

TO: R.J. ORF
FROM: J.J. FITZER
SUBJECT: MONTHLY REPORT FOR SEPTEMBER 1993

O/U SHOTGUN:

DAILY SUPPORT OF PRODUCTION IS ONGOING. THE NEW COOLANT CHARGE IN FMS PHASE I HAS BEEN USED DURING THE MONTH OF SEPTEMBER. FEED RATES AND TOOL LIFE HAVE IMPROVED TO EXPECTED RATES. CYCLE TIMES AND SURFACE FINISH ON THE MONOBLOCK HAVE IMPROVED THROUGH THE USE OF NEW ROUGH AND FINISH MILLS. ALL OTHER CUTTERS ARE NOW RUNNING AT 100% FEED RATES FOR ALL COMPONENTS. WORKING WITH JON WALDO WE HAVE DETERMINED THE FOLLOWING PRODUCTION RATES ARE ATTAINABLE WITH SIX (6) MACHINES AND CURRENT CONDITIONS REMAINING CONSTANT:

FMS 24 HR. WORKING DAYS TO SUPPORT FIVE (5) ASSEMBLY DAYS

5 DAYS	22 GUNS/DAY
6 DAYS	27 GUNS/DAY
7 DAYS	33 GUNS/DAY

GOALS FOR COMPLETION THIS MONTH ARE THE FRAME "B" LOAD PROGRAM TO BE RUNABLE ON T-10 #12 AND AN EIGHT PART MONOBLOCK PROGRAM TO ALLOW FOR SPLITTING THE FIXTURES IF REQUIRED.

NEW VIBRATORY FINISHING SYSTEM:

ALMCO INC. IN ALBERT LEA, MN. WAS VISITED ON 9/13 THRU 9/16 TO PROCESS SHOTGUN AND RIFLE RECEIVERS IN THEIR LABORATORY. 120 PARTS WERE PROCESSED USING VARIOUS CYCLE TIMES; WITH FORTY MINUTES VS. THE CURRENT SIXTY PRODUCING ACCEPTABLE PARTS. DURING DISCUSSIONS ON EQUIPMENT REQUIREMENTS AND FLOOR LAYOUTS IT WAS DECIDED TO PROPOSE A "CELL STYLE" SYSTEM THAT COULD BE PURCHASED AND INSTALLED INCREMENTALLY, IF DESIRED. THIS WOULD ALSO ELIMINATE MASS SHUTDOWN OF THE ENTIRE SYSTEM IN CASE OF A COMPONENT BREAKDOWN OR REQUIRED MAINTENANCE. ANOTHER ADVANTAGE WOULD BE MORE FLEXIBILITY IN THE MEDIA USED FOR VARIOUS COMPONENTS THAT WOULD NOT BE POSSIBLE WITH A SYSTEM AS WE KNOW IT TODAY WITH COMMON HOPPERS SEPARATORS AND CONVEYERS. FINAL SPECIFICATIONS AND BUDGET FIGURES ARE BEING PREPARED BY TOM HAWKINS.

M/7400-7600 (NON-FMS) RECEIVER PRODUCTION:

START UP OF THE CONVENTIONAL MACHINING LINE TO PRODUCE THESE RECEIVERS HAS BEEN PROPOSED TO ADD CAPACITY TO FMS. MACHINE REPAIR PROBLEMS HAVE CONTINUED TO DELAY START OF PRODUCTION AT FULL CAPACITY. ADDITIONAL GAGING TO CHECK THE BOLT CARRIER SLOT IS STILL BEING BUILT WHICH WILL BETTER ACCOMMODATE THE CURRENT MACHINING PROCESS. THE FIRST FORTY RECEIVERS WERE BUILT AND SHOT WITH SIMILAR RESULTS TO THE FMS PRODUCED PARTS. THE NEXT ONE HUNDRED PIECES WILL BE MONITORED BEFORE PRODUCTION BEGINS; THEY WILL BE PROCESSED THE WEEK OF 10/4/93.

FLAT RECEIVER MACHINING TRANSFER LINE:

THE NEXT GENERATION OF PRODUCING FLAT RECEIVERS IS PROPOSED TO INCORPORATE NC CONTROLLED MACHINING HEADS WITH AUTOMATICALLY CONVEYED PARTS FROM ONE TO THE NEXT STATION. JASON BAUMGART HAS BEEN ASSIGNED TO COLLECTING THE DATA NECESSARY TO PUBLISH A SPECIFICATION PACKAGE OF WHAT WE THINK SUCH A SYSTEM SHOULD INCLUDE. I HAVE CONTINUED TO WORK WITH JASON DURING SEPTEMBER WHILE HE PREPARES PROCESS SHEETS OF THE VARIOUS RECEIVERS. IT IS EXPECTED THAT ANOTHER COUPLE OF WEEKS WILL BE NECESSARY FOR COMPLETION.