

ILION PLANT QUALITY PROGRAM

J.P. Linde - Review of Ilion Plant Quality Program - Contd.

WOOD FINISHES

Wood has a natural inherent beauty and the finishing is very important to the customer. The following improvements have been made or will be made in the future to improve the wood finishes.

In reviewing the wood program today, we will begin with purchased wood blanks and follow the parts through machining, sanding and finishing operations.

Our supply of walnut blanks (Exhibit 6-1) has long been controlled by two primary suppliers. Quality problems in the past have been overshadowed by short supplies and escalating prices. During the past year, a third vendor has been supplying a portion of our needs. This added competition is already putting pressure on the other vendors to improve their wood blank quality. Randy Swartz's study into backward integration of wood manufacturing could also lead to improved wood blank quality in the future.

Turning of wood components from machined blanks is accomplished on multi-spindle copy lathes (Exhibit 6-2). Four new copy lathes with improved accuracy potential have been installed in the last year to replace worn equipment and to meet capacity requirements.

Turned parts are used for both sanding and press formed components.

Press forming of short Stocks has been in use since 1968, beginning with the Model 870 (Exhibit 6-3). This process yields a stock with a smooth surface and very little dimensional variation. Custom checkering patterns blend perfectly with the external form. The most recent models to be press formed are the Model 1100 LT-20, and the new Model Four (Exhibit 6-4) which has a cheek piece and is cut checkered. Approximately 90% of our short Stocks are now press formed. We are presently looking into the possibility of press forming Fore-ends, as we once did with the Model 870.

Recent in-house advancements in computer aided design and N/C technology now enable us to develop and more accurately reproduce master Stocks (Exhibit 6-5). Press forming dies, (Exhibit 6-6) and copy lathe formers required for turning and press forming.

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