

To: R.A. Jackson

October 29, 1993

From: R.S. Murphy

Subject: October Progress Report

o The 700 Detachable Box Magazine continues to lead my priority list as we are beginning to machine trial and pilot components.

The fourth axis fixture is working acceptably and is milling approximately 250 parts per day over two shifts. New locators are to be made to replace a condition where shims are required to centrally locate the guards. New backer plates to prevent part bending are being wired EDMed at an outside vendor and will be installed by 11/5. The program is also being rewritten to try removing the roughing cuts and completely mill the parts in one pass.

Secondary milling cuts on the Light Machines Co. "mini-mill" are going well with the majority of the guards already milled.

o 90-T support is continuing. A top lever return spring will be redesigned and a DCR will be done for the locking bolt to reduce the occurrences of the top lever opening on firing. Development of the locking bolt to monoblock contact surface angle is continuing and it appears that an 8 degree angle will keep the gun closed on firing but not be too "sticky". The 90-T from the Test Lab will be sent to Kolar along with ammo to confirm this design change.

o The design of a palletized fixture to drill and tap 541 receiver scope holes is continuing. Project money that I felt was available to design and build this fixture is not available so a project write-up has been started.

o The balance of my time was applied towards plant support activities too numerous to itemize but too important to ignore. As always, additional time could be spent in this area as there are many opportunities for process improvements.