

PROCESS RECORD

TOOLS, GAGES AND EQUIPMENT		GA. OR CAL.	7MM	264	30-06-308	270	280	243
SPEED	FEED	Flash Pin Gage - Rifling runout	A-86895A	A-86896	A-86900	A-86895-B	A-86895A	A-86899
		Snap Gage Muzzle Diam	B-86825	B-86825	B-86825	B-86825	B-86825	B-86825
		No Go .035	- Use No Go Ga. only	to insure Mat'l for finish	turn			
		Snap Gage - 6" from chldr. (Reg.)			C-86824	C-86824	C-86824	C-86824
		No. Go .035	Use No Go	Ga. only to insure Mat'l for finish	turn			
		Snap Gage - 6" from shoulder (Max)	C-86827	C-86827	C-86827			C-86827
		No. Go .905	Use No Go	Ga. only to insure Mat'l for finish	turn			
		Sheffield Air Gage						
		2 Column H-601	Std.	Std.	Std.	Std.	Std.	Std.
		Air Gage Spindle (Rifling Dia.)	C-84804	C-83844	C-54294	C-54290	C-84804	C-86340
		Air Gage Spindle (Bore diam)	C-84974	C-83842	C-54292	C-54290	C-84974	C-86352
		Set Ring (Rifle diam. Min.)	B-814330	B-814330	B-52462R	B-52462T	B-814330	B-814330
		Set Ring (Rifle diam. Max.)	B-81433P	B-81433U	B-52462S	B-52462U	B-81433P	B-81433J
		Set Ring (Bore diam. Min.)	B-81433R	B-52462V	B-52580H	B-52723T	B-81433R	B-72928P
		Set Ring (Bore diam. Max.)	B-81433U	B-83045V	B-52580J	B-52580W	B-81433U	B-73928H
		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 1/2"	9 3/4" - 10 1/2"	9 3/4" - 10 1/2"	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.	.2837-.2847	.264-.265	.303-.309	.2770-.2780	.2837-.2847	.243-.244
Begin sequence		Check every 5th Bbl. for lat 15 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") (20" Bbl. 21.200")			
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 1/4	9 1/4	9 1/4	9 1/4
		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

742C-760C-600-742-760-700-600

MODEL No.

OPER. No. 50

TYPE

MACH. HRS.

DEPT. No.

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MACHINE : GFM Machine