

To: R. A. Jackson  
From: J. A. Rabbia  
Subject: Progress Report (10-29-93)

M/700 Stainless Steel Fluted Barrel

Process development is still underway with respect to the cutting and finishing of the flutes. The cycle times as of now are as expected, approximately fifteen minutes per barrel. I expect to eliminate at least two to three minutes from this time by using other fixturing and tooling. Additional tooling for trial and pilot is on order, being designed, and being built. Further development of the process will be done the week of November shut down. At this time it appears from an engineering stand point we will be ready for trial and pilot the week of 12/06.

Model 870 and Model 700 Police Manganese Phosphating

We continue to struggle with the manganese phosphate coating (Parkerize) we currently put on the two models noted. There are several different variables which are difficult to control in this process which affect the coating. In an effort to create a more robust process Production called Heat Bath corporation in the hopes they could lend some technical expertise. Heat Bath has helped us with some critical processing issues. However, until we improve our equipment in terms of the tank line itself we will not be fully in control of all the variables which affect this process. As discussed in last months progress report an estimate was generated in order to replace the manganese phosphate line and we continue to move forward with it.

Model 541-T Heavy Barrel SS

Process development is still underway for this shot show special. The main development lies in the exact surface finish specifications. Various surface finishes are being tested and tried.

Model 700 Magnum Upsetter

With the addition of the Model 700 SS to the magnum upsetter process we are experiencing accelerated wear and fatigue failures to the tooling on the machine. As previously discussed the upsetter is in great disrepair and must be addressed in the near future. However, with recent developments I fear the upsetter will not hold out as long as I had hoped and we may experience a machine failure which we cannot resolve. As previously stated capital money will be needed to address the problems with the upsetter as a whole.

Model 700 Classic

All tooling is expected by November 9th. We will begin forging barrels November 1st using interim gaging and monitoring the process closely.