

REMINGTON ARMS COMPANY, INC.

Elion Works

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PROJECT M-121 M/721 TOOLING EXPENDITURES THRU MAY 12, 1946

Work Orders approved by Works Engineer

<u>W/O #</u>	<u>Quan.</u>	<u>Trans. to Stores</u>	<u>Description</u>	<u>Part & Oper.</u>	<u>Spent</u>
80633	2	1	Cutters-Dwg. A-50001	Stock-Inlet for rec., etc.	.22
80634	1		Cutter-Dwg. A-50000	Stock-Inlet for rec., etc.	.21
80638	2		Templata-Dwg. B-50005		56.76
80743			Tooling to produce firing pin head-Dwg. B-17023		2,501.22
81001			1 set of necessary Tools & Gages for production of M/721 Bbl. Bracket-consisting of Progressive Piercing & Blanking Die, Reaming Plate, Banding Fixture & Plug Gage		-
81002	1		Receiving gage-Dwg. B-50140	Barrel bracket	-
81003	1		Clamp-Dwg. B-50148	Housing	-
81004	1		Functional receiving gage Dwg. A-50002	Safety snap washer	-
81005	1		Master comparator-Dwg. B-50156	Master comp. stage	60.06
81006	1		Plug gage-Dwg. A-50141	Bolt stop release	-
81007	1		Plug gage-Dwg. A-50142	Bolt stop release	-
81008	1		Width gage-Dwg. A-50125	Safety detent spring	-
81009	1		Taper ring gage-Dwg. A-50122	Bolt handle	3.08
81010	1		Plug gage-Dwg. B-80008	Barrel bracket	3.08
81011	4		Thread roll snaps-Dwg. B-80018	Various uses	98.50
81012	2		Ring thread gages-Dwg. B-80025	Rec. plunger screw	96.30
81013	3		Plug gages-Dwg. B-80005	Various uses	29.36
81014	2		Ring thread gages-Dwg. B-80026	Trigger adj. screw	49.10
81015	6		Plug gages-Dwg. B-80002	Various uses	-
81016	3		Setting plugs-Dwg. B-80019	Various uses	77.18
81017	16		Adj. snap gages-Dwg. B-80013	Various uses	-
81018	8		Adj. snap gages-Dwg. B-80012	Various uses	-
81019	6		Adj. snap gages-Dwg. B-80024	Various uses	-
81020	1		Taper plug gage-Dwg. A-50123	Bolt handle ball	4.62
81021	1		Radius gage-Dwg. A-50126	Butt plate	-
81022	2		Adj. snap gages-Dwg. B-80010	Various uses	-
81023	1		Dial micrometer-Dwg. B-80036	Safety pivot pin	71.47
81024	1		Fixture-Dwg. B-50317	Trigger	-
81025	1		Receiving gage-Dwg. B-50131	Plate	-
81026	1 set		Cams-3 Dwg. C-50040	Front guard screw	10.95
81028	2		Circular form & cut-off tools Dwg. A-50025	Front guard screw	-
81029	1		Brill slotting bushing per Dwg. A-50028	Front guard screw	19.66

<u>N/O #</u>	<u>Quan.</u>	<u>Trans. to Stores</u>	<u>Description</u>	<u>Part & Oper.</u>	<u>Spent</u>
81030	2	1	Circular form tools-Dwg. A-50024	Front guard screw	32.36
81031	1	1	Broach-Dwg. D-50187	Receiver-Broach bolt	-
81032	1	1	Broach-Dwg. D-50079	guide slots	-
81033	1	1	Broach-Dwg. D-50195	Receiver-Broach mag.	-
81034	1	1	Broach-Dwg. D-50186	slot & ejector part	-
81035	1	1	Rectangular Broach-Dwg. D-50078	Rec.-Broach bore to	-
81036	1	1	Adj. snap gage-Dwg. A-50159	final I. D.	-
81037	2	1	Circular cut-off tools-Dwg. A-50026	Rec.-Broach bolt guide	-
81038	2	1	Circular form tools-Dwg. A-50027	slots	-
81039	4sets	2sets	Chasers for geometric die head	Rec.-Broach mag. slot, etc.	-
81040	1	1	Solid adj. die head-Dwg. B-90039	Rec. Plug screw	-
81041	2	1	Circ. form & cut off tools-Dwg. A-50021	Rec. plug screw	-
81042	1	1	Cylindrical plug gage-Dwg. B-80006	Rec. plug screw	-
81043	2sets	1set	Die chasers-Dwg. B-90038	Various uses	14.64
81044	1set	1	Three cams-Dwg. C-50041	Various uses	31.94
81045	1	1	Hole locating gage-Dwg. B-50284	Trigger stop screw	30.31
81046	1	1	Gage & master-Dwg. C-50264	Trigger guard	14.22
81047	1	1	Snap gage-Dwg. B-50128	Various uses	14.48
81048	1	1	Slotting bushing-Dwg. A-50030	Rec. plug screw	9.49
81049	2	1	Adj. die heads-Dwg. B-90037	Housing	8.80
81050	1	1	Std. bal. turning tool-Dwg. B-90014	Housing	131.28
81051	1	1	Comparator fixture-Dwg. C-50678	Housing	18.68
81052	1	1	Comp. screen & 1 reproduction to Dwg. B-50685	Rec. plug screw	34.34
81053	10	1	Carbide tips	Various uses	63.77
81054	2	2	Turning tools-Dwg. A-50277	Various uses	32.51
81055	2	2	Turning tools-Dwg. A-50280	Trigger guard	-
81056	2	2	Radius tools-Dwg. A-50281	Firing pin	-
81057	2	2	#2 Turning tools-Dwg. A-50278	Firing pin	.10
81058	2	2	#3 cut-off tools-Dwg. A-50279	Firing pin	-
81059	1	1	Mag. driving collet-Dwg. B-90035	Firing pin	14.59
81060	1	1	Comp. fixture-Dwg. C-50362	Various uses	-
81061	1	1	Functional rec. gage-Dwg. C-50365	Bolt stop	6.53
81062	1	1	Functional rec. gage-Dwg. C-50339	Magazine	-
81063	1	1	Comp. screen & 1 reproduction Dwg. B-50360	Magazine	-
81064	1set	1	3 cams-Dwg. C-50042	Open sight stop	2.86
81065	1	1	Comp. screen & 1 reproduction Dwg. B-50373	Trigger Adj. screw	10.73
81066	1	1	Comp. fixture-Dwg. D-50400	Bolt stop	19.86
81067	1	1	Master comp.-Dwg. B-50403	Bolt stop release	-
81067	1	1	Comp. fixture-Dwg. D-50325	Sear	-
81067	1	1	Comp. master-Dwg. B-50332	Sear	-

