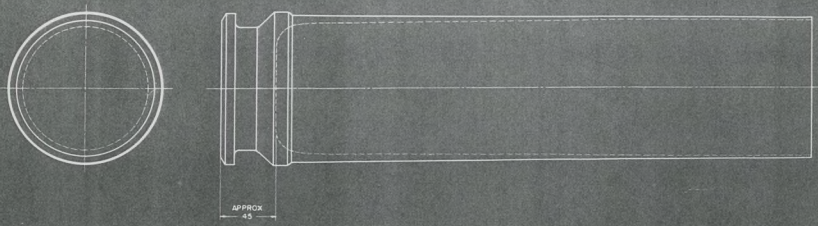
ARMY SERVICE FORCES
ORDNANCE DEPARTMENT
ORDNANCE DRAWING - SIZE C

FC 4347

ORIGINAL DATE OF DRAWING APRIL 15, 1954

NO.	DATE	REVISIONS NOT AUTH. BY	BY	CHK



CARTRIDGE BRASS SPEC MIL-B-50

FOR FINISHES AND OTHER DIMENSIONS SEE DRAWING FD18081

CASE, CARTRIDGE DUMMY 30 MM, (EXPERIMENTAL)

PHYSICAL PROPERTIES	DRAWING PERTAINS TO	
	FD18096	CTG DUMMY 30MM, T252

WT. DRWG OR APPROX	SO NOT	APPLY PART NO. (As Type Listed)
SCALE 1	7.5	QDM
TOLERANCES ON DIMENSIONS (Unless Otherwise Specified) Fract. ± Dec. ± Angles ± Finish (Surface Roughness)	7.5	QDM
	C.R.F.	
	SUBMITTED Alfred P. Holmes	
	APPROVED Samuel W. Rumbaugh Jr.	

ORD. ORD. CORPS

LT. COL. ORD. CORPS

FRANKFORD ARSENAL

FC 4347

OTICE-
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

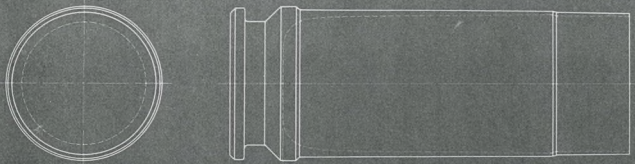
1038

ORDNANCE DRAWING - SIZE C

FC4302

ORIGINAL DATE OF DRAWING MARCH 12, 1953

REVISIONS



APPROX
.45

CARTRIDGE BRASS SPEC. MIL-B-50
FOR OTHER DIMENSIONS SEE DRAWING 07553342

CASE, CARTRIDGE DUMMY, 30 MM, (EXPERIMENTAL)

PART OR PROJECT NO.	FD18055
STANDARD PRACTICE TO	GTO DUMMY 30 MM, T159
NO. UNIT	30
SCALE	1
DRAWN BY	L. Alfred B. Peterson
APPROVED	Ray C. Mueller

FRANKFORD ARSENAL

NOTICE
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT

~~RESTRICTED~~

FC4302

1030

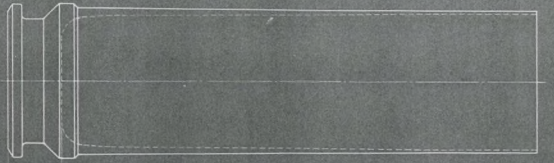
ORDNANCE DRAWING - SIZE E

FC4325

ORIGINAL DATE OF DRAWING OCT 23, 1953

REVISIONS			
NO.	DATE	BY	APPROVED





APPROX
45

CARTRIDGE BRASS SPEC MIL-B-50

FOR FINISHES AND OTHER DIMENSIONS SEE DRAWING FD18030

CASE, CARTRIDGE DUMMY 30MM, (EXPERIMENTAL)

MATERIAL PROPERTIES	SERIALS PERTAIN TO	
	FD18080	CTG DUMMY 30 MM, T205

MF ENG'G APPROV	DO NO.	APPLY PART NO.
SCALE - 4/1	2-8	2PH
TOLERANCES OR DEVIATIONS (Unless otherwise specified)	3-8	2PH
		2PS

DRAWN: Clifford J. Hutchison JR
ENG

APPROVED: W. W. Walter
ENG

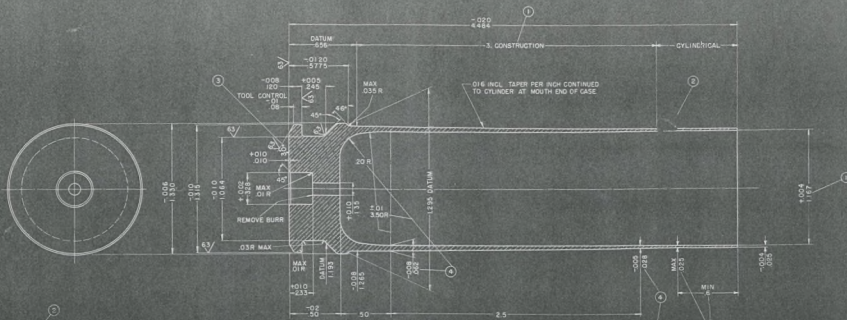
FRANKFORD ARSENAL

NOTICE -
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

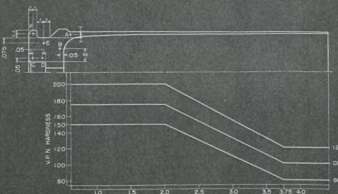
~~RESTRICTED~~

CLASSIFIED

FD18030



NOTE:-
HEAD HARDNESS FIGURES AT POINTS INDICATED "A" TO "I" MUST BE NOT LESS THAN 150 V.P.N.



HARDNESS DIAGRAM
SCALE 1:1

NOTICE - THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT

RESTRICTED

FA T15

4th ECO # 39,754	10-30-56
3rd ECO # 39,461	8-3-55
2nd ECO # 39,412	11-7-55
1st ECO # 39,350	7-14-55

ORIGINAL DATE	JUNE 27 1956
DRAWING NO.	FA T15
MATERIAL	CARTRIDGE BRASS
SPEC. MIL-S-10	
HEAT TREATMENT	
FINAL PROTECTIVE FINISH	

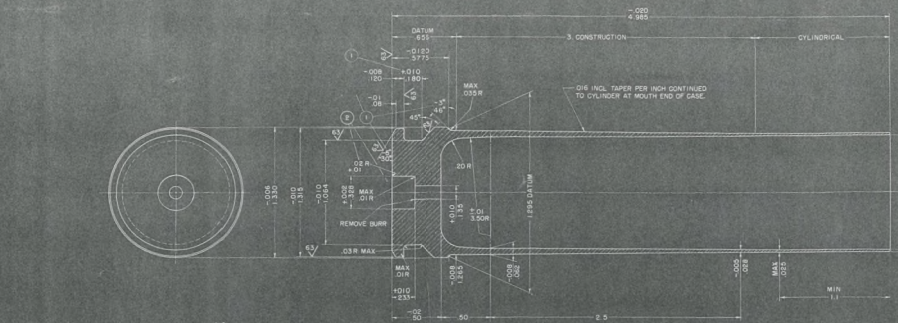
CASE, CARTRIDGE
30 MM
FA T15

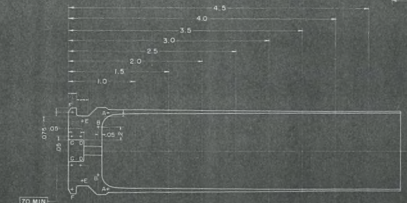
FRANKFORD ARSENAL

SIZE D

CLASS & DIV.

FD18081





ROCKWELL HARDNESS 30-T REQUIREMENTS

CASES SHALL BE SECTIONED THROUGH THE LONGITUDINAL AXIS FOR HARDNESS TESTS.

HARDNESS FIGURES ARE AVERAGES OF ALL READINGS TAKEN ON AN INDIVIDUAL CASE AT THE POSITION LISTED.

POSITIONS 1.5, 4.0, 3.5, 3.0, 2.5, 2.0, 1.5 AND 1.0
FOUR READINGS SHALL BE TAKEN AT EACH POSITION ON THE INNER WALL, TWO ON EACH HALF OF THE SECTIONED CASE.

POSITIONS A, B, C, D, E AND F ON HEAD SECTION
TWO READINGS SHALL BE TAKEN AT EACH POSITION, ONE ON EACH SIDE OF LONGITUDINAL AXIS ON SECTION.

FA T15-EI

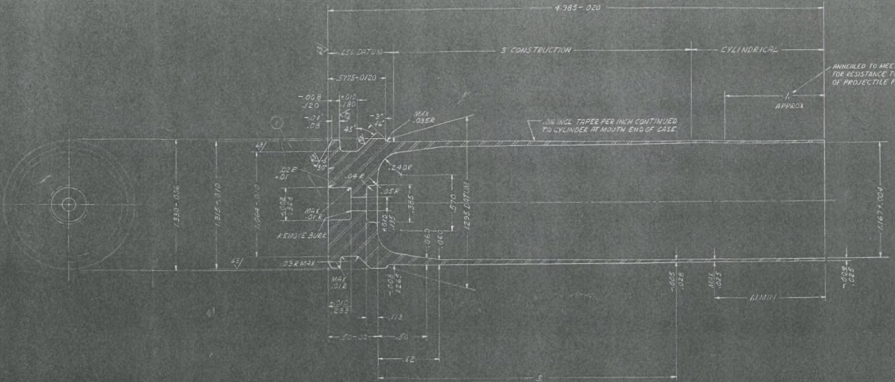
REVISIONS		
5	E.C.O. W61,214	4-23-56
1	E.C.O. #140,199	3-9-54

MATERIAL		DRAWN BY	DEC 11, 1953	FRANKFORD ARSENAL	
CHECKED		TRACED BY		ORDNANCE DEPT.	
APPROVED		CASE NO. CARTRIDGE BRASS SPEC MIL-B-150		DEPT. OF THE ARMY	
		HEAT TREATMENT		CASE, CARTRIDGE 30 MM FA T15-EI	
		APPLICATION DO NOT SCALE THIS DRG	FINAL PROTECTIVE FINISH	WT. (STD. OF APPROX.)	SIZE D

NOTICE—
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

FD18081

CLASS & DIV. D SCT/SA936/M



NOTE
MANUFACTURED BY ARC LIGHT DIV. OF THOMAS INDUSTRIES INC.

