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C.F. BARREL BLANK - G.F.M.

Many variables must be considered when evaluating the feed rate of centerfire GFM barrel blank forming. Twist, internal and external hammer marks, internal bugging, hammer life and the machine are some of the most prominent areas of concern.

The process record calls for a feed rate of 10 I.P.M. which can and is often used with a good compromise of all the affected parameters. However, there are times when necessitate slower feed rates due to the steel, tooling or machine state of repair.

I do not believe that it would be advantageous to lose 10% or more production across the board by changing the Process Record to 8 or 9 I.P.M. to agree with the exceptions to the rule.