.50 CAL BROWNING TARGET RIFLE

BIG 50

GUNMETAL Designs

15 Sunnyview Dr.
Jericho, Vt 05465
1.) PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENCE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.

2.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.

3.) ESTABLISH -C- BY LEAVING A .030 GAP TO BOLT WHEN ASSEMBLED TO BOLT.

BOLT END PLUG

UNLESS OTHERWISE SPECIFIED
ALL DIMENSIONS ARE IN INCHES
PRODUCTION TOLERANCES X 0.001 ANGULAR TOL. 60"
XXX 010 SURFACE FINISH 63

MATERIAL: 4130 C.M. STEEL
FINISH: HOT BLUE
HEAT TREAT RE: 35

DO NOT SCALE
REMOVE ALL BURRS
BEAK SHARP EDGES

SCALE: 1/1 SHEET 1 OF 1
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INTERPRET DRAWING IAW Y14.5M-82

DO NOT SCALE REMOVE ALL BURNS BREAK SHARP EDGES

EXTRACTOR

TITLE: EXTRACTOR

SIZE ORG. NUM: BMG003-DG

SCALE: 4/1 SHEET 1 OF 1
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INTERPRET DRAWING IAW Y14.5M-82

NOTE: UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES. PRODUCTION TOLERANCES: ±.015 ANGULAR TO .02" SURFACE FINISH 63µ

MATERIAL: A130 HOT ROLLED FINISH:

1. BOLTS

DO NOT SCALE

REMARKS: REMOVE ALL BURRS

15 Sunnyvale Dr.
Jericho, VT 05465

GUNMETAL Designs

BOLT RETAINER PLATE

SIZE: ORG: BMG005 - DG

SHEET: 1 OF 1

SCALE: 4/1
NOTE:

1.) PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENCE OR OWNERSHIP OF THE DESIGN PRESENTED HERE.

2.) THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG SO" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.

INTERPRET DRAWING IAW Y14.5M-82

[Diagram with dimensions and notes]

SIGNATURE DATE

DRAWN BY: JMD 10/9/92
ENGINEER: JMD 10/9/92

MATERIAL: O1 TOOL STEEL
OIL QUENCHED

FINISH: HOT DIP

THIS DOCUMENT CONTAINS CONFIDENTIAL AND PROPRIETARY INFORMATION OF GUNMETAL DESIGNS AND NEITHER IT NOR THE INFORMATION CONTAINED THEREIN MAY BE SHOWN, MADE ACCESSIBLE, OR DUPLICATED OR USED FOR OTHERS WITHOUT EXPRESS WRITTEN CONSENT OF GUNMETAL DESIGNS.

SCALE: 4/1 SHEET 1 OF 1
NOTES:
1. FIT SLOT TO SAFETY LEVER AFTER ASSEMBLY.
2. PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENSE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.
3. THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE 'BIG 50' WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
4. SILVER SOLDER SEAR IN PLACE
1.) PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENCE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.

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NOTE:
ALL RADIUS TO BE .25
UNLESS OTHERWISE NOTED
WELD .50 SR BALL TO HANDLE, GRIND AND POLISH FILLET SMOOTH
1. PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENCE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.

2. THESE DOCUMENTS ARE PRESENTED AS A DESCRIPTION OF HOW THE "BIG 50" WAS CONSTRUCTED. THERE IS NO IMPLICATION THAT A GUN BUILT TO THESE PLANS WILL FUNCTION IN A SAFE AND PROPER MANNER.
1. Scope mounts must be made as matched assemblies.
2. Dovetails must be as // to the .500 radius as possible.
3. Purchase of these documents does not imply license or ownership for the design presented here.
4. These documents are presented as a description of how the "Big 50" was constructed. There is no implication that a gun built to these plans will function in a safe and proper manner.
NOTE:

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Ø .190 THRU
Ø .344 TO DEPTH SHOWN
Ø .014 @ A B C
BX

8.0

A
B
C
D
E
F
G
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K
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7
8
9

0.000

.500
1.500
2.500
3.500
4.500
5.500
6.500
7.500

.135

.010 @ A B C

.14

R 1.062

.000

60°
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INTERPRET DRAWING IAW Y14.5M-82

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES, PRODUCTION TOLERANCES:

