

**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE

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"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

Ilion, New York  
March 6, 1974

TO: D. S. HARDY  
FROM: B. C. PROSSER  
SUBJECT: UNIAPT AND POST-PROCESSOR STATUS  
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UDS

At present there is only one problem with UDS. When a program is being executed thru the post-processor, a page of paper is skipped for every page that is printed. United computing is aware of the problem and is working on a solution. A correction for this should be received by approximately April 15, 1974.

MILWAUKEE-MATIC POST-PROCESSOR

Problems that exist with this post-processor are as follows:

- (1) Post-processor won't output circular contouring in the YZ and ZX planes using circular interpolation (currently outputs in short linear moves).

Test programs and sample printouts have been sent to United. A new tape correcting the above problems should be received approximately April 1, 1974).

RICHARDSON ROUTER

Problems that exist with this Post-processor are as follows:

- (1) Erroneous output in certain cases of points at the start of a circle.
- (2) Post-processor won't output circular motion along an inclined plane in circular interpolation mode (outputs in short linear moves).

Subject: Uniapt and Post-processor Status (Con't)

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RICHARDSON ROUTER (Con't)

- (3) Post-processor won't output circular motion in the YZ and ZX planes in circular interpolation modes (currently outputs in short linear moves).
- (4) Post-processor will not automatically return to linear interpolation from circular interpolation or at the start of a program. Currently the programmer must use the PREFUN/1 statement to accomplish this.
- (5) The post-processor won't output zero values.

Test programs and sample printouts have been sent to United. In addition, the addition of RETRCT and CLEARP statements has been requested. A new tape with the above changes and additions should be received approximately March 25, 1974.

POSITOOL POST-PROCESSOR

The specs on this post-processor were received, proof read and returned to United with all necessary revisions noted. A tape for this post-processor should be received approximately March 15, 1974.

BOSTOMATIC POST-PROCESSOR

Quote due March 11, 1974.

BCP:bd  
Illion Research Division

MEASUREMENT / TEST LAB

M/3200 Over and Under Shotgun

- (1) 12 Ga. - 3" - Endurance 1 7/8 - New Top Tang design.
  - a. SN 20822 - 10,000 Rounds completed.
  - b. Expect three more test guns 3/6 for 10,000 Rounds Endurance.
- (2) Developing 12 Ga. R-W-F target ammo internal ballistic data at a hold - Biomation.
- (3) Have request for clay bird trajectory data.
- (4) Shooting single barrel trap design for shoulder force and gun function.
- (5) Recoil Pad Testing is started (part of Recoil Program).

M/742-X New Design Autoloading Rifle

- (1) No testing activity.

M/1100-X New Design Autoloading Shotgun

- (1) SN0001 - Started post 15,000 Round modification endurance and have function problems with mag.
- (2) SN0001 - Fired for high speed movies.
- (3) Assisting set-up pendulum test fixture set-up for teunnion disc evaluation.

M/1100 Product Improvement

- (1) Plant / CBW 12 Ga. Skeet D.B.B. - no activity.
- (2) Locking block endurance test complete - report being prepared.
- (3) M/1100 Experimental High Rib POI Test (J.S. M.)
  - a. Tested Exp. Rib Barrels.
  - b. Tested Prop. Rib Barrels.
  - c. Re-tested Exp. Rib Barrel with altered stocks.
  - d. Tested 3200 12 Ga. Trap Top barrel POI from shoulder.
  - e. Tested 3200 12 Ga. Trap Top Barrel POI from gallery device.
  - f. Tested 3200 - 12 Ga. Trap Bottom Barrel POI from shoulder.
  - g. Tested 1100 - Exp. High Rib "Altered" for POI.

