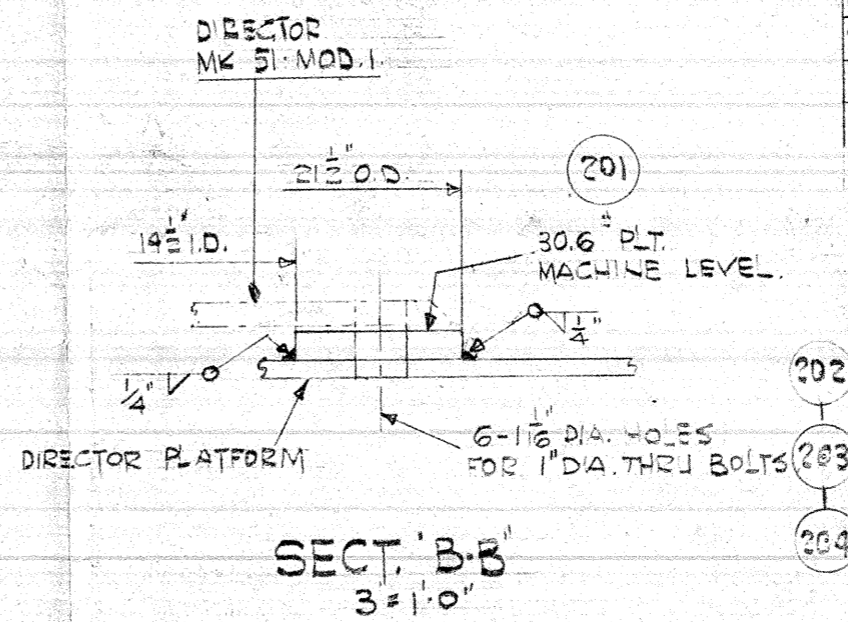
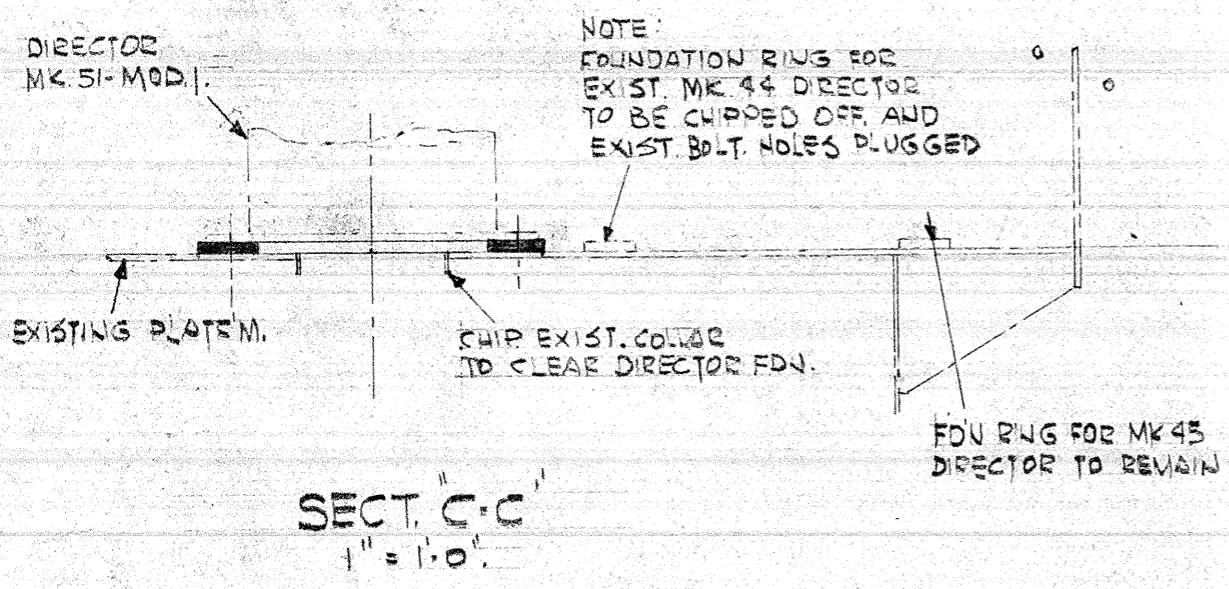


