

PRG. 555 RECORD

DATES AND REASONS FOR REVISIONS							
7/23/68 - Retyped from 2/5/68 - 266576							
9/10/68 - Correct twist page dwg. no. - Blair - 266775							
APPROVAL AND DATES							
TOOLS, GAGES AND EQUIPMENT	GA. ON GAL	744	264	30-05-308	270	280	243
SPEED FEED	Flush Pin Gage - Rifling Runout	A-86095A	A-86096	A-86900	A-86895-B	A-86895A	A-86899
	Enam Gage Muzzle Diam	B-86825	B-86825	B-86825	B-86825	B-86825	B-86825
	No. Co .835	Use No Go Ga. only	to insure Mat'l for finish	turn			
	Snap Gage - 5" from shldr. (Reg.)			C-86824	C-86824	C-86824	C-86824
	No. Co .835	Use No Go Ga. only	to insure Mat'l for finish	turn			
	Snap Gage - 6" from shoulder (Reg.)	C-86827	C-86827	C-86827			C-86827
	No. Co .905	Use No Go Ga. only	to insure Mat'l for finish	turn			
	Sheffield Air Gage						
	2 Colmen M-601	Std.	Std.	Std.	Std.	Std.	Std.
	Air Gage Spindle (Rifling Dia.)	C-84804	C-84804	C-54294	C-54290	C-84804	C-86340
	Air Gage Spindle (Bore diam.)	C-84804	C-84804	C-54292	C-54290	C-84804	C-86352
	Set Ring (Rifle diam. Min.)	B-814330	B-83845W	B-52462R	B-52462T	B-814330	B-81433K
	Set Ring (Rifle diam. Max.)	B-81433P	B-81433U	B-52462S	B-52462U	B-81433P	B-81433T
	Set Ring (Bore diam. Min.)	B-81433R	B-52462V	B-52588H	B-52723T	B-81433R	B-72920P
	Set Ring (Bore diam. Max.)	B-81433U	B-83845V	B-52588J	B-52588W	B-81433U	B-72920U
	Twist Gage	C-53981S	C-53981R	B-53982	B-53983	C-53981S	C-53981U
	Twist, 1 Turn in	9" - 9 1/2"	8 3/4" - 9 1/4"	9 3/4" - 10 1/4"	9 3/4" - 10 1/4"	9" - 9 1/2"	8 7/8" - 9 3/8"
	Bore Diam. tolerance	.2770-.2780	.256-.257	.300-.301	.270-.271	.2770-.2780	.237-.238
	Rifle or groove diam toler.	.2037-.2047	.264-.265	.303-.309	.2770-.2780	.2037-.2047	.243-.244
	Gaging sequence - Check every 5th Bbl. for	1st 1 1/2 Bbl. each time a new caliber is set up for bore, groove and twist.					
	Check 2 Bbl's every 1/2 hr. during run						
	Template Ga. Min. length	C-87259	C-87259	C-87259	C-87259	C-87259	C-87259
	Cut-off length	(18" Bbl. 19.160") (22" Bbl. 23.160")	(24" Bbl. 25.160")	(24" Bbl. 25.160")	(20" Bbl. 21.290")		
NOTE:	Sample - Worst acceptable visual ripple in muzzle end of bore GA-2 Dated 4/8/64						
NOTE:	For Machine layout see	D-75572					
	Part etc. See Spread Sheet C-75570-21						
	Speed - RPM	61-62	61-62	61-62	61-62	61-62	61-62
	Feed - Inches per minute	7 1/2	7 1/2	9 1/2	9 1/2	9 1/2	9 1/2
	Feed Setting			C-2			
NOTE:	RPM figure above is starting point and must be finally determined from results obtained on twist gage and suitable hammer pattern.						

GFM Centerfire Bbl. Blank

PART NAME	COOLANT	SET UP TIME	MODEL No.	OPER. No.
TYPE		MACH. HRS.	DEPT. No.	PAGE 3 OF 6
		MACHINE	GFM Machine	

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