

25B 10-1-51

Assumptions:

- The three quote requirements will be waived, per critical tooling, in order to take advantage of favorable delivery if necessary.
- Trial and Pilot cutters will be purchased from Valeron if necessary to get delivery times bettered.
- The design will be firm when transmitted and there will not be changed significantly between Trial and Pilot and production.

Machining Operations	Machines	Tooling	
		Design	Stock
Spok drill, drill, etc		5	15
Mill tang crosswise, etc		30	80
Mill angle on tang		125	370
Tri-ordinate operation		5	80
Mill Safety clearance		118	350
Drill & tap rear guard screw hole		90	270
Rollmark		20	60
Stamp "5" & "F"	ROM. 3PAC. \$5000.00	100	90
		493	1315
	\$5000.00	\$10,850	\$36,200

5

Cancellation Charge	3,000
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total \$ 13,550

Advance authorization
Transmittal of Docs.
Tool # mach. design
Process work
Trial and Pilot

Stock & Stock Assembly

medium glass finish

L56 10-1-81

This write-up covers a Walnut Stock having a ~~Model III~~ finish, the same as the present M700 CDC, and N/C checkering.

Assumptions:

- There is capacity on the hand spray and N/C checkering equipment to handle this model.
- Design will be firm at the time advance funding is authorized.
- There will not be significant design changes between Trial and Pilot and production.

Machining Operations	Vendor Tooling	Machines	Tooling design	build
Finish & plane			4	20
Shape top & bottom			132	256
Shape top only			132	256
Shape butt, etc.			156	134
Inlet top & vent etc.			1578	3424
Profile		RICHARDSON GRIP LATHE \$30,000 ⁰⁰	148	964
Mill Tang Margin		NICHOLS XSF MILL \$22,000 ⁰⁰	170	642
Inlet bottom, etc.		RISM SPAC. No. 1 \$71,000 ⁰⁰	575	620
Mill Bottom of Grip, etc.		RISM SPAC. No. 2 \$74,000 ⁰⁰	280	660
Saw Line - End Tip		CHOD SAW \$3,000 ⁰⁰	45	164
Shape Line - End Tip		TWIN MILL \$25,000 ⁰⁰	156	530
Butt Plate mold	\$15000 ⁰⁰			
Sand complete		2 Vertical spindles \$14,000 ⁰⁰ 1 Flat Center \$7,000 ⁰⁰ 1 Horizontal spindle \$5,000 ⁰⁰		

Feb 10-1-5'

This assembly is made of two components: the Silver Plate Base, and the Trigger Guard Plate which are brazed together.

Assumptions:

- The design will be frozen when transmitted.
- There will not be significant design changes between Trial and Pilot and production.

		Tooling	
	Machines	Design	Build
Machining Operations			
Induction Brgs		150	315
Straighten		50	150
B'drill rear gear & screw hole, etc.		93	271
		293	736
		\$6500.00	\$20,200.00

Advance authorization to be requested

Tool design

\$6500

cancellation charges

total

\$ 6500⁰⁰

Advance authorization

Transmittal of Lungs

Tool design

Tool procurement

Trials and Pilots

Floor Plate Pad

This component is a molded nylon part which will be used at Final Assembly.

Assumptions:

- Design will be firm when transmitted
- There will not be significant design changes between Trial and pilot and production.

Operations

Injection mold

Vendor tooling

290 hours design & build

\$8000⁰⁰ cost for design & build

Advance authorization to be requested:

Mold design & build

\$8000⁰⁰

Cancellation charges

2400⁰⁰

total

10400⁰⁰

Advance authorization

Transmittal of specs

Mold design and build

Trial and Pilot

	0	4	8	12	16	20	24	28	32	36	40	44	48
Transmittal of specs													
Mold design and build													
Trial and Pilot													

Floor Plate Cover

This component is a steel stamping requiring secondary machining. It is part of the Floor Plate Cover Assembly.

Assumptions:

- Design will be firm when transmitted.
- There will not be significant design changes between Trial and Pilot and production.

