

APR 12 1983

cc: W.S. Johnson W.J. Newkirk  
R.J. Long D.D. Ricci  
J.F. Matousek G.J. Hill  
J.P. Linde L.B. Bosquet  
W.W. Cook P.G. Johnson  
M.J. Kantor G.D. Campbell  
J.R. Snedeker J.D. Rogers

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H.K. Boyle

M/700 Manufacturing Constraints

1) M/700 Bolt Components

Dept. 8560 - Line Capacity

Alternative machine groupings have been determined. Line capacity = 715 pcs./day. Final plan for MPR assignments to be determined.

Dept. 8560 - Layout

Jewel group rearrangement scheduled 4-17. Layout for alternative machine groupings to be determined.

Inventory - Bolt Handle *shear test?*

Salvage program underway. Actual count required.

Bolt Head  
*Chp. 5 handle*  
*purchase o/s. 12*

Alternate facility is available - Dept. 8502. Need Bolt Heads to try out. Planning & Production to *5/2* phase in. *Review 1st A. pt*  
*222 gms. w/ 1/6" R&D*

S/A Floor Plates & Trigger Guard

Order of 1200 due, should fulfill requirement. Planning to confirm.

2) M/700 Stock Production

Roughed Extractor

Reject Handling & Repair

Production plan needed to establish Dept. 8453 MPR assignments. Layout revision required.

Reject Salvage

Retiree to assist with training. Staff to advise on contract options.

White Wood Repair

Q.C. acceptance standard needed for wax patch and one drop application. Retraining may be necessary.

M/700 Manufacturing Constraints - (cont'd.)

2) M/700 Stock Production - (cont'd.)

Multi-Spindle Output

Incentive standards in effect  
4-11, output to be monitored.

3) M/700 Receiver

Steel

Confirmation on month's supply  
needed. 4140 I.M.P. acceptance  
test scheduled 4-18.

Screw Machine

Production & I.E. to monitor out-  
put.

Line Capacity

Present line capacity = 692 pcs./  
day. Tri-Ordinate cutter require-  
ments and cam alterations to be  
determined. M/7 LWT fixture and  
locators required for mill ext.  
cam. & bolt hole slot. Optimum  
line output to be determined.

TDC's M T.R.m

Crew Requirements

		<u>Present</u>	<u>June</u>	<u>Sept.</u>	<u>Comment</u>
Dept. 8560	M/700 Bolt Components Floor Plates & Trig- ger Guard	17	17	20	5 Requisitions In Progress
Dept. 8579	Braze	2	3	3	
Dept. 8502	M/7400 Breech Bolt (1 Rem. Spec.)				198/Shift
	M/700 Bolt Head (1 Rem. Spec.)				590/Day
	M/700 Firing Pin Head, Firing Pin		1	TBD	
Dept. 8354	M/700 Receiver	23	28	30	
Dept. 8453	M/700 Handling Pro- cedure				Crew to be de- termined.

A meeting will be held Tuesday, April 19, in the 52-2H Conference Room at  
2:00 P.M. to review the preceding items.

Industrial Engineering Section  
S.M. Morris, Group Leader

*S.M.M.*

SMM/kc