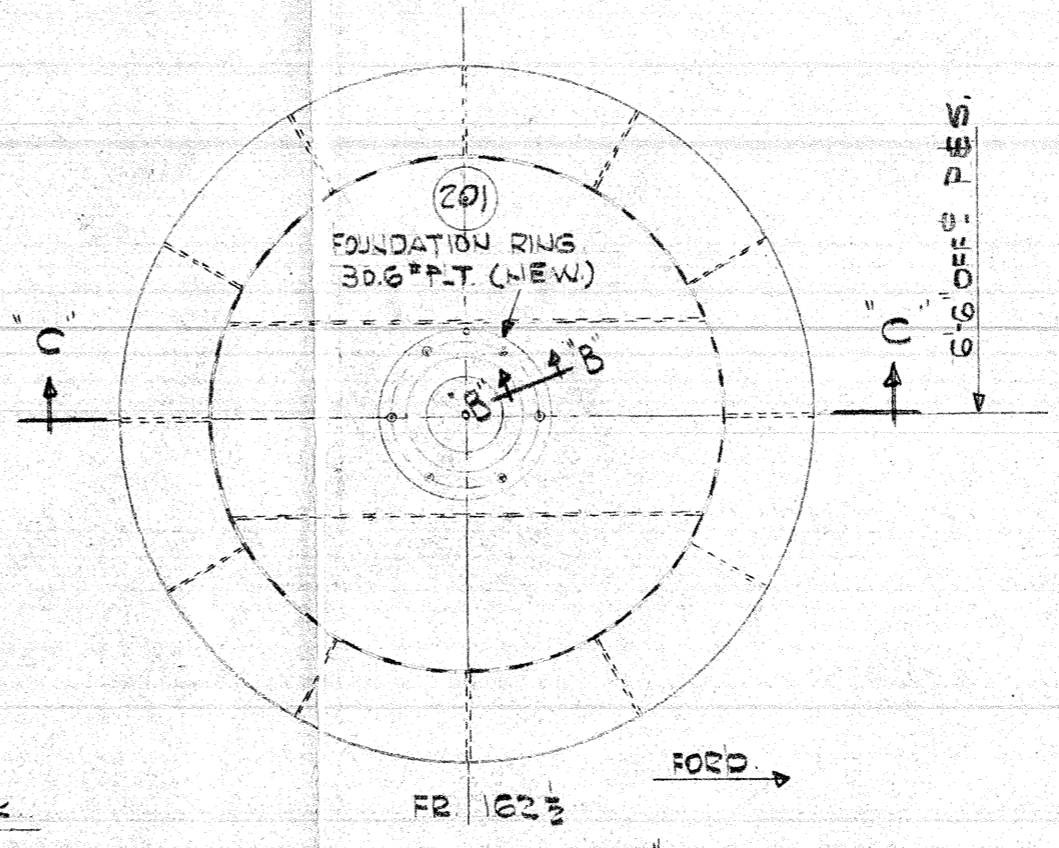
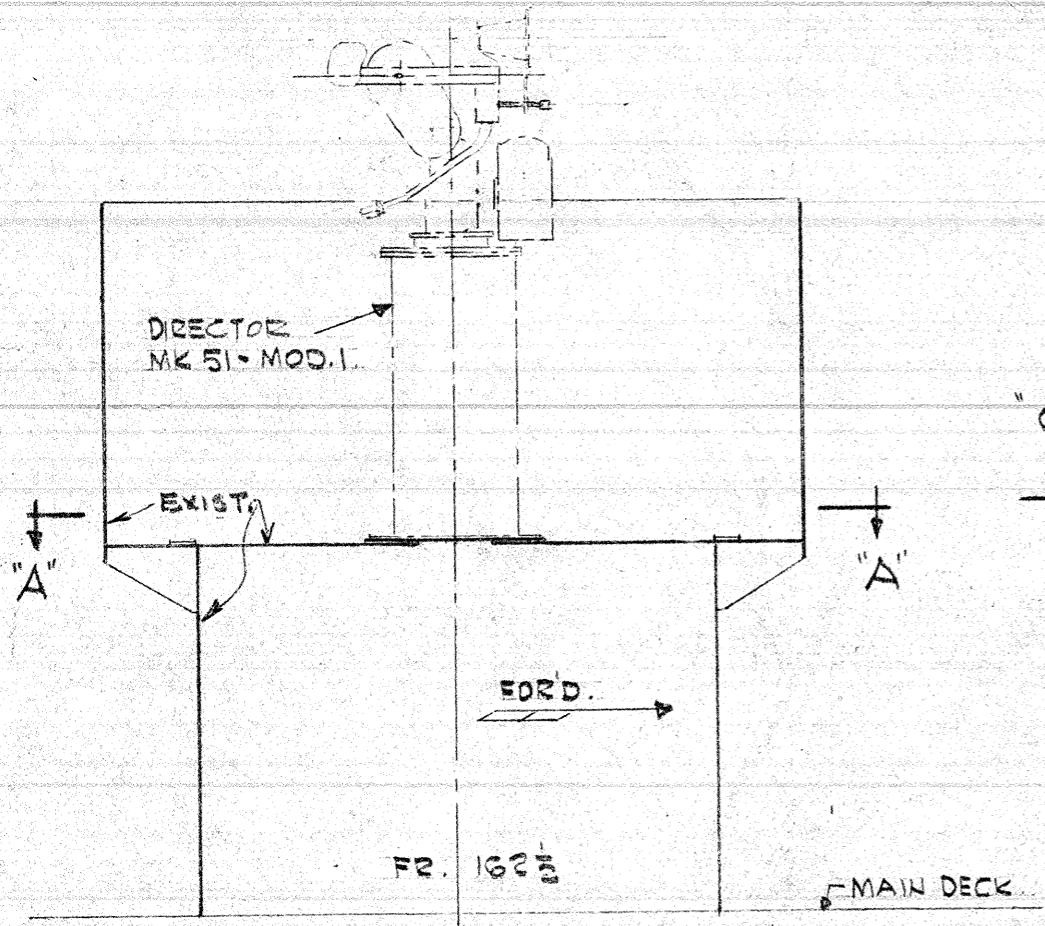
No 54194

