

M/40X XMP Trig Assy
2008 Cost Estimate

DESCRIPTION	M/700 X-Mark Pro Trigger Assy						M/40X XMP Trigger Assy	
	PART #	MATL \$/PC	PLATING \$/PC	LABOR \$/PC	OHEAD \$/PC	TOTAL \$/PC	New Part #	
700 XMARK PRO TRIG ASSY RH	305571			\$ 2.737	\$ 7.828	\$ 10.565	306372	
SAFETY DETENT SPRING	300679	\$ 0.034				\$ 0.034		
SEAR SPRING	300686	\$ 0.022				\$ 0.022		
TRIGGER PULL SPRING	300694	\$ 0.034				\$ 0.034	301708	
BLOCKER AFTER PLATE	300660			\$ 0.397	\$ 1.520	\$ 1.917		
BLOCKER PLATED	202557		\$ 0.088			\$ 0.088		
BLOCKER BEFORE PLATED	202555	\$ 1.149		\$ 0.104	\$ 0.430	\$ 1.683		
BLOCKER HOLD DOWN STUD	300666	\$ 0.094				\$ 0.094		
BOLT STOP RELEASE PLATED	300668		\$ 0.038			\$ 0.038		
BOLT STOP REL BEOFRE PLATE	202549	\$ 0.090		\$ 0.104	\$ 0.431	\$ 0.625		
SAFETY ASSY RH SILVER	305581		\$ 0.108			\$ 0.108		
SAFETY ASSY RH BEFORE PLATE	202579	\$ 2.225		\$ 0.077	\$ 0.352	\$ 2.654		
SAFETY PIVOT PIN	300682	\$ 0.480				\$ 0.480		
SAFETY RETAINING CLIP	300683	\$ 0.040				\$ 0.040		
SEAR SAFETY CAM AFTER PLATE	401559		\$ 0.085			\$ 0.085		
SEAR SAFETY CAM BEFORE PLATE	401558	\$ 0.942		\$ 0.686	\$ 2.641	\$ 4.269		
TRIGGER PLATED	300688		\$ 0.038			\$ 0.038	301463	
TRIGGER BEFORE PLATE	202559	\$ 1.391		\$ 0.525	\$ 2.045	\$ 3.961	301462	
TRIG ENGAGEMENT SCREW	300696	\$ 0.161				\$ 0.161		
TRIG HOUSING ASSY	306380			\$ 0.498	\$ 1.911	\$ 2.409	306365	
TRIG HOUSING ASSY PLATED	202563		\$ 0.206			\$ 0.206		
TRIG HOUSING ASSY BEFORE PLATE	202562			\$ 0.339	\$ 1.306	\$ 1.645		
TRIG SIDE PLATE	301435	\$ 0.145				\$ 0.145		
TRIG SIDE PLATE MODIFIED	301442	\$ 0.145		\$ 0.072	\$ 0.282	\$ 0.499		
TRIG HOUSING RIVET (3)	301430	\$ 0.020		\$ 0.141	\$ 0.522	\$ 0.682		
TRIG HOUSING SPACER FRT	301436	\$ 0.149		\$ 0.022	\$ 0.063	\$ 0.254		
TRIG HOUSING SPACER REAR	301438	\$ 0.154		\$ 0.021	\$ 0.077	\$ 0.252	301444	
SEAR SPG SUPPORT	301441	\$ 0.260				\$ 0.260		
TRIGGER PIVOT PIN	301516	\$ 0.522				\$ 0.522		
TRIG PULL SCREW	300914	\$ 0.413				\$ 0.413		
TRIG PIVOT PIN RET RING	301517	\$ 0.135				\$ 0.135		
BOLT STOP PIN	24484	\$ 0.097		\$ 0.001	\$ 0.006	\$ 0.103		
BLOCKER ADJ SCREW	300664	\$ 0.130				\$ 0.130		
TRIG PULL SCREW SECONDARY	n/a						301429	
TRIG PULL SPG SECONDARY	n/a						301460	
Total Gun Cost in SAP		\$ 8.83	\$ 0.56	\$ 5.72	\$ 19.43	\$ 34.55		

