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PROJECT: REPLACE M700 BOLT BODY GRINDER

ENGINEER: KENNEY

DESCRIPTION: EVALUATE THE REPLACEMENT OF THE CINCINNATI PLINCE GRINDER WITH A CNC TURNING CENTER.

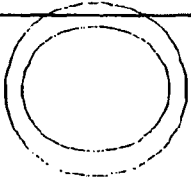
CAP:

OPER:

UPDATED: 09/14/90

| KEY EVENT             | SCHEDULED |         | ACTUAL   | STATUS                                    |
|-----------------------|-----------|---------|----------|---|
|                       | START     | COMPLT  | COMPLT   |   |
| FEASIBILITY STUDY     | 10/01/89  | 2/23/90 | 04/03/90 | COMPLETE                                  |
| WRITE SCOPE           | 2/26/90   | 3/02/90 | 04/19/90 | COMPLETE                                  |
| REQUEST QUOTES        | 3/05/90   | 3/16/90 | 04/05/90 | COMPLETE                                  |
| SELECT VENDOR         | 3/19/90   | 3/23/90 | 06/08/90 | COMPLETE                                  |
| WRITE PROJECT REQUEST | 3/26/90   | 4/27/90 | 06/20/90 | COMPLETE                                  |
| RELEASE P. O.         | 4/30/90   | 8/10/90 | 07/19/90 | COMPLETE                                  |
| INSTALL NEW MACHINE   | 8/13/90   | 8/17/90 | 08/31/90 | COMPLETE                                  |
| TRAIN OPERATORS       | 8/20/90   | 8/24/90 |          | Training is scheduled for 09/17-09/19/90. |
| RUN T & P             | 8/27/90   | 9/07/90 |          |   |
| RELEASE TO PRODUCTION | 9/10/90   |         |          |   |

COMMENTS: To reduce the amount of waiting time between the setup and release to production of the lathe, Mike Paestella and myself attended a programming course during 08/21-08/23/90. On 08/27/90, the Okuma 12-9 CNC Turning Center was delivered to Remington Arms. Due to special attention by the machine and crafts shops, the machine was installed and power dropped by 08/31/90. To receive proper warranty of the machine, a setup engineer from the vendor was on plant 09/05/90 to install software and inspect the setup of the machine. As stated above, operator training is scheduled for 09/17-09/19/90. Trial and pilot will be run on 09/20/90, and the machine will be released to production on 09/24/90.



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W/700 BOLT BATTLE BUNCH: (KORNEY)

The new insert that was designed by Ohio Broach to remove a burst-left by previous broach design has been received. The broach holding bar has to be altered in house to accept the new insert. Due to the continuous use of the broach, the work will have to be scheduled around production, therefore, Bob Sporer and John Luzzo will have to schedule the alteration.

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ASSISTANCE TO OPERATIONS