NOTE
THIS PLATE PER D 161 EXTERIOR SURFACE TYPE II CLASS 3 SPEC. MIL-C-12 SCD EXCEPT ONLY ONE TEST

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVAL

PHYSICAL PROPERTIES			
YS			
TS			
EL			
RA			
BH			
NEXT ASSY		USED ON	
APPLICATION			
DO NOT	APPLY PAINT NOR		
DO	AS SPECIFIED		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON DECIMALS	
ANGLES	FRACTIONS
MATERIAL SPECIFICATION MIL-S-12560	
HEAT TREATMENT	
FINISH	
FINAL PROTECTIVE FINISH	

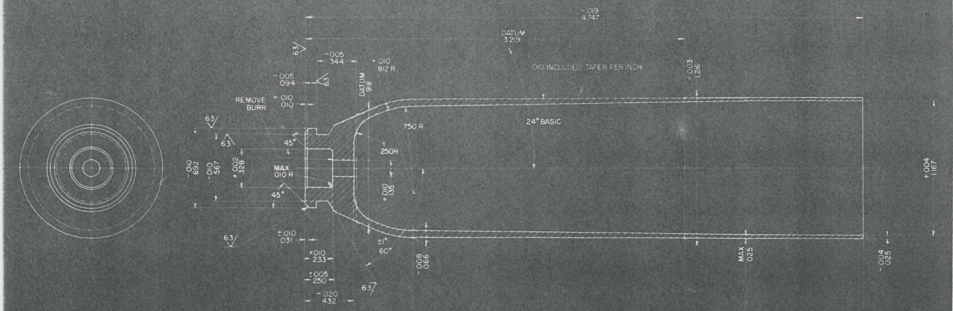
ORIGINAL DATE 20 JULY 1960	
APPROVED	ENGINEER
DRAWN	CHECKER
TRACED	CHECKER
STRESS	ENGINEER
SUBMITTED	
DES. ENGR.	
APPROVED BY DIRECTOR THE ORD. CORPS	
DES. ITEMS	SCALE 3/1
UNIT WT	

CASE, CARTRIDGE, 3 MM
TATNUM/EL HEAT TREATS
DESIGN STUDY

FRANKFORD ARSENAL ORDNANCE CORPS
DEPT OF THE ARMY

SIZE D
SHEET OF

FG 4324



CASE, CARTRIDGE
30 MM
FA T32

	FD 18079	GTC, PRACTICE 30MM T224

WT (TBD) OR APPROX		
DRAWN	J.C.	2-3-44
TRACED	J.C.	2-3-44
CHECKED		E.K.C.
APPROVED	Alfred S. Holmes	ENG.
APPROVED	W. A. Walters	ENG.

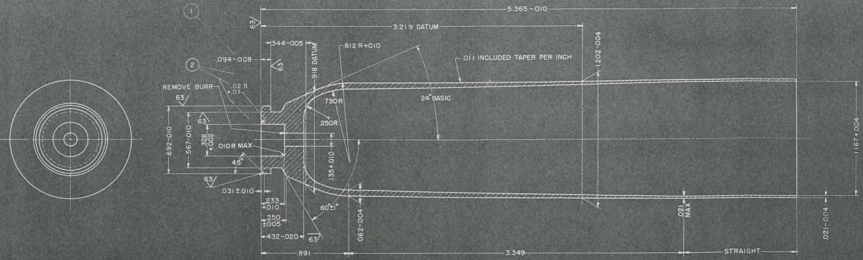
C FRANKFORD ARSENAL

NOTICE: THIS DRAWING SHALL NOT BE USED NOR REPRODUCED, EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

RESTRICTED
FA T32

CLASS A DIV

FD18201



FA T32-E1

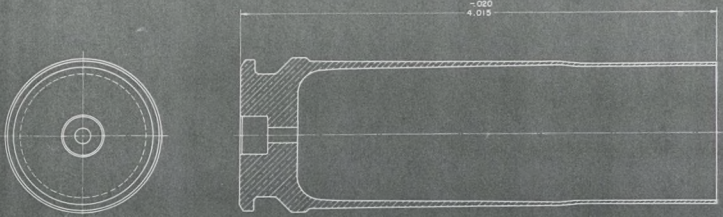
FD18200 CTG. 30MM, T269	CARTRIDGE BRASS SPEC. MIL-C-50	AUG 8 1955	CASE, CARTRIDGE, 30MM, FA T32-E1	FRANKFORD ARSENAL ORDNANCE CORPS
			WT. 1865 GR APPROX	D

NOTICE:
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED FOR THE MANUFACTURE EXCEPT WHERE SUCH USE IS IN CONFORMITY WITH UNITED STATES GOVERNMENT PROCUREMENT

FD18200

FC4326

ORIGINAL DATE OF DRAWING: DECEMBER 4, 1953



CARTRIDGE BRASS SPEC MIL-B-50
FOR FINISHES AND OTHER DIMENSIONS SEE DRAWING D7553342

CASE, CARTRIDGE
30 MM,
FA T33

SCALE — 2

Alfred S. Hudson
ENG

V W Wallace
ENG

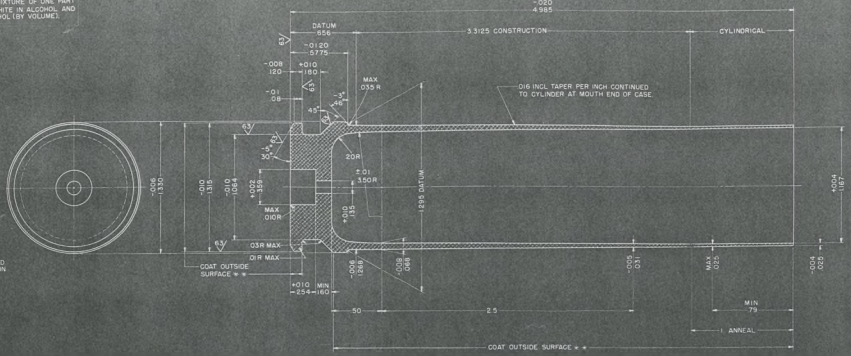
FRANKFORD ARSENAL

FA T33
RESTRICTED

NOTICE
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT

HEAT TREATMENT AND FINAL FINISH
HEAT TO 870°F, HOLD FOR 30 MIN THEN QUENCH IN WATER AT ROOM TEMPERATURE AGE AT 250° F FOR 3 HOURS FOLLOWED BY 350° F FOR 3 HOURS. COOL IN AIR.
PRETREATMENT AND FINISH PER 23.04, SPEC MIL-P-12011, FOR ALL SURFACES, INSIDE AND OUTSIDE, (NON-ANODIZED AREAS NOT ALLOWED)
HEAT I.D. NECK IN SALT BATH AT 700° F FOR 15 SECONDS, THEN QUENCH IN WATER AT ROOM TEMPERATURE.
COAT OUTSIDE SURFACE * * WITH A MIXTURE OF ONE PART CONCENTRATED DISPERSION OF GRAPHITE IN ALCOHOL, AND TEN PARTS DENATURED ETHYL ALCOHOL BY VOLUME.

NOTE:-
PRIMER POCKET IS DIMENSIONED FOR ASSEMBLY WITH REMINGTON SEALED CUP PRIMER

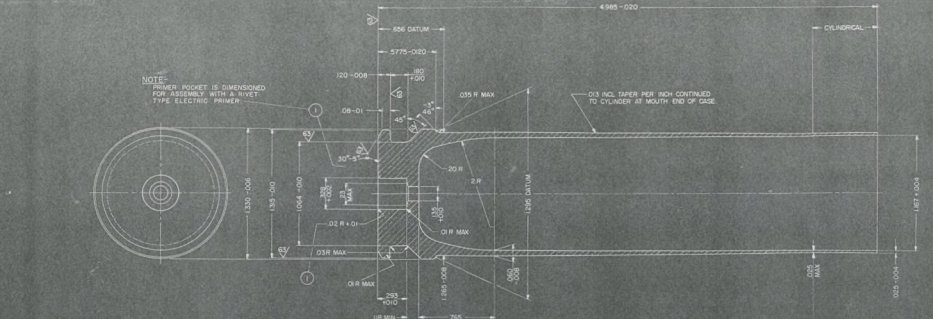


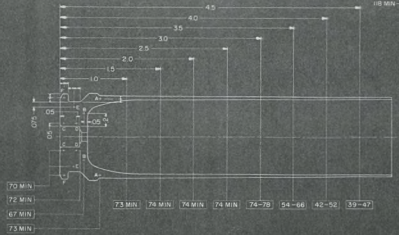
FA T40

		ALUMINUM ALLOY SPEC QQ-A-283	APRIL 21, 1955	CASE, CARTRIDGE 30MM FA T40	FRANKFORD ARSENAL ORDNANCE CORPS DEPT OF THE ARMY
					D

FD18192

CLASS A DIA FD18219





ROCKWELL HARDNESS 30-T REQUIREMENTS

CASES SHALL BE SECTIONED THROUGH THE LONGITUDINAL AXIS FOR HARDNESS TESTS.

HARDNESS FIGURES ARE AVERAGES OF ALL READINGS TAKEN ON AN INDIVIDUAL CASE AT THE POSITION LISTED.

POSITIONS 4.5 4.0 3.5 3.0 2.5 2.0 1.5 AND 1.0
FOUR READINGS SHALL BE TAKEN AT EACH POSITION ON THE INNER WALL, TWO ON EACH HALF OF THE SECTIONED CASE.

POSITIONS A, B, C, D, E, AND F ON HEAD SECTION
TWO READINGS SHALL BE TAKEN AT EACH POSITION, ONE ON EACH SIDE OF LONGITUDINAL AXIS ON SECTION.

FA T50

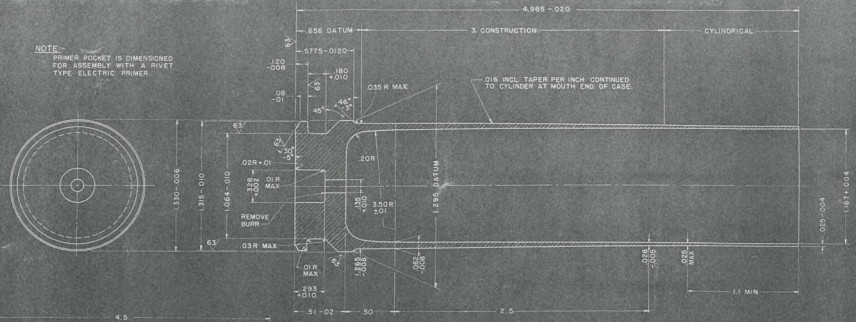
1ST E.C.O. 4-23-56

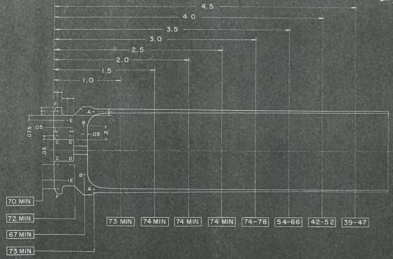
NOTICE- THIS DRAWING SHALL NOT BE USED, NOR REPRODUCED EITHER WHOLLY OR IN PART, EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT

	NOV 15, 1955	CASE, CARTRIDGE, 30 MM, FA T50	FRANKFORD ARSENAL, ORDNANCE CORPS
	CASE — CARTRIDGE BRASS SPEC. NO. — 8-50		
	Alfred B. Nielsen 87		

CLASS & DIV.

FD 18244





ROCKWELL HARDNESS 30-T REQUIREMENTS

CASES SHALL BE SECTIONED THROUGH THE LONGITUDINAL AXIS FOR HARDNESS TESTS. HARDNESS FIGURES ARE AVERAGES OF ALL READINGS TAKEN ON AN INDIVIDUAL CASE AT THE POSITION LISTED. POSITIONS 4.5, 4.0, 3.5, 3.0, 2.5, 2.0, 1.5 AND 1.0

FOUR READINGS SHALL BE TAKEN AT EACH POSITION ON THE INNER WALL, TWO ON EACH HALF OF THE SECTIONED CASE POSITIONS A, B, C, D, E AND F ON HEAD SECTION.

