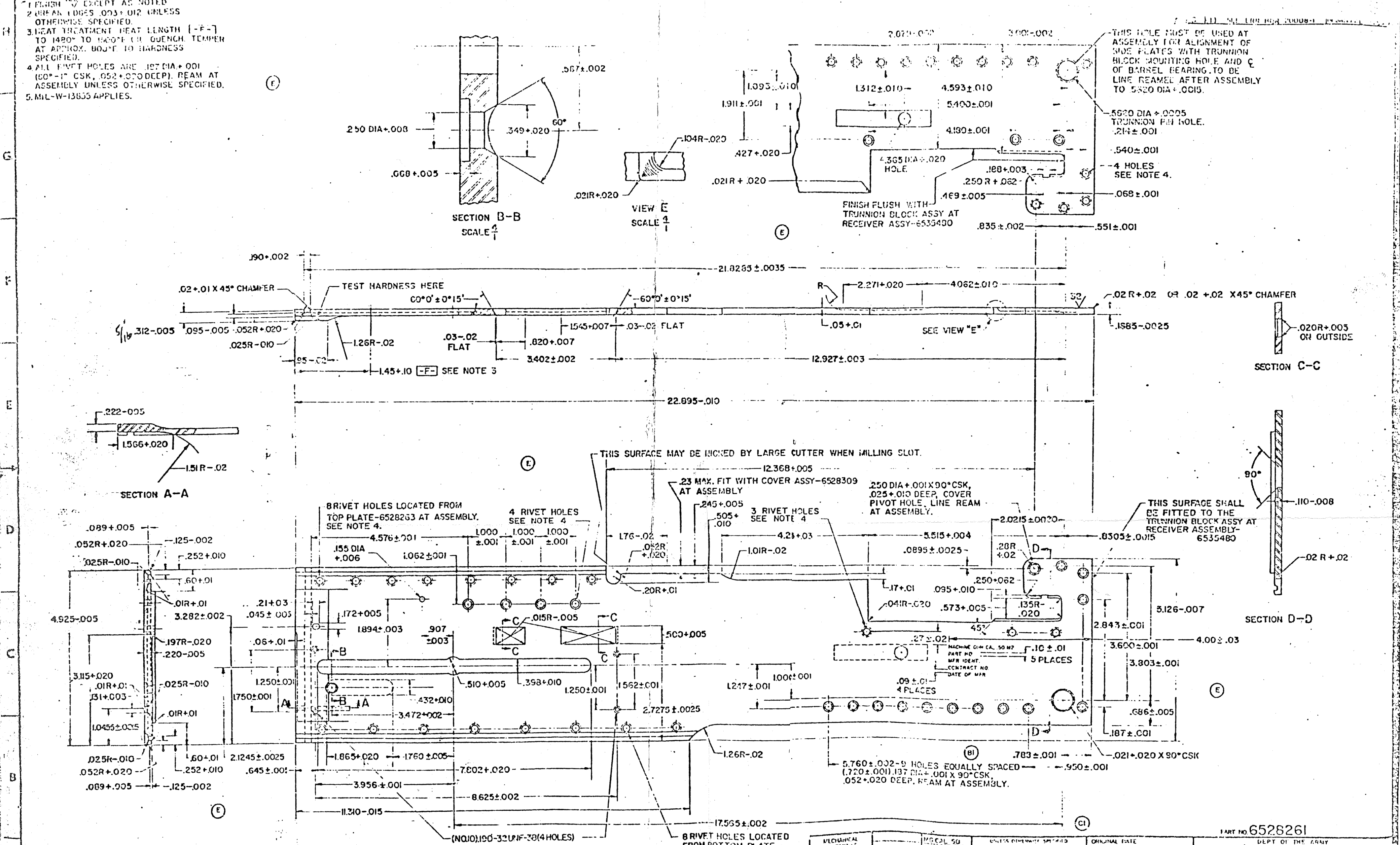
5.760 ± .002 - 9 HOLES EQUALLY SPACED .720 ± .001, .187 DIA ± .001 (90° CSK X .052 ± .020 DEEP). REAM AT ASSEMBLY.

8 RIVET HOLES LOCATED FROM BOTTOM PLATE - 6528257 AT ASSEMBLY. SEE NOTE 5.

This drawing may be downloaded free of charge from <http://www.josreichert.com>. It is provided by Joseph Reichert, d/b/a/ Reichert Büchsenmacher (RB).

MIL-STD-883C CAL. 50 68U-10/7A		GUN. ACFT CAL. 50 68U-10/7A		PART NO 6528262	
MECHANICAL PROPERTIES		MIL. SPEC. 50		DEPT. OF THE ARMY ROCK ISLAND ARSENAL ROCK ISLAND, ILLINOIS 61201	
VP	1/2 HB FXD.	TOLERANCES ON DIMENSIONS UNLESS OTHERWISE SPECIFIED		ORIGINAL DATE OF DRAWING 1 MAY 34	
TS	FLEX, TT	DIMENSIONS IN PARENTHESES ARE ANGLES IN DEGREES		DRAWN BY 137 CHECKED BY 20	
EL 2	MIL. CAL. 50	MATERIAL STEEL, ASTM ASSN. 4340		TRAFFIC BY 206 CHECKED BY 20	
RA	D5504085	HEAT TREATMENT SEE NOTE 3		ENGINEER BY 206	
WH	HEAT ASSY	APPLIED AFTER ASSEMBLY		APPROVED BY [Signature]	
RI	D55-60	APPLY DATE NO.		DRAWN BY [Signature]	
				DRAWING NO. F 19204 6528262	
				SCALE 1:1 SHEET 1 OF 1	

1. FINISH EXCEPT AS NOTED
2. BREAK EDGES .003 ± .012 UNLESS OTHERWISE SPECIFIED.
3. HEAT TREATMENT HEAT LENGTH [-F-] TO 1480° TO 1500° OH QUENCH TEMPER AT APPROX. 90°F TO HARDNESS SPECIFIED.
4. ALL PIVOT HOLES ARE .107 DIA + .001 (50°-1° CSK, .052 ± .020 DEEP). REAM AT ASSEMBLY UNLESS OTHERWISE SPECIFIED.
5. MIL-W-13635 APPLIES.



This drawing may be downloaded free of charge from <http://www.josreichert.com>. It is provided by Joseph Reichert, d/b/a/ Reichert Büchsenmacher (RB).

MECHANICAL PROPERTIES		MATERIAL		TOLERANCES ON DIMENSIONS		ORIGINAL DATE OF DRAWING		PART NO	
YP		M2 CAL 50	M2 HB FxD	TOLERANCES ON DIMENSIONS		1 MAY 34		6528261	
TS		FLX, TT		DECIMALS		CHECKER		DEPT OF THE ARMY	
HZ		M2 CAL 50		ANGLES 10		CHECKER		ROCK ISLAND ARSENAL	
RA		M2 CAL 50		FRACTIONS		ENGINEER		ROCK ISLAND, ILLINOIS, 61901	
RH		M2 CAL 50		CONTRACT NO		SUBMITTED		PLATE, SIDE, R.H.	
RH		M2 CAL 50		DATE OF MFR		APPROVED		F 19204 6528261	
HEAT TREATMENT		MATERIAL		TOLERANCES ON DIMENSIONS		APPROVED		SHEET 1 OF 1	
SEE NOTE 3		MATERIAL		CONTRACT NO		DATE OF MFR			