
From: Becker, Craig
Sent: Tuesday, June 10, 2008 2:19 PM
To: Luke, Kyle D.
Cc: Shoemaker, Christopher D.
Subject: New XMP Adjustable Trigger Manpower Needs
Attachments: 40xmark pro cost estimate.xls; Copy of XMP EA TRIG HOUS SPACER REAR 700 .xls;
Copy of XMP EA TRIGGER 7 700 Before PLATE.xls

Kyle and Chris,
Attached is the spreadsheet Dan Shumway put together early this year for costs and manpower requirements.

The new trigger will require a preliminary Engis hone operation to provide a close tolerance on the trigger pivot hole for the next operations. The cell for the new trigger will operate in similar fashion to the operation for Drilling and tapping the holes in the XMP housing assembly. The operation will require 2 power fed drill steps and 1 hand fed tap cycle, all into the same tumble fixture. This will require 3 spindles, locations to be nested.

The new rear spacer for this fire control will require one hole to be drilled in a fixture using a power fed drill spindle.

The drill presses are ordered and due soon. They will be placed in 84-2 next to the CMM room. The process sheets I have attached are preliminary drafts, but will at least give you an idea of the routing of each new part.
Call me if you wish to discuss further.

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