TWO READINGS SHALL BE TAKEN AT EACH POSITION, ONE ON EACH SIDE OF LONGITUDINAL AXIS ON SECTION.

FAT55

PHYSICAL PROPERTIES	DIMENSIONS ON MATERIAL BEFORE PROCESSING	ORIGINAL LIMITS ISSUED	REVISIONS
	MATERIAL: CARTRIDGE BRASS SPEC MIL-B-50 CLASS 2 (HOT ROLLED)	JUNE 18, 1956 R.P.P.	
	FINISH: SEE SPECIFICATION		
	HEAT TREATMENT:		
	FINAL PROTECTIVE FINISH:		

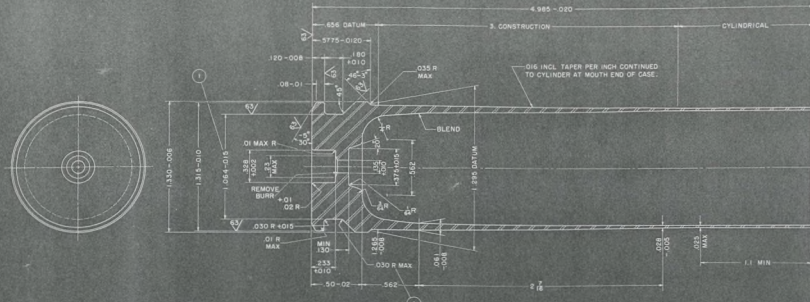
CASE, CARTRIDGE, 30 MM, FAT55

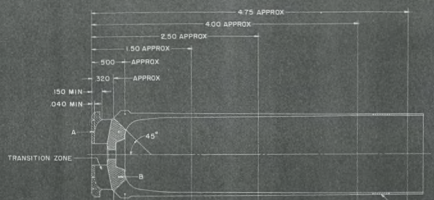
AMMUNITION GROUP
ORDNANCE CORPS
DEPT OF THE ARMY
FRANKFORD ARSENAL

SIZE D FD 18244

AMM DEV DIV

NOTICE:-
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.





ROCKWELL HARDNESS REQUIREMENTS

GASES SHALL BE SECTIONED THROUGH THE LONGITUDINAL AXIS FOR HARDNESS TESTS.
HARDNESS FIGURES ARE AVERAGES OF ALL READINGS TAKEN ON AN INDIVIDUAL CASE AT THE POSITION LISTED.
POSITIONS 4.75, 4.00, 2.50, & 1.50
FOUR READINGS SHALL BE TAKEN AT EACH POSITION, TWO ON EACH HALF ON THE INSIDE SURFACE OF THE SECTIONED CASE, NOT MORE THAN ONE READING AT EACH POSITION MAY BE OUTSIDE OF THE VALUES SHOWN.
POSITION .500
TWO READINGS SHALL BE TAKEN, ONE ON EACH SIDE OF LONGITUDINAL AXIS ON SECTION AS INDICATED.
POSITION IN SECTION "B"
TWO READINGS SHALL BE TAKEN, ONE ON EACH SIDE OF LONGITUDINAL AXIS ON SECTION AS INDICATED.
POSITION IN SECTION "A"
FOUR READINGS SHALL BE TAKEN, TWO ON EACH SIDE OF LONGITUDINAL AXIS ON SECTION AS INDICATED.

* NOTE-
ZINC PLATE, REQ'D ON EXTERIOR SURFACE, TYPE II, CLASS 3, SPEC QQ-Z-325, EXCEPT SALT SPRAY TEST.

FA T56

REVISIONS		
LTR	ECO #	DATE
D	ECO #41,035	11-7-56
E	ECO #41,028	8-7-56

NOTICE:-
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

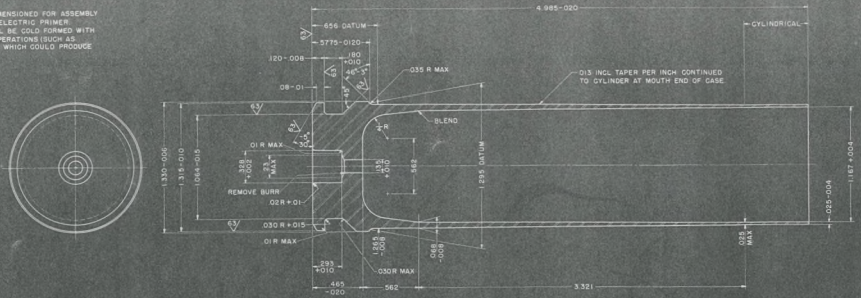
MATERIAL SPECIFICATIONS		DRAWN BY	DATE	CASE, CARTRIDGE 30MM, FA T56	AMMUNITION GROUP ORDNANCE CORPS DEPT OF THE ARMY FRANKFORD ARSENAL
COMPOSITION		TRACED BY	DATE		
MIL-S-5281	STEEL-SPEC-	CHECKED BY	DATE		
TEMPER	HARDEN &	APPROVED BY	DATE		
APPLICATION					
FOR MAKE	FOR INSPECT				

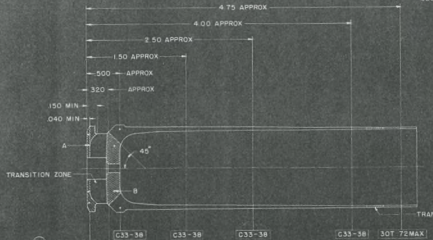
SIZE D | FD18246
SCALE 1/1 | SHEET 1 OF 1

FD20363

A	ECO # 41,058	8-30-97

NOTE:
PRIMER POCKET IS DIMENSIONED FOR ASSEMBLY WITH A RIVET TYPE ELECTRIC PRIMER. PRIMER POCKET SHALL BE COLD FORMED WITH NO LATER MACHINE OPERATIONS (SUCH AS REAMING OR DRILLING) WHICH COULD PRODUCE SCORE MARKS.





HARDNESS DIAGRAM

ROCKWELL HARDNESS REQUIREMENTS

CASES SHALL BE SECTIONED THROUGH THE LONGITUDINAL AXIS FOR HARDNESS TESTS.
HARDNESS FIGURES ARE AVERAGES OF ALL READINGS TAKEN ON AN INDIVIDUAL CASE AT THE POSITION LISTED.
POSITIONS 4.75, 4.00, 2.50, & 1.50
FOUR READINGS SHALL BE TAKEN AT EACH POSITION, TWO ON EACH HALF ON THE INSIDE SURFACE OF THE SECTIONED CASE, NOT MORE THAN ONE READING AT EACH POSITION MAY BE OUTSIDE OF THE VALUES SHOWN.
POSITION .500
TWO READINGS SHALL BE TAKEN, ONE ON EACH SIDE OF LONGITUDINAL AXIS ON SECTION AS INDICATED.
POSITION IN SECTION "B"
TWO READINGS SHALL BE TAKEN, ONE ON EACH SIDE OF LONGITUDINAL AXIS ON SECTION AS INDICATED.
POSITION IN SECTION "A"
FOUR READINGS SHALL BE TAKEN, TWO ON EACH SIDE OF LONGITUDINAL AXIS ON SECTION AS INDICATED.

* NOTE:
ZINC PLATE, REQ'D ON EXTERIOR SURFACE, TYPE II, CLASS 3, SPEC QQ-Z-325, EXCEPT SALT SPRAY TEST.

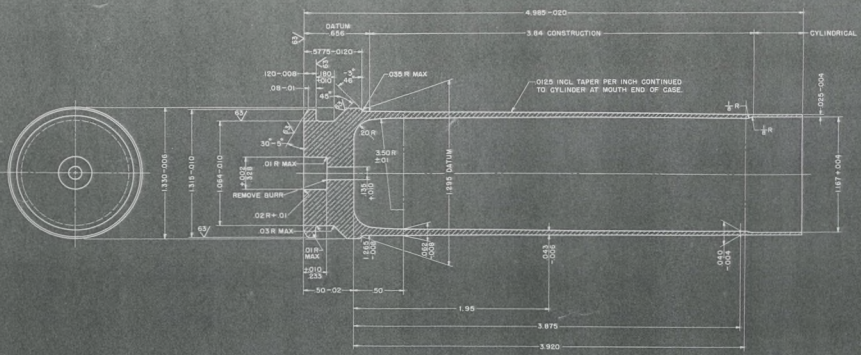
NOTICE
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

FA T56-E1

			CASE, CARTRIDGE, 30MM, FA T56-E1	AMMUNITION GROUP ORDNANCE CORPS DEPT OF THE ARMY FRANKFORD ARSENAL
				D FD20363

CLASS & DIV.

FD20315



FA T58

REVISIONS			
LTR	DESCRIPTION	DATE	APPD

NOTICE-
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

MATERIAL PROPERTIES			

NEXT ASSY | USED ON
APPLICATION
DO NOT APPLY PART NO'S

MANUFACTURING DEPARTMENT OF RECORD	
TOLERANCES ON: DECIMALS	
ANGLES	FINISH
MATERIAL- CARTRIDGE BRASS SPEC. MIL-S-55	
HEAT TREATMENT	
FINAL PROTECTIVE FINISH	

ORIGINAL DATE SEPT 13, 1956
LAST DRAWING REVISION DATE
SECTION
VIEW
APPROVED
DRAWN
TRACED
CHECKED
ENGR APPROVAL
DES. CHIEF
ENGR. GROUP
SCALE

CASE, CARTRIDGE, 30 MM, FA T58

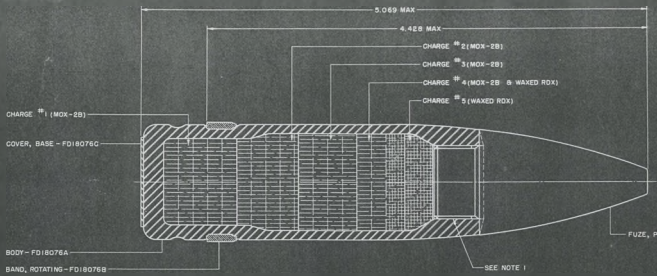
AMMUNITION GROUP
ORDNANCE CORPS
DEPT OF THE ARMY
FRANKFORD ARSENAL

SIZE D | FD20315

UNIT WT | SHEET 1 OF 1

CLASS A DIV

FD18078



NOTES :-

1. COAT THREADS OF FUZE OR BODY WITH CEMENT, TYPE A, SPEC JAN-C-99 AND ASSEMBLE WHILE WET. WHEN THE CEMENT HAS SUFFICIENTLY SET, FUZE SHALL WITHSTAND 10 IN LB TORQUE (COUNTER-CLOCKWISE) WITHOUT LOOSENING.
2. FUZE MAY BE ASSEMBLED TO CHARGED SHELL AFTER ASSEMBLY OF SHELL WITH CARTRIDGE CASE.