BILL OF MATERIALS - QUANTITIES FOR ONE SHIP

NO.	NAME	AMT.	MAT.	REMARKS
201	DBLE PLT. 30.6"	2	M.S. 22"x22"	
202	1" DIA. BOLT - 3" LG.	12	C.B.	
203	1" DIA. NUT, LOCK WASHER	12	C.C.	
204	GROMMET - CANVAS	12		



ORDERSHIP				DRIFTS		
A.T.	ON	SUPP.	SHIP	PL.	SHOPS.	
					11	38 M.L.
-	1/4	3	1	1	3	3



BB 59 MASSACHUSETTS  
SHIP NO. NAME

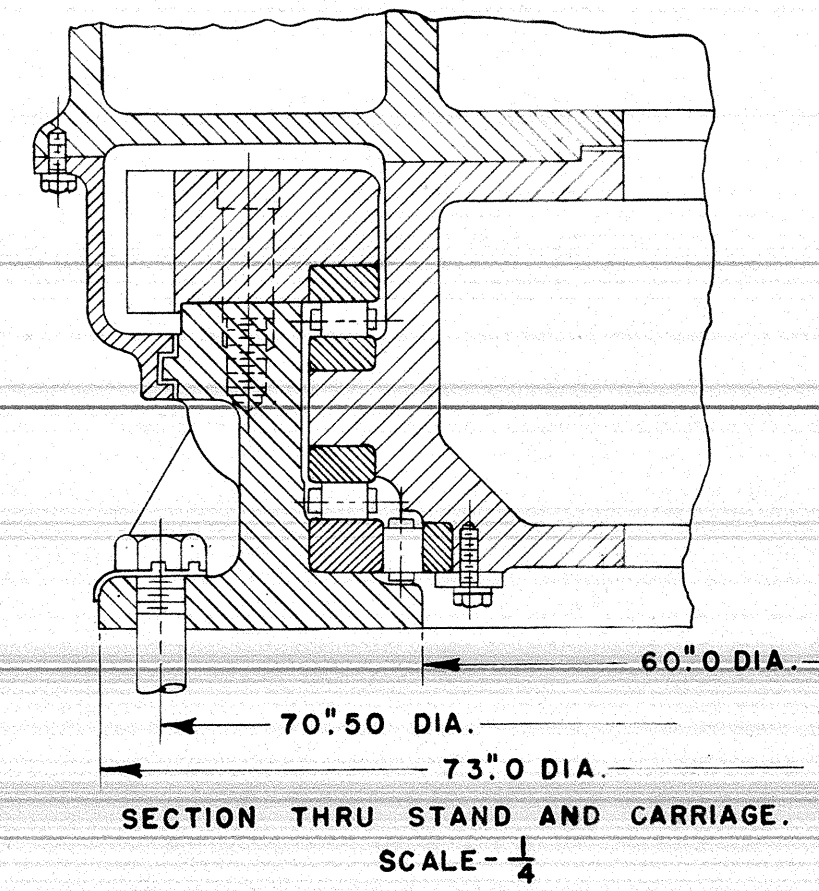
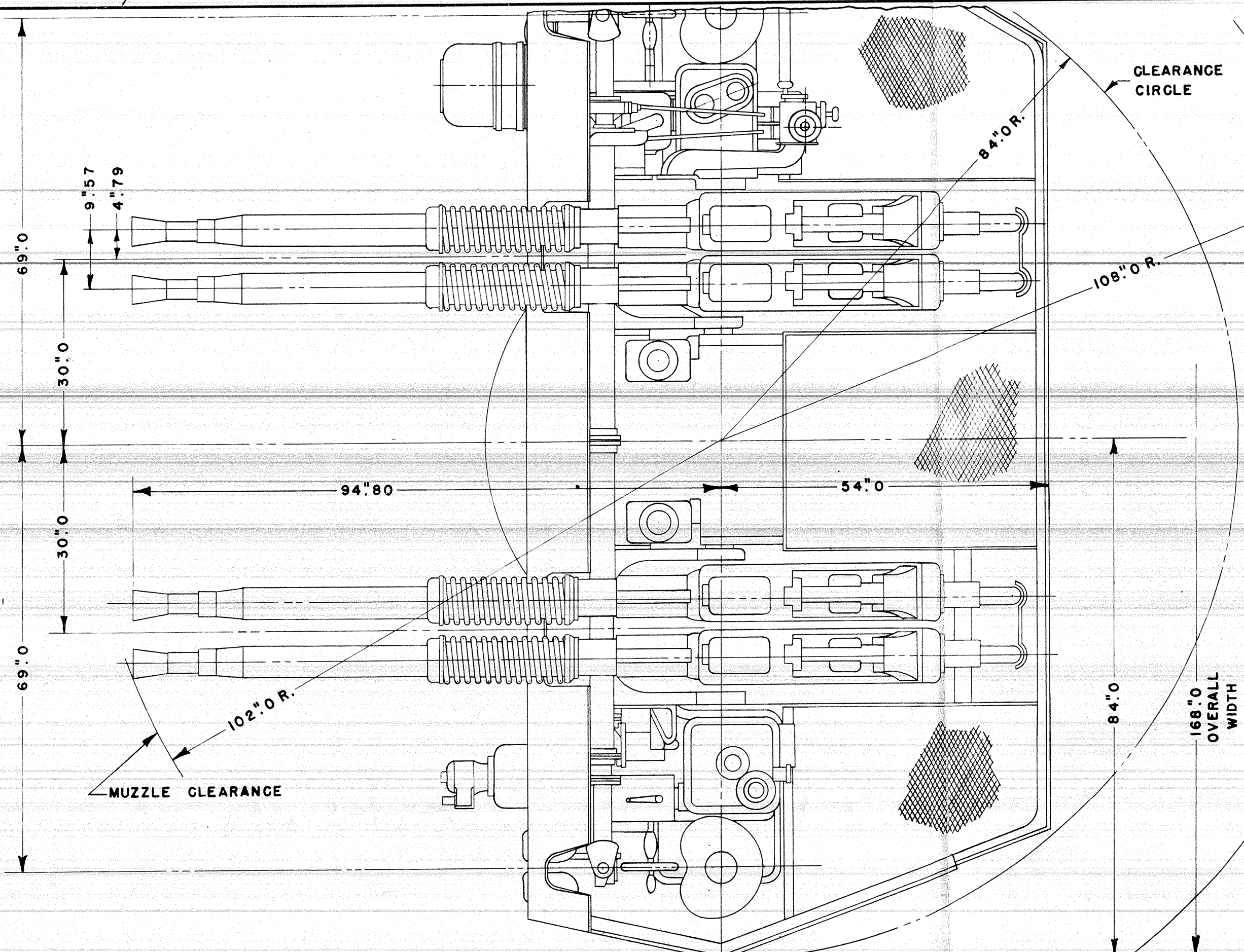
FDN. FOR GUN DIRECTOR  
MARK 51-MOD.1.  
MAIN DK - FR. 162 1/2 - P.E.S.  
NAVY YARD BOSTON  
SCALE: AS NOTED