W/O #	Quan.	Trans. to Stores	Description	Part & Over.	Spent
81068	1		Comp. fixture-Dwg. C-50356	Open sight step	-
	1		Comp. master-Dwg. A-50361		-
81069	1		Comp. screen and 1 reproduction Dwg. C-50333	Sear	23.26
81070	1		Slotting bushing-Dwg. A-50031	Trigger Adj. screw	15.42
81071	1		Plug gauge-Dwg. A-50249	Receiver	14.96
81072	1		Snap gauge-Dwg. A-50251	Receiver	20.90
81073	2	1	Circ. form tools-Dwg. A-50023	Trigger adj. screw	-
81074	1		Position gage-Dwg. B-50313	Receiver	-
81075	1		Position & length gage-Dwg. B-50257	Receiver	-
81076	2		Plug gauges-Dwg. A-50296	Receiver	37.84
81077	1		Plug ga.-Dwg. B-50256	Receiver	-
81078	1		Dial depth gauge-Dwg. B-50240	Receiver	4.62
81079	1		Complete checking ga. Dwg. D-50694	Extractor	-
81080	1		Templet gage-Dwg. D-50841	Stock	-
81081	1		Fixture-Dwg. C-50121X	Ebl.-Draw rifle	-
81082	1		Brazing fixture-Dwg. D-50169	Bolt handle & ball assy.	-
81083	1		Comp. screen & 1 reproduction Dwg. B-50838	Bolt handle	2.86
81084	6		Plug gauges-Dwg. B-80002	Various uses	-
81085	1		Plug gauge-Dwg. B-80001	Various uses	-
81086	6		Snap gauges-Dwg. B-80010	Various uses	-
81087	2		Plug gauges-Dwg. B-80003	Safety	-
81088	2		Snap gauges-Dwg. B-80012	Various uses	-
81089	2	1	Circ. form tools-Dwg. A-50022	Safety pivot pin	-
81090	3		Adj. limit length gauges-Dwg. B-80020	Various uses	-
81091	1		Complete e'bore & facing tool Dwg. B-50255	Receiver	-
81092	1 set		3 Cams-Dwg. C-50034	Safety pivot pin	10.84
81093	4		B&S spring collets-Dwg. B-90034	Various uses	13.19
81094	4		B&S feeding fingers-Dwg. B-90031	Various uses	8.46
81095	10	9	Std. H.S.S. Ser. slotting cutters Dwg. B-90007-W	Various uses	8.91
81096	2	1	Std. st. cir. cut-off tools-Dwg. B-90005-W	Various uses	14.41
81097	1		B&S feed finger-Dwg. B-90012W	Various uses	-
81098	2	1	Slotting bushings-Dwg. A-50029	Trigger stop screw	16.72
81099	20	18	Std. ser. H.S.S. slotting cutters-Dwg. B-90006-W & B-90006-V	Various uses	17.61
81100	1		Solid adj. die head-Dwg. B-90037-W	" "	-
81101	2		Dial indicator snap gauges	" "	-
81102	1		Comp. screen & reproduction Dwg. B-50392	Open sight assem.	19.86
81103	1		B&S feeding finger-Dwg. B-90033-W	Bolt handle	-
81104	1		Spring collet-Dwg. B-90036-W	Bolt handle	-
81105	1		Comp. screen & 1 reproduction Dwg. B-50801	Bolt handle	19.86
81106	1		Complete sanding fixture Dwg. C-50143	Bolt handle	-

