

**REMINGTON ARMS COMPANY, INC.**

INTER-DEPARTMENTAL CORRESPONDENCE

*Remington*  
OLDFONT

*PETERS*  
OLDFONT

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"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York  
July 17, 1974

**LIMITED DISTRIBUTION**

TO: W. E. LEEK

FROM: C. W. STEPHAN

SUBJECT: TECHNICAL SERVICES STAFF MEETING - JULY 22, 1974  
(Last Meeting Held July 8, 1974)

COMPUTER AIDED DESIGN

The high speed range has been used but preliminary runs indicate that peak pressures don't agree with oscilloscope readings. Therefore, a calibrated signal device has been designed which can be used for set-up and check-out. Two new features have been added to the high speed range. Peak values are printed for every shot and, if required, available impulse is also printed.

Due to part delivery and testing problems, the mylar punch tape will not be shipped until approximately July 29, 1974.

The gun-motion program is waiting for empirical data from the test lab. (Shoulder-force, pressure-time, and displacement curves for a heavy-shoulder shooter firing M/870 12 Ga. shotgun with a heavy load).

Preliminary testing shows that Program 27 now stores data correctly. All related programs are being modified to comply with Program 27. Modification of these programs will continue as time permits.

A program that will control and monitor the 1100 dry cycle machine has been written. Further program development will continue upon installation of necessary hardware by test lab personnel.

UNIAPT AND POST-PROCESSOR STATUS

UDS

At present, the only problem with UDS occurs when a UNIAPT program is being executed through a post-processor. The problem is that a page of paper is being skipped for each page that is printed. More pressure is being applied to United Computing for a solution. In addition, a solution is being worked on independently here. It is not known when this will be corrected.

MILWAUKEE-MATIC POST-PROCESSOR

- (1) United Computing has completed debugging of the X - Y and Y - Z circular contouring tests, and have found errors in both the post-processor and programming technique. As yet no date has been set for the receipt of the corrected post-processor. With proper programming technique, this problem can be worked around. A copy of a test program showing this technique was received July 1, 1974.
- (2) A revised tape with the 2 axis circular contouring with third axis linear contouring capability has been received. Preliminary tests show correct output. The revised post-processor with the correction for contouring in other than the X - Y plane should be received by Aug. 15, 1974.

RICHARDSON ROUTER

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

- (1) Post-processor will now output circular contouring along an inclined plane in circular interpolation mode, except no K value is output.
- (2) The latest tape received for this post-processor had the addition of CLEARP and RETRCT included. Neither of these additions function properly. The revised method for circular contouring in other than the X - Y plane does not work on this post-processor. At present there appears to be no method of working around the problem. Test data has been sent to United for evaluation.

A tape containing the above corrections should be received by July 26, 1974.

UNIAPT AND POST-PROCESSOR STATUS (Con't)

EX-CELL-O POST-PROCESSOR

The revised tape with the 2 axis circular contouring with third axis linear contouring capability has been received. Preliminary tests show correct output.

BOSTOMATIC POST-PROCESSOR

The up-dated and more detailed quote for this Post-Processor has been received. A purchase order has been issued. Receipt should be approximately Jan. 1, 1975.

POSITOOL POST-PROCESSOR

The first release of this Post-Processor was received July 1, 1974. Preliminary testing revealed two errors. In some cases circular interpolation is not being output on circular moves. Also, blocks are being output containing only I and J values (no X and/or Y departures). A tape containing corrections for the above problems should be received by July 26, 1974.

BCP:sse

SPECIFICATIONS, TECHNICAL INFORMATION & SERVICES

1. Owner's Manual for Models 40XR - 40XC completed. In Bridgeport for approval.
2. Mutilated or otherwise unsatisfactory drawings are being redrawn when time permits.
3. Alter 3200 Owner's Manual exploded view and parts list to latest revision.
4. Upgrading of microfilm cards has been started.
5. Wonder Trap service manual has been revised to "B" Model and has been sent to Bridgeport for approval.
6. Remington Logo marking drawings have been altered.
7. Mechanical for hang tag requested by planning for Mohawk 48 completed.
8. M/540XR Owner's Manual has been approved and is in print.
9. Prepare new mechanicals for extra barrels package labels. Requested by Legal Dept. to include New Remington Logo.
10. Assist W. Warren in competitive arms report.
11. Prepare mechanical for front page of Union Contract Booklet. Completed.
12. Prepare package label mechanicals for:
  - 3200 Magnum - 30"
  - 3200 Trap - 32"
  - 788 223 Cal.
  - 788 223 Cal. (with scope)

FGH:s

Technical Services Staff Meeting - July 22, 1974  
(Last meeting held July 8, 1974)

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N/C MAINTENANCE

Debugging of XLO 108 and Positool near completion.

Additional Spares For All N/C Systems:  
N/C machine systems spare parts are being ordered at random  
with cost savings being a primary consideration.

IF 100 vendor service will no longer be available because of  
major changes in Meson Electronics Co.

REPORTS ATTACHED

N/C Status Report

Model Shop Work Load

Numerical Control Work in Progress

WMC:s

Illion Research Division  
Attached