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## MEMORANDUM

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**DATE:** May 24, 2006  
**TO:** Jim Rabbia  
**FROM:** Mike Santillo  
**RE:** M/710 Rev 2 High Spot Estimate Review meeting -  
8/26/98  
**CC:** J. Mead, D. Diaz, M. Keeney, J. Swanson, W. Zarnoch, M. LeMay, J.  
Parkhurst

The Process Engineering group met today to begin the high spot estimating process for the revised M/710. The following is a synopsis of the foreseeable issues regarding manufacture and manufacturing cost of the proposed design changes. The premise of the meeting was to review the original high-spot estimate done by Ilion on 6/9/98, review the proposed design concept, identify potential manufacturing issues and assign components to engineers for estimation. Below are the issues discussed with significant points pertaining to each.

### Barrel - Summary

- Blank Size -
  - Requires a new 3-pass upset blank
  - New blank can be upset on manual machine only
  - New blank requires new tooling
  - Increased cycle time
  - Capacity
- Drilling - DEHOFFs
  - Requires all new cups
  - Capacity
- Turning - Monarchs
  - Requires all new heads
  - Capacity
- GFM
  - Requires new collets
- Chamber & Hub -
  - Requires a new CNC Chucker - Tight internal machining tolerances
  - Requires new depth gages

**Tang - Summary**

- Subsequent part - attach fire control & assemble to stock

**Tang - Summary**

- Removal of bolt with cam screw @ bottom of receiver, hidden in stock