

Keeney, Mike

From: Sietsema, Glen
Sent: Tuesday, November 02, 1999 4:18 PM
To: Keeney, Mike; Zajk, Joseph J
Cc: Rabbia, James A.
Subject: RE: 710 Barrel hardness

Per our telephone conversation today:

- The hardness spec for the heat treated zone is HRc 37 - 42.
- The heat treated zone is .835 - .90" from the rear face of the barrel, or the B datum on my print.
- The heat treat transition zone is to 1.30" from the B datum.
- I will fax you a marked up print.
- Welduction will charge us \$200 set up and \$1.54 per part to run additional lots of prototypes.
- Welduction is expecting us to come out in the next 2 - 4 weeks to run the next lot of samples and discuss production fixturing.
- The change to AISI 4140 will require some set up of tuning of the process at Welduction. The alloy heat treats differently than 155 and the process will need to be modified accordingly.

Let me know when there will be barrels available to heat treat and I'll set up accordingly.

Glen

From: Zajk, Joseph J
Sent: Saturday, October 30, 1999 11:27 AM
To: Sietsema, Glen; Keeney, Mike
Subject: 710 Barrel hardness
Importance: High

What spec are you hardening the 710 barrel hub to? How long is the hardened area? Print E-305315 doesn't have any information regarding either question