

Summary of
Advanced Authorization Request and Cancellation Charge
for the Proposed Bolt Action Carbine.
Advance funding should be requested as follows:

Receiver	10,850
Stock & Stock Assembly	90,000
Floor Plate Assembly	6,500
Floor Plate Pad	8,000
Floor Plate Cover	18,600
Floor Plate Base	6,000
Floor Plate Cover Assembly	2,400
Magazine Followers	5,300
Misc.	<u>5,800</u>
Total	\$153,450

Cancellation charges:

Receiver	\$3,000
Stock & Stock Assembly	90,300
Floor Plate Assembly	0
Floor Plate Pad	2,400
Floor Plate Cover	0
Floor Plate Base	6,400
Floor Plate Cover Assembly	0
Magazine Followers	9,000
Misc.	<u>11,200</u>
Total	\$122,100

Total amount to be requested on advanced authorization
\$275,550

FBI 10-1-51

Assumptions:

- The three quote requirements will be waived, in critical tooling, in order to take advantage of favorable delivery if necessary.
- Trial and Pilot cutters will be purchased from Valerus if necessary to get delivery times bettered.
- The design will be firm when transmitted and there will not be changed significantly between Trial and Pilot and production.

Machining Operations	Machines	Tooling	
		dispos	renew
Spot drill, drill, etc		5	15
Mill tang crosswise, etc		30	80
Mill angle on tang		125	370
Tri-ordinate operation		5	80
Mill Safety clearance		115	350
Drill & tap rear guard screw hole		90	270
Rollmark		20	60
Stamp "5" & "F"	RUN. SPEC. \$5000.00	100	90
		493	1315
totals in: <i>Lessons</i> <i>Dollars</i>	\$5000.00	\$10,850	\$36,200

Advance authorization to be requested:

Tool and machine design \$10,850

Cancellation Charge	3,000
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Total \$ 13,850

Advance authorization

Transmittal of divgs.

Tool & mach. design

Procurement

Trial and Pilot

Stock & Stock Assembly

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This write-up covers a walnut Stock having a Model III finish, the same as the present M/700 EDC, and N/C checkering.

Assumptions:

- There is capacity on the hand spray and N/C checkering equipment to handle this model.
- Design will be firm at the time advance funding is authorized.
- There will not be significant design changes between Trial and Pilot and production.

Machining Operations	Vendor Tooling	Machines	Tooling design	Tooling build
Joint & plane			4	20
Shape top & bottom			132	256
Shape top only			132	256
Shape head, etc.			156	134
Inset top & seat etc.			1375	5424
Profile		RICHARDSON COPY LATHE \$30,000 ⁰⁰	145	964
Mill Tang Margin		NICHOLS ZSF MILL \$22,000 ⁰⁰	170	642
Inset bottom, etc.		RUM SANC. No. 1 \$71,000 ⁰⁰	515	620
Mill Bottom of Grip, etc.		RUM SANC. No. 2 \$74,000 ⁰⁰	250	660
Saw Fore-End Tip		CHOP SAW \$3,000 ⁰⁰	25	106
Shape Fore-End Tip		TWIN MILL \$25,000 ⁰⁰	150	530
Butt Plate mold	\$15000 ⁰⁰			
Sand complete		2 Vertical Spindles \$14,000 ⁰⁰		
		1 Flat Grinder \$7,000 ⁰⁰		
		1 Horizontal Spindle \$5,000 ⁰⁰		

Machining Operations	Vendor Tooling	Machines	Tooling	
			Design	Price
N/C checker Grip			360	450
N/C checker Two-arm			360	450
Production aids			15	75
Totals in: hours			4051	10755
dollars			\$90,000	\$296,000

Advance authorization to be requested:

Tool & machine design	\$90,000
Vendor tooling (Grip Top model) - cancellation	15,000
Cancellation charges	\$75,300
total	\$180,300

Advance authorization
Transmittal of design
Tool and machine design
Procurement
Trial and Pilot

0	4	8	12	16	20	24	28	32	36	40	44	48

Flame Plate Base Assembly

4/16 1945

This assembly is made of two components: the Flame Plate Base, and the Trigger Guard Plate which are brazed together.

Assumptions:

- The design will be firm when transmitted.
- There will not be significant design changes between Trial and Pilot and production.

Machining Operations	Machines	Tooling	
		Design	Build
Inspection Bege		150	315
Straighten		50	150
B'drill ree guard screw etc, etc.		93	271
Total in: hours		293	736
dollars		\$6500 ⁰⁰	\$20,200 ⁰⁰

Advance authorization to be requested

Tool design

\$6500

cancellation charges

0

Total

\$6500⁰⁰

Advance authorization

Transmittal of design

Tool design

Tool procurement

Trial and Pilot

	4	8	12	16	20	24	28	32	36	40	44	48
Advance authorization												
Transmittal of design												
Tool design												
Tool procurement												
Trial and Pilot												

Floor Plate Pad

This component is a molded nylon part which will be used at Final Assembly.

Assumptions:

- Design will be firm when transmitted
- There will not be significant design changes between Trial and pilot and production.

