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Ilion, New York
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FROM: E. K. Wheat

SUBJECT: MEETING - CENTER FIRE RIFLE ACCURACY

PURPOSE OF MEETING:

To report progress and discuss the future program in the Accuracy Study.

CONCLUSIONS:

1. The Barnes reamer must be controlled for diameter, visual, bell mouth, and eggshape conditions. Maximum limits cannot be exceeded without detrimental effect, particularly in the muzzle.
2. Salvage methods for over size reamed barrels must be carefully considered thru complete barrel operations to include ramp brazing.
3. The upset barrel blank and/or steel to be further studied in process to determine the cause of longitudinal bore fluctuation.
4. The Plug Ream and Plug Rifle operations must be done separately at present. Exploratory tests indicate a larger size ream plug must be used. Larger plugs now on hand for experimental trial. A .0005" reduction in diameter on the rifle will be tried.
5. Target checks on the M/721 Cal. 270, now being assembled, reflect satisfactory results attained by controlled barrel processing.
6. The 30-06 M/721 scrapped gun barrels at targeting amounted to 1.7% of production during the period from 1/19 to 3/15. Eighty nine out of ninety guns were over bore specifications at 1/4" from the muzzle. The one gun was .0002" from max bore specifications. 270 caliber now in production for one week indicate 0% scrap gun barrels at targeting.