N/O #	Trans.	Quanta	Description	Part & Oper.	Spent
81107		1	Comp. fixture-Dwg. C-50833	Bolt handle	-
81108		1	Comp. fixture-Dwg. C-50796	Bolt handle	-
81109		1	Comp. fixture-Dwg. C-50383	Open sight assembly	-
		1	Comp. master-Dwg. A-50391		-
		1	Insp. gauge-Dwg. A-50155		-
81110		1	Box tool-Dwg. B-90024-W	Various uses	-
		1	Box tool-Dwg. B-90024-U		-
81111		2	1 Blades for style 1 box tool	Various uses	-
			Dwg. B-90028		-
81112		1	Std. turret back rest-Dwg. B-90009-V	Various uses	-
81113		1	Style 1 box tool-Dwg. B-90025-W	Various uses	-
81114		1	Std. floating holder-Dwg. B-90000-A	Safety pivot pin	-
81115		2	Plug thread gauges-Dwg. B-80032-P	Housing	-
81116		2	Plug thread gauges-Dwg. B-80031-P	Housing	-
81117		4	2 Std. str. cir. cut-off tools	Various uses	17.12
			Dwg. B-90003		-
81118		1	Snap gauge-Dwg. B-50032	Safety	-
81119		2	Master plugs-Dwg. B-80038	Various uses	-
81120		6	Master plugs-Dwg. B-80039	Various uses	-
81121		3	2 Std. H.S.S. spiral double end	Receiver	-
			and mills-Dwg. B-90051-W		-
81122		2	1 Cir. form tools-Dwg. A-50062	Bolt handle	37.83
81123		4	3 Std. H.S.S. spiral double end	Receiver	2.74
			and mills-Dwg. B-90050-W		-
81124			Cost of spotting one machine	Screw mach.	-
			shop man at the Greenlee mach.		-
			in 48-2-8 to learn function of		-
			machine		-
81125		1	Std. Stock stop-Dwg. B-90011-V	Various uses	-
		1	" " " " B-90013-W		-
		1	" " " " B-90013-U		-
		1	" " " " B-90012-W		-
81126		2	2 Cutters-Dwg. A-50000	Stock	29.34
81127		2	Templet gages-Dwg. D-50005	Stock	20.84
81128		2	Rec. gages-Dwg. D-50818	Extractor	-
81129		1 set	2 Trigger-Dwg. C-50043	Trigger stop screw	9.35
81130		1	Comp. screen & reproduction	Bolt stop release	23.26
			Dwg. C-50399		-
81131		1	Machine layout for spacer blocks	Stock	144.94
			Dwg. D-50178		-
81132		1	Templet-Dwg. A-50181	Stock	-
81133		1	Plug gauge-Dwg. A-50884	Stock	-
81134		1	Broach-Dwg. D-50188	Receiver	-
81135		1	Plug gauge-Dwg. A-50883	Stock	-
81136		3	2 Comb. Drills & rebores-Dwg. A-50840	Stock	5.30
81137		1 set	Nec. tools & gages for producing		-
			M/721 follower assemblies to		-
			Dwg. C-17115Y & C-17024		-
		1 set	Nec. tools & gages for producing		-
			M/722 follower assemblies to		-
			Dwg. C-17116Y & C-17056		-

W/O #	Quan.	Trans. to Stores	Description	Part & Spec.	Spent
81138	1		Fixture-Dwg. B-50006	Stock	33.60
81139	1		Adj. snap gauge-Dwg. B-80012-H	Bolt plug	-
81140	1		Complete receiving gage-Dwg. B-50970	Follower assembly	-
81141	1		Snap gauge-Dwg. A-50314	Ejector	-
81142	1		Complete receiving gauge-Dwg. B-50975	Follower assembly	-
81143	1		Gage for thickness-Dwg. A-50842	Stock	-
81144	1		Min. gauge-Dwg. A-50994	Stock	-
81145	1		Adj. snap gage-Dwg. B-80024-P	Follower assem.	-
81146	2		Std. tool blades-Dwg. B-90043	Various uses	-
81147	1 set		Neo. tools for producing M/721 magazine to Dwg. C-17027		-
81148	2	1	Blades for style 1 box tool-Dwg. B-90029	Various uses	-
81149	1		Depth gage-Dwg. A-50918	Bolt head	-
81150	1		Comp. tem. ga.-Dwg. A-50686	Barrel	-
81151	3		Plug gages-Dwg. B-50715	Barrel	-
81152	2		Comp. snap gauges-Dwg. B-50674	Barrel	-
81153	1		Ring gauge-Dwg. A-50817	Barrel	-
81154	1		Complete temp. ga.-Dwg. B-50378	Barrel	-
81155	1		Tem. gage-Dwg. B-50374	Barrel	-
81156	1		Sight gage-depth-Dwg. A-51035	Receiver	-
81157	1		Comp. snap gage-Dwg. B-51098	Firing pin head	-
81158	1		Comp. comb. gage-Dwg. B-50905	Bolt head	-
81159	4		Spring testing bushings-Dwg. B-50127	Various uses	-
81160	5		Spg. testing pin gages-Dwg. B-51001	Various uses	-
81161	5		Spg. testing ring gauges-Dwg. B-51000	Various uses	-
81168	2	2	Cutters-Dwg. A-50001	Stock	24.15
81171	1		Clearance gage-Dwg. B-50446	Receiver	-
81178	1		Width gage-Dwg. A-50124	Safety	-
81180	1		Comp. inletting fixture-Dwg. B-50934	Stock	-
81183	1		Adj. snap gage-Dwg. B-80024-M	Bolt body	-
81184	1		M.S.B. starting (spot) drill to Dwg. B-90056-U	Receiver	-
81185	3		Tap, each, taps(H.S.B.)-Dwg. B-50359-W	Bolt body	-
81186	1		Radius gage-Dwg. A-50126	Butt plate	-
81187	1		Comp. ind. length gage-Dwg. C-50241	Trigger connector	-
81188	2		Barrel racks-Dwg. D-50880	Barrel	-
81189	1		Comparator fixture-Dwg. B-51366	Bolt handle	-
81190	2		Boring bar bushings-Dwg. B-90049-N	Receiver	-
81191	1		Holding fixture-Dwg. C-51141	Firing pin head	-
81192	2		Comp. master contour gages Dwg. C-50792	Receiver	-
81193	1		Comp. comb. pos. gage-Dwg. B-50889	Bolt head	-

