

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" _____

Ilion, New York
September 15, 1972

TO: C.B. WORKMAN
FROM: R.J. SANZO
SUBJECT: NUMERICAL CONTROL WORK IN PROGRESS

M/742-X Barrel Extension

(Mag.) Programming to include design changes to make another run is complete.
100% of tools are set for run. Will run after 510 bolt. (500 lot run)
(Program complete -- not debugged.)

(Std.) No request has been made to program for standard barrel extension.
Programming for standard barrel extension will follow magnum program.
(Program complete -- not debugged.) (No Change)

M/742-X Frame (Mag.) Before EB Welding

Will be set to debug after M/870 "AA" trigger plates,
540-X butt pads and butt pad bases and (depending on Plant)
510 bolt. Will investigate changing program over to the
Compudyne or Edlund. (No Change)

M/742-X Barrel (Mag. & Std.)

Ran two (2) 7mm Mag. Barrels.
Ran one (1) 30-06 Std. Barrel.
Ran one (1) 300 Win. Mag. Barrel.
Ran two (2) 22-250 Barrels.
(Contour and Hub-Treading and chambering complete)
(No Change)

M/742-X Forward Frame Block

Processing and tooling started.
Tooling 75% -- Processing 10%.
Programming -- not started.

M/742-X Bolt

(Mag.) Operation No. 1 (Comp) -- Face and centerdrill -- twenty (20) complete.

Operation No. 2 (Lathe) -- Part is to gage. Program to improve finish to lighten roughing cuts is complete. (Program complete, debugged and run 6 parts) (No Change)

Operation No. 3 (Comp) -- Contour and Drill Rear.
Program is in final stages of debugging.
(Revising program for design changes -- additional changes are in progress.)

(Std.) Operation No. 1 (Comp) -- Ready to run.
(Program complete and debugged.)

Operation No. 2 (Lathe) -- Mag. program has been revised for Std. Dimensions. (Program complete, debugged and ran 7 parts)

Operation No. 3 (Comp) -- Program is in final stages of debugging on computer. (Revising program for design changes. Additional changes are in progress)

M/742-X Stock

Program complete for old design. Have received changes for new design and have started reprocessing, and reprogramming for revisions required. (Programming duration -- 4 weeks)

Operation No. 1 -- Processing complete -- Programming 40%.
(Complete program will have five (5) operations.) (No Change)

M/510 Bolt

- (1) Have completed 265 bolts through N/C. Sent bolts with one fixture for final operation in Jim Henry's Dept.
(8/15/72 -- have been completed and fixture returned.)
- (2) 257 Bolts are 80% complete with 265 lot should complete by 9/8/72 (500 lot order).
- (3) Have started another run of 543 9/5/72 -- about 20% complete.

M/870 "AA" Trigger Plates

Operation No. 1 (Eb) -- have completed 525 (Operation No. 1)

Operation No. 2 (Comp). -- setting up on Compudyne (6/12/72)
Have completed 525 (Operation No. 2). Run complete.

Contacted Dick Long on making another run -- stated that he would like to hold until process is finalized. (No Change)

M/540-X Butt Pads

First Run -- Operation No. 1 (B & S) -- 600 complete.

First Run -- Operation No. 2 (Eb) -- 590 complete 6/20/72.
Run complete.

Second Run -- Operation No. 1 (B & S) -- Set up and running.
(Operation No. 1 complete 8/9/72.

Second Run -- Operation No. 2 (Eb) -- Not started --
will run approximately 393 pieces.

M/540-X Butt Pad Bases

First Run -- Operation No. 1 (B&S) -- 450 complete.

First Run -- Operation No. 2 (Eb) -- 430 complete 6/22/72.

Second Run -- Operation No. 1 (B&S) -- Operation No. 1 complete
8/30/72 (539 pieces).

Second Run -- Operation No. 2 (Eb) -- not started.
Will run approximately 539 pieces.

M/XP-100 Barrels

First run complete -- 172.

Second run complete -- 258.

Third run set up -- will have 100 complete 6/22/72.
(Run should be complete by 6/27/72 -- 300).

Completed fourth run 8/4/72 -- 187.

M/742-X Top Lock

Estimate complete. Processing and tooling started.

M/870 - 12 Gauge Vent Rib Template

Re-run of old program. Material is in and tools are set up
(ready for Eb).

Two (2) blanks have been prepared in Tool Room. Will run after
barrel extension. (No change)

M/742-X Trigger Plate

Estimate complete (start 3/13/72 -- complete 10/1/72).
Have started processing and programming.
Holding for process change. (No change)

M/1100-X Trigger Plate

Estimate complete (start 7/20/72 -- complete 8/20/72)
Holding for process change (No change).

The 3200 Shotgun Fore-End

Program debugged and running.

105 Trap and Skeet complete through Operation No. 1.

71 Skeet complete through Operation No. 2.

Plant is requesting revisions. (Revisions are complete, program debugged and running.)

The 3200 Stock

Program complete and in final debugging on machine.

30 Blanks are ready for lathe. Facing and center drilling complete.

M/600 Mohawk GFM Form Template

Program complete and ready to run (Eb).

M/788 GFM Form Template

Program complete and ready to run.

N/C Engraving Machine

Machine

1. Fabrication of the spare workhead assembly has been started. We have the gear-pinion assembly and the linear motion bearings (4). Three of the parts are on N/C. Blanks and program ready to run. (No change)
2. Primary design of new bushing made of carbide is ready for vendor's recommendations.

Fixturing

1. The new design for the 870 "AA" receiver top radius front fixture design is complete. Detailing is complete. Paul Croop will provide a man for checking.
2. The new design for the 870 "AA" receiver top radius rear fixture is complete. Paul Croop will provide a man for checking.

N/C Checkering Machine

Machine

1. "X" and "Y" stops are being fabricated. "X" and "Y" and head stock stop settings for 870 fore-end are in final stages of debugging.
2. Recommend adding programmed deceleration to "X" and "Y" moves when approaching stops.

R.J. Sanzo:sp
Ilion Research Division