

Bull in one month

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What are your thoughts
on completing the collection.

June 18, 1980

JPL

J. P. LINDE

File in 1700

Program started

J. Hill

M/700 Final Assembly Excess Costs - Dept. 61

Listed below are costs incurred during the M/700 Final Assembly operation due to assembly problems:

CK 7/7/80 Marshall Phil
- Leary Wilkie
- Rewis (Logan)

	<u>Annual Cost</u>
1. Using washers as spacers under the trigger guard to compensate for the depth of inletting in stock and then hammering the floor plate to make it fit flush. (The washer was not required in the past and doesn't appear on the parts list for the gun).	\$ 15,240
2. File front edge of top lug slot in front end of receiver to facilitate ejection of bullet from chamber.	\$ 5,210
3. File striker notch to enable shoulder of firing pin to close against end of bolt.	\$ 9,080
4. Filing leading edges of bolt lugs to eliminate bolt binding.	\$ 1,480
5. Remove and file follower - Reassemble to gun (feeding problems have existed since the change from a chrome plated to the New Style follower).	\$ 3,130
6. Pre-compress spring with pliers to make fit. (This is presently done by most operators and could cause feeding problems at a later time).	\$ 1,960
7. Drive extractor and rivet in (not properly picking up shells).	\$ 1,310
8. Remove and ream cam slot, or file firing pin to eliminate firing pin binding.	\$ 1,410
9. Reject stock, chalk defect and get another and inspect (about 25% of incoming stocks).	\$ 1,090
10. Change stock after being rejected at Final Inspection (20% of guns rejected for bad stocks).	\$ 7,620

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	<u>Annual Cost</u>
11. Miscellaneous repairs after Final Inspection (4% of guns inspected).	\$ 2,320
12. Repairs after Gallery Test (12% of guns tested).	\$ 4,760
13. Cost of running rejects back through Gallery (17,157 guns in 1979).	\$ 19,410

Correction of the above items should improve quality and result in a potential annual savings of \$74,620.

INDUSTRIAL ENGINEERING SECTION

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