DRAWN BY: W.E.B. SUPV'R. R. Ingleson  
CHKD BY: SR. NAV. ADJ. S. Egan

APPROVED: 1 JUNE 1942.

*W.E.B.*  
DESIGN SUPT.

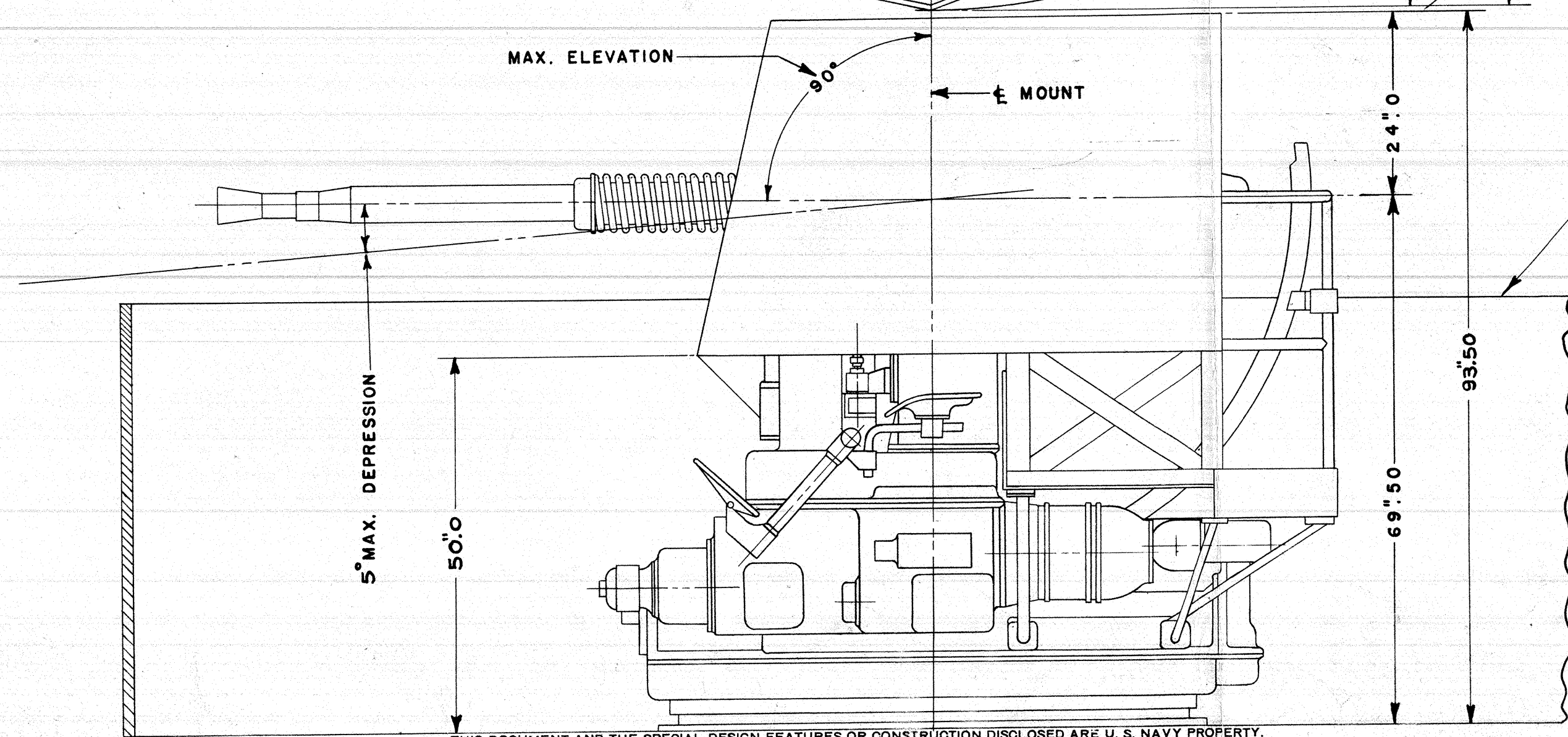
No 54194



DRILL AND REAM FOR 18-1" D. BOLTS EQUALLY SPACED.  
 DRILLING JIG FURNISHED BY THE GOVERNMENT.  
 BOLTS FURNISHED BY PARTIES INSTALLING WORK.

BRAKE LOAD - 4,850 LBS. PER GUN  
 ESTIMATED WEIGHT - 21,650 LBS.  
 SHIELD PLATE THICKNESS -  $\frac{3}{8}$ " (15.3 LB./SQ.FT.)

**Sk. No. 99008**



CIRCULAR BULWARK NOT TO BE SUPPLIED BY THE BUREAU OF ORDNANCE.