Operations

Injection mold

Vendor tooling

290 hours design & build

\$8000⁰⁰ cost for design & build

Advance authorization to be requested:

Mold design & build	\$8000 ⁰⁰
Cancellation charges	<u>2400⁰⁰</u>
total	10400 ⁰⁰

Advance authorization
Transmittal of design
Mold design and build
Trial and Pilot

0	4	8	12	16	20	24	28	32	36	40	44	48

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Assumptions:

- Machining Operations
Purchase Insp.
Straddle Mill Hinge
Beam Hole in Hinge

Vendor tooling

Design	Build
121	385
173	400
42	84
336	869
\$7400 ⁰⁰	\$24,000 ⁰⁰

Tool design 0 \$7400

Cancellation charges 0

Advance authorization

Foot design
Foot measurement

Trial and Pilot

[illegible]

Floor Plate Base

This is a steel stamping, requiring secondary machining operations, which becomes part of the Floor Plate Base Assembly.

Assumptions:

- Design will be firm when transmitted
- There will not be significant design changes between Trial and Pilot and production.

Secondary Operations	Vendor tooling	Machines	Tooling	
			design	build
Purchase hump.			101	318
Weld slot in hinge			126	308
Beam hole in hinge			42	84
Totals in: hours			269	710
dollars	\$21,200 ⁰⁰		\$6000	\$19500

Advance authorization to be requested:

Tool design	\$6000
Vendor tooling - cancellation	6400
Machine cancellation charge	0
Total	\$12400 ⁰⁰

Advance authorization

Transmittal of dwgs

Tool design

Tool procurement

Vendor tooling & samples

Trial and Pilot

	0	4	8	12	16	20	24	28	32	36	40	44	48
Transmittal of dwgs													
Tool design													
Tool procurement													
Vendor tooling & samples													
Trial and Pilot													

Slide Plate Cover Assembly

This assembly is made by spotwelding the Magazine Spring Retainer to the Slide Plate Cover.

Assumptions:

- Design will be firm when transmitted
- There will not be significant design changes between Trial and Pilot and production.

Operations:

Spot weld
Polish and buff bottom

totals in : hours
dollars

Totals	
design	build
100	250
10	20
110	270
\$2400	\$7500

Advance authorization to be requested:

Tool design \$2400⁰⁰
Cancellation charges 0
total \$2400⁰⁰

Advance authorization
Transmittal of design
Tool design
Tool procurement
Trial and Pilot

	0	4	8	12	16	20	24	28	32	36	40	44	48
Advance authorization													
Transmittal of design													
Tool design													
Tool procurement													
Trial and Pilot													

Miscellaneous Components

The components and/or assemblies listed in this write-up are grouped together as there are no new machines involved and the processes are relatively slack or are ad-used from current processes.

Assumptions:

- Design will be firm when transmitted
- There will not be significant design changes between Trial and Pilot and production.

Component or Assembly	Vendor Tooling	Tooling	
		design	build
Front Sight Ramp Screw	\$150 ⁰⁰	4	
Rear Guard Screw	200 ⁰⁰	4	
Bolt Stop Release	3850 ⁰⁰	32	60
Safety Assembly		25	40
Safety	725 ⁰⁰	54	70
Safety Button (P/M)	4800 ⁰⁰		
Trigger Guard Plate	3700 ⁰⁰	12	
Magazine Spring Retainer	6300 ⁰⁰	36	50
Floor Plate Latch (P/M)	5725 ⁰⁰		
Floor Plate Latch Spring	5700 ⁰⁰	36	30
Trigger Guard	5000 ⁰⁰	44	115
Barrel Assembly		5	10
Bolt Assembly			
Bolt Final Assembly			
Final Assembly		10	30
		264	405
totals in: hours		\$5800 ⁰⁰	\$11,200 ⁰⁰
dollars	\$36200 ⁰⁰		

Advance authorization to be requested:

Tool design

\$ 5800 ⁰⁰

Vendor tooling - cancellation

11000 ⁰⁰

Machine cancellation charges

0 ⁰⁰

total

\$ 16800 ⁰⁰

Advance authorization

Transmittal of drawings

Tool design

Tool procurement

Vendor tooling & samples

Trial and Pilot

	0	4	8	12	16	20	24	28	32	36	40	44	48
Advance authorization													
Transmittal of drawings													
Tool design													
Tool procurement													
Vendor tooling & samples													
Trial and Pilot													

Magazine Followers

This component is to be a new design steel stamping, hardened and chrome plated.

Assumptions:

- Design will be firm when transmitted.
- There will not be significant design changes between trial and Pilot and production.

		Tooling	
		Design	Shield
Vendor tooling (for 2 part)	\$30,000 ⁰⁰		
Purchase Imp. Jags		240	720
Tool in: Low		240	720
: Dollars \$30,000 ⁰⁰		\$5300	\$20,000

Advance authorization to be requested:

Tool design	\$5300
Vendor tooling (cancellation)	9000
Machine cancellation	<u>0</u>
total	\$14,300 ⁰⁰

Advance authorization
Transmittal of drawings
Tool design
Tool procurement
Vendor tooling & samples
Trial and pilot

	0	4	8	12	16	20	24	28	32	36	40	44	48
Advance authorization													
Transmittal of drawings													
Tool design													
Tool procurement													
Vendor tooling & samples													
Trial and pilot													