

April 26, 1991

TO: Hal Munson  
FROM: Jim Ronkainen JR  
SUBJECT: April Monthly Report

M/700 SYNTHETIC VARMINT

The drawing package for the M/700 SV has been held up for a metal finish change on the barrel assembly and bolt requested by Jay Bunting. I received a sample stock from HS that represents the proposed stock design and color. We will use the sample stock with the sample actions and bolts put up by Dick Frappier for final approval by the Product Team at next week's meeting. The approved design will be transmitted after approval.

M/700 EUROPEAN STOCK

The sample European stock was sent to S&K for an estimate to produce the stock in the US instead of importing it from Germany. Walt Bazan at S&K estimated the tooling cost to produce the stock at approximately \$29000 (960 hrs @\$30/hr). The finish on the stock would be linseed oil. Walt and Gerry Helmer estimated the cost of the stock to be the same or slightly less than our current M/700 ADL stocks. Bud Zumsteg is providing 2 sample stocks from the German supplier for us to look at. The first sample stock was poorly inlet and executed, and would be unacceptable for production because of the hand fitting required to make the stocks "right". Bud is also getting a cost estimate for the stocks from the German supplier.

M/700 SS

There has been a lot of activity on this project in the past month. I have received stainless steel bolt handles from the vendor (17-4PH and 416). Mike Keeney has processed the 17-4 bolt handles with no problem. The 416 bolt handles are in heat treat to be annealed prior to processing in the plant. Bob Kozakowski in the NC shop turned several reject 416

barrel blanks into 1.375 and .750 diameter round stock for receivers and bolt bodies, respectively. Mike Keeney has made several long and short action bolt bodies on the Miyano lathes utilizing this material. We should be able to make receivers on the Miyano lathes in May when the alterations to the lathes are complete. Bob Sanzo made several 416 barrel brackets in the NC shop. Five of the barrel brackets have been heat treated and are ready for use. Bolt head blanks (416 SS) for standard (30-06 family) and magnum calibers were made at Parker and Harper. All passed inspection with no problems. Bolt pins to assemble the bolts were made in the Model shop from 416. Mike Keeney and I are going to process bolts through the plant early next week. Mike also ran 12 bolt plugs on production equipment. We should have bolts to start preliminary testing by the second week in May. Material to make upset barrels is being turned down in the NC shop. An R&D cost estimate for the program was completed. Glen Sietsema has started metallurgical testing on competitive stainless bolt action rifles which shows that Browning is using 416 for their barrels and Ruger is using an alloy that could be 416, although it has not been proved conclusively.

#### M/700 CLASSIC FOR 1992

The drawing package to add the .222 REM as the M/700 Classic for 1992 was transmitted.

#### .223 REM TWIST RATE

Per a suggestion from customer service, I am looking at the ability of our the current twist rate for .223 REM (1:12) to stabilize .223 caliber bullets above 62 grains. Several law enforcement organizations have complained that our M/700 Police Sniper rifles will not accurately shoot the same bullet used in their tactical weapons (69 gr. Federal Match). With Lonoke's help, I will investigate the effect of different twist rates on accuracy of light and heavy bullets.

#### M/700 STOCK REINFORCEMENT CHANGE

Mike Keeney put in a suggestion to change the brass stock reinforcing screw currently used on all M/700 long stocks to the Mountain Rifle reinforcing rivet design. The MR rivet is covered with plastic plugs which gives it a higher quality appearance. Walt Bazan estimated the cost to make the change at approximately \$10000 for tooling with a machine time savings of approximately .5-.9 minutes/stock, depending on the configuration. Ron Farrington is preparing a cost estimate of the change for the Product Team meeting next week.

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