1 LINE NO.	2 DRAWING NO.	3 PIECE MARK	SHELL, H.E., 30MM, T23925 LIST OF PARTS & ASSEMBLIES	4 MATERIAL	5 MATERIAL SPEC	6 NO. REQ'D PER UNIT ASSY.	7 WEIGHT IN GRAINS	
1	FD18075		SHELL LOADING ASSY & MARKING DIAGRAM				3912.	APPROX
2	FC 4321		METAL PARTS ASSY & MARKING DIAGRAM				2390.	APPROX
3	FD18076	FD18076A	BODY	STEEL	MIL-S-43	1	2960.	APPROX △
4	FD18076	FD18076B	BAND, ROTATING	GILDING METAL	MIL-B-20292	1		
5	FD18076	FD18076C	COVER, BASE	STEEL AS CUP TO SUIT	57-136	1	30.	APPROX
6			CHARGE # 1	MOX-2B		1	224.	±2.
7			CHARGE # 2	MOX-2B		1	224.	±2.
8			CHARGE # 3	MOX-2B		1	224.	±2.
9			CHARGE # 4	MOX-2B & WAXED ROX		1	115.	±1.
10			CHARGE # 5	WAXED ROX		1	69.	± *
11			FUZE, PD, T105			1	735.	APPROX
12				TOTAL WEIGHT OF SHELL			4647.	APPROX

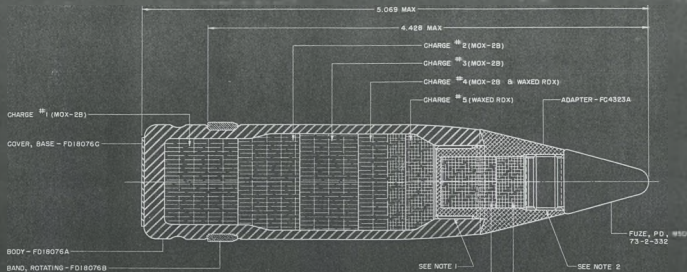
△ WEIGHT OF ROTATING BAND 153 GRAINS APPROX

* SEE LOADING ASSEMBLY

NOTICE :-
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PRO-CUREMENT

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED

PHYSICAL PROPERTIES		FD18077 STR, H.E., 30MM, T105D	TOLERANCES ON: DECIMALS ANGLES FRACTIONS	ORIGINAL DATE OF DRAWING MARCH 11, 1954	SHELL, H.E. I., 30MM T23925 ASSEMBLY	FRANKFORD ARSENAL ORDNANCE DEPT DEPT OF THE ARMY	
LB				DRAWN BY JC CHECKED BY JC			
TL				TRACED BY JC CHECKED BY JC			
RA				DESIGNED BY			
BH		NEXT ASSY	USED ON	MATERIAL	SUBMITTED: Albert E. Nelson		
		APPLICATION		HEAT TREATMENT	APPROVED: J. W. Watson		
BH		DO NOT	APPLY PART NO.	FINAL PROTECTIVE FINISH		SCALE: 2	WT- SEE TABLE
		DO	AS SPECIFIED			SIZE D	SHEET 1 OF



NOTES :-

1. COAT THREADS OF ADAPTER OR BODY WITH CEMENT, TYPE A, SPEC JAN-C-99 AND ASSEMBLE WHILE WET. WHEN THE CEMENT HAS SUFFICIENTLY SET, ADAPTER SHALL WITHSTAND 10 IN LB TORQUE (COUNTER-CLOCKWISE) WITHOUT LOOSENING.
2. COAT THREADS OF FUZE OR ADAPTER WITH CEMENT, TYPE A, SPEC JAN-C-99 AND ASSEMBLE WHILE WET. WHEN THE CEMENT HAS SUFFICIENTLY SET, FUZE SHALL WITHSTAND 10 IN LB TORQUE COUNTER-CLOCKWISE) WITHOUT LOOSENING.
3. ADAPTER AND FUZE MAY BE ASSEMBLED TO CHARGED SHELL AFTER ASSEMBLY OF SHELL WITH CARTRIDGE CASE

COL. LINE	1 DRAWING NO.	2 PIECE MARK	3 SHELL, H.E.I., 30 MM, T239E6 LIST OF PARTS & ASSEMBLIES	4 MATERIAL	5 MATERIAL SPEC	6 NO. REQ'D PER UNIT ASSY	7 WEIGHT IN GRAINS	
1	FD18075		SHELL, LOADING ASSY @ MARKING DIAGRAM				3912. APPROX	
2	FC 4321		METAL PARTS ASSY @ MARKING DIAGRAM				2990. APPROX	
3	FD18076	FD18076A	BODY	STEEL	MIL-S-43	1	2960. APPROX	△ WEIGHT OF ROTATING BAND 153. GRAINS APPROX
4	FD18076	FD18076B	BAND, ROTATING	GILDING METAL	MIL-B-20292	1	30. APPROX	
5	FD18076	FD18076C	COVER, BASE	STEEL RESIDUE TO MIL-S-43	97-136	1	30. APPROX	
6			CHARGE #1	MOX-2B		1	224. ±2.	
7			CHARGE #2	MOX-2B		1	224. ±2.	
8			CHARGE #3	MOX-2B		1	224. ±2.	
9			CHARGE #4	MOX-2B & WAXED RDX		1	112. ±1. 69. ±	* SEE LOADING ASSEMBLY
10			CHARGE #5	WAXED RDX		1	69. *	
11	FC 4322		ADAPTER LOADING ASSY				369. APPROX	
12	FC 4323	FC 4323A	ADAPTER	ALUMINUM ALLOY 24S	QQ-A-227 QQ-A-268	1	285. APPROX	
13			CHARGE #1	WAXED RDX		1	56. ±1.	
14			CHARGE #2	WAXED RDX		1	28. *	
15	73-2-332		FUZE, PD, M505			1	330. APPROX	
16				TOTAL WEIGHT OF SHELL			4611. APPROX	

NOTICE:-
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PHYSICAL PROPERTIES

FD18075 CTG, H.E.I., 30MM, T160

MATERIAL

HEAT TREATMENT

APPLICATION

NEXT ASSY USED ON

FINISH

PROTECTIVE FINISH

ORIGINAL DATA
SC DRAWING MARCH 11, 1954
DRAWN JP
TRACED JP
CHECKED JP
APPROVED
SUBMITTED
APPROVED

SHELL, H.E.I., 30MM T239E6 ASSEMBLY

FRANKFORD ARSENAL ORDNANCE DEPT DEPT OF THE army

SIZE D

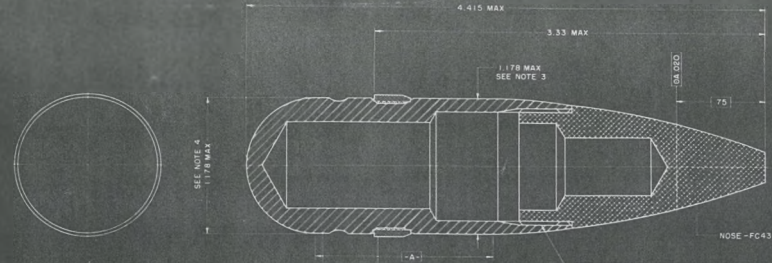
SCALE 1 WT- SEE TABLE

SHEET

REVISIONS

LTR	DESCRIPTION	DATE	APPROVED

FC4317



COAT THREADS OF NOSE OR BODY WITH CEMENT, PETTMAN, TYPE A, SPEC JAN-C-99 * AND ASSEMBLE WHILE WET. WHEN THE CEMENT HAS SUFFICIENTLY SET, NOSE SHALL WITHSTAND 10 IN. LB TORQUE (COUNTER-CLOCKWISE) WITHOUT LOOSENING

* ALTERNATIVE MATERIAL - CEMENT, PETTMAN, TYPE B, SPEC JAN-C-99

NOTES:-
1. FOR TOLERANCE SYMBOLS, INTERPRETATION SEE DRAWING 30-[illegible]
2. TO BE MEASURED BEFORE COATING
3. DIMENSION .78 MAX IS INCLUSIVE OF APPLIES AFTER COATING, INCLUDING TOUCH-UP IF REQUIRED
4. DIMENSION .78 MAX AT REAR OF ROTATING BAND APPLIES AFTER COATING

COL. 1	2	3	4	5	6	7
LINE NO.	DRAWING NO.	PIECE MARK	PROJECTILE, PRACTICE 30MM, T304 LIST OF PARTS & ASSEMBLIES	MATERIAL	MATERIAL SPEC	NO. REQ'D PER UNIT ASSY	WEIGHT IN GRAINS
			MARKING DIAGRAM				
1	FC4318						
2	FC4319	FC4319A	BODY	STEEL	MIL-S-43	1	
3	FC4319	FC4319B	BAND, ROTATING	GILDING METAL	MIL-B-20292	1	2720 ±50 Δ
4	FC4320	FC4320A	NOSE	ALUMINUM ALLOY	QQ-A-[illegible]	1	495 ±40
5				TOTAL WEIGHT OF PROJECTILE			3215 ±90

Δ WEIGHT OF ROTATING BAND 153 GRAINS APPROX

SEE DETAIL DRAWINGS FC4319 & FC4320 FOR ALTERNATIVE MATERIALS & ALTERNATIVE DESIGNS

NOTICE:-
[illegible]

ORIGINAL DATE OF DRAWING AUGUST 24, 1951

NO.	DATE	BY	ECO NO.
1	1-15-54	ECO	38,767
2	6-25-54	ECO	40,144

PROJECTILE, PRACTICE 30MM, T304 ASSEMBLY

WEIGHT SEE TABLE

SCALE 4

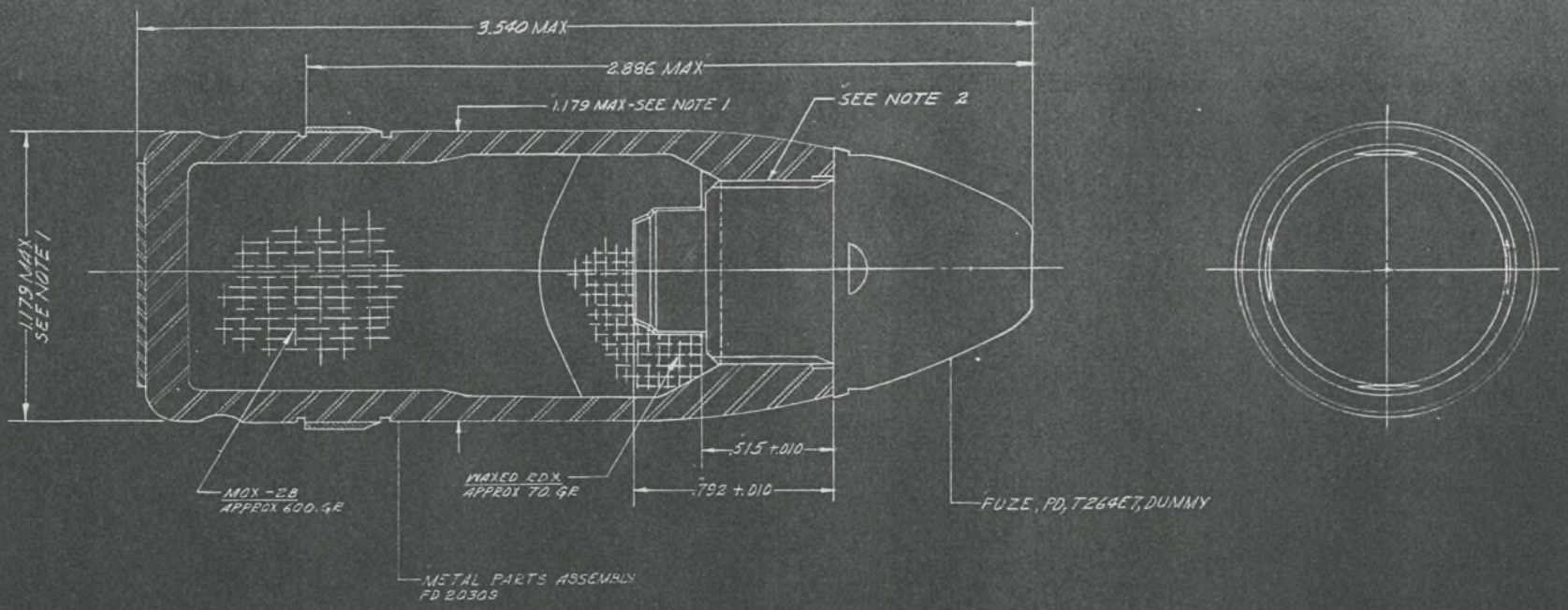
DO NOT SCALE PRINT	AS DRAWN (Inches)
	.78
	.78
	.780