MEASUREMENT / TEST LAB (Con't)

M/1100 Product Improvement (Con't)

- (4) Received production sample of poly duck plugs (410 Ga.) for evaluation. .
- (5) Received sample of 410 - M/1100 extractors for evaluation.
- (6) Setting action bar test machine for expected experimental bar evaluation.
  - a. Standard production.
  - b. Standard production - ribbed at cam notch.
  - c. Experimental heat treat modification.
  - d. Experimental double heat treat.
  - e. Straight rib at bar front end.
  - f. L - rib at bar front end.
- (7) Evaluate shot peened music wire 1100 Firing Pin Retractor Springs.
- (8) Received sample M/1100 Fore-end/liner for thunder test.

Miscellaneous Lab Activity

- (1) M/700 - 222 Rem. Quality Audit (waiting guns).
- (2) S.A.A.M.I. 6 vs. 4 groove P. & V. Test & Report ;completed.
- (3) M/700 - 264 Win. Mag. Barrel Erosion Test in process.
- (4) M/1100 Dry Cycle machine is in excess of 15,000 cycles.
- (5) Process of summarizing 12 Ga. High pressure work data.
- (6) High speed movies of Remington and Winchester Trap.
- (7) M/1100 - 12/20 Barrel Burst Test Report #4 finished.
- (8) M/870 Max. open velocity/unlock time needs more testing per CBW.
- (9) Safety meeting 3-4-74 (movie in large conference room).
- (10) Center Fire S. A. A. M. I. round robin test scheduled for first part of march.

MEASUREMENT / TEST LAB (Con't)

Miscellaneous Lab Activity (Con't)

- (11) Tested magazine cap retainer system for (T. J. P.).
- (12) Setting-up 12/20 Pressure Test program.
- (13) Drilled Winchester Center Fire functional dummy primers.
- (14) Moved couple truck loads of guns out for employee sales.  
Preparing more as part of house cleaning (J. H.).
- (15) Reviewing headspace, breechspace, and cartridge mix-up  
feasibility per C. B. W.
- (16) Continuing work/debugging of biomation.
- (17) Normal photography support activity.
- (18) W. R. Goggin on vacation week of 3-4-74.

AAH:bd  
Measurement/Test Lab  
Ilion Research Division

SPECIFICATIONS, TECHNICAL INFORMATION & SERVICE

- (1) Owner's Manual for Model 540XR & Jr. -- Completed.
- (2) Models 40XR & 40XC Standards -- Completed and out for approvals.
- (3) Model 870 Ducks Unlimited Standards -- Completed and out for approvals.
- (4) 3200 O/U Shotgun Standards for 32" Trap grades and 30" Magnum -- Completed and out for approvals.
- (5) Combination Owner's Manual for Models 40XR - 40XC has been started.
- (6) New assembly drawings for M/40XR Bolt Assembly, Bolt Body and Firing Pin Assembly, Bolt Body Assembly -- Completed.
- (7) New serial marking drawings (Ref:) for M/540XR, 40XR, 40XC, 3200 1 of 1000 (Trap and Skeet) and Premier -- Completed and prints distributed.
- (8) Change for M/700 Owner's Manual Safety Copy (M. H. Walker) -- Completed and to Marketing & Legal for approval.
- (9) Typesetting for Remington Action -- Completed.
- (10) Development Schedule Typeset and being revised.
- (11) Duplicate aperture cards mailed to Wilmington for Feb.
- (12) Plant organization chart being typeset.

FGH:bd

N/C MAINTENANCE

Ex-Cell-O 108E Post-Processor

- (1) The only known problem with this post-processor is that zero values for I and J are not output. They are required by the machine tool.
- (2) Due to misinterpretation of machine capabilities with regard to 3 axis contouring, testing of this capability has not been completed as yet. Testing should be completed by March 15, 1974.

Extended Warrenty for A-B Eb

Plans for continuation of debugging Eb control problems have been made tentatively for March 25. This week will be in areas where machine performance has never been up to specs.

See attached N/C Status Report.

REPORTS ATTACHED

Model Shop Work Load

Numerical Control Work in Progress.

Plastic Research Lab.

C.B. Workman:bd  
Illion Research Division  
Attached