

REQUEST 2  
261

XC: N.R. 620815

|                                                                                                                                                                                                                                                                                                                                                                   |                         |                                                            |                                   |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------|------------------------------------------------------------|-----------------------------------|
| REQUESTED BY<br><u>C.F. CIECKO</u>                                                                                                                                                                                                                                                                                                                                | DATE<br><u>1/11/81</u>  | AGE<br><u>m/700</u>                                        | PART DESCRIPTION<br><u>BARREL</u> |
| PART NO.<br><u>26289</u>                                                                                                                                                                                                                                                                                                                                          | OPER.<br><u>100+130</u> | OPERATION DESCRIPTION<br><u>POLISH BREECH END TO BLEND</u> | DEPT.<br><u>58</u>                |
| WORK REQUESTED                                                                                                                                                                                                                                                                                                                                                    |                         | BLOS.<br><u>66-</u>                                        |                                   |
| <p>Please measure the diameter of (30) m/700 .270 Rem-um<br/>Op. 100 (Rough Centerless Polish) at a point 2.808 inches from the breech face<br/>after identifying these barrels ready to your measurement after Op. 130<br/>(Polish Breech End to Blend) with the first 12 samples at every 2nd barrel<br/>on a fresh belt and the last 18 barrels every 3rd.</p> |                         |                                                            |                                   |
| MEASURED BY<br><u>JAMES B. McLAUGHLIN</u>                                                                                                                                                                                                                                                                                                                         | DATE<br><u>2-9-82</u>   | SAMPLE SIZE<br><u>30</u>                                   |                                   |
| REMARKS * PLEASE CONTACT WRITER FOR SEPARATED WHEEL I-7721                                                                                                                                                                                                                                                                                                        |                         |                                                            |                                   |

28341-PRODUCTION MACH. MEASURED DIMENSIONS

| DESC. OF CHARACTERISTIC |        |          |    |        |   |          |        |       |    | DESC. OF CHARACTERISTIC |   |       |       |          |    |                      |        |          |       |  |
|-------------------------|--------|----------|----|--------|---|----------|--------|-------|----|-------------------------|---|-------|-------|----------|----|----------------------|--------|----------|-------|--|
| BEFORE OPERATION # 100  |        |          |    |        |   |          |        |       |    | AFTER OPERATION # 130   |   |       |       |          |    |                      |        |          |       |  |
| MODEL                   |        | ONE-STEP |    | MODEL  |   | ONE-STEP |        | MODEL |    | ONE-STEP                |   | MODEL |       | ONE-STEP |    | MODEL                |        | ONE-STEP |       |  |
| #                       | DIR.   | X        | #  | DIR.   | X | #        | DIR.   | X     | #  | DIR.                    | X | #     | DIR.  | X        | #  | DIR.                 | X      | #        | DIR.  |  |
| 1                       | 1.0092 |          | 1  | 1.0068 |   | 2        | 1.0062 |       | 1  | .9793                   |   | 1     | .9945 |          | 2  | .9899                |        |          |       |  |
| 2                       | 1.0107 |          | 12 | 1.0060 |   | 2        | 1.0073 |       | 2  | .9794                   |   | 12    | .9915 |          | 2  | .9921                |        |          |       |  |
| 3                       | 1.0011 |          | 13 | 1.0071 |   | 3        | 1.0042 |       | 3  | .9820                   |   | 13    | .9902 |          | 3  | .9915                |        |          |       |  |
| 4                       | 1.0050 |          | 14 | 1.0023 |   | 4        | 1.0074 |       | 4  | .9837                   |   | 14    | .9869 |          | 4  | .9903                |        |          |       |  |
| 5                       | 1.0019 |          | 15 | 1.0072 |   | 5        | 1.0110 |       | 5  | .9799                   |   | 15    | .9887 |          | 5  | .9938                |        |          |       |  |
| 6                       | 1.0090 |          | 16 | 1.0080 |   | 6        | 1.0029 |       | 6  | .9908                   |   | 16    | .9903 |          | 6  | .9850                |        |          |       |  |
| 7                       | 1.0073 |          | 17 | 1.0053 |   | 7        | 1.0004 |       | 7  | .9858                   |   | 17    | .9918 |          | 7  | .9852                |        |          |       |  |
| 8                       | 1.0139 |          | 18 | 1.0057 |   | 8        | 1.0068 |       | 8  | 1.0008                  |   | 18    | .9862 |          | 8  | .9872                |        |          |       |  |
| 9                       | 1.0071 |          | 19 | 1.0088 |   | 9        | 1.0058 |       | 9  | .9913                   |   | 19    | .9921 |          | 9  | .9878                |        |          |       |  |
| 10                      | 1.0075 |          | 20 | 1.0088 |   | 10       | 1.0033 |       | 10 | .9970                   |   | 20    | .9907 |          | 10 | .9915                |        |          |       |  |
|                         |        |          |    |        |   |          |        |       |    |                         |   |       |       |          |    |                      |        |          |       |  |
| R                       |        |          |    |        |   |          | .0135  |       | R  |                         |   |       |       |          |    | .0235                |        |          | MD    |  |
| Z                       |        |          |    |        |   |          | 1.0067 |       | Z  |                         |   |       |       |          |    | -.045 <sup>LOW</sup> |        |          | .9974 |  |
| S                       |        |          |    |        |   |          | .00314 |       | S  |                         |   |       |       |          |    |                      | .00522 |          |       |  |