



COLD HAMMER FORGED BARREL BLANKS

GFM hammer forging equipment is used to manufacture our barrels. This forging technology was developed in Germany during World War II and continued after the war by GFM of Steyer, Austria. Our barrels are deep bored and honed before the hammer forging process imparts the rifling. After rifling, the barrels are stabilized and straightened. Strict quality control is applied to all barrels.

Limits of forging dimensions:

Inner diameter:

- 】 Min 4.27 mm (.168")
- 】 Max 18.30 mm

External diameter:

- 】 Min 18.00 mm
- 】 Max 42.50 mm

Length limits for forging:

- 】 Min 300 mm 11,81"
- 】 Max 850 mm 33,46"

Barrel Material

The material used in the barrel production must meet high standards for purity. Impurities in steel have negative impact on deformation characteristics in the hammer forging process. For this reason all delivered melt material is controlled for chemical composition, structure and mechanical properties of the input material.

Available Steel:

Carbon steel:

- 】 C50E (AISI 1055)

Alloyed steel:

- 】 42 CrMo4 (AISI 4140)
- 】 32CrMoV12-10 (DIN 1.7765 , similar to AISI H10)
- 】 special rifle steel 15230 (similar to 50Cr V 4 or AISI 6150)

Stainless steel:

- 】 DIN 1.4034 (AISI 420F)
- 】 DIN 1.4006 (AISI 410)
- 】 1.4112 (AISI 440B)



Heat Treatment

After the forging process all barrel blanks are stabilized. Custom heat treating is also available.

Barrel Contour

The standard contours of our barrel blanks are listed below. Custom contours are available.

Group	Description	Typical Cal.	External Dia. Max. [mm] / [inch]	External Dia. Min. [mm] / [inch]	Length [mm] / [inch]	Shape
A	Rimfire rifle	.22 LR	26,0 / 1.02	19,0 / 0.75	620 / 24.41	Tapered
B	Lite centerfire rifle	222Rem.	28,5 / 1.12	20,0 / 0.79	620 / 24.41	Tapered
C	Centerfire rifle	308Win	30,0 / 1.18	23,0 / 0.91	630 / 24.80	Tapered
D	Magnum centerfire rifle	458WinMag	37,0 / 1.46	26,5 / 1.04	645 / 25.39	Tapered
E	Pistol	40S&W	36,5 / 1.44	36,5 / 1.44	530 / 20.87	Cylindrical
F	Pistol	45 AUTO	35,5 / 1.40	35,5 / 1.40	565 / 22.24	Cylindrical



Calibers available:

】 **airguns:** cal. 4.5 mm, cal.5.5mm

】 **handguns:** 6.35, 7.65 Browning, 9 mm Luger, 9 mm Browning, .40 S&W, .45 AUTO

】 **rifles:** 17 Rem, 17 HMR, .204 Ruger, 22LR, 22 Hornet, 5.56 x 45 mm, 22WMR, 223 Rem, 221 Rem, 222 Rem, 22-250, 243 Win, 6.5 x 57R, 6.5x55SE, 270 Win, 7x64, 7x57R, 7x57, 7x65R, 7mm Rem Mag, 300 Win Mag, 30-06 Sprg., 308 Win, 7.62x39, 300 WSM, 8 x 57 IS, 9.3x62, 9,3x74R, 375H&H, 416 Rem Mag, 416 Rigby, 458 Win Mag, 458 Lott

】 **shotguns:** gauge 12, chokes available

Other calibers can be supplied at additional costs.

Other calibres currently available can be found on our company website in the menu Products - Other - Barrel blanks