

CENTER FIRE RIFLESMODEL 7400-7600 - Contd.

All three N/C Checkering Machines are running: two purchased for the 7400, plus a third machine to meet capacity requirements for the M/700.

Area rearrangement, scheduled for completion by mid-August, was completed August 1.

Previously reported startup problems with a pot broaching operation on the Breech Bolt have been resolved. Chips building up in the broach bar coolant channels were restricting coolant flow to the inserts, causing them to break. The broach bar has been altered to clear the chips and the pot broach is running satisfactorily. Over 25,000 blanks have now been broached. 83

Conversion to dual line operation was started and completed ahead of schedule. During this period, the remainder of the 742/760 spare parts were completed. Arms Service now has at least a ten year supply of all metal components and about a two year supply of Stocks and Fore-ends. The machining lines have now been converted entirely to 7400-7600 production.

Initial Rifle assembly was started on July 28. Warehousing began on August 4, slightly ahead of schedule.

In general, assembly of the rifles has gone well, though improvements are still required in some areas (Exhibit 4). Most of the problems relate to visual, wood-related items. This primarily reflects the timing of the Stock and fore-end trial and pilot. In retrospect it would have been better to trial and pilot the wood components along with the metal parts. Because this was not done, processes found lacking during the wood trial and pilot are being corrected now, during initial production and assembly startup. In all cases, the cause of the problem has been determined and corrective action is being taken.

The last item listed in Exhibit 4 refers to the powder metal magazine latch used on all models. During initial assembly of the rifles, Production discovered a number of broken latches. All fire controls which had been built, as well as all latches ahead of assembly, were screened immediately. A 100% inspection procedure is still in effect, and Powder Metal Division is reviewing their process to determine the cause. As a contingency, Production is investigating the possibility of making this part as an investment casting.