

PROCESS RECORD

9/10/60 - Correct twist gage dmc. no. - Blair - 266715

7/23/68 - Retyped from 2/5/68 - 266576

TOOL, GAGE AND EQUIPMENT		GA. OR CAL.	TIME	APPROVAL AND DATES			
ITEM	DESCRIPTION	GA. OR CAL.	TIME	264	270	280	243
1	Flash Pin Gage - Rifling runout	A-86895A		A-86896	A-86895-B	A-86895A	A-86899
2	Snag Gage Muzzle Diam	B-86825		B-86825	B-86825	B-86825	B-86825
3	No Go .875	- Use No Go Ga. only		to insure Mat'l for finish	turn		
4	Snag Gage - 6" from chldr. (Reg.)			C-86824	C-86824	C-86824	C-86824
5	No. Go .875	Use No Go		Ca. only to insure Mat'l for finish	turn		
6	Snag Gage - 6" from shoulder (Max.)	C-86827		C-86827			C-86827
7	No. Go .905	Use No Go		Ca. only to insure Mat'l for finish	turn		
8	Sheffield Air Gage						
9	2 Coluwer H-501						
10	Air Gage Spindle (Rifling Dia.)	C-84824		Std.	Std.	Std.	Std.
11	Air Gage Spindle (Bore diam.)	C-84824		C-84824	C-51290	C-84804	C-86340
12	Set Ring (Rifle diam. Min.)	D-814330		D-814330	D-52462R	D-814330	D-81433K
13	Set Ring (Rifle diam. Max.)	D-81433P		D-81433P	D-52462R	D-81433P	D-81433I
14	Set Ring (Bore diam. Min.)	D-81433R		D-81433R	B-52723T	B-81433R	D-72928P
15	Set Ring (Bore diam. Max.)	D-81433U		D-81433U	B-52588U	B-81433U	D-73928H
16	Twist Gage	C-53981S		C-53981S	B-53982	C-53981S	C-53981U
17	Twist, 1 Turn in	9" - 9 1/2"		9 3/4" - 10 1/4"	9 3/4" - 10 1/4"	9" - 9 1/2"	8 7/8" - 9 3/8"
18	Bore Diam. tolerance	.2770-.2780		.256-.257	.300-.301	.2770-.2780	.237-.238
19	Rifle or groove diam toler.	.2837-.2847		.264-.265	.303-.309	.2837-.2847	.243-.244
20	Twist - Check every 5th rbl. for	at 1 1/2 rbl. each time a new caliber is		set up for bore, groove and	twist.		
21	Twist - Check 2 rbl's every 1/2 h	ca. during run					
22	Template Ga. Min. length	C-87259		C-87259	C-87259	C-87259	C-87259
23	Cut off length	(10 1/2" rbl. 19.160") (22" rbl. 23.160")		(24" rbl. 25.160") (20" rbl. 21.200")			
24	Sample - Worst acceptable visual	ripple in muzzle end of bore GA-2 Dated 4/8/64					
25	For Machine layout see	D-75572					
26	Speed - RPM	See Spread sheet C-75570-21					
27	Feed - Inches per minute	61-62		61-62	61-62	61-62	61-62
28	Feed Setting	7 1/2		9 1/2	9 1/2	9 1/2	9 1/2
29	RPM Figure above is starting point and must be finally determined from results obtained on twist gage and suitable hammer pattern.			C-2			
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PART NAME: GFM Centerfire Ebl. Blank
TYPE: COOLANT: SET UP TIME: 7420-7600-600-742-760-700-600
MACHINE: GFM Machine
DEPT. No. 48
OPER. No. 50
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