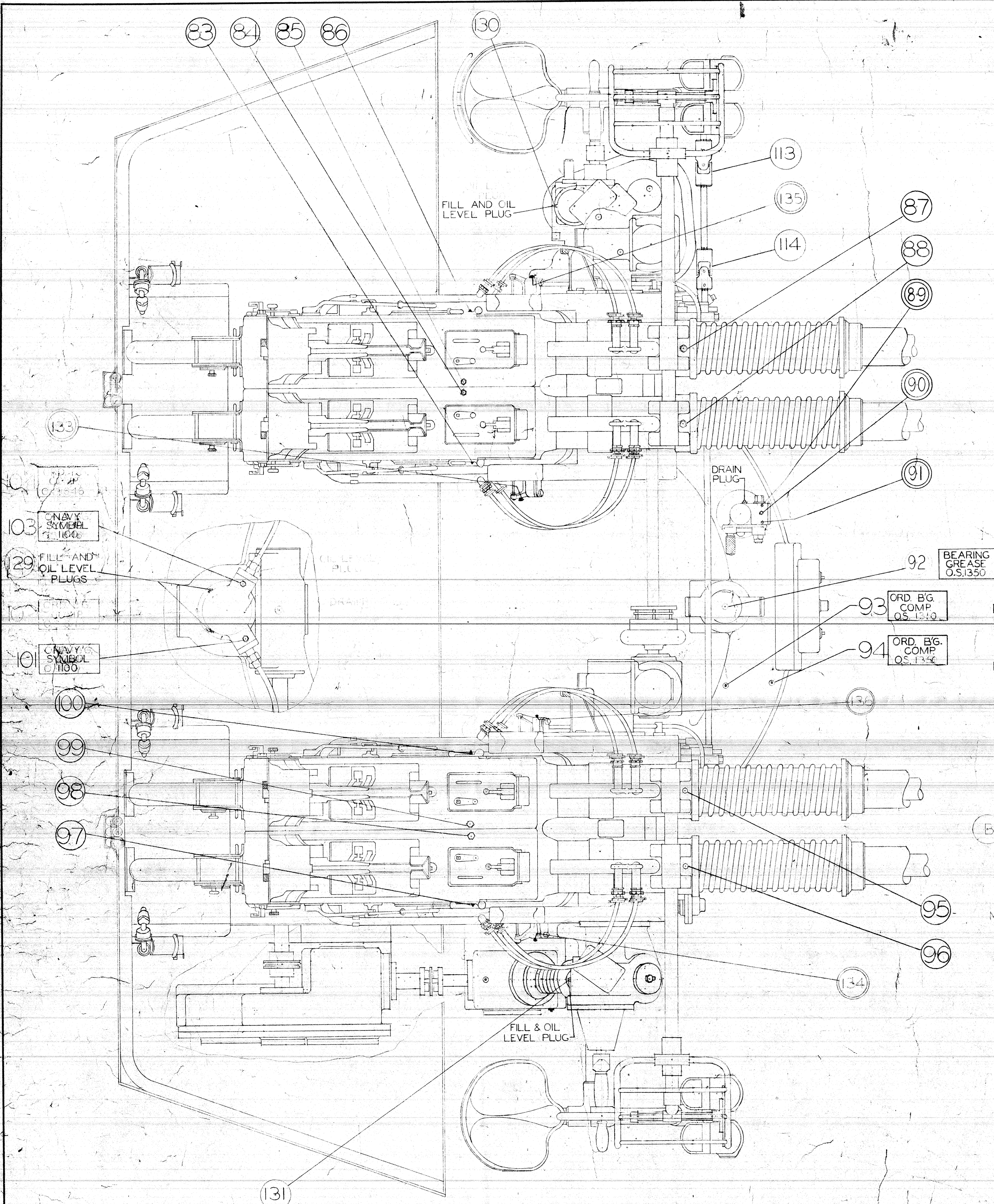
REVISIONS			40MM MOUNT MARK 2 MOD. 5 (QUADRUPLE MOUNT)	
LET.	NUMBER	DATE		
			<b>WORKING CIRCLE</b> SCALE - $\frac{1}{16}$ & $\frac{1}{4}$	
			NAVY DEPARTMENT BUREAU OF ORDNANCE WASHINGTON, D. C. <i>March 11, 1942</i>	
			<i>J.W.D. Mum</i> CHIEF OF BUREAU	
			BUREAU'S FILE	CLASSIFICATION
			JOB ORDER	ORD. SKETCH NO.
			1857	<b>99008</b>

**WARNING:-** THE DISCLOSURE OF NATIONAL DEFENSE SECRETS, IS A PENAL OFFENSE PUNISHABLE BY A FINE, IMPRISONMENT OR BOTH.

299397  
1927

YORK SAFE & LOCK REVISIONS		
LOC.	NUMBER	DATE
A	6360	10-16-42
SEE ORDNANCE REVISIONS		

ABOVE REVISION LETTERS ARE NOT TO BECOME A PART OF THE PIECE NUMBER. A BLANK SPACE SHOULD BE ALLOWED ON THE PIECE TO BE MARKED FOR FUTURE REVISION LETTERS.



PLAN VIEW

NOTE:- FOR FREQUENCY SCHEDULE SEE DR. NO. 299396.

NOTE:- THE FREQUENCY OF LUBRICATION IS DEPENDENT UPON THE USE OF THE MECHANISM. THE SCHEDULE GIVEN IS REQUIRED WHEN THE OUTFIT IS USED DAILY. LUBRICATION MAY BE LESS FREQUENT FOR LESS FREQUENT USE OF THE OUTFIT BUT IN NO CASE SHALL THE MAXIMUM PERIOD BETWEEN REGULAR INSPECTIONS OF PARTS FOR PROPER LUBRICATION ON SHIPS IN COMMISSION EXCEED ONE MONTH. EXERCISE THE PARTS AFTER LUBRICATING.

NOTE:- THE LUBRICATION PROVIDED IS FOR USE IN SUMMER TEMPERATURES OF A MINIMUM OF 50°F. FOR LOWER TEMPERATURES IT IS RECOMMENDED THAT ORDNANCE BEARING COMPOUND (O.S. 1350) BE THINNED WITH ICE MACHINE OIL (NAVY SYMBOL 2075) TO A SATISFACTORY CONSISTENCY. MEDIUM MINERAL OIL SHOULD BE REPLACED BY LIGHT MINERAL OIL. NAVY SYMBOL 1100 MUST BE MIXED WITH HYD. GEAR LUB. OIL (O.S. 1113).

