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REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



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"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

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Illon, New York  
May 23, 1974

TO: W. E. LEEK  
FROM: D. S. HARDY  
SUBJECT: TECHNICAL SERVICES STAFF MEETING - MAY 28  
(Last Meeting Held May 13, 1974)

COMPUTER AIDED DESIGN

The high speed range has been used but preliminary runs indicate that peak pressures don't agree with oscilloscope readings. Therefore, a calibrated signal device has been designed which can be used for set-up and check-out. Two new features have been added to the high speed range. Peak values are printed for every shot and, if required, available impulse is also printed.

Mylar tape punch should be delivered approximately June 25, 1974.

RAMPS preliminary instructional meeting held on Feb. 14. All persons responsible for making schedules have been contacted and are preparing their preliminary CPM-PERT runs. Fred Martin has delivered his project-Initial CPM-PERT has been done. No other preliminary CPM-PERTS have been received.

The gun-motion program is waiting for empirical data from the test lab. (Shoulder-force, pressure-time, and displacement curves for a heavy-shoulder shooter firing M/870 12 Ga. shotgun with a heavy load).

A revision is being made to the target measuring program to allow rotation of the horizontal and vertical axes. This will be a console switch option, and a message will be printed to that effect.

A problem still exists in contour measuring program 27. This is a streamlined version of program 26. Work is being continued on a solution as time permits. Until a solution is finalized it is necessary to use program 26 for all contour measuring.

A program that will control and monitor the 1100 Dry-cycle machine is being written.

UNIAPT AND POST-PROCESSOR STATUS

UDS

At present, the only problem with UDS occurs when a UNIAPT program is being executed through a post-processor. The problem is that a page of paper is being skipped for each page that is printed. More pressure is being applied to United Computing for a solution. It is hoped that a solution is found by June 15, 1974.

MILWAUKEE-MATIC POST-PROCESSOR

- (1) United Computing had completed debugging of the X - Z and Y - Z circular contouring tests, and have discovered errors in both the post-processor and the programming technique. The revised post-processor and an example of the proper programming technique, should be received approximately May 31, 1974.
- (2) A revised tape with the addition of the 2 axis circular contouring with third axis linear motion capabilities has been received. Preliminary testing showed that K is not being calculated properly. Test data has been sent to United. A new revision should be received by approximately May 31, 1974.

RICHARDSON ROUTER

Problems that exist with the post-processor are as follows:

- (1) Erroneous output in certain cases of points at the start of a circle.
- (2) Post-processor won't output circular motion along an inclined plane in circular interpolation mode (outputs in short linear moves). This feature will be added for a fee of \$360.
- (3) Post-processor won't output zero values.
- (4) The addition of RETRACT and CLEARP statements is to be added for a fee of \$60.
- (5) The post-processor does not have the capability of outputting and offset feedrate (G92 Fxxxxxx) before the cutter compensation is used for the first time in the program.

All of the above changes and additions should be received by June 5, 1974.

The information pertaining to the Milwaukee-Matic Post-Processor item (1) also applies to the Richardson Router.

UNIAPT AND POST-PROCESSOR STATUS (Con't)

EX-CELL-O POST-PROCESSOR

The revised tape with the addition of the X-Y circular Z linear contouring capability has been received. The calculation of both K and the corrected feedrate number are incorrect. This addition is being made at a cost of \$360. which as yet, has not been paid. A corrected post-processor should be received by May 31, 1974.

BOSTOMATIC POST-PROCESSOR

A purchase order will be issued for this post-processor upon receipt of an up-dated and more detailed quote. Delivery will be 180 days after receipt of order.

POSITOOL POST-PROCESSOR

This post-processor is very near completion. A tape should be received by May 23, 1974.

BCP:B

SPECIFICATIONS, TECHNICAL INFORMATION & SERVICES

1. Owner's Manual for Models 40XR - 40XC 75% complete.
2. Safety copy change for M/700 Owner's Manual has been requested and written by Legal Department. Inserts with this information have been printed in plant to use up manuals already printed. The new copy will be incorporated into manuals at next reprint.
3. Mutilated or otherwise unsatisfactory drawings are being redrawn when time permits.
4. Alter 3200 Owner's Manual exploded view and parts list to latest revision.
5. Exploded view and parts list requested by field personnel has been completed and forwarded to Arms Service for distribution.
6. Upgrading of microfilm cards has been started.
7. Wonder Trap service manual being revised to "B" Model.
8. Package label mechanicals for M/870 AP Magnum grades completed.
9. Suggestion re. unloading of M/700 BDL Magazine by Legal Dept. has been forwarded to Custom Shop for consideration.
10. Review all Remington Logo marking dwgs.
11. Wood identification label for 552 - 572.

FGH:B

N/C MAINTENANCE

A proposal for retrofitting Compudyne No. 2 has been received from Simplex Industrial Corp. The cost quote will be good until Nov. 1974.

Debugging of XLO and Positool is continuing with minimal detriment to up time.

A two week trial of the trac digital read out system is scheduled for the week of June 10th. Brook ANCO Corp. will install this at no obligation on the AUS lathe.

REPORTS ATTACHED

Model Shop Work Load.

Numerical Control Work in Progress.

Plastic Research Lab:

D. S. Hardy  
Illion Research Division  
Attached