

Technical Services Staff Meeting - March 25

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REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

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"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" _____

Ilion, New York
March 19, 1974

TO: D. S. HARDY
FROM: B. C. PROSSER
SUBJECT: UNIAPT AND POST-PROCESSOR STATUS

UDS

At present there is only one problem with UDS. When a program is being executed thru the post-processor, a page of paper is skipped for every page that is printed. United computing is aware of the problem and is working on a solution. A correction for this should be received by approximately April 15, 1974.

MILWAUKEE-MATIC POST-PROCESSOR

At this time, it cannot be determined if a problem exists with X-Z and Y-Z contouring. The test programs we sent to United Computing supposedly do not incorporate the proper techniques for this function. United is going to revise one of these programs and send us the results. The results should be available March 29. If a problem does exist with the post-processor, the correction should be received approximately April 15, 1974.

RICHARDSON ROUTER

Problems that exist with this post-processor are as follows:

- (1) Erroneous output in certain cases of points at the start of a circle.
- (2) Post-processor won't output circular motion along an inclined plane in circular interpolation mode (outputs in short linear moves).

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To: D. S. Hardy

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RICHARDSON ROUTER (Con't)

- (3) Post-Processor will not automatically return to linear interpolation from circular interpolation or at the start of a program. Currently, the programmer must use the PREFUN/1 statement to accomplish this.
- (4) Post-Processor won't output zero values.
- (5) Post-Processor won't output M-Code for indexing fixture No. 2 functions properly for fixture No. 1.

Corrections for the above problems and the addition of RETRACT and CLEARP statements is expected March 27, 1974.

A problem has been encountered in the use of copy logic through the Post-Processor. Further definition and documenting of this problem should be completed March 22, 1974. Corrections for this problem should be received by April 12, 1974. Programmers can currently work around this problem using looping or MACRO'S.

The information pertaining to the Milwaukee-Matic Post-Processor also applies to the Richardson Router.

EX-CELL-O POST PROCESSOR

A revision to this Post-Processor is required to permit Z axis linear motion in conjunction with Z and Y axis linear or circular motion. This was not included in the original Post-Processor because the information was not available at that time. Information pertaining to this change should be in the mail to United by March 22, 1974. A corrected post-processor should be received by April 15, 1974.

POSITOOL POST-PROCESSOR

The specs on this Post-Processor were received, proof read and returned to United with all necessary revisions noted. A tape for this Post-Processor should be received approximately April 5, 1974.

BOSTOMATIC POST-PROCESSOR

Quote due March 22, 1974.

BCP:B

Ilion Research Division

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MEASUREMENT / TEST LAB

M/3200 Over and Under Shotgun

1. 12 GA. - 3" New Tang Design endurance with 1 7/8.
 - (a) Received three guns on 3-6-74 for 10,000 round endurance.
 - (b) S. N. 22670 - at 10,000 - continued to 20,000.
 - (c) S. N. 22669 - at 10,000 - completed test.
 - (d) S. N. 22668 - at 10,000 - continued to 20,000 the last 10,000 is assorted 2 3/4" ammo.
2. Developing 12 Ga. R-W-F target ammo internal ballistic data at a hold - biomation.
3. Have request for clay bird trajectory data.
4. Completed shooting single barrel trap design for shoulder force and gun function.
5. Completed Recoil Pad testing (part of single barrel recoil reduction program).

M/742-X New Design Autoloading Rifle

1. Design test started 3-15-74; Headspace, Proofing and 100 round lanyard firing (no gas system).
2. Design is conducting round robin accuracy test.

M/1100X New Design Autoloading Shotgun

1. No test activity.
2. Setting - up high speed movies.

MEASUREMENT / TEST LAB (Con't)

M/1100X New Design Autoloading Shotgun (Con't)

3. Assisting set-up pendulum test fixture for trunnion disc evaluation.
4. Scheduled to conduct 12/20 Barrel Burst Test with 1100X Barrel mock-up.

M/1100 Product Improvement

1. Plant / CBW 12 Ga. Skeet D. B. B. - no activity.
2. Locking Block endurance test complete -- report started.
3. M/1100 experimental high rib P.O.I. test (JSM) being re-organized and gun stocks rebuilt for testing.
4. Received M/1100 (410) extractors and poly duck plugs for final evaluation.
5. Action Bar thumper test converted over for Fore-end liner test (CBW).
6. Received shot peened music wire firing pin retractor springs for evaluation.
7. Will receive Exp. M/1100 action bar for evaluation.
8. Setting-up drop test for Exp. Fore-end support.

Miscellaneous Lab Activity

1. Prepared for McAndrews visit of 3-21-74.
2. M/700 - 264 Win. Mag. Barrel erosion test in process.
3. M/700 - 222 Rem. Q. A. (waiting guns).

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MEASUREMENT / TEST LAB (Con't)

Miscellaneous Lab Activity (Con't)

4. M/1100 Dry Cycle machine is in excess of 25,000 cycle.
5. Process of summarizing 12 Ga. High Pressure Data.
6. M/870 Max. Open Velocity / Unlock Time needs more testing per C.B.W.
7. Fired S.A.A.M.I. Center Fire Round Robin Test.
8. Instrumented and set-up for 12/20 Pressure Test program.
9. Checked gallery 30-06 proof ammo. for pressure.
10. Checked gallery 22 Rim Fire Hi speed shorts for pressure.
11. Checked lab 25-06 proof ammo for pressure.
12. Dry Cycle Testing M/700 extractors.
13. Conduct 12 Ga. Burst Barrel Test for P. E. & C. (Legal).
14. Repaired and calibrated gallery shooting jack.
15. Review test butt dust/sand removal problems with plant engineering.
16. Started (Chris) on M. O. C. activity.
17. Check gallery 16 Ga. proof ammo for pressure.
18. Normal photographic work activity.
19. Moved truck load of test lab guns out for employee sales.
20. Received additional 742X test ammo.
21. Reviewing Headspace, Breech Space, and Cartridge mix-up feasibility per C.B.W.

AAH:B

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SPECIFICATIONS, TECHNICAL INFORMATION & SERVICE

1. Combination Owner's Manual for models 40XR - 40XC has been started. Okayed by Marketing.
2. Model 870 "Ducks Unlimited" Standards -- completed. Still awaiting approval from J. H. Sweeney.
3. 3200 O/U shotgun standards for 32" Trap grades and 30" Magnum -- completed and distributed.
4. Models 40XR and 40XC standards -- completed and distributed.
5. Change for M/700 Owner's Manual safety copy (M. H. Walker) being held pending change requested by Legal. Safety may be re-designed.
6. New copy requested by Marketing (re shooting glasses) being written for all Owner's Manuals/Instruction Folders.
7. Check copy for du Pont book re Remington Products. Requested by F. E. Morgan.

FGH:bd

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N/C MAINTENANCE

XLO 108E 3 Axis Contouring

Difficulties encountered programming X & Y axis in circular and Z axis in linear have been corrected. The UMAC 7 control as received did not have this capability.

Positool 900 3 IPM feed problem

Autonumerics has informed us of the possibility of losing motor pulses at 3 IPM because of motor resonance. This situation is easily avoided by programming around 3 IPM.

Auto numerics will correct this as quickly as possible.

N/C Status Report Attached.

REPORTS ATTACHED

Model Shop Work Load

Numerical Control Work in Progress.

Plastic Research Lab.

C.B. Workman: bd
Illion Research Division
Attached