R ± .02 MAX
.015 X 45° CHAMFER
R ± .03 MAX

CENTER LINE DRAWING

DO NOT SCALE REMOVE ALL BURRS BREAK SHARP EDGES

THIRD ANGLE PROJECTION

DRAWN: JMR
CHECKED: JMR
PREPARED FOR PRODUCTION: JMR

18 Summitview Dr.
Jericho, VT 05465

GUNMETAL Designs

FIRING SPRING RETAINING COLLAR

BMG008-DG

SCALE: 4/1 SHEET 1 OF 1
1.) PURCHASE OF THESE DOCUMENTS DOES NOT IMPLY LICENCE OR OWNERSHIP FOR THE DESIGN PRESENTED HERE.

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INTERPRET DRAWING IAW Y14.5M-82

UNLESS OTHERWISE SPECIFIED  SIGNATURE  DATE

ALL DIMENSIONS ARE IN INCHES  ENG:

PRODUCTION TOLERANCES:

XI: .015  ANGULAR TOL: .2°

XX: .010  SURFACE FINISH: 63√

XXX: .005  

MATERIAL:  4130

FINISH:  Heat treated

SIGNATURE DATE

DIR:  JR

ENG:

MG:

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INTERPRET DRAWING IAW Y14.5M-82

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES. PRODUCTION TOLERANCES:

.0015 LEAD (.015)

NOMINAL TOL. (.2)

SURFACE FINISH 63 µ

MATERIAL: 4130 STEEL
NO HEAT TREAT

FINISH: HOT BLUISH

DO NOT SCALE

REMOVE BREAK SHARP ALL BURRS EDGES

GUNMETAL Designs

15 Sunnyside Dr.
Jericho, Vt 05455

BOLT END CAP

BMG016-DG

SCALE: 4/1
SHEET: 1 OF 1
Ø .190 THRU

Ø .37 x .25 DEEP

.405

EXISTING HOLE

REMOVE BOSS FLUSH TO .020 UNDER FLUSH

INTERPRET DRAWING IAW Y14.5M-82

ALL DIMENSIONS ARE IN INCHES

PRODUCTION TOLERANCES:

.0015

.010

.005

.002

.010

SURFACE FINISH 63

MATERIAL:

WEATHERBY

MARK V

TRIGGER ASSEMBLY

FINISH:

THIRD ANGLE PROJECTION

DO NOT SCALE

REMOVE ALL BURRS

BREAK SHARP EDGES

TRIGGER MODIFICATION

SIZE: B

NO: BMG017-DG

SCALE: 2/1

SHEET 1 OF 1
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FINE DIAMOND OR STRAIGHT KNURL

0.030 X 45° CHAMFER

\[ 3\times \]

\[ 0.8 \]

\[ 0.4 \]

\[ 0.000 \]

\[ D \]

\[ \phi 0.160-32\ UNF-2A \]

\[ \phi 0.014\ M A B \]

\[ \phi 0.31 \pm 0.05 \]

\[ -A- \]

INTERPPET DRAWING IAW Y14.5M-82

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<td>ALL DIMENSIONS ARE IN INCHES</td>
<td>DATE</td>
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<tr>
<td>PRODUCTION TOLERANCES:</td>
<td>10/9/32</td>
</tr>
<tr>
<td>[ X 0.015 ] ANGULAR TOL. [ 3^\circ ]</td>
<td></td>
</tr>
<tr>
<td>[ 1 X 0.010 ] SURFACE FINISH 63</td>
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<tr>
<td>[ 1 X 0.005 ]</td>
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<tr>
<td>MATERIAL:</td>
<td>FINISH:</td>
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<td>4130 STEEL</td>
<td>HOT BLUE</td>
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<tr>
<td>NO HEAT TREAT</td>
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DO NOT SCALE

REMOVE ALL BURRS

BREAK SHARP EDGES

THIRD ANGLE PROJECTION

BOLT RETAINER KNOB

SIZE ORG

B NO.

BMG018-DG

SCALE: 4/1 SHEET 1 OF 1
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3. DIAMETER TO MATCH MAXIMUM DIAMETER OR THREADS

4. CRITICAL HEADSPACE DIMENSION. MEASURE ACTION ASSEMBLY TO DETERMINE DIMENSION. USE HEADSPACE GAUGES.