

Technical Services Staff Meeting - April 29

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REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington
OF THEPETERS
OF THE

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York
April 24, 1974

TO: D. S. HARDY

FROM: B. C. PROSSER

SUBJECT: UNIAPT AND POST-PROCESSOR STATUS

UDS

At present there is only one problem with UDS. When a program is being executed thru the post-processor, a page of paper is skipped for every page that is printed. United Computing is aware of the problem and is working on a solution. A correction for this should be received by approximately May 15, 1974.

MILWAUKEE-MATIC POST-PROCESSOR

- Same as Richardson ??*
- (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 1, 1974.
 - (2) The addition of the capability for circular contouring in the X and Y with simultaneous Z axis linear motion. This addition will be made for a fee of \$360. delivery is the same as the above date.

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.

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UNIAPT AND POST-PROCESSOR STATUS (Con't)

RICHARDSON ROUTER (Con't)

- (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. *why?*
- (3) Post-Processor won't output zero values.
- (4) The addition of RETRCT and CLEARP statements is to be added for a fee of \$60. *why?*
- (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 May 1, 1974.

The information pertaining to the Milwaukee-Matic Post-Processor also applies to the Richardson Router.

EX-CELLO-O POST-PROCESSOR

why?
A revision to this Post-Processor is required to permit Z axis linear motion in conjunction with X and Y axis linear or circular motion. This was not included in the original Post-Processor because the information was not available at that time. This addition will be made for a fee of \$360. Delivery will be approximately May 1, 1974.

POSITOOL POST-PROCESSOR

The specs on this Post-Processor were received, proof read and returned to United with all necessary revisions noted. A tape for this Post-Processor should be received approximately May 17, 1974.

BOSTOMATIC POST-PROCESSOR

PE&C
A quote has been received from United Computing for this Post-Processor. The price would be \$2,265. and would be capable of making tapes for both the old and new Bostomatics. Delivery is 180 days after receipt of order. This quote is valid through May 19, 1974.

BCP:s
Ilion Research Division

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MEASUREMENT AND TEST LAB

M/3200 Over and Under Shotgun

1. 12 Ga. - 3" New Tang Design Endurance w/1 7/8 oz. load.
 - (a) 22668 - completed.
 - (b) 22659 - completed.
 - (c) 22670 - completed.
 - (d) Report being prepared by J. Hennings.
2. Fore-end design changes.
 - (a) Testing was added to above testing.
 - (b) Results being included in above (d) report.
3. 3200 Single Barrel Trap gun - no test activity.
4. Wide cam plate drycycle test @ 9,420 waiting for new ejectors.
5. Received compiled list of coming/needed 3200 test activity from J. Linde.
 - (a) Clay bird trajectory velocity data.
 - (b) Customer blown top lock investigation.
 - (c) Over bore (.750) pattern, pressure, velocity and gas leakage.
 - (d) High pressure hand load pressure - travel.
 - (e) Single barrel trap - piston velocity, gas system pressure, shoulder force, crud build-up, and recoil pad.
 - (f) Single barrel trap gun testing.

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MEASUREMENT AND TEST LAB (Con't)

M/3200 Over and Under Shotgun

- (g) Combination skeet sets.
- (h) 410 Pattern - choke work.
- (i) Review of problems encountered during top tang testing.

M/742-X New Design Autoloading Rifle

- 1. Designed and fabricating transducer for Soucy Gas System mock-up velocity measurements.

M/1100-X New Design Autoloading Shotgun

- 1. Conducted 12/20 testing in M/1100X barrels using test gun mock-up fixture.
- 2. Assisting set-up Pendulum Test fixture for trunnion disc evaluation.

→ M/1100 Product Improvement

- 1. Experimental fore end support testing in Pendulum drop test at approximately 6500 cycle, machine broke down.
- 2. Action bar Thumper being revised.
- 3. M/1100 L.W. 20 Ga. .475 wide locking block test gun scheduled for proof ammo testing.
- 4. Action bar testing on full cycle dry cycle machine at a hold - waiting new drive spring.
- 5. Field tested 410 extractors and poly duck plugs.
- 6. Locking block endurance (1018 vs. 8640) report started.
- 7. Experimental high rib P.O.I. testing - no activity - received new barrels.

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MEASUREMENT AND TEST LAB (Con't)

M/1100 Product Improvement

8. Shot peened music wire firing pin - no activity.
9. Reviewing 20 ga. L.W. locking block loading via strain measurements.
10. Reviewing action bar loading via strain measurements.

Lab Support Activity

1. Received M/700 - 222 quality audit test guns.
2. Received M/700 - 30/06 Q.A. test guns.
3. M/870 max. open velocity/unlock time needs more test data.
4. Fired 12/20 pressure test program and in process of summarizing data.
5. Conducted 12/20 barrel burst test (10barrels)
6. Dry cycle testing M/700 extractors.
7. Dry cycle testing M/700 striker springs and firing pin heads.
8. Destroyed contents of casualty ammo box and old foreign shotshells.
9. Shot patterns with choke/matic device.
10. Shot five M/1100 - 12 ga. - 3" chambered shotgun for bolt velocity (D.B.B.)
11. Made up one hundred (100) 243 cal. functional dummies.
12. Assisted P.E. & C with 30/06 proof ammo.
13. Fired Winchester Super X Model 1 shotgun 101 rounds in Lab test jack.
14. Received two Browning Model 2000 shotguns for evaluation.

AAH:s

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SPECIFICATIONS, TECHNICAL INFORMATION & SERVICE

1. Owner's Manual for models 40XR - 40XC has been started.
2. Change to M/700 Owner's Manual copy approved and at printer.
3. All Owner's Manuals have been revised to include copy Re: Use of shooting glasses as requested by Marketing.
4. Multilated or otherwise unsatisfactory drawings are being pulled and redrawn as time permits.
5. Alter 3200 Owner's Manual exploded view and parts list to latest revisions. (Summer printing).
6. Exploded view and parts list for M/58 has been started.
7. New copy written for 3200 Owner's Manual revision.
8. Upgrading of IBM microfilm cards to 3M Brand to provide better prints.
9. Microfilm Accounting Dept. records.
10. Type-set Remington Action.

FGH:s

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N/C MAINTENANCE

XLO 108E

Cutter radius compensation quoted from XLO Parker 4/23/74
will be about \$1,500.00 installed.

Random tool selection is not practical to add in the field.

See N/C Status Report

REPORTS ATTACHED

Model Shop Work Load.

Numerical Control Work in Progress.

Plastic Research Lab.

C. B. Workman:bd
Illion Research Division
Attached