Machining Operations	Vendor tooling	Tooling	
		design	build
Purchase Insp.		121	385
Straddle Mill Hinge		173	400
Beam hole in hinge		42	84
		336	869
Totals in: Rupees		\$ 7400 ⁰⁰	\$ 24,000 ⁰⁰
dollars	\$ 11,200 ⁰⁰		

Advance authorization to be requested:

Tool design	\$ 7400
Vendor tooling	11200
Cancellation charges	<u>0</u>
total	\$ 18600

Advance authorization

Transmittal of drugs.

Tool design

Tool design
Tool procurement

Vendor tooling & samples

Trial and Pilot

[illegible]

Floor Plate Cover Assembly

This assembly is made by spotwelding the Magazine Spring Retainer to the Floor Plate Cover.

Assumptions:

- Design will be firm when transmitted
- There will not be significant design changes between Trial and Pilot and production.

Operations:

Spot weld

Polish and buff bottom

totals in : hours
dollars

Tooling	
design	build
100	250
10	20
110	270
\$2400	\$7500

Advance authorization to be requested:

Tool design	\$2400 ⁰⁰
Cancellation charges	0
total	\$2400⁰⁰

Advance authorization
Transmittal of design
Tool design
Tool procurement
Trial and Pilot

	0	4	8	12	16	20	24	28	32	36	40	44	48
Advance authorization													
Transmittal of design													
Tool design													
Tool procurement													
Trial and Pilot													

Miscellaneous Components

The components and/or assemblies listed in this write-up are grouped together as there are no new machines involved and the processes are relatively slack or are addressed from current processes.

Assumptions:

- Design will be firm when transmitted
- There will not be significant design changes between Trial and Pilot and production.

Component or Assembly	Vendor Tooling	Tooling	
		Design	Build
Front Sight Ramp Screw	\$150 ⁰⁰	4	
Rear Guard Screw	200 ⁰⁰	6	
Bolt Stop Release	3850 ⁰⁰	32	60
Safety Assembly		25	40
Safety	725 ⁰⁰	54	70
Safety Button (P/M)	4800 ⁰⁰		
Trigger Guard Plate	3700 ⁰⁰	12	
Magazine Spring Retainer	6300 ⁰⁰	36	50
Floor Plate Latch (P/M)	5725 ⁰⁰		
Floor Plate Latch Spring	5700 ⁰⁰	36	30
Trigger Guard	5000 ⁰⁰	44	115
Barrel Assembly		5	10
Bolt Assembly			
Bolt Final Assembly			
Final Assembly		10	30
totals in: hours		264	405
dollars	\$36200 ⁰⁰	\$58	



5800.00

11000 ⁵⁰

010

16800 00

Magazine Followers

This component is to be a new design steel stamping, hardened and chrome plated.

Assumptions:

- Design will be firm when transmitted.
- There will not be significant design changes between trial and pilot and production.

		Tooling	
		Design	Build
Vendor tooling (for 2 parts)	\$30,000 ⁰⁰		
Purchase Insp. Jages		240	720
		—	—
Machine: Lones		240	720
: Dollars	\$30,000 ⁰⁰	\$5300	\$20,000

Advance authorization to be requested:

Tool design	\$5300
Vendor tooling (cancellation)	9000
Machine cancellation	—
total	\$14,300 ⁰⁰

Advance authorization
Transmittal of drawings
Tool design
Tool procurement
Vendor tooling & samples
Trial and pilot

	0	4	8	12	16	20	24	28	32	36	40	44	48
Advance authorization													
Transmittal of drawings													
Tool design													
Tool procurement													
Vendor tooling & samples													
Trial and pilot													

Bolt handle - Statute of Casting vendor
Stock - Statute of master stock
Bolt plug - add polish ~~stuff~~ sampler
Bolt handle - add polish
Followers - add polish.

Cast triggers & trigger guard up update
original ~~cast~~ casts

Need write up on AOL - BDL Statute of items

MISS 2 Blown cases at proof - story

Receiver Castings are they running.