W/O #	Quan.	Trans. to Stores	Description	Part & Over.	Spent
81194	2		Reap gages-Dwg. B-50410	Receiver	-
81195	3		Spg. testing rods-Dwg. B-51364	Various uses	-
81196	1		Comp. fixture-Dwg. B-51235	Firing pin head	-
81197	1		Dovetail sight gage-Dwg. C-51295	Open sight assembly	-
81198	3		Spg. testing collars-Dwg. B-51365	Sear spring	-
81199	1		Templet gage-Dwg. C-51243	Stock	-
81200	1		C'sink gage-Dwg. C-50349	Housing	-
	1		Master-Dwg. A-50355		-
81201	1		Contour milling fixture-Dwg. D-50921	Stock	-
81202	1		Templet gage-Dwg. C-51249	Stock	-
					<u>4,608.15</u>

Work orders issued or approved by R & M to take charges originally assigned to Project
FXL-3

W/O #	Quan.	Description	Part & Oper.	Serial
80682	2	Fixtures, 1 L.H. & 1 R.H. each to Receivers Oper. #11		
	1	hold one of either part		
	3	Cycle selector		
	2	2-5/8" dia., milling cutters with		
	1	1" hole		
80683	2	Arbors		
CANCELLED	1	Cycle selector	Receivers-Oper. #14-End	
	1	Fixture	mill fire control slot	
	3	1/2" dia. Weldon two flute		
	2	double end w. 3/8" shank		
80684	2	Weldon holders BN-2		
	1	Cycle selector	Receivers-Oper. #15-Mill	
	1	Fixture to hold one of either part bolt handle clear		
	3	.700 dia., 2 flute Weldon dbl.		
	2	end end mills 3/4		
80685	2	Weldon holders BN-5		
	1	Cycle selector	Rec. Oper. #16 End mill	
	1	Fixt. to hold 1 of either Pt.	firing pin clear slot	
	3	3/16" dia., 2 flute Weldon dbl.		
	2	end end mills w. 3/8" shank		
	2	Weldon holders BN-2		
80686	1	Hand indexing, hand clamping	Rec.-Oper. #17-Mill mag.	
CANCELLED	1	Fixt. to hold 1 of either Model	holding slot	
	3	3/8" dia., Weldon dbl. end end		
	2	mills		
	2	Weldon holders BN-2		
	1	Fixt. to hold 1 of either Model		
	3	.546 dia., Weldon dbl. end end		
	2	mills		
	2	Weldon holders BN-4		
80687	2	Fixts., 1 R.H. & 1 L.H. each to	Rec.-Oper. #4 Plunge mill	
	6	hold 2 of either of above	mag. slot & eject. Part	
	2	4" dia., cutters 1 1/2" hole for		
	2	M/722		
	2	Spec. spec. collars for M/722		
	6	Arbors 50-1 1/2 B 18-4 for M/722		
	2	4" dia. cutters 1 1/2" hole for M/721		
	2	Spec. spec. collars for M/721		
	2	Arbors 50-1 1/2 B 18-4 M/721		
80688	2	Fixt., 1 R.H. & 1 L.H. each to hold	Rec. Oper. #7 Rough	
	3	1 of either Model	mill ejection part &	
	6	3-3/4" dia. cutters 3-1/8" W 1 1/2"	bolts handle slot	
	2	hole for M/721		
	2	3-3/8" dia. cutters 7/16" W 1 1/2"		
	2	hole for M/721-722		
	2	Special spacing collars for M/721		
	2	Arbors 50-1 1/2 B 18-4 for M/721		
	3	3-3/4" dia. cutters 2-9/16" wide		
	2	1 1/2" hole M/722		
	2	Spec. Spacing collars M/722		
	2	Arbors 50-1 1/2 B 18-4 M/722		