DRAWN [illegible]

APPROVED [illegible]

FRANKFORD ARSENAL

FC 5977



NOTES:-

1. DIMENSIONS 1.179 MAX APPLY AFTER COATING INCLUDING TOUCH-UP.
2. SECURE DUMMY FUZE TO BODY BY APPLYING LAMINAC DM4116 WITH LUPERSOL DDM OR APPROVED EQUAL TO DUMMY FUZE AND BODY THREADS.
3. DUMMY FUZE MAY BE ASSEMBLED TO CHARGED SHELL AFTER ASSEMBLY OF SHELL WITH CARTRIDGE CASE.

NOTICE:
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

SYM	DESCRIPTION	DATE	APPROVAL

REVISIONS

PHYSICAL PROPERTIES

YP
TS
EL 2
RA
BH
RH

CTG. 30MM, HEI, T306E14

NEXT ASSY | USED ON

APPLICATION

DO NOT | APPLY PART NO.
DO | AS SPECIFIED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCES ON DECIMALS
ANGLES FRACTIONS

MATERIAL

HEAT TREATMENT

FINAL PROTECTIVE FINISH

ORIGINAL DATE OF DRAWING NOV 16, 1936

DRAFTSMAN [illegible] CHECKER [illegible]

SUBMITTED [illegible] ORD CORPS

APPROVED [illegible] COL. ORD CORPS

SHELL, 30 MM, HEI, T306E14 DESIGN STUDY #2

SCALE:- 2 | UNIT WT

AMMUNITION GROUP
ORDNANCE CORPS
DEPT OF THE ARMY
FRANKFORD ARSENAL

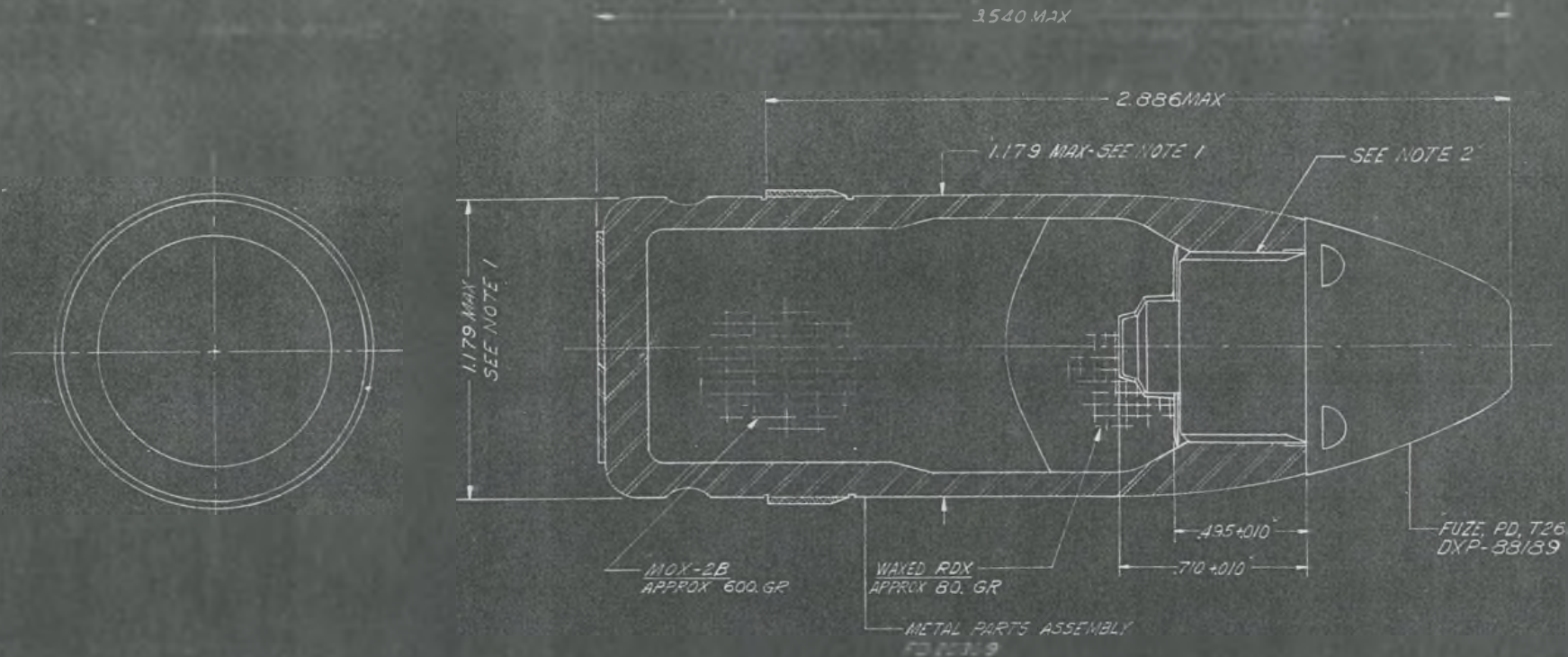
DWG SIZE C | FC 5977

SHEET 1 OF 1

AM. DEF.

RAPID

FC5966



NOTES -

1. DIMENSIONS 1.179 MAX APPLY AFTER COATING INCLUDING TOUCH-UP.
2. SECURE FUZE TO BODY BY APPLYING LAMINAC CA-116 WITH LUPERSOL DDM OR APPROVED EQUAL TO FUZE AND BODY THREADS.
3. FUZE MAY BE ASSEMBLED TO CHARGED SHELL AFTER ASSEMBLY OF SHELL WITH CARTRIDGE CASE.

NOTICE:-
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

PHYSICAL PROPERTIES	CTG, 30 MM, HEI T206E14	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TP		TOLERANCES ON DECIMALS
TS		ANGLES FRACTIONS
EL 2		MATERIAL
RA		
BH	NEXT ASSY USED ON	HEAT TREATMENT
	APPLICATION	FINAL PROTECTIVE FINISH

ORIGINAL DATE OF DRAWING	JUNE 4, 1956
DRAFTSMAN	CHECKER
TRACER	
SUBMITTED	ORD CORPS
APPROVED	

SHELL, 30MM, HEI, T306E14 DESIGN STUDY #1

SCALE | UNIT WT

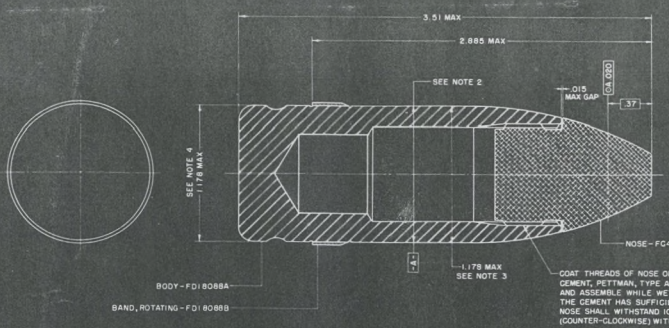
AMMUNITION GROUP
ORDNANCE CORPS
DEPT OF THE ARMY
PRANSCRE ARSENAL

DWG SIZE C | FC5966 | SHEET OF

FC43

ORIGINAL DATE OF DRAWING FEBRUARY 26, 1954

NO.	REVISED DATE	BY	CHK	APP'D	REMARKS
1	6-15-54	E.C.O. # 40,164			
2	7-20-54	E.C.O. # 40,185			
3	12-7-55	E.C.O. # 40,975			



NOTES -
1. FOR TOLERANCE SYMBOL INTERPRETATION SEE DRAWING 30-1-7.
2. TO BE MEASURED BEFORE COATING.
3. DIMENSION 1.178 MAX ON BOURRELET APPLIES AFTER COATING, INCLUDING TOUCH-UP IF REQUIRED.
4. DIMENSION 1.178 MAX AT REAR OF ROTATING BAND APPLIES AFTER COATING

COL.	1	2	3	4	5	6	7
LINE NO.	DRAWING NO	PIECE MARK	PROJECTILE, TARGET PRACTICE 30MM, T328 LIST OF PARTS & ASSEMBLIES	MATERIAL	MATERIAL SPEC	NO. REQ'D PER UNIT ASSY	WEIGHT IN GRAINS
1	FC 4338		MARKING DIAGRAM				
2	FD18088	FD18088A	BODY	STEEL	OAC-PD-17	1	3450 ± 40 △
3	FD18088	FD18088B	BAND, ROTATING	COPPER	⊕	1	
4	FC 4339	FC 4339A	NOSE	ALUMINUM ALLOY	QQ-A-367 QQ-A-286	1	450 ± 15
5				TOTAL WEIGHT OF PROJECTILE			3900 ± 55

△ WEIGHT OF ROTATING BAND 75 GRAINS APPROX

SEE DETAIL DRAWINGS FD18088 & FC4339 FOR ALTERNATIVE MATERIALS & ALTERNATIVE DESIGNS.
⊕ SEE COMPONENT DRAWING FOR COMPOSITION

NOTICE -
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT

PROJECTILE, TARGET PRACTI
30MM, T328
ASSEMBLY

MATERIAL PROPERTIES	DRAWN BY / DATE / CHK'D BY
WEIGHT SEE TABLE	DO NOT SCALE PRINT
SCALE — 2	P.C. 2-2-54
TOLERANCES UNLESS OTHERWISE SPECIFIED	P.C. 2-2-54
	E.R.S.
	SUBMITTED: Alfred P. Hottman, Jr. ENG.
	APPROVED: W. W. Walton ENG.

