

## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

Remington  
SUPERPETERS  
SUPER

"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" \_\_\_\_\_

Ilion, New York  
April 11, 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 May 15, 1974.

MILWAUKEE- MATIC POST-PROCESSOR

- (1) 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 April 15, 1974. If a problem does exist with the post-processor, the correction should be received approximately May 15, 1974.
- (2) The addition of the capability for circular contouring in the X and Y with simultaneous Z axis linear motion. This addition will be made for a fee of \$360. delivery is the same as the above date.

RICHARDSON ROUTER

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

- (1) Erroneous output in certain cases of points at the start of a circle.

To: D. S. Hardy  
From: B. C. Prosser

April 11, 1974  
Page 4

UNLAPT AND POST-PROCESSOR STATUS (Con't)

RICHARDSON ROUTER (Con't)

- (2) Post-processor won't output circular motion along an inclined plane in circular interpolation mode (outputs in short linear moves). This feature will be added for a fee of \$360.
- (3) Post-Processor won't output zero values.
- (4) The addition of RETRCT and CLEARP statements is to be added for a fee of \$60.
- (5) The post processor does not have the capability of outputting and offset feedrate (992 Fxxxxxxx) before the cutter compensation is used for the first time in the program.

All of the above changes and additions should be received by May 15, 1974.

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. This addition will be made for a fee of \$360. Delivery will be approximately May 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 May 17, 1974.

BOSTOMATIC POST-PROCESSOR

A quote has been received from United Computing for this Post-Processor. The price would be \$2,265. and would be capable of making tapes for both the old and new Bostomatics. Delivery is 180 days after receipt of order. This quote is valid for 60 days from March 19, 1974.

BCP:B  
Illion Research Division

Technical Services Staff Meeting - April 15  
Last meeting held (March 25, 1974)

April 8, 1974  
Page 5

MEASUREMENT / TEST LAB

M/3200 Over and Under Shotgun

1. 12 Ga. - 3" New Tang Design Endurance w/ 1 7/8 oz.
  - (a) 22668 - 10,000 w/ 1 7/8, 10,000 assorted 2 3/4" -- complete.
  - (b) 22669 - 10,000 w/ 1 7/8 -- complete.
  - (c) 22670 - 26,700 w/ 1 7/8 -- fires on closing.
2. Fore-end design changes - wood and latch cover.
  - (a) 22668 - 1,000 Rds. w/ 1 7/8 -- complete.
  - (b) 22669 - 1,000 Rds. w/ 1 7/8 -- complete.
  - (c) 4208 - 1,000 Rds. w/ 1 7/8 -- complete.
3. 3200 Single Barrel Trap gun limited test assistance.
4. Developing 12 Ga. R-W-F target ammo, internal ballistic data at a hold.
5. Have request for clay bird trajectory data.
6. Have request for blow-up-(Rim Burst approach in top barrel for removing top lock).
7. Received wide cam plate 3200 for Dry Cycle.

M/742-X New Design Autoloading Rifle

1. Round Robin Accuracy Test conducted by design appear complete.
2. Proofed K. Soucy's Gas System mock-up.
3. High speed movies of K. Soucy's Gas System mock-up.
4. High speed movies per J. Hutton.

-----  
MEASUREMENT / TEST LAB (Con't)

M/1100-X New Design Autoloading Shotgun

1. Fired high speed movies of feeding/ejection with bolt latch changes.
2. Received 1100-X Barrel - Bolt Test mock-up for 12/20 testing.
3. Assisting set-up Pendulum Test fixture for trunnion disc evaluation.

M/1100 Product Improvement

1. Set-up Drop Test for experimental fore-end support tests.
2. Action Bar Thumper revised.
3. Received M/1100 20 Ga. L. W. Exp. gun for endurance. Test stopped due to Locking Block failure. (24,300)
4. Fired high speed movies of M/1100 - 20 Ga. L. W. Locking Block.
5. Fore-end liner dry cycle test and report - completed.  
(11 x 25,000 = 275,000 Dry Cycles)
6. Magazine Cap shooting evaluation per T. Plunkett.
7. Testing Action Bars also on full cycle dry cycle machine (W.A.W)
8. Received 410 extractors and poly duck plugs for evaluation.
9. Locking Block Endurance (1018 vs. 8640) report started.
10. M/1100 experimental high rib P. O. I. testing -- no activity.
11. Received shot peened music wire firing pin retractor spring for evaluation.
12. Reviewing 20 Ga. L. W. Locking Block loading.

MEASUREMENT / TEST LAB (Con't)Miscellaneous Lab Activity

1. M/700 - 264 Win. Mag. Barrel erosion test continues.
2. M/700 - 222 Rem. Quality Audit (waiting guns).
3. M/1100 Dry Cycle Machine is in excess of 35,000 cycles.
4. M/870 Max. open velocity / unlock time needs more testing per (C. B. W.)
5. Instrumented and set-up for 12/20 Pressure Test program.
6. Conducted 12/20 Barrel Burst Test for (W. E. L.)
7. Conducted 12 Ga. High pressure chamber test per (H. Boyle)
8. Reviewed proof primer blanking/expanded primer pocket calculation with P E & C. This is problem in C. F. proofing.
9. Dry Cycle Testing M/700 extractors.
10. Low speed / High speed is being repaired for electronic function bugs.
11. Chris is working on M. O. C. activity.
12. Normal photographic work activity.
13. Reviewing C. F. Headspace, Breech Space, and Cartridge mix-up feasibility per (C. B. W.)
14. Received M/700 experimental firing