NOTE:- ALL POINTS PREPARED FOR A PRESSURE GUN WILL BE LUBRICATED WITH THE DESIGNATED LUBRICANT.

CARE MUST BE TAKEN TO INSURE THAT THE PRESSURE GUN CONTAINS THE CORRECT LUBRICANT.

IN ADDITION TO THE FOREGOING, ALL WORKING PARTS, e.g. JOINTS OF LEVERS, CATCHES, ETC., (WHERE LUBRICATION HOLES ARE NOT PROVIDED), SHOULD BE OCCASIONALLY OILED.

NOTE:- FOR LUBRICATION OF MACHINE GUN MECHANISM SEE DRAWING NO. 345605.

NOTE:- FOR LUBRICATION OF POWER DRIVES SEE DR. NO'S. 345914 AND 346504. INTRODUCTION TO O.S. 1113.

NOTE:- FOR FRONT ELEVATION AND REAR ELEVATION SEE DR. NO. 299395. FOR RIGHT SIDE ELEVATION AND LEFT SIDE ELEVATION SEE DR. NO. 299396.

NOTE:- FOR LUBRICATION INSTRUCTIONS SEE DR. NO. 345605.

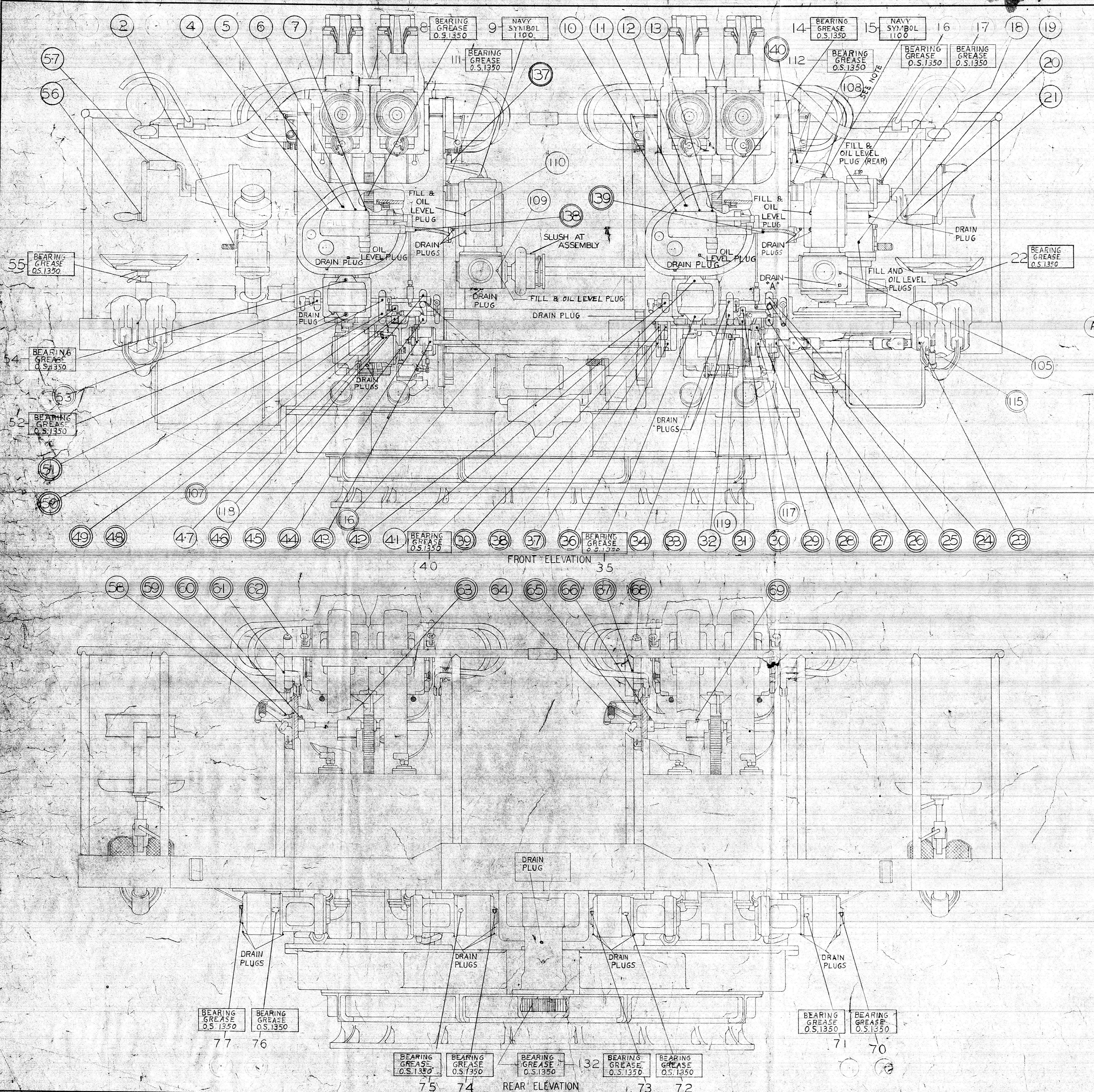
- INDICATES LIGHT MINERAL OIL FOR LUBRICATION (NAVY SYMBOL 2075 OR 2110)
- ◐ INDICATES MEDIUM MINERAL OIL FOR LUBRICATION (NAVY SYMBOL 3050 OR 2135)
- ◑ INDICATES HEAVY MINERAL OIL FOR LUBRICATION (NAVY SYMBOL 2190)
- △ INDICATES EXTRA HEAVY MINERAL OIL FOR LUBRICATION (NAVY SYMBOL 3100)
- ◔ INDICATES ENCLOSED TRANSMISSION LUBRICANT (NAVY SYMBOL 5190)
- INDICATES CUP GREASE FOR LUBRICATION (NAVY SPECIFICATION 14 G 1)
- ▭ INDICATES SPECIAL ORDNANCE LUBRICANT OR COMPOUND.

