

11/17/98

M/710 DESIGN & ESTIMATE REVIEW NOTES**8:00 AM: Jeff Swanson****I. Receiver Insert**

- A. Material
 - 1. Questioned Rev. 4 estimate material cost - Rev. 5 estimate changed to \$.47
 - 2. Questioned material to be quoted - Glass filled Nylon - Need specifics
- B. Tooling - Goal is to mold part complete w/o secondary op's
 - 1. Quote 2 cavity mold - Rev. 5 estimate to reflect cycle time change
 - 2. Can TRT pull adjustment screw holes as designed?
 - change screw holes to open faced to eliminate secondary op's.
 - 3. Need positional tolerance $>.003$
 - 4. \varnothing tolerance in question due to shrink, etc.
 - 5. Need to sink threaded insert in tang - Rev. 5 estimate to reflect this
- C. E'town Estimates:
 - Material = \$3/lb.
 - Part Volume = 1.8 in^3
 - Cycle Time = 20.7 sec.
 - Part Cost = \$.40 ea.
- D. Mold Flow Analysis - Needed to be done to determine accurate cycle time, material, cavitation, etc.

II. Bolt Head

- A. Oper. 80 (Drill Cross Pin Hole) - Eliminated, redundant
- B. Oper. 30 (Chamfer Lugs) - Eliminated, incorporated into barrel chamber

III. Bolt Plug

- A. Lugs
 - 1. Need to determine if current design is strong enough to support loading
 - 2. Need to determine material to be used - Can we flow glass into this area
- B. Mold Cycle Time - Rev. 4 estimate high, potential \$ savings
 - 1. Revisited & corrected in Rev. 5 estimate

IV. Stock Ass'y - Rev. 5 estimate to reflect stock w/ recoil pad

- A. Recoil Pad Cost - Rev. 5 estimate to reflect M/700 outsource \$
- B. Stock Cost - Rev. 5 estimate to reflect M/700 outsource \$

Subject to Protective Order - Williams v. Remington