

File m17 LWT

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MODEL SEVEN PRODUCTION STARTUP

A summary of the active programs to resolve startup difficulties with the Model Seven LWT is attached. Program status and anticipated completion dates are as of December 17, 1982. Progress will be monitored and status updated as required.

GDC/DJA:hv
Attachment

MODEL SEVEN PRODUCTION STARTUP

PROGRAM STATUS

<u>PROGRAM/KEY EVENT</u>	<u>RESPONSIBILITY</u>	<u>COMPLETION</u>
I. Eliminate/Minimize ESCR Rejects (.243 Cal.)		
o File chamfer on rail to repair finished guns and Barrel assemblies (.243 only)	PRODUCTION	COMPLETE
o File chamfer on rail of all new .243 Receivers prior to assembly to Barrels (Dept. 58)	PRODUCTION	IN PROGRESS
o Revise Receiver design (add angle to rail) and process for all calibers-M/Seven only		
- Provide samples for test	PE&C/PRODUCTION	1/14/83
- Function test	RESEARCH	TBD
- Transmit design change	RESEARCH	TBD
- Revise process	PE&C/PRODUCTION	TBD
II. Eliminate Floor Plate Latch Failure		
o Continue M/Seven assembly with available Latches - hold for Latch replacement	PRODUCTION	IN PROGRESS
o Provide correct Latches using EDM process in quantities sufficient to support production		
- Start producing 60/day with Research EDM (3 shifts)	RESEARCH	COMPLETE
- Order additional from Farmer Tool & Die (rate TBD)	PE&C/PURCHASING	12/17/82
- Complete straddle mill fixture	TOOL ROOM	12/20/82
- Start mill, drill, deburr, and heat treat operation	PRODUCTION/PE&C	12/20/82
- First parts to Final Assembly	PRODUCTION/PE&C	12/21/82 2

135 parts from R&D

50/day two shifts

Set up to mill 2 operations 1 tang + Rear.
Set up mill per hole. - will start 7:30 AM Tomorrow
~~heat treat~~ + colored.
mi

MODEL SEVEN PRODUCTION STARTUP
PROGRAM STATUS

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12/17/82

<u>PROGRAM/KEY EVENT</u>	<u>RESPONSIBILITY</u>	<u>COMPLETION</u>
II. Eliminate Floor Plate Latch Failure (Continued)		
o Provide correct Powder Metal Latches		<i>8mm</i>
- Revise tooling	POWDER METAL	<i>ship 1/7 air</i> 1/3/83
- Production parts	POWDER METAL	1/5/83 21 <i>coin ship 1/14</i>
III. Establish Floor Plate to Stock clearance specification		
o Continue M/Seven assembly holding maximum clearance at 0.035 inch (nominally same as M/700)	PRODUCTION	IN PROGRESS
o Determine clearance specification required	RESEARCH	TBD
o Revise design and/or process so that specification can be met	RESEARCH/PE&C	TBD

GDC:hv