xc: J. J. Bechard
W. M. Curry
B. C. Prosser
F. G. Hart
R. J. Sanzo

REMINGTON ARMS COMPANY, INC.
INTER-DEPARTMENTAL CORRESPONDENCE

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Ilion, New York
Oct. 31, 1974

TO: W. E. LEEK

FROM: C. W. STEPHAN

SUBJECT: TECHNICAL SERVICES STAFF MEETING - NOV. 4, 1974
(Last Meeting Held Oct. 21, 1974)

COMPUTER AIDED DESIGN

The Calcomp Flowchart program has been converted to run on our system. At present, a Flowchart of the 3200 repair process is being processed.

The listings of all N/C checkering pattern processing programs have been received. Work on the conversion of these programs will continue as time permits.

The mylar tape punch has been received and was sent to General Electric for interfacing to the 4020. The punch with interface will be installed Nov. 5, 1974.

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).

The program that will control and monitor the 1100 dry cycle machine has been written. Further program development will continue upon installation of necessary hardware by test lab personnel.

The 2 million word disc for the 4020 has been ordered, delivery is expected approximately Nov. 15, 1974. Work has been started on software modifications necessary for using the new disc. Work will continue as time permits.

UNIAPT AND POST-PROCESSOR STATUS

UDS

United Computing is working on solutions to the system problems we have encountered. These problems include page skipping in the Post-Processors, and automatic program turn-off in the event of a card reader failure.

UNIAPT

The latest release of Uniapt 2 has been received. Most of the problems associated with Uniapt 2 have been corrected. Upon testing, only one of the previous problems still exist. This problem occurs in the area of 3 axis linear positioning, and occurs only in one case. The test program contains many such moves which Uniapt 2 handles correctly. Uniapt 1 is still available in the event an error should result in Uniapt 2. A correction for Uniapt 2 should be received by Nov. 15, 1974.

MILWAUKEE-MATIC POST-PROCESSOR

The latest revision to this Post-Processor has been received. At present, there are no known errors.

RICHARDSON ROUTER POST-PROCESSOR

Errors in this Post-Processor are as follows:

1. Will not contour in planes other than X-Y plane.
2. K values being output incorrectly.
3. Incorrect depth calculations when using cycle/mill.
4. Cycle/deep does not function according to specifications.
5. Feedrated ignored by Retrct.
6. When using Retrct, tool will not remain at retracted position until another Z move is called for.
7. First X-Y departure not being output in same block with cutter compensation right or left code.
8. Improper output of circular interpolation data in special cases.

Documentation concerning all of the above errors has been sent to United Computing. Corrections for these errors should be received by Nov. 8, 1974.

UNIAPT AND POST-PROCESSOR STATUS (Continued)

EX-CELL-O POST-PROCESSOR

At present there are no known errors in this Post-Processor.

BOSTOMATIC POST-PROCESSOR

The specifications for this Post-Processor were sent back to United Computing on October 7, 1974 with all known modifications noted. Delivery of a test tape from this Post-Processor should be received by Nov. 8, 1974. Upon approval of the test tape, the Post-Processor will be delivered.

POSITOOL POST-PROCESSOR

At present there are no known errors in this Post-Processor.

ADAPT AND POST-PROCESSOR

COMPUDYNE POST-PROCESSOR

An error was detected in this Post-Processor in which in certain cases, the points output when contouring are rounded improperly. Since we are beyond the warranty period, Remington will be charged for any work done on this Post-Processor. Apparently, there are two options available for correction. The first option involves approximately 3 man days of work at $250/day and would be warranted for 90 days. The second option would cost $200 and would carry no warranty. A purchase order has been issued to have the necessary repairs made via Option 1. Delivery should be approximately Nov. 1, 1974.

BCP:sse

SPECIFICATIONS, TECHNICAL INFORMATION & SERVICES

1. Alter 3200 Owner's Manual (exploded view and parts list) to latest revisions.

2. Art work for extra barrel package labels completed.

3. Prepare supplementary parts/price list for all 870 Military special parts requested by Government Sales. Awaiting prices from Accounting Division.

4. Add 223 cal. to 788 Standards & Owner's Manual. Parts list has been transmitted.

5. Redrawing model drawings where necessary to upgrade files and make better microfilm cards for reproduction.

6. Assist W. A. Warren in gun evaluation report.

7. Type electric Skeet Trap parts list.

8. Monthly microfilm cards have been sent to Wilmington for security.

FGH:sse

N/C MAINTENANCE

Eb rotary axis repairs complete. Steps have been taken to prevent the condensation that caused failure condition.

Information received at XLO Parker Customer Training is being passed on to E. Saunders as time permits.

Additional Spares For All N/C Systems:

N/C machine systems spare parts are being ordered at random with cost savings being primary consideration.

REPORTS ATTACHED

N/C Status Report

Model Shop Work Load

Numerical Control Work in Progress

WMC:sse
Ilion Research Division
Attached