W/O #	Quan.	Trans. to Stores	Description	Part & Oper.	Spec.
80689	1		Spec. 72AB Cycle selector	Rec. Oper. #5 Rough end mill mag. slot & eject.	
CANCELLED	1		Fixt. to hold 1 of either Model 7/16" dia., 2 flute Walden dbl. end end mills 1/2" shank		
	3		Walden holders CW-3		
80690	2		Spec. cycle selector	Rec. Oper. #8 rough & finish mill tang	
	1		Fixt., 1 R.H. & 1 L.H. each to hold 1 of either part		
	2		4" dia., angular cutters 1 1/2" hole		
	2		Arbors 50-1 1/2 B 18-4		
	2		Spec. profile cams incl. cam roller		
80691	1		Spec. cycle selector	Rec. Oper. #9 profile mill eject. part & extractor cam of belt slot	
	2		Fixt. 1 R.H. & 1 L.H. each to hold 1 of either model		
	2		Spec. profile cams incl. rollers		
	4	8	Spec. spacing collars		
	4		Arbors 50-1 1/2 B 18-4		
	3		3-3/4" dia. cutters 3.250" wide 1 1/2" hole for M/721		
	3		3-3/4" dia. cutters 2.400" wide 1 1/2" hole for M/722		
	6		3-5/8" dia. cutters 1/2" wide 1 1/2" hole for M/721-722		
80692	1		Spec. cycle selector #90-AB	Rec. Oper. #13 mill fire control slot	
	2		Fixt. 1 R.H. & 1 L.H. each to hold 1 of either model		
	3		3.400 dia., cutters .312 wide 1 1/2" hole		
	2		Spec. spacing collars		
	3		3.560 dia., cutters .108" wide 1 1/2" hole		
	2		Arbors 50-1 1/2 B 18-4		
80693	1		Spec. cycle selector	Rec. Oper. #22 mill bridge for scope mount & radius adjacent to extractor cam	
	2		Fixt., 1 R.H. & 1 L.H. each to hold 1 of either model		
	3		4" dia., cutters 2" wide 1 1/2" hole		
	3		4.120 dia., formed cutters 3/4" wide 1 1/2" hole		
	2		Arbors 50 1 1/2 B 18-4		
80694	1		Accessory head	Bbl. Oper. #37 mill thds. on breech end of bbl.	
	1		Working fixt. for either model		
	3		Ind. mill. cutters HSS, 1 1/2", OD 1" wide shell		
80695	1		Spec. set of vise jaws to hold 2 pieces abreast	Bolt handle-Oper. #5 mill top form	
	6		4" dia., half side mills 1 1/2" hole		
	2		Spec. spacing collars		
	2		Arbors 40-1 1/2 B 15 1/2-3		
80696	1		Spec. set of vise jaws to hold 1	Bolt handle-Oper. #4 mill angular end	
CANCELLED	3		1 1/2" dia., shell end mills		
	2		Shell end mill arbors 40-1/2 B 15 1/2-3/4		
80697	1		Hartford #3 vise spec. jaws to hold 2 pieces abreast	Bolt handle-Oper. #3 mill top form	
	2		Spec. spacing collars		
	2		Arbors 40-1 1/2 B 15 1/2-3		

N/O #	Trans. to Stores	Description	Part & Oper.	Spent
80698	1	Spec. lathe spindle	Bbl. Oper. 27 rough turn	
	1	Spec. centering & locating plug	breach end	
	1	Spec. chuck adapter		
	1-8"	Spec. 3 jaw cushion chuck		
	1set	Spec. adj. chuck jaws drilled		
	1	Front tool block for 1 tool drilled for coolant		
	1	Carbide tipped turning tool		
	1	Spec. form bar		
	1	Spec. vibration damper		
	1	Spec. tailstock center		995.00
80699	1	Spec. lathe spindle	Bbl. Oper. 29 finish	
	1	Spec. centering & loc. plug	turn breach end	
	1	8" 3 jaw cushion chuck		
	1	Spec. chuck adapter		
	1set	Spec. adj. chuck jaws		
	1	Front tool block for 1 tool, drilled for coolant		
	1	Rear tool block for 1 tool		
	1	Spec. form bar		
	2	Carbide tipped tools		
	1	Spec. vibration damper		
	1	Spec. tailstock center		1,000.00
80700	1	Spec. lathe spindle	Bbl. Oper. 31 rough	
	1	Spec. centering & loc. plug	turn muzzle end	
	1	8" 3 jaw cushion chuck		
	1	Spec. chuck adapter		
	1set	Spec. chuck jaws		
	1	Front tool block for 1 tool drilled for coolant		
	1	Carbide tipped turning tool		
	1	Spec. form bar		
	1	Spec. vibration damper		
	1	Spec. tailstock center		920.00
80701	1	Spec. lathe spindle	Bbl. Oper. 33 finish	
	1	Spec. centering & loc. plug	turn muzzle end	
	1	8" 3 jaw cushion chuck		
	1	Spec. chuck adapter		
	1set	Spec. chuck jaws		
	1	Front tool block for 1 tool drilled for coolant		
	1	Carbide tipped turning tool		
	1	Spec. form bar		
	1	Spec. vibration damper		
	1	Spec. tailstock center		920.00
80702	1	Rectangular broach, H.S.S., 2.90" x .540" x 38" long	Rec. Oper. #6 broach	
	1	Work guide bushing	mag. slot	
	1	Round broach .703" dia. - 36" long H.S.S.	Oper. #2 broach .703 hole	
	1	#3B Broach holder		
		#1 broach 2 spline .848" OD 48" long H.S.S.	Oper. #3 rough & finish	
		#2 2 spline .995" OD 48" long broach H.S.S.	broach guide slot	