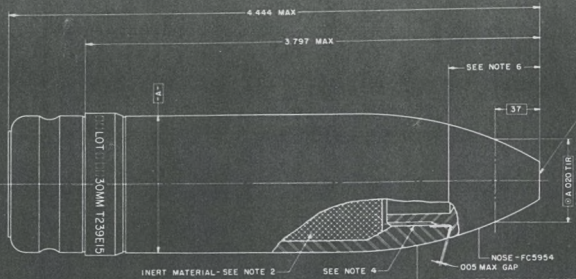
FRANKFORD ARSENAL

1038

ORDNANCE DRAWING - SIZE C

FC5953

MARCH 16, 1956



TES-

FOR TOLERANCE SYMBOL INTERPRETATION SEE MIL-STD-8
INERT MATERIAL TO MEET WEIGHT REQUIREMENT
OF PROJECTILE
RETOUCH BODY SURFACE OF ASSEMBLY, WHERE DAMAGED,
WITH ENAMEL, LUSTRELESS, QUICK DRYING, SPEC
MIL-E-10687 (GREEN NO 3412, SPEC TT-C-595)
SECURE NOSE TO BODY BY APPLYING LAMINAC DM4116
WITH LUPERSOL DDM OR APPROVED EQUAL TO NOSE
AND BODY THREADS
CONCENTRICITY OF ASSEMBLY TO BE MEASURED
BEFORE PAINTING NOSE
COAT NOSE, AFTER ASSEMBLY, WITH ENAMEL,
LUSTRELESS, QUICK DRYING, SPEC MIL-E-10687 OR LACQUER
LUSTRELESS, HOT SPRAY, SPEC MIL-L-11195 COLOR-BLACK
NO.3725, SPEC TT-C-595

ASSEMBLIES & LIST OF PARTS

LINE NO.	DRAWING NUMBER	PIECE MARK	NAME OF PART
1	FC5953		PROJECTILE, BALL, 30MM, ASSEMBLY
2	FC4333		METAL PARTS ASSEMBLY AND MARKING DIAGRAM
3	FD18086	FD18086B	BAND, ROTATING
4	FD18086	FD18086A	BODY
5	FD18086	FD18086C	COVER, BASE
6	FC5954	FC5954	NOSE
7	FC5953		INERT MATERIAL

CE-
IS DRAWING SHALL NOT BE USED NOR
RODUCED EITHER WHOLLY OR IN PART
CEPT WHEN AUTHORIZED IN CONNECTION
TH UNITED STATES GOVERNMENT PRO-
REMENT

PROJECTILE, BALL, 30MM, ASSEMBLY

MATERIAL (NOMENCLATURE) | STANDARD PERTAINING TO | CERT. WEAPONS: BALL, 30MM, M2A1

WT. 430 OZ APPROX | SIZE | APPLY PART NO. to Item Number

SCALE 1

TOLERANCES ON 2 PLACE DEC. ±.01 3 PLACE DEC. ±.005 ANGLES ±1/2°

DRAWN BY: J.S. 2-24-56
TRACED BY: J.S. 2-24-56
CHKD: MJ

SUBMITTED: Alfred P. Hutton, 2ND LIEUT. ORD. CORPS

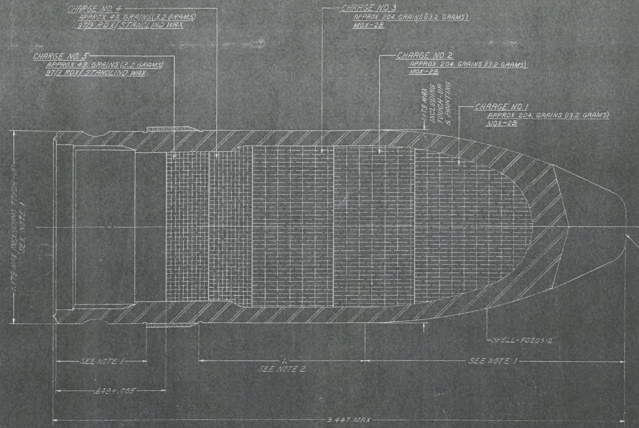
APPROVED: [signature], CAPT. ORD. CORPS

C | FRANKFORD ARSENAL

FC5953 AMM DEV DIV

CLASS & DIV.

FD20311



NOTES:
1. RETOUCH SHELL AFTER LOADING WHERE REVISED CART NO 12 DAMAGED WITH ENAMEL, LUSTRELESS, QUICK DRYING, SPEC MIL-E-11487 OR LACQUER, LUSTRELESS, NOT SPRAY, SPEC MIL-L-19537, COLOR LUSTERLESS GREEN NO 34102 FED STD 595.
2. CONT SURFACE AFTER LOADING WITH ENAMEL, LUSTRELESS, QUICK DRYING, SPEC MIL-E-11487. (RED NO 31136 SPEC FED STD 595).

REQUIREMENT CHARGE NO.	ADVISORY 10 OF PELLETS	DIAMETER	HEIGHT OF PELLET	CRUSH STRENGTH PSI(MINIMUM)
CHARGE NO 1	2	.631	.577-.601	20,000
CHARGE NO 2	2	.631	.577-.601	20,000
CHARGE NO 3	2	.631	.577-.601	20,000
CHARGE NO 4	1	.631	.327-.301	20,000
CHARGE NO 5	1	.631	.327-.301	20,000

NOTICE:-
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REVISIONS			
ZONE	DESCRIPTION	DATE	APPROVAL

PHYSICAL PROPERTIES		
A.S.		
T.S.		
E.L.		
R.A.		
BH		
H		

ORIGINAL DATE OF DRAWING	DRAWN	TRACED
SUPERSEDS DWG NO	CHECKED	APPROVED
SUBMITTED		
APPROVED		

SHELL, 37 MM, TARGET PRACTICE, LOADING ASSEMBLY & ASSEMBLY, LUBRICATING, PRIMER & WADS

ORDNANCE CORPS

DEPT OF THE ARMY

FD20311

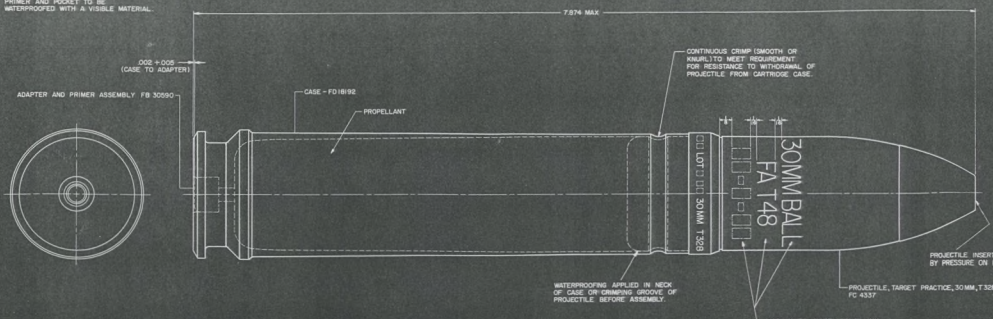
SCALE: 4

UNIT WT

SHEET 1 OF 1

AM. DEV. DIV.

CLASS & DIV. FD18212



LIST OF DRAWINGS

LINE NO	DRAWING NUMBER	TITLE
1	FD18212	CARTRIDGE, BALL, 30MM, FA T48
2	FD18192	CASE, CARTRIDGE, 30MM FA T40
3	FB30590	ADAPTER AND PRIMER ASSEMBLY
4	74-2-79	PRIMER, ELECTRIC, M52A3, ASSEMBLY AND DETAILS
5	FA28867	ADAPTER
6	FC4337	PROJECTILE, TARGET PRACTICE, 30MM, T328 ASSEMBLY
7	FC4338	MARKING DIAGRAM
8	FD18088	BODY AND ROTATING BAND
9	FC4339	NOSE

FA T48

1 ECOP 40,997 2-20-56

NOTICE-
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

MATERIAL PROPERTIES

DIMENSIONS ARE NOMINAL UNLESS OTHERWISE SPECIFIED

MATERIAL

HEAT TREATMENT

FINISH

APPLICATION

NEXT ASSY

FINAL PROTECTIVE FINISH

ORIGINAL DATE OCT. 7, 1955

DRAWN 22-8 2-20-56

TRACED 22-8 2-20-56

CHECKED Alfred A. Nelson 2-20-56

APPROVED Samuel Rosenblatt 2-20-56

CARTRIDGE, BALL, 30MM, FA T48

U. S. ORDNANCE CORPS

HANFORD ARSENAL

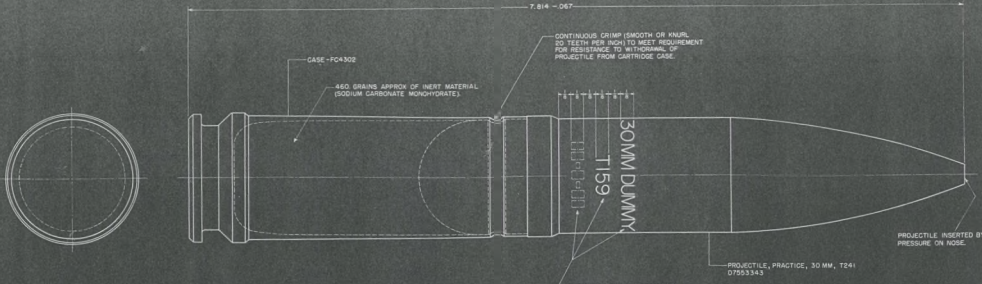
DEPT OF THE ARMY

SIZE D

5720.6R APPROX

CLASS 6 DIV.

FD18055



RESTRICTED

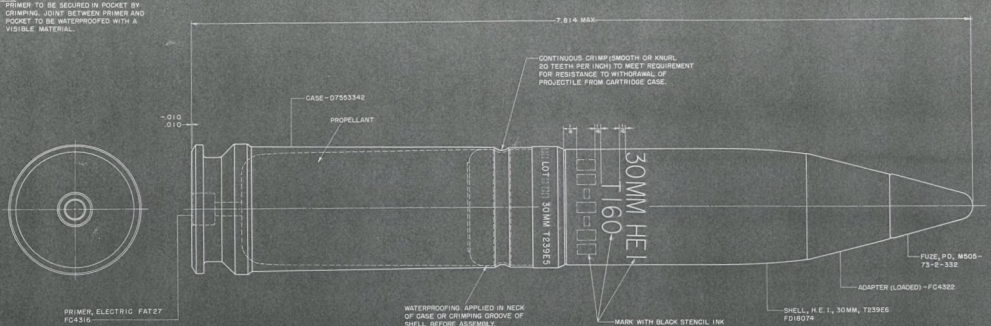
NOTICE
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED		TOLERANCES ON:		MARCH 10, 1953	FRANKFORD ARSENAL ORDNANCE DEPT DEPT OF THE ARMY
PROPERTIES		DECIMALS	.XX ±.02		
			.X ±.05		
		ANGLES	±1°		
		HEAT TREATMENT			CARTRIDGE, DUMMY 30 MM, T159
		FINAL PROTECTIVE FINISH			
APPLICATION					
DO NOT SCALE FROM THIS DRAWING					

1 E.C.O. # 34,656 3-31-55

CLASS & DIV. FDI8073

NOTE:—
PRIMER TO BE SECURED IN POCKET BY CRIMPING. JOINT BETWEEN PRIMER AND POCKET TO BE WATERPROOFED WITH A VISIBLE MATERIAL.



