

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



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"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" _____

Ilion, New York
August 4, 1981

TO: J. P. GLAS

FROM: C. B. WORKMAN

CBW ←

SUBJECT: STATUS OF SCOPE MOUNTS FOR BOLT ACTION RIFLES

As stated in the July Operations Committee, there are five scope mounts designs being considered. Samples of two designs have been made (Post Mount and Thumbwheel Mount), two are in the Model Shop (Hinged Clamp and Formed Clamp), and one is still in the conceptual stage (Collet Post).

A "High Spot" review of these designs with Process Engineering shows that the "Post Mount" designed to be attached to the present scope mount holes in the M/700 receiver is the only one that can be implemented in time to be considered for 1983 introduction. Delivery times of machinery to modify the receiver for dovetail mounts (Designs 2, 3, and 4 in attached table) range from 12 to 16 months. Release of a dovetail design to production could not reasonably be expected to occur before November 1981.

The Post Mount requires no modification to the receiver and could also be transmitted by November.

Four different processes are being considered for the mounts. All fall within a narrow range of high spot estimated factory cost of from \$11.00 to \$13.00 per set.

	<u>Tooling</u>	<u>Capital</u>	<u>Factory Cost</u>
Investment Cost	\$15,000	0	\$11.07
Bar Stock	\$33,000	0	\$11.44
Powder Metal	\$21,000	0	\$13.07
Injection Molded P.M.	\$44,000	0	\$11.20

CBW:sse
Attach

	Sample for Test	Complete Test	Transmit to Prod.	Process & Tool	Trial & Pilot	Trial & Pilot Test	Type of Process	Tooling Cost	Capital Equip. Cost	(Std.) (Matl.) Blank Cost	(Std.) (Labor) Prod. Cost	c=1.3(std. matl.) +4.2 (std. lab) Estimated Total Factory Cost
(1) Post Mount (Contoured) Ring							Inv. Cast	\$15,000	0	\$4.70	\$1.18	\$11.07
	10/1/81	10/15/81	11/1/81				Bar Stock	\$33,000	0	\$2.76	\$1.87	\$11.44
							Pwdr. Metal	\$21,000	0	\$1.27	\$2.72	\$13.07
	1/1/82	1/15/82	2/1/82				Int. Mold Pwdr. Metal	\$44,000	0	\$4.80	\$1.18	\$11.20
(2) Thumbwheel Mount (Req. Item (6) below)				Approximately same as Post Mount but probably slightly more expensive, also requires item (5) below								
(3) Hinge Clamp (Req. Item (6) below)												
(4) Formed Clamp (Req. Item (6) below)							Formed (Stamping)					
(5) Collet Post (Screw Eye)												
(6) Receiver (Dovetail) For 2,3,4				14 mos.			Mill & dovetail (two level rec.)	\$40,000	\$100,000			