W/O #	Quan.	Trans. to Stores	Description	Part & Oper.	Spent
80702	Cont'd		#2 spline .999" OD-48" long H.S.S.		
	1		Fixture to hold 3 pts. simultaneously		
	1		Triple broach puller		
	1		Work holding fixture	Rec. Oper. #6-broach mag.	
	1		Rectangular broach 3.758" x .540" x 38 H.S.S.	slot	
	1		Spec. broach puller		
80703	1		Forged boring bar with carbide tip for boring bar holder on square turret	Rec. Oper. #1 drill, counterfore, thd., turn OD & out-off	
	1		H.S.S. oil hole drill w/adaptor for D speeder		
	1		Start drill TX-463-3		
	2		Carbide tipped boring tools #261 for positions 4 & 5 of hex turret		
	1		Carbide tipped chamfer tool for pos. 5		
	1		Carbide tipped facing tool #142 for rear of cross side	Rec. Oper. #6	
	1		Carbide tipped tool for roller turner TX-1151-3		
	1		Carbide tipped cut-off tool #201		
	2sets		Round collet bushings for holding stock 3/4" & 1 1/2"	Rec. Oper. #1	
	2		Flanged tool holders TX-447		
	1		Roller back rest turner with needle bearing roll cap. 1/2 to 2 1/2 TIE13		
	1set		2 roller turner adapters for turner TX-465-5		
	1		Releasing tap holder TX-472		
	1		Comb. stk. stop & dead center TX-463		
	1		Slide tool, flanged type TX-452		
	2		Sockets for #2 Morse taper shanks 10932		
	2		3/4" single & angular boring bars with 5/16" sq. tool TX-432		
	2		3/4" boring bar bushings 10936		
	1		Bushing for tap holder 7045-13		
	2		Revolving tool blocks each with 3 tool ser., 1 binding pin & 1 binding ser.		
	1		Revolving tool blocks with 3 tool ser., 1 binding pin, 1 binding ser., 20 deg. angular tool slot A-3059		
	1		Boring bar holder for sq. turret TX-628		
	1		High speed drill. attachment		
	1		Guard for high speed drill attach.		
	1		Boring bar cutter head TX-1226		
80847			Tools required to produce M/721		
80848			Bolt Stop Release		
			Tools required to produce M/721		
			Housing		
80849			Tools required to produce M/721		
			Safety		

<u>N/O #</u>	<u>Quan.</u>	<u>Trans. to Stores</u>	<u>Description</u>	<u>Part & Oper.</u>	<u>Spent</u>
80850			Tools required to produce H/721 Bolt Stop		-
81503	6		High speed steel spiral form relieved cutters (3 R.H. & 3 L.H.) & 6 H.S.S. half side mills (3 R.H. & 3 L.H.)		-
81506	24		High speed drills, 27/64" dia., whole length 9-15/16" twist cut 7-5/16" with 1 oil hole		203.09
81518			Tooling for use with Cincinnati 4-spindle 360° automatic profile machine		-
81522	1		Fixture		-
	3		Unground H.S.S. shell type thd. milling cutters 2 1/4 x 1-1/8		-
	2		Sheaves (spindle)		-
81535	1 set		Fixtures for drill. & ream. holes in Bolt Head B-17009HX		-
81539			Milling cutters as follows:		-
	1		Plain Mill size 3 x 6 cat. #A-589		-
	1		Plain Mill " 3 x 6 " #A-301		-
	1		Saws " 3 x 1/32 #H-13		-
	1		Saws " 4 x 1/16 #H-29		194.23
81540			Weldon dbl. end mills as follows:		-
	3		1/8 dia. Cat. #BB4-2		-
	3		3/16 " " BB6-2		-
	3		1/4 " " BB8-2		-
	3		3/8 " " BB12-2		-
	3		1/2 " " BB16-3		-
	2		5/8 " " BB20-4		-
	2		3/4 " " BB24-5		-
	2		1 " " BB32-7		60.45
81547	1		Situff kit consisting of 1 each of 12 different sizes of wire brushes & 1 each of the 2 Situff holders mounted in a wood block		-
81548	6		Crystolon vitrified wheels		72.82
81550	1		Model #7836 Calibration stand. #A-3 Pickup (.0001" stylus reading)		24.75
81563	1		1/2" Collet bushing for #5 Turret lathe		-
81567	1		#196-A Starrett universal dial test indicator complete with all attachments		21.73
81576	2		High speed attach. (unit 510-2) comp. except for bracket with clamp, cap screw & key. retainer		-
	2		Y Universal chucks (#2 MT)		-
	4		Oiling collars IA-306		-
	8		Oiling Collars 508-IA		-
81578			Type A Special precisionaire spindle assembly		-