PIECE NO.	NOMENCLATURE	NO. REQ'D	MATERIAL AND SPECIFICATION NO.	WEIGHT PER PC.
"NO. REQ'D." ARE FOR				
40MM MOUNT MARK 2 (QUADRUPLE MOUNT)				
LUBRICATION CHART				
SCALE: 1/8"				
YORK SAFE & LOCK CO. SPECIAL ORDNANCE PLANT YORK, PA.				
DRAWN BY 3-2042		DATE		
CHECKED BY 3-2042		DATE		
APPROVED BY 3-2042		DATE		
ENGINEER		DATE		
CONTRACT		CLASSIFICATION		YORK SAFE & LOCK CO. NO. 1927
				ORDNANCE DR. NO. 299397

299395  
1925



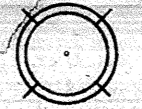




YORK SAFE & LOCK REVISIONS		
LOC.	NUMBER	DATE
A1	4741	6-14-41
B	5601	10-16-42
C	6708	11-26-42

ABOVE REVISION LETTERS ARE NOT TO BECOME A PART OF THE PIECE NUMBER. A BLANK SPACE SHOULD BE ALLOWED (ON THE PIECE TO BE MARKED) FOR FUTURE REVISION LETTERS.



NOTE  
IN ALL MOUNTS MADE PREVIOUS TO MOUNT SERIAL NUMBER 10025 TARGET NO. 15 IS TO BE GREASED DAILY AND THE EXCESS LUBRICANT IS TO BE DRAINED DAILY AT DRAIN PLUG "A".

- NOTE: FOR LUBRICATION INSTRUCTIONS SEE DR. NO. 345605
- NOTE: FOR GENERAL NOTES SEE DR. NO. 299397
- NOTE: FOR RIGHT SIDE ELEVATION AND LEFT SIDE ELEVATION SEE DR. NO. 299396. FOR PLAN VIEW SEE DR. NO. 299397.
- NOTE: FOR FREQUENCY SCHEDULE SEE DR. NO. 299396.

-  INDICATES LIGHT MINERAL OIL FOR LUBRICATION (NAVY SYMBOL 2075 OR 2110)
-  INDICATES MEDIUM MINERAL OIL FOR LUBRICATION (NAVY SYMBOL 3050 OR 2135)
-  INDICATES HEAVY MINERAL OIL FOR LUBRICATION (NAVY SYMBOL 2190)
-  INDICATES EXTRA HEAVY MINERAL OIL FOR LUBRICATION (NAVY SYMBOL 3100)
-  INDICATES ENCLOSED TRANSMISSION LUBRICANT (NAVY SYMBOL 5190)
-  INDICATES CUP GREASE FOR LUBRICATION (NAVY SPECIFICATION 14 G 1)
-  INDICATES SPECIAL ORDNANCE LUBRICANT OR COMPOUND.

PIECE NO.	NOMENCLATURE	NO. REQ'D.	MATERIAL AND SPECIFICATION NO.	WEIGHT PER PC.
"NO. REQ'D." ARE FOR				
40 MM MOUNT MARK 2 (QUADRUPLE MOUNT)				
LUBRICATION CHART				
SCALE: 1/8				
<b>YORK SAFE &amp; LOCK CO.</b> SPECIAL ORDNANCE PLANT YORK, PA.				
DRAWN BY: <i>RESSE</i> DATE: 3-18-42				YORK SAFE & LOCK CO. NO. 1925
CHECKED BY: <i>RESSE</i> DATE: 3-26-42				ORDNANCE DR. NO. 299395
APPROVED BY: <i>RESSE</i> ENGINEER DATE: 3-26-42				
CONTRACT		CLASSIFICATION		