

REMINGTON ARMS COMPANY, INC.  
INTER-DEPARTMENTAL CORRESPONDENCE

Remington  
OPEN

RECEIVED

JAN 5 1967

R. M. MALCOM

cc: H.B. Harmon/J.P. Barry  
R.H. Gruss

Bridgeport, Connecticut  
January 4, 1967

RALPH MALCOM

MEMO ON DEVELOPMENT ITEMS

You ask the question, "Status of retooling an existing mold frame for interim production."

We are figuring on taking a 16 cavity overlay frame and designing tooling to make the new wad. We will start with four cavities because we are sure that changes will be required to obtain the correct configuration because of shrinkage problems. Tooling and adapting the mold frame will take six to eight weeks plus two weeks' board time, for a total of eight to ten weeks.

There are no tolerances on SKRL 10-2066-1 but we have been informed that tolerances will be on the order of the present overlay. To the best of our knowledge it will be impossible to maintain these tolerances on the proposed wad.

Present standard overall cycle time on overlays is twenty-two seconds and we estimate forty-five seconds on the new wad. This would mean tying up a minimum of four injection molding machines where we now use two on overlays so that a capital investment of \$125,000.00 would be required for two machines plus operations' money of approximately \$90,000.00 for five molds.

This covers molding only. There will also be the cost of converting the Assemble Head & Prime machine plus conversion of the old headers and assemblers for interim production to meet the target date.

We understand that it is proposed to ship a quantity of target shells with the new design base wads to the Grand in 1967. This means that the design of the wad must be firmed up, a mold producing, interim changes made to Assembly, Heading and Loading by June 1st. This all appears to be well-nigh impossible.

J. Dowie  
Chief Supervisor  
Tool & Equipment Unit

JD:awt

WIL01326