

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington
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"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York
November 6, 1972

TO: C. B. WORKMAN
FROM: R. J. SANZO
SUBJECT: NUMERICAL CONTROL WORK IN PROGRESS

M/742-X Barrel Extension

(Mag) Revised program and tooling ready to debug on machine. (Eb)
(Std) Revised program and tooling ready to debug on machine. (Eb)

M/742-X Frame—Before EB Welding

(Mag) Program is being changed over to Compudyne.

M/742-X Barrel

(Mag) Program and tooling ready to run.
(Std) Program and tooling ready to run.

M/742-X Bolt

(Mag) Operation No. 1 (Comp) — Debugged, Ran 20
Operation No. 2 (Lathe) — Debugged, Ran 6
Operation No. 3 (Comp) — Debugging on machine
(Std) Operation No. 1 (Comp) — Debugged
Operation No. 2 (Lathe) — Debugged
Operation No. 3 (Comp) — Debugging on machine
Work stopped for design changes.

M/742-X Forward Frame Block

Program should be complete by Nov. 10, 1972.

M/742-X Stock

Five Operations --- Processing and tooling complete --- Programming 85%

M/510 Bolt

265 Bolts complete and delivered.
257 Bolts 80% complete
117 Bolts 40% complete
420 Bolts 20% complete
350 Bolts 10% complete

Drilling of the firing pin holes is being done on the B & S. Remaining operations are being completed on the Eb.

M/ 870 - AA Trigger Plates

Ran hand polished Trigger Plates with negative results on the Engraving Machine. Expect production request for N/C machined Trigger Plates in near future.

M/540-X Butt Pad

First Run --- 590 complete 6/20/72
Second Run --- Operation No. 1 (B & S) --- 393 complete 8/9/72
Operation No. 2 (Eb) --- Not started
Operation No. 2 (Eb) - Reprogrammed to convert to AB7300 control on New Eb.

M/ 540-X Butt Pad Bases

First Run --- 430 complete 6/22/72
Second Run --- Operation No. 1 (B & S) --- 539 complete 3/30/72
Operation No. 2 (Eb) - - Not started
Operation No. 2 (Eb) - Rewriting program to convert to AB7300 control on New Eb.

M/ XP100 Barrels

First Run -- 172 Second Run -- 258 Third Run -- 300
Fourth Run -- 187 Fifth Run -- 180 lot run completed 10/12/72

M/ 742- X Top Lock

Estimate Complete -- Processing and tooling 50% -- Programming 75%
on geometrics.

Work stopped for design changes.

M/ 870 - XX Stock Sanding Templates

A good plot has been taken with output in a form that can be handled readily
for N/C computer programming. Programming will begin this week.

M/3200 Stock and Fore-End

Programs debugged and running. Mike Sparrin has trained plant personnel to
run Edlund. Mike is assisting in maintaining machine, tape, and tooling.

M/ Timent Trap - C-90853 Throwing Arm Carrier

Estimate for 10 and 100 completed 10/11/72

M/3200 Stock - cutter Blanks for Edlund

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|---------------|--------------|------------------------------|
| A - TS - 6179 | No. 1 cutter | |
| A - TS - 6185 | No. 2 cutter | |
| A - TS - 6178 | No. 3 cutter | 6 of each delivered 10/24/72 |
| A - TS - 6180 | No. 4 cutter | |

Post Processors

The N/C Programmers are checking out the post processors for the Edlund,
Brown and Sharpe, Milwaukee-Matic Eb, compudyne, and AVS Lathe.

Milwaukee-Matic Eb and Compudyne Post Processors are debugged.

N/C Engraving Machine

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|-----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Machine | <ol style="list-style-type: none"> 1. Spare Workhead Assembly --- Three parts programmed for the EB --- were completed 10/31/72. New linear motion bearing design will be incorporated in the spare workhead and on the workheads for the new machines. 2. New Accessory Bushings made of carbide were completed by vendor, but were returned because of tight fit with engraving tool. |
| Fixturing | <ol style="list-style-type: none"> 1. 870-AA Top Radius Front --- Fabrication started 2. 870-AA Top Radius Rear --- Fabrication started |

N/C Checkering Machine

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| Machine | <ol style="list-style-type: none"> 1. "X" and "Y" adjustable stops completed. Fixed stop for Head Stock (870-AA Fore-End) is completed. Fixed stops have been fabricated for the "X" and "Y" rails (machine No. 1). 2. 870-AA Fore-end pattern is debugged. Production operators have been trained. 3. 3200 Fore-End is debugged on machine No. 2. Fixed stops for Head Stock and "X" and "Y" rails have been fabricated. 4. 870-AA Stock - Right & Left pattern is debugged on Machine No. 2. Fixed stops for Head Stock and "X" and "Y" rails have been fabricated. 5. 3200 Fore-End was set up on machine No. 1 & No. 3 to debug dual control "X" and "Y" stops are being fabricated for machine No. 1. Head Stock stop is complete. |
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R.J.SANZO:bd
Illion Research Division