



Counter Bore Machining Center

*Keystone will create any NEW PRODUCT
to solve your unique production issues.*



The M769 60mm FRPC ROUND is the centerpiece of a work cell KEYSTONE built to **manufacture special artillery rounds for the Army which are used for training purposes** and have four holes that allow smoke to escape on impact. This group has more than one machine in it.

Artillery rounds are center drilled with the single head drill machine after forging. The surface is then machined. Four equally spaced holes are drilled. After drilling, the round is placed in the Deburr machine to remove all external burrs. Finally, a narrow band of paint is applied to the area around the four holes to identify it as a practice round.

KEYSTONE made all the components for this work cell, and had DOD acceptance at the facility. It was used two shifts a day for two years to complete the order with minimal complications encountered during operation.

The contractor is continuing use of the machine to satisfy continuing orders as a result of the success of the M769 60mm FRPC ROUND machine.