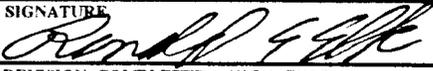
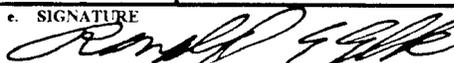


NOTICE OF REVISION (NOR)				1. DATE (YYMMDD) 000327		Form Approved OMB NO. 0704-0188	
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				7. CAGE CODE		8. DOCUMENT NO.	
				19200		12991255	
9. TITLE OF DOCUMENT <b>Legacy Gage Designs</b>				10. REVISION LETTER		11. ECP NO.	
				19. CURRENT		19. NEW	
12. CONFIGURATION ITEM (OR SYSTEM) TO WHICH ECP APPLIESD <b>Bolt Subassembly, <del>...</del> M2 Browning Machine Gun</b>				NOR SHT <b>1 of 4</b>			
See attached draft QAP that includes the following changes to the QAP characteristics: Add the following to drawing 12991255 showing the gages removed from SQ6147463: "SYSTEM - M2 Browning Heavy Machine Gun, Caliber .50							
DRAWING #		QAP #		DESCRIPTION			
6147463		SQ6147463		(Alternate Feed) Bolt Subassembly (Inspection position C			
5152858		SQ6147463		Recoil Plate (Inspection position A			
6528256		SQ6147463		Alternate Feed Bolt (Inspection position B)			
SQ6147463 Rev G with gages				SQ6147463 Rev H QAP gages removed (L0Q2017)			
	No	Description	Gage #	Gage Title	Pos	No.	Description
1	103.	.204 max. Firing pin hole dia	7270055	No-Go Special Plug Gage	B	103.	.204 max. Firing pin hole diameter
2	105.	Location of front tracks relative to the barrel extension ways	11827906	Receiver Gage	B	105.	Location of top tracks (.3775+.3775+.260= 1.015) to 1.176 barrel extension ways, Datum -C- (11827906)
3	106.	Location of cartridge slot opening	11827906	Receiver Gage	B	106.	Location of .6830 cartridge slot opening to 1.176 barrel extension ways, Datum -C- (11827906)
4	107.	Location of rear tracks relative to the barrel extension ways	11827906	Receiver Gage	B	107.	Location of rear tracks (.3775+.3775+.260= 1.015) to 1.176 barrel extension ways, Datum -C- (11827906)
5	111.	.359 diameter, extractor stud hole and .093 width lock out	7315987	Swing Plug Gage	B	111.	.359 diameter, extractor stud hole diameter Datum -J-
6	111.	.359 diameter, extractor stud hole and .093 width lock out	7315987	Swing Plug Gage	B	112.	.093 width lock out groove width
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d. TITLE <b>Chief, Cmbt Spt &amp; Sm Cal Wpn Sys Div</b>		e. SIGNATURE 		f. DATE SIGNED (YYMMDD) <b>20000613</b>			
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<b>Legacy Gage Designs</b>				20. CURRENT			
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<b>Bolt Subassembly, <del>...</del> M2 Browning Machine Gun</b>				<b>2 of 4</b>			
<b>SQ6147463 Rev G with gages</b>				<b>SQ6147463 Rev H QAP gages removed (L0Q2017)</b>			
	No	Description	Gage #	Gage Title	Pos	No.	Description
7	112.	Minimum diameter and position of accelerator stop hole to firing pin extension hole	6045702	Location Gage	B	113.	.158 accelerator stop hole diameter (6045702)
8	112.	Minimum diameter and position of accelerator stop hole to firing pin extension hole	6045702	Location Gage	B	114.	Position of .158 accelerator stop hole to .497 firing pin extension hole (6045702)
9	113.	Position and .07 depth of D.472 bolt stud hole counterbore	7315966	Location Gage	B	115.	.359 bolt stud hole diameter (7315966)
10	113.	Position and .07 depth of D.472 bolt stud hole counterbore	7315966	Plug Gage	B	116.	.472 bolt stud hole counterbore (7315966)
11	113.	Position and .07 depth of D.472 bolt stud hole counterbore	7315966	Plug Gage	B	117.	.07 depth of D.472 bolt stud hole counterbore (7315966)
12	113.	Position and .07 depth of D.472 bolt stud hole counterbore	7315966	Plug Gage	B	118.	Position of .472 bolt stud c'bore to .359 bolt stud hole (7315966)
13	117.	R.332 & R.38 extractor locking lug clearance cut radii, check go condition only for R.38	7317898	Location Gage	B	120.	.38 extractor locking lug clearance groove radius (7317898)
14	117.	R.332 & R.38 extractor locking lug clearance cut radii, check go condition only for R.38	7317898	Location Gage	B	121.	.093 extractor locking lug clearance groove width (7317898)
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				7. CAGE CODE <b>19200</b>		8. DOCUMENT NO. <b>12991255</b>	
9. TITLE OF DOCUMENT <b>Legacy Gage Designs</b>				10. REVISION LETTER		11. ECP NO.	
				21. CURRENT		21. NEW	
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<b>SQ6147463 Rev G with gages</b>				<b>SQ6147463 Rev H QAP gages removed (L0Q2017)</b>			
	No	Description	Gage #	Gage Title	Pos	No.	Description
15	117	R.332 & R.38 extractor locking lug clearance cut radii, check go condition only for R.38	7317898	Location Gage	B	122.	.332 radius of extractor locking lug (7317898)
16	202.	1.823 Depth and position of spring hole	7317946	Depth Gage	B	202.	.247 spring seat diameter (7317946)
17	202.	1.823 Depth and position of spring hole	7317946	Depth Gage	B	203.	1.823 Depth of .247 dia. spring hole (7317946)
18	202.	1.823 Depth and position of spring hole	7317946	Depth Gage	B	204.	.410 sear slot opening (7317946)
19	202.	1.823 Depth and position of spring hole	7317946	Depth Gage	B	205.	.617 sear slot groove width, Datum -R- (7317946)
20	202.	1.823 Depth and position of spring hole	7317946	Depth Gage	B	206.	Location of .247 diameter spring seat to sear slot (7317946)
21	203.	.410 Position of sear slot	11827907	Location Gage	B	207.	Position of .410 sear slot opening to .617 sear slot sear width, Datum -R- (11827907)
22	204.	Alignment of sear slide slots	5076309	Alignment Plug Gage	B	208.	.359 sear slide groove width (5076309)
23	204.	Alignment of sear slide slots	5076309	Alignment Plug Gage	B	209.	.298 sear slide groove opening (5076309)
24	204.	Alignment of sear slide slots	5076309	Alignment Plug Gage	B	210.	.101 sear slide groove thickness (5076309)
25	204.	Alignment of sear slide slots	5076309	Alignment Plug Gage	B	211.	Alignment of sear slide slots (5076309)
26	207.	Position of extractor hole to bolt switch hole	7317898	Location Gage	B	214.	Position of .359 extractor hole to .970 bolt switch hole (7317898)
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<b>Bolt Subassembly, <del>XXXXXXXXXXXX</del> M2 Browning Machine Gun</b>				<b>4 of 4</b>			
SQ6147463 Rev G with gages				SQ6147463 Rev H QAP gages removed (L0Q2017)			
	No	Description	Gage #	Gage Title	Pos	No.	Description
27	208.	Location of cocking lever slot to firing pin extension hole	5520267	Location Gage	B	215.	Position of cocking lever slot to firing pin extension hole (5520267)
28	211.	Location of cartridge slot angle (actually 5076313)	5077313	Angle Plug Gage	B	218.	.70 location of 8°15' cartridge slot angle (5076313)
29	212.	.770 Ways to top distance	7319502	Indicator Gage	B	229.	.770 ways to top distance (7319502)
<b>Bolt Subassembly (Alternate Feed) (Inspection position C</b>							
SQ6147463 Rev G with gages				SQ6147463 Rev H QAP gages removed (L0Q2017)			
	No	Description	Gage #	Gage Title	Pos	No.	Description
30	105.	Alignment of firing pin holes	5520317	Alignment Gage	C	106.	Alignment of firing pin holes (5520317)
31	106.	Position of track bolt switch stud and 1.812 Diameter To .970 Diameter	6045518	Location Gage	C	107.	Position of track bolt switch stud and 1.812 Diameter To .970 Diameter (6045518)
32	107.	Location of striker hole to barrel extension ways	6511092	Alignment Gage	C	108.	Location of .080 firing pin hole to barrel extension ways (6511092)
33	108.	Location of breech locking surface (after proof firing and final machining)	6511093	Flush Pin Gage	C	109.	6.304 location of breech locking surface (after proof firing and final machining) (6511093)
34	109.	3.336 Firing pin hole depth	6511125 6047015	Indicator Gage Mean Master	C	110.	3.336 Firing pin hole depth (6511125 6047015)
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