

METHODS AND STANDARDS PROGRESS REPORT - OCTOBER 1974

Suggestion Plan

Suggestion Plan data for the month of October 1974 are as follows:

	<u>Current Month</u>	<u>Total Year to Date</u>	<u>Total Last Year to Date</u>
Suggestions received	17	219	218
" in effect	6	66	69
" withdrawn	5	130	119
" pending	131	131	114
Cash awards	\$ 245.	\$ 3,858.	\$ 4,538.
Estimated gross savings	\$ 2,520.	\$ 47,260.	\$ 59,480.
Average award per suggestion	\$ 41.	\$ 58.	\$ 66.

Methods Studies

Economics were completed for the First Year Accomplishment Report on In-Plant molding of polystyrene inserts for the new shotgun cartons.

Economics have been updated and revised to reflect changes that have been made to the Press Form Process for M/870 Fore Ends. Eliminating operations to Form Corners and Harper Buff have changed the project from a cost increase to a cost savings.

A Methods Review was completed for (3) operations in Dept. #55 on the Expanded Polystyrene Block resulting in a substantial labor savings.

Capacity studies were completed and equipment requirements listed for the Production Section based on the new 5-Year Executive Committee's Projected Forecast.

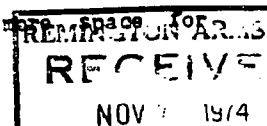
Assistance was given Production with the development of machine groupings and labor assignments to meet current production schedules on the Rim Fire Barrel Torrington swagers.

A 3200 N/C Tool Usage Report was issued for Dept. 53 as part of a program to improve tool usage and reduce tool inventories.

Method Reviews of the Centerfire Rear Sight Aperture and slide groups resulted in a substantial reduction in labor costs.

The following layouts were completed this month:

1. Completed a layout for Bldg. #50-4-N to provide space for the M/3200 Final Assembly.
2. Re-arranged equipment in Bldg. #48-1-S to regroup the M/870-1100 Barrel heading and Ejector groups to provide for additional capacity.
3. Revised the layout for Bldg. #48-2-N (Cutter Grind) to provide space for the 4th Barber-Coleman Hob Grinder.



FIREARMS DESIG

METHODS & STANDARDS PROGRESS REPORT - OCTOBER 1974Cost Improvement Program

	<u>Current Month</u>	<u>Year to Date</u>
New items added	8	181
Anticipated savings	\$ 972,000	\$ 1,953,300
Items closed out	16	210
Anticipated savings	\$ 221,800	\$ 1,632,400
Actual reported savings	\$ 122,400	\$ 1,197,200
Active items being followed	216	
Total anticipated savings (All items on Agenda)	\$ 2,534,300	
Last year's total	\$ 2,294,100	

Cost Improvement Items Anticipated

(This is a partial listing of items being worked on and scheduled for completion)

<u>Code No.</u>		<u>Est. Gross Savings</u>	<u>Estimated Completion Date</u>	<u>% Return on Investment</u>
PB-294	Chemical etch matting on Vent Rib Barrels.	\$ 14,300	Nov.'74	39%
PB-251	Adhesive Bonded Vent Rib Shotgun Barrel Ass'y.	74,300	July'75	24%
PB-342	Shotgun Vent Ribs - replace (2) mills with (1) Telematic mill.	5,300	Nov.'74	23
WE-61	Provide additional plant well water. (Bal.)	5,900	Nov.'74	21
HD-7	Purchase new Multipress for powder metal parts.	6,600	Nov.'74	C
PBB-116	M/3200 Frame-build special machine, Oper. #83 & 87.	4,900	Nov.'74	16
PBB-118	M/3200 Frame-build special machine, Oper. #245.	2,500	Nov.'74	16
PBB-121	M/3200 Frame-build special machine, Oper. #290 & #300, & Oper. #30 - Frame Sear Block Assembly.	3,800	Apr.'75	11
PBB-120	M/3200 Frame Assembly-build special machine, Oper. #40.	4,900	Nov.'74	17
PL-22	Warehouse rearrangement in Bldg. 52.	5,200	Nov.'74	**
PBB-37	M/3200 Frame Assembly Complete - Vibratory finish vs. polish.	15,500	Nov.'74	**
PA-125	New Center Fire, Rim Fire Rifle carton with molded inserts.	105,500	Jan.'75	Inf.
PBM-90	M/742-760 Firing Pin-purchase vs. manufacture.	7,300	Nov.'74	**
PBM-109	Install auxiliary filter at Barnes Drills. Reclaim additional oil.	4,200	Dec.'74	C
PBB-146	M/3200-make (7) components from formed bar stock.	19,400	Feb.'75	71
PBB-178	M/3200 Ejector-proposed cold headed construction.	10,600	Feb.'75	**
PL-21	Use of storage racks and stock pickers in Warehouse.	16,100	Nov.'74	67
WE-105	Install new windows in Bldg. 50, 82, 84 and 86. Reduce fuel oil usage.	25,500	Jan.'75	M
PBM-127	M/600-700 Bolt Body-replace special machine.	22,000	Jan.'75	99
PL-260	M/3200 Fore End-Combine Oper. #40 & #50 on N/C Router.	4,900	Nov.'74	**
PBB-181	New type coolant to improve tool life.	10,000	Dec.'74	**

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Cost Improvement Items Anticipated - cont'd.

Code No.		Est. Gross Savings	Estimated Completion Date	% Return on Investment
PBB-124	M/3200 Firing Pin Housing-purchase M/C Drilling machine for Oper. #80, 90 & 100 and Tang Connecting Block, Oper. #105.	\$ 6,700	Nov. '74	15%
PL-21	M/1100 design improvements - reduce custom repair costs.	52,200	Jan. '75	**
WE-103	Change from Ammonia to Nitrogen Gas - Bldg. 76 & 80.	5,600	Dec. '74	21
PBM-129	M/1100 Action Bar Sleeve, Oper. #24 - alter fixture. Eliminate file operation.	2,300	Nov. '74	**
PBB-355	Shotgun Vent Rib Barrels - improve type grinding wheels.	7,600	Nov. '74	**
PE-36	In-plant forging - Family Trigger Plates, M/700 Trigger Guard & Floor Plates.	138,200	May '75	32
HD-10	Powder metal - Purchase grinder vs. vendor grind, Part #12819.	62,800	Dec. '74	62
PBM-110	Centerfire Front Sight Ramp - Replace (2) Special machines with (1) Kingsbury machine.	6,600	Apr. '75	
GA-12	System to separate water from soluble oil before burning. Reduced fuel oil usage.	11,500	Dec. '74	
Total		\$ 662,200		

** - No capital investment.
 R - Machine Replacement.
 C - Increased plant capacity.
 M - Plant modernization.

Incentive Wage Plan

"Off Standard" time under the Measured Performance Plan averaged 7.1% for the month of October, as compared to 6.4% for the month of September and 7.0% for the month of August.

The Measured Performance Plan variance averaged 3.3% for the month of October, as compared to 3.2% for the month of September and 3.4% for the month of August.