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MATL \$/PC	PLATING \$/PC	LABOR \$/PC	OHEAD \$/PC	TOTAL \$/PC
		\$ 3.097	\$ 8.868	\$ 11.965
\$ 0.034				\$ 0.034
\$ 0.022				\$ 0.022
\$ 0.034				\$ 0.034
		\$ 0.397	\$ 1.520	\$ 1.917
	\$ 0.088			\$ 0.088
\$ 1.149		\$ 0.104	\$ 0.430	\$ 1.683
\$ 0.094				\$ 0.094
	\$ 0.038			\$ 0.038
\$ 0.090		\$ 0.113	\$ 0.417	\$ 0.620
	\$ 0.108			\$ 0.108
\$ 2.225		\$ 0.077	\$ 0.352	\$ 2.654
\$ 0.480				\$ 0.480
\$ 0.040				\$ 0.040
	\$ 0.085			\$ 0.085
\$ 0.942		\$ 0.686	\$ 2.641	\$ 4.269
	\$ 0.038			\$ 0.038
\$ 1.391		\$ 1.245	\$ 4.815	\$ 7.451
\$ 0.161				\$ 0.161
		\$ 0.672	\$ 2.579	\$ 3.251
	\$ 0.206			\$ 0.206
		\$ 0.339	\$ 1.306	\$ 1.645
\$ 0.145				\$ 0.145
\$ 0.145		\$ 0.072	\$ 0.282	\$ 0.499
\$ 0.020		\$ 0.141	\$ 0.522	\$ 0.683
\$ 0.149		\$ 0.022	\$ 0.083	\$ 0.254
\$ 0.260		\$ 0.023	\$ 0.080	\$ 0.363
\$ 0.260				\$ 0.260
\$ 0.522				\$ 0.522
\$ 0.413				\$ 0.413
\$ 0.135				\$ 0.135
\$ 0.097		\$ 0.001	\$ 0.006	\$ 0.104
\$ 0.130				\$ 0.130
\$ 1.530				\$ 1.530
\$ 0.040				\$ 0.040
\$ 10.51		\$ 6.99	\$ 23.90	\$ 41.96

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CHANGES								
TRIG PULL SCREW SECONDARY	301429	\$ 1.530				\$ 1.530		New
TRIG PULL SPG SECONDARY	301460	\$ 0.040				\$ 0.040		New
Trigger (Delta w/addl ops)	301463			\$ 0.720	\$ 2.770	\$ 3.490		
Trigger Blank (Delta)	301462					\$ -		
Trig Housing Assy (Delta w/addl ops)	306365			\$ 0.174	\$ 0.668	\$ 0.842		
Rear Spacer Block (Delta)	301444	\$ 0.106				\$ 0.106		
Trig Assy (Delta w/addl ops)	306372			\$ 0.360	\$ 1.040	\$ 1.400		
Total adjusted Gun Cost		\$ 10.51	\$ 0.56	\$ 6.98	\$ 23.91	\$ 41.96		
Delta difference M/700 vs M/40X		\$ 1.68	\$ -	\$ 1.25	\$ 4.48	\$ 7.41		
Parts that changed from M/700 XMP								

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Backup for 40X XMP Trig Assy									
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Trigger	Hrs/pc	\$/hr	\$/pc	Oheads \$/pc	Daily Rates	Hrs needed	Manpower needed	Manpower needed	
Engis operation	0.00850								
Drill 1 thru hole	0.00826						@100%	@85%	
Drill 2 recesses	0.01229								
Tap hole	0.00504								
Deburr	0.00221								
Total	0.03630	\$ 19.88	\$ 0.72	\$ 2.77	\$ 3.49	620 750	22.5 27.2	2.8 3.4	3.3 4.0
Trig Assy	Hrs/pc	\$/hr	\$/pc	Oheads \$/pc					
Addl Assembly	0.01015								
Addl adjustment	0.00955								
Total	0.0197	\$ 18.47	\$ 0.36	\$ 1.04	\$ 1.40	620 750	12.2 14.8	1.5 1.8	1.8 2.2
Trig Housing Assy	Hrs/pc		Labor \$/pc	Ohead \$/pc					
Drill hole in rear spacer	0.00876	\$ 19.88	\$ 0.174	\$ 0.668	\$ 0.84	620 750	5.4 6.6	0.7 0.8	0.8 1.0
								620/day	5.0
								750/day	5.9
									6.1
									7.1

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