

CENTER FIRE RIFLESMODEL 7400, 7600, FOUR AND SIX
(1981 Introduction)

Production reported that assembly to the Gallery and warehouse is continuing on all four models. Exhibit 2 shows the quantities warehoused to date for each model. All production to the warehouse has been in 30-06 Caliber. An additional 291 Model Four and Six Rifles have been built in 308 WIN. Caliber, but are being held for Magazine Box revisions. The next two Calibers scheduled for production are 7mm EXP REM. and 243 WIN.

Process improvement efforts are now concentrated in three basic areas, shown in Exhibit 3. Flow of guns to the warehouse is currently limited by production of Stocks for Models Four and Six. Production noted that trial and pilot of this component was completed just prior to line changeover and production startup. As a result, the difficulties encountered during trial and pilot are just now being corrected. An active program is underway to improve both the quality and quantity of Stocks to Assembly. 83

The second process improvement being pursued involves heading. The 7400 and 7600 require selective assembly of Bolts and Barrels, as did the 742 and 760. However, because selective assembly of 7400 components was expected to be considerably easier, no gages were provided. It is now apparent that heading of the 7400 is just as demanding as it was for the 742. A gage for segregating Breech Bolt Assemblies by heading dimensions is now on the job and should provide some short term relief. For the long term, the most effective procedure would be to individually head Bolts and Barrels, as is done on Bolt Action Rifles. A process to accomplish that has been layed out and should be operational by March, 1981.

Process improvements to the 30-06 Magazine Box have significantly reduced Gallery rejects in that Caliber. However, additional problems have been encountered with 308 WIN Caliber Rifles. These difficulties are again associated with the Magazine Box. Specifically, the front end of the Magazine Follower comes out of the Box when feeding the last shell. The Follower is a takeover part from the 742, and caused similar problems on that model. However, corrective action is much more difficult on the 7400 due to the heavier material in the new Box. No trial and pilot was run on the Magazine Assembly prior to production startup. The trial and pilot is, in effect, being conducted concurrent with production.