<u>N/O #</u>	<u>Quan.</u>	<u>Trans. to Stores</u>	<u>Description</u>	<u>Part & Oper.</u>	<u>Spent</u>
81581			Small Saws & Files: DoAll Proc. Files		
	1		1 flat short angle	SPING	
	1		3/8" Half round short angle	SPURT	
	1		3/8" half round bastard	SPZIT	
81582			Following items as shown in Syracuse		
			Supply Cat. No. 1, Pg. A-409		
	1set		27 letters 1/8" size		
	1set		9 figures 1/8" size		
	1set		27 letters 3/16" size		
	1set		9 figures 3/16" size		
81585	4		27/64 H. S. Steel-st. shank		
			drill - oil hole - Morse		
			#1479 or similar		
80686	1		Flxt. to hold 1 of either Model	Rec. Oper. #18 mill feed	
	3		.546 dia., Weldon dbl. end end	ramp	
			mills		
	2		Weldon holders DN-4		

1,507.62

Transfers requested by Technical - now in process - of Tooling from Project FTI-5 to Tooling Project FI-183

Present W/O #	Quantity	Description	Est. Cost
81520		<u>For one Barnes drum type barrel reamer</u>	
	180	M/721-722 Barrel - Operation #7 - 1st, 2nd, 3rd ream 12 Reamers each of the following sizes: .212 .243 .262 .294 .340 .216 .245 .265 .297 .343 .2175 .2485 .2685 .3005 .347	8,766.00
81523		<u>For one Line 9" x 20" Production Lathe -</u>	
	1	M/721-722 - Bolt Body - Operation #3 - Turn O. D. for concentricity	
	1	Special Threaded Arbor	75.00
	1	Front Tool Block	75.00
	1	Carbide Tipped Turning Tool	15.00
	1	Special Ball Bearing Tailstock Center	25.00
81539		<u>For one Schmidt #175 Hydraulic Marking Machine</u>	
	1	M/721-722 Barrel Assembly - Operation #11 - Roll	
	1	Table Fixture & Gage to Support Barrel	400.00
	1	" " " " for Marking	25.00
	1	Comb. Concave Knurl & Logotype Holder	115.00
	1	Insert for Knurl .30-.06 Springfield	75.00
	1	" " .300 Savage	75.00
	1	Combination Concave Knurl	140.00
	1	Insert M/721	62.00
			1,120.00
81542		<u>For one M/86-2 Spindle New Britain Chucking Machine-</u>	
	6 sets	M/721-722 Barrel Oper. #29-Face, counterbore & chamber	
	1	False Jaws (1st Pos.)	
	1	Counterbore (2nd Pos.)	
	1	Bushing & Floating Holder (2nd Pos.)	
	1	Gross Facing Holder (2nd Pos.)	
	1	Counterbore (3rd Pos.)	
	1	Bushing & Floating Holder (3rd Pos.)	
	1	Floating Reamer Holder & Bushing (4th Pos.)	
	1	" " " " (5th Pos.)	
	1	Transfer Tool Block & Bit (5th Pos.)	
	1	Floating Reamer Holder & Bushing (6th Pos.)	
	1	" " " " (7th Pos.)	
	1	" Counterbore Holder & Bushing (8th Pos.)	1,785.00
81549		<u>For one Gorton 3-V Pantograph Engraving Machine -</u>	
	6	M/721-722 Final Assembly Oper. #1-Engrave serial No.	46.68
	1	Boxes of 6 2-style Gorton Shank Cutters	121.00
		Special serial numbering holder	171.68
81558		<u>For one #4 Cincinnati Centerless Grinder</u>	
	1	M/721-722 Barrel-Oper. #35-Centerless Grind	
	1	Special Infeed Work Rest	645.00
	1	Special Hand Operated Loading Fixture	1,810.00
	2	#210329 Wheel Truing Diamonds	80.00
	1	Automatic Infeed Cam	85.00