REVISIONS			
NO.	REVISION	DATE	APPROVED

PHYSICAL PROPERTIES		TOLERANCES ON ...	ORIGINAL DATE OF DRAWING MARCH 11 1954
		DRAWN	
		MATERIAL	
		HEAT TREATMENT	
NEXT ASSY.	USED ON APPLICATION		
DO NOT SCALE PRINT	SUPPLY PART NO.	FINAL PROTECTIVE FINISH	

CARTRIDGE, HIGH EXPLOSIVE INCENDIARY, 30MM, T160

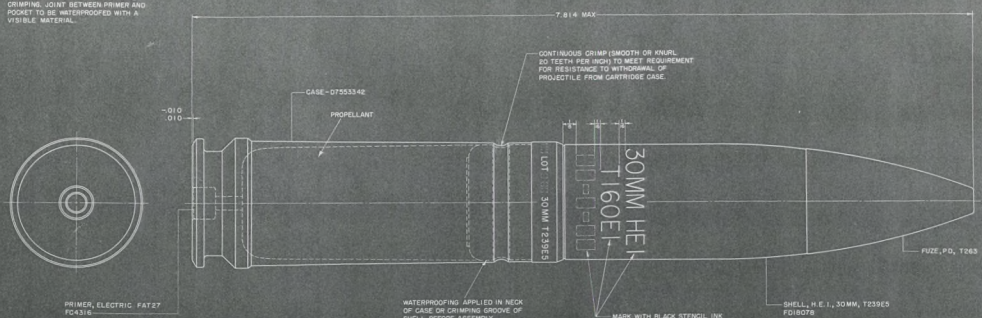
FRANKFORD ARSENAL ORDNANCE DEPT DEPT OF THE ARMY

SIZE D

SCALE 2" = 1" NOT TO SCALE OR APPROX

NOTICE:—
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

NOTE:-
PRIMER TO BE SECURED IN POCKET BY CRIMPING. JOINT BETWEEN PRIMER AND POCKET TO BE WATERPROOFED WITH A VISIBLE MATERIAL.



NOTICE:-
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

PHYSICAL PROPERTIES		TOLERANCES ON DECIMALS	ORIGINAL DATE OF DRAWING MARCH 11, 1954	CARTRIDGE, HIGH EXPLOSIVE INCENDIARY, 30MM T160E1	FRANKFORD ARSENAL ORDNANCE DEPT DEPT OF THE ARMY
		MATERIAL			
MFG. ADV.	USED ON	HEAT TREATMENT			
APPLICATION					
DO NOT	APPLY PART NO.	FINAL PROTECTIVE FINISH		WT. 736G OR APPROX	SIZE D

REVISIONS

LTR	DESCRIPTION	DATE	APPROVED

CLASS & DIV.

FD10837

NOTE –
PRIMER TO BE SECURED IN POCKET BY CRIMPING JOINT BETWEEN PRIMER AND POCKET TO BE WATERPROOFED WITH A VISIBLE WATERSEAL

7.314 - .047

.010 .015

CASE - FD10853

PROPELLANT

CONTINUOUS CRIMP (SMOOTH DIE KNURL 20 TEETH PER INCH) TO MEET REQUIREMENT FOR RESISTANCE TO WITHDRAWAL OF PROJECTILE FROM CARTRIDGE CASE

LOT NO. 30 MM T 204

30MM PRACTICE T204

PROJECTILE UNSEATED BY PRESSURE ON NOSE.

PRIMER, ELECTRIC 74-2-79

WITZEPOODING APPLIED IN NECK OF CASE BE COMING ADJACENT OF PROJECTILE BEARING ASSEMBLY.

PROJECTILE, PRACTICE 30 MM T 334 FD43117

MARK WITH WHITE STENCIL WA (APPROVAL), SPEC. TT-S-558, CALIBER, DESIGNATION AND AMMUNITION LOT NUMBER INCLUDING INITIALS OR SYMBOL OF LOADER) WITH 3/4 NUMERALS AND LETTERS.

4	4 JUNE 74	E.K.T.			
3	3 JUNE 74	E.K.T.			
SYM.	DESCRIPTION OF REVISIONS	DATE	BY	CHK'D	APP'D

PHYSICAL PROPERTIES

W	
CL	
CLS	
KS	
SH	
SM	

NEXT ASSY USED ON

APPLICATION

DO NOT SPLIT PART NO.

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES

TOLERANCES ON DECIMALS

ANGLES FRACTIONS

MATERIAL

HEAT TREATMENT

FINAL PROTECTIVE FINISH

ORIGINAL DATE OF DRAWING OCT. 6, 1955

DRAWN

TRACED

CHECKED

SUBMITTED

APPROVED

SCALE 1/1

CARTRIDGE, PRACTICE 30 MM T204

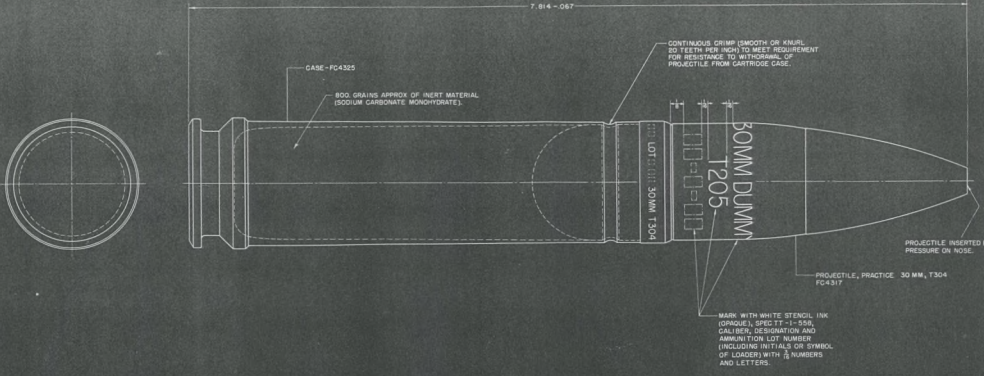
FRANKFORD ARSENAL ORDNANCE DEPT DEPT OF THE ARMY

SIZE D

DRAWING NO.

SHEET NO.

CLASS & DIV. FD18080



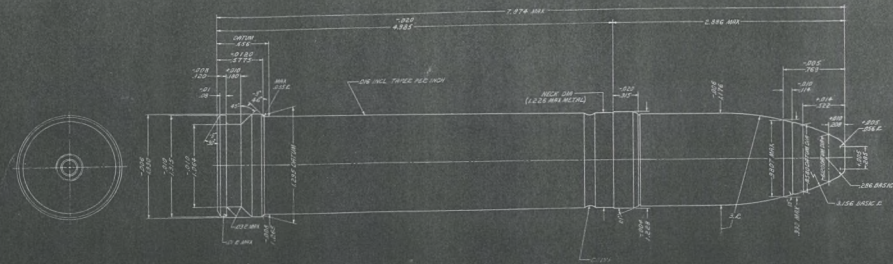
RESTRICTED

NOTICE—
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH U.S. GOVERNMENT PROCUREMENT

MATERIAL PROPERTIES		TOLERANCES ON DECIMALS	DRAWING DATE OCT 23,1953	CARTRIDGE, DUMMY 30 MM, T205	FRANKFORD ARSENAL ORDNANCE DEPT DEPT OF THE ARMY
		MATERIAL			
		HEAT TREATMENT			
		FINAL PROTECTIVE FINISH			
APPLICATION DO NOT APPLY PART NO.				SIZE D	

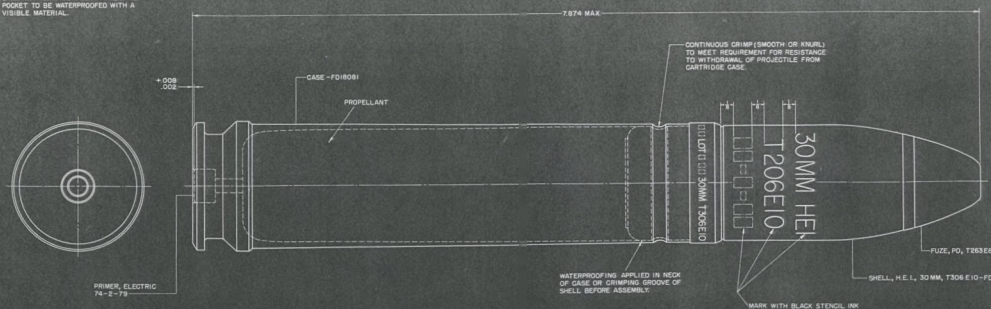
NEXT ASSEMBLY | USED ON | APPROVED D. W. Walker | SCALE: 3 | WT ENGLISH AVDP | DRAWING NO. FD18080

SKFSA9194


7.974 MAX
7.925
4.585
2.596 MAX
CAUTION
.4318
.4572
.205
.195
.205
.195
.205
.195

CLASS & DIV. FDI8097

NOTE:-
PRIMER TO BE SECURED IN POCKET BY CRIMPING. JOINT BETWEEN PRIMER AND POCKET TO BE WATERPROOFED WITH A VISIBLE MATERIAL.



LIST OF DRAWINGS

LINE NO.	DRAWING NUMBER	TITLE
1	FDI8097	CARTRIDGE, H.E.I., 30 MM, T206E10
2	FDI8081	CASE, CARTRIDGE 30 MM FA T15-E1
3	74-2-79	PRIMER, ELECTRIC, M52A3, A4 & AS ASSEMBLY & DETAILS
4	FDI8098	SHELL, H.E.I., 30 MM, T306E10 ASSEMBLY
5	P86172	SHELL, H.E.I., 30 MM, T306E10 LOADING ASSEMBLY AND MARKING DIAGRAM
6	FC4315	METAL PARTS ASSEMBLY & MARKING DIAGRAM
7	FDI8083	BODY, ROTATING BAND AND BASE COVER
8	FF6375	FUZE, PD, T263E8. LIST OF PARTS, LIST OF SPECIFICATIONS AND DIAGRAM
9	FF6376	FUZE, PD, T263E8. ASSEMBLY AND DETAILS.
10	FF6377	FUZE, PD, T263E8. DETAILS.
11	FF6378	FUZE, PD, T263E8. DETAILS.
12	FF6379	BOOSTER, T- ASSEMBLY AND DETAILS.
13	P86243	DETONATOR, T- ASSEMBLY

REVISIONS		
3	ECO 2763-387	12-1-55
2	ECO 2763-357	7-20-55
1	ECO P 40,151	2-9-54

NOTICE:-
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ORIGINAL DATE MARCH 30, 1954
APPROVED
DATE
DRAWN
CHECKED
APPROVED
Alfred F. Hebard
CHF, ENG CORPS
APPROVED
DATE

CARTRIDGE, HIGH EXPLOSIVE INCENDIARY, 30 MM, T206 E10

WT 7365. GR APPROX

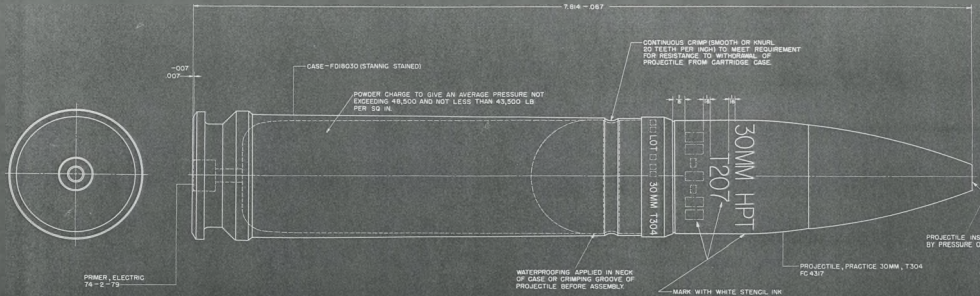
FRANKFORD ARSENAL
ORDNANCE CORPS
DEPT OF THE ARMY

