

The following economics are presented for applying the rivet ejection control to the annual volume of 600 TB and TX grades Sportsman-58 shotguns, using the described method in the receiver production line -

Material	\$ 24.72
Labor	31.23
Burden	33.20
Plant overhead	22.93
Inventory adjustment	1.12
Total annual cost - 600 guns	\$ 113.20
Unit cost per gun	.189
Estimated expenditures:	
Initial tooling	\$1,650.00
Engineering, etc.	550.00

While the Committee is reluctant to consider addition of a modification such as that described to a total annual volume of 600 guns at the cost presented, there appears to be no other course if Sportsman-58 shotguns are to appear in trapshooting circles.

Decision

The Operations Committee (Ilion Division) recommends to Management addition of the Nelson type Ejection Control Device to new production grade TB and TX Sportsman-58 shotguns at a unit cost per gun of \$.189 and an estimated tooling and engineering expenditure of \$2,200.

CENTER FIRE RIFLES

MODEL 725 BARRELS FOR CALIBER 244 (WEIGHT & RIFLING)

The Plant reports that accuracy tests of 75, 90 and 105 grain 244 ammunition have been completed in both one-in-10" and one-in-12" twist barrels. Results are as follows -

	10"		
	75 Gr.	90 Gr.	105 Gr.
Average	2.10"	1.75"	2.51"
Max.	3.00"	2.50"	4.6"
Min.	.95"	1.35"	.85"
	12"		
	75 Gr.	90 Gr.	105 Gr.
Average	1.54"	1.57"	8.23"*
Max.	2.00"	1.90"	13.4" *
Min.	.90"	1.20"	4.5" *

Comments: The 12" twist show very little difference between 75 grain and 90 grain in averages or extremes while 10" twist show much poorer groups and progressively poorer as bullet weight decreases.

* All rounds badly keyholed.