Present W/O #	Trans. Quas.	Est. Cost
81558 Cont'd		
1	Special Profile Grinding Wheel Truing Cam	110.00
1	" " Regulating " " "	110.00
1	" T. C. Formed Work Blade	175.00
1	Grinding Wheel Spindle with all Component Parts	1,915.00
1	" " 24 x 26 1/2 x 12	327.00
		5,297.00
81510	For A 12" x 18" Line Mechanical Carbo Lathes M/721-722 Barrels	
	Operation #19 Rough turn muzzle end	
	Operation #21 Rough turn breech end	
	Operation #23 Finish turn muzzle end	
	Operation #27 Finish turn breech end	
2	Spec. lath centers for .270 Bbls. A-50085W	50.00
2	" " " " .270 " A-50085-V	50.00
2	" " " " .270 " A-50085-W	50.00
2	" " " " .270 " A-50085-F	50.00
4	Carboloy Lathe Tools B-50099	40.00
1	" " " B-50100	25.00
12	Special Adjusting Screws A-50101	30.00
70173	Headstock & tailstock centers - .22 cal.	20.00
4	" " " .257 "	20.00
4	" " " .270 "	20.00
		600.00
80744	For one Wickman #2 Precision Automatic Box Mach. M/721-722 Firing Pin - Operation #1 - Screw Machine	
1	Special Adj. Stead Rest Attachment	39.50
3sets	Cutting Tools	118.50
1set	Cams	196.00
2	Steel Collets	15.00
1	T. C. Guide Bushings	-
1	B-20117 Closing Cam	5.50
1	B-20120 Opening Cam	5.50
4	162-7 No. 10 Washers	.20
4	A-20160 Tee Bolts	2.00
4	B-21099 Tee Bolt Nuts	1.00
1	Carbide Lined S-255, .437 Guide Bushing Collet	35.00
		421.20
70096	For two Pratt & Whitney Inletters M/721-722 Stock - Operation 17 Inlet Operation 23 - Inlet	
2	Carbide Tipped Router Bits A-50001	33.40
70197	For One Greenlee 1-1/8" 6-Spindle Auto. Screw Mach. M/721-722 Firing Pin Head - Operations #1 Box Mach. (6) .445 rd Collets & Pushers - Milled for Fin. " 1/2 " Stock Reel Bushings " " "	
1set	Drill Bushing	
1set	2 Universal Collet	
1	5/8" Drill (Spec. 90° Pt)	
2	Fillers (1st. & 3rd Pos.)	
1	Bit Type Form Tool	
1	Filler (2nd Position)	
2	Y Universal Collet	

Present W/O 4	Trans. to Stores	Est. Cost
70197 Cont'd	2 Drills 1 Bit (3rd Pos.) 1 " (4th Pos.) 1 Bushing 1 Spec. Counterbore with Pilot 1 Tool Bit (5th Pos.) 1 Drill Bushing 1 Reamer Bushing 1 Reamer	362.00
70197	N/721-722 Bolt Plug - Operation #1 Screw Machine 1 Can 3/4" I 2 Can 4" I 1 Can 2 1/4" I 1 Can 3/4" G.O. 1 Bit Type Form Tool 2 Fillers 1 Drill Bushing 1 Y Universal Collet 1 7/16" Drill 1 Dovetail Form Tool (2nd Pos.) 1 " " (3rd Pos.) 1 " " (4th Pos.) 1 Reamer Bushing 1 Special Step Reamer 1 Dovetail Form Tool (30° side clearance) 2 7 MM Drills	219.30
70197	N/721-722 Bolt Head - Operation #1 Screw Machine 2 Can 2 1/4" I 1 Can 2 1/4" I 1 Can 2 1/4" G. O. 1 set (6) Collate & Pushers 1-1/32" Rd. 1 set (6) Stock Reel Bushings 1-1/8" Rd. 2 Y Universal Collate 1 Dovetail Form Tool (1 St. Pos.) 1 29/64" Drill 1 Dovetail Form Tool (2nd Pos.) 1 11/32" Drill (Flat Bottom) 1 Dovetail Form Tool (3rd Pos.) 1 Access Tool 1 Shave Tool & Roller 2 Fillers 1 GW Universal Collet 1 #48 Drill	327.95
70197	N/721-722 Bolt Body - Operation #1 Screw Machine 1 set (6) Collate & Pushers 3/4" Rd. 1 " (6) Stock Reel Bushings 13/16" Rd. 1 3 Universal Collet 1 13 mm. Drill 4 Y Universal Collate 3 Drill Bushings 1 Floating Holder Bushing 1 Tap Bushing 1 Tap 1/2"-13 (Prec. Ground)	192.60

Present W/O #	Trans. to Store	Est. Cost
81502		
		<u>For One Cincinnati #3-S Rise & Fall Mill. Mach. (Spec.)</u>
		<u>N/721-722 Bolt Body & Bolt Head Assemblies</u>
		<u>Operation #7 Mill. Cocking Notches</u>
1	Spec. Fixture to hold 1 of either part	950.00
3	Spec. 2 Flute Weldon End Mills	9.15
1	Spec. Contour Gun	200.00
2	Weldon Holders	25.00
		<u>1,184.15</u>
81504		
		<u>For One Barnes C-Spindle Vertical Barrel Drill</u>
		<u>N/721-722 Barrel - Operation #3 - Drill Barrel</u>
12	T. C. Tipped Drills (.209x57")	570.00
12	T. C. " (.238x57")	630.00
12	T. C. " (.257x57")	630.00
12	T. C. " (.268x57")	642.00
12	T. C. " (.335x57")	684.00
		<u>3,156.00</u>
		<u>24,932.35</u>