

a visual waviness in the bore also presented problems. Because of these above problems, making this now a borderline process, a new program has been initiated with TMD for producing a trial lot of no-turn, no-reamed barrels again using welded tubing as a starting blank. If successful, a lower Capital investment of approximately 1/3 the cost of our current GFM-Verson process is indicated and again, the operating cost savings stake, if successful, is indicated at a minimum of one quarter million annually. The proposed process essentially is a two-stage process. First operation is a warm extruded, 70% reduction over mandrel to establish reversed taper, bore and O.D. The second operation consists of die sinking to form over a finished mandrel this tubing, resulting in a shotgun barrel blank having a finished bore, choke, and chamber and a finished contoured outside diameter. Experimental tooling is currently in fabrication. Current schedules call for the completion of sample barrels from this process in December, 1975.

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