

November 29, 1993

TO: R.J. ORF  
FROM: D. RONKAINEN

RE: MONTHLY REPORT, NOVEMBER 1993

OVER/UNDER MISCELLANEOUS PARTS

\* The first C-style Fore End Irons are at Assembly. Working with production, a method has been established for straightening and checking the fit of the Fore End Iron, although the process has not been perfected.

The current Fore End Iron process requires the components to be moved 14 times through various departments. A meeting was held with production supervision to discuss plans to eliminate some of the handling and trucking of the components. Preliminary plans are to move polishing, straightening and flame harden to one area.

SHOTGUN BREECH BOLT BROACHING

\* Quotes for rebuilding the three broach machines have been reviewed and the choice vendor for all three machines is Ohio Broach Company. A project will be submitted during the second week of December, with plans to place orders immediately after project approval.

MIM EXTRACTOR FOR 870 12 & 20 GA EXPRESS

\* A thirty piece sample was sintered and inspected. The samples have flash and parting lines which may be detrimental to the function of the extractors. In addition, the identification mark needs to be enlarged and the hook area of the extractor is under-formed. The samples have been heat treated, and a full dimensional layout will be performed for each cavity. Once the layout is complete, the mold will be sent to Wilderness Tool to correct the items mentioned above, to add hot sprues and run-off grooves, and any necessary items as determined from the layout.

SP10 CASTINGS

\* Hitchiner has not been fully approved for the Carrier castings since a full dimensional layout has not been received.

\* Ejector casting samples were inspected and found to be satisfactory. Hitchiner has approval to begin production on this component.

\* Wax samples of the Operating Handle molded from the corrected tooling have been inspected and found to be satisfactory. PMI has approval to begin a full production run.

\* The problem with mold mismatch on the Extractor casting has been resolved with PMI. We determined how to eliminate the mismatch without rebuilding the entire tool, and tooling changes are currently being completed. I expect to see wax samples of the Extractor by late December.