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Estimate File #26642

Ilion, New York
March 23, 1970

E. SPARRE

MODEL 700 SNIPER RIFLE - U. S. MARINE CORPS - ESTIMATED FACTORY COSTS
Reference: Letter EG Garrity/MS Adams to ESparre dated 2-19-70

Following the request made by Government Sales in the above reference letter, an up-dating of estimated manufacturing costs has been prepared.

Minor changes have occurred in some previously quoted items. These and costs for the latest modifications are listed below:

Basic Gun Less Packaging and Packing - Sniper Rifle to Standard Specifications as Provided on Previous Contracts

Estimated full factory cost -	\$ 70.54 each
This includes mounting the Scope Base but not the cost of the Base itself which we assume will be government furnished.	

Additional Cost for Packaging and Packing - (Palletized)

Modified Level "C" with Protecto Case -	\$ 3.93 each
(Protecto Case to be supplied by government)	
Level "A" -	\$ 12.92 each

Additional Cost for Mounting, Setting and Sighting Scope -

(Scope to be supplied by government)	\$ 13.11 each
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The following estimated costs cover possible changes or modifications being considered by the Marine Corps:

	<u>Estimated Add'l Cost per Gun</u>
1. <u>Stock</u> - In place of oil finish - dark stained RK-W to pass 72 hour water soak with only 7% weight increase.	\$ 1.91
2. <u>Stock</u> - Special HI-Comb To allow just enough clearance for Bolt removal. Tooling charges are estimated at \$660. Unit Tooling Cost for 500 guns -	\$.14
" " " " 1000 " -	\$ 1.32 66
3. <u>Barrel</u> - Standard dimensions except material to be 416 Stainless in place of Regular Remington Barrel Steel.	\$ 8.53
4. <u>Barrel - Receiver (Barrel Assembly)</u> Finish to be sand blasted Black Oxide.	No extra cost (Covered in Stainless Steel cost)

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	Estimated Add'l Cost per Gun
5. <u>Floor Plate and Trigger Guard -</u> Replace present Aluminum with Steel investment castings. To complete this item there would be charges for new tooling totaling \$8,150. This is over and above the unit cost of \$7.00/gun. Unit Tooling Charges for 500 guns - " " " " 1000 guns -	\$ 7.00 \$16.30 8.15
6. <u>Rubber Butt Pad -</u> Furnish and fit Model 40 XB type Rubber Butt Pad in place of Regular Aluminum Butt Plate.	\$ 1.24
7. <u>Mount for M-16 Type Pl-Pod -</u> (Per sample in possession of M. H. Walker) Tooling charges for this item \$1,160 over and above estimated unit cost. Unit Tooling Cost per 500 guns - " " " " 1000 guns -	\$ 1.12 \$ 2.32 1.16
8. <u>Receiver -</u> A radius can be made in place of the present flat on rear top of Receiver without adding to the cost per gun. However, tooling charges required are estimated at \$1,100. Unit Tooling Charges per 500 guns - " " " " 1000 guns -	\$ 2.20 1.10

The items listed below can be done without extra cost:

1. Trigger Assembly - Scar Engagement Screw, Trigger Adjusting Screw, Trigger Stop Screw, sealed with "Loctite", Trigger Stop Screw and Trigger Adjusting Screw not staked, Scar Engagement Screw staked, (This procedure is current practice on all Model 700's except sealant being used is DuPont cement).
2. Stock - Standard Sniper dimensions except Fore End section to be 1/4" wider and Barrel groove clearance increased by 1/32".

If the clip slots are deleted from the Receiver, there would be a reduction in cost of \$1.01 per gun.

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Government Furnished Materials

Should we be awarded with another contract for a quantity of these rifles, it is our understanding that the government will furnish (if required) the following materials:

1. Telescopes
2. Scope Mounts
3. Protective Carrying Cases
4. Sling Straps
5. Cleaning Brushes, etc.

Deliveries

A ninety (90) day lead period will be required after receipt of a contract before initial deliveries can be made. This is due to the time needed to order and receive packaging and packing materials, stainless steel (if specified) and government furnished items. The balance of contract quantities could be shipped at the rate of fifty (50) guns per week.

R. A. Williamson
Plant Manager



By: F. G. Carlson, Superintendent
Methods & Standards Section

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