SIZE D

CLASS & DIV

FD18094

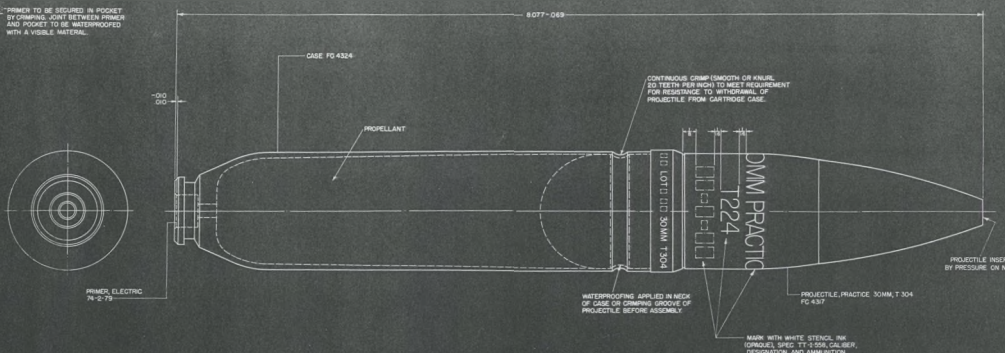
NOTE:
PRIMER TO BE SECURED IN ROCKET BY CRIMPING JOINT BETWEEN PRIMER AND POCKET TO BE WATERPROOFED WITH A VISIBLE MATERIAL



NOTICE:
THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PRODUCEMENT

PROJECTILE		TO ENABLE ON (NAME)	MAR 25/1954	CARTRIDGE, HIGH PRESSURE TEST 30MM, T207	FRANKFORD ARSENAL ORDNANCE CORPS
		MATERIAL			
		CERT. EMBLEMENT			
NOT USED		APPLICATION			
DO NOT	APPLY PAINT OR FINAL PROTECTIVE FINISH				
DO					D

WT 6325 GRS APPROX.



RESTRICTED

NOTICE: THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN APPROVED BY THE ORDNANCE OFFICER UNITED STATES GOVERNMENT PROCUREMENT.

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVAL

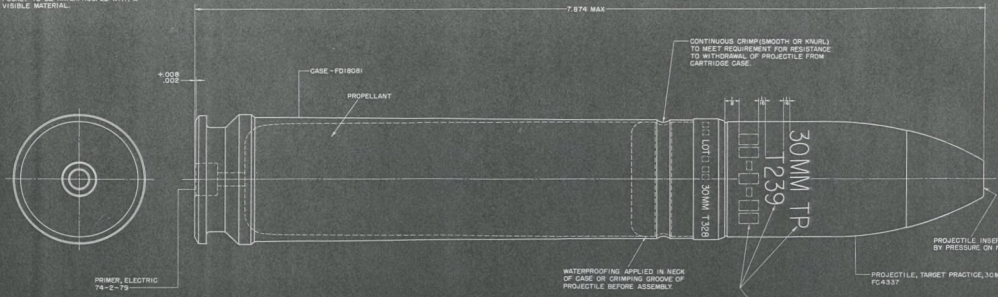
PHYSICAL PROPERTIES			
APPLICATION	USED ON	HEAT TREATMENT	
DO NOT	APPLY PORE NOT	FINAL PROTECTIVE FINISH	

ORIGINAL DATE: OCT 20, 1953
DRAWN: [illegible]
TRACED: [illegible]
CHECKED: [illegible]
APPROVED: [illegible]
ENGR. OFF.

CARTRIDGE, PRACTICE 30 MM T 224

FRANKFORD ARSENAL ORDNANCE DEPT DEPT OF THE ARMY

SIZE D



E	E.C.O. #AL393	7-13-56
D	E.C.O. #AL395	9-30-55

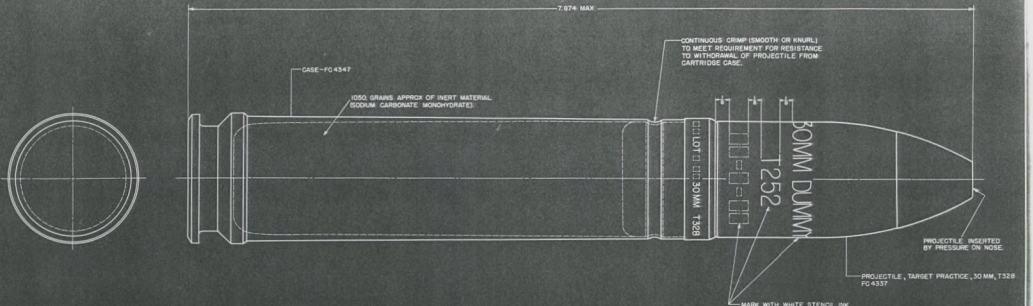
NOTICE:-
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MATERIAL PROPERTIES		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN DECIMAL TOLERANCES ON ANGLES ± FRACTIONS	ORIGINAL DATE OF DRAWING MARCH 1954	CARTRIDGE, TARGET PRACTICE, 30 MM, T239	FRANKFORD ARSENAL ORDNANCE DEPT DEPT OF THE ARMY
UP			DRAWN P.B. CHECKED P.B.		
TL			TRACED P.B. CHECKED P.B.		
FJ		MATERIAL	ENGINEER CHECKED		
BO	NEXT ASSY USED ON	HEAT TREATMENT	APPROVED: Alfred A. Nelson FOR DIR. OPNS.		
NO	APPLICATION DO NOT APPLY PART NO.	FINAL PROTECTIVE FINISH	MANUFACTURED: D. W. Mell FOR DIR. PROD.		
NO				SCALE 1-1	WT 7500.68 APPROX

SIZE D

CLASS & DIV.

FD18096

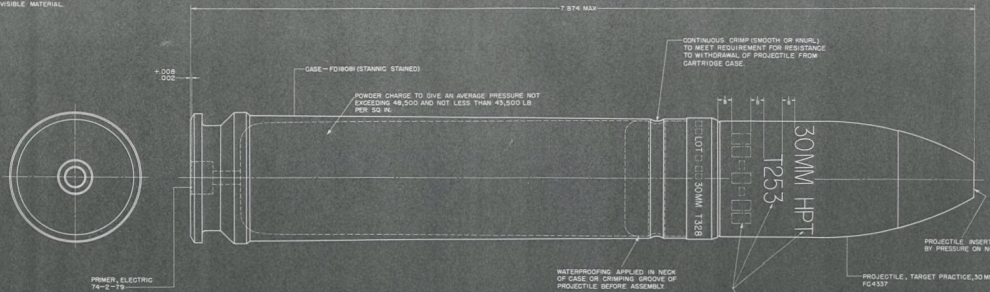


NOTICE - THIS DRAWING SHALL NOT BE USED NOR REPRODUCED EITHER WHOLLY OR IN PART EXCEPT WHEN AUTHORIZED IN CONNECTION WITH UNITED STATES GOVERNMENT PROCUREMENT.

CLASS & DIV.

FD 18095

NOTE-
PRIMER TO BE SECURED IN POCKET BY CRIMPING JOINT BETWEEN PRIMER AND POCKET TO BE WATERPROOFED WITH A VISIBLE MATERIAL.



REVISIONS			
LTR	DESCRIPTION	DATE	APPROVED
B	ECO #40,387	1953 08	
C	ECO #40,387	1954 05	

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PHYSICAL PROPERTIES					

NEXT ASSY	USED ON	HEAT TREATMENT	
APPLICATION			
DO NOT	APPLY PART NO	FINAL PROTECTIVE FINISH	
DO	AS SPECIFIED		

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
TOLERANCES ON: DECIMALS ANGLES FRACTIONS
MATERIAL

ORIGINAL DATA
1ST DRAWING APPR'D 15-1954
DRAWN: [illegible] 7-54
TRACED: [illegible] 7-54
CHECKED: [illegible] 7-54
SUBMITTED: [illegible] 30
APPROVED: Alfred S. Hutson 1 DEC 1954
CONCURRED: [illegible]
SCALE 1/1 WT 7500 GR APPROX

CARTRIDGE, TEST, HIGH PRESSURE 30 MM, T253

FRANKFORD ARSENAL ORDNANCE CORPS DEPT OF THE ARMY

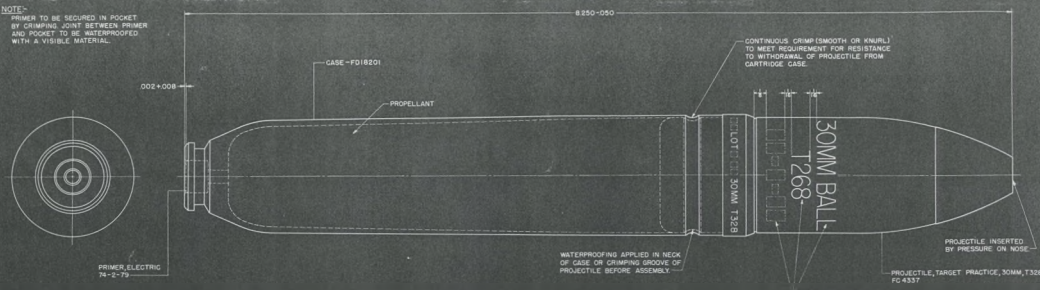
SIZE D

CODE IDENT NO 11236

CLASS

CARTRIDGE

CLASS 8 D.V. FD18200



COL. 1 2

LIST OF DRAWINGS

LINE NO.	DRAWING NUMBER	TITLE
1	FD18200	CARTRIDGE, BALL, 30MM, T268
2	FD18201	CASE, CARTRIDGE, 30MM, T32-EI
3	74-2-79	PRIMER, ELECTRIC, M52A1, AA & AS ASSEMBLY & DETAILS
4	FC4337	PROJECTILE, TP, 30MM, T328 ASSEMBLY
5	FC4339	MARKING DIAGRAM
6	FD18288	BODY AND ROTATING BAND
7	FC4339	NOSE

COL. 1 2 3 4 5

ASSEMBLIES & LIST OF PARTS

LINE NO.	DRAWING NUMBER	PIECE MARK	NAME	NO PIECE PER UNIT ASSY	WEIGHT IN GRAINS
1	FD18200		CARTRIDGE, BALL, 30MM, T268		684.7 APPROX
2	FD18201	FD18201	CASE, CARTRIDGE, 30MM, F&T32-EI	1	385 APPROX
3	74-2-79		PRIMER, ELECTRIC, ASSEMBLY & DETAILS	1	22. APPROX
4	FC4337		PROJECTILE, TP, 30MM, T328 ASSEMBLY	1	1900.255
5			PROPELLANT		060. APPROX

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DATE 8 1955

CARTRIDGE, BALL, 30MM, T268

FRANKFORD ARSENAL ORDNANCE CORPS, DEPT OF THE ARMY

APPROVED BY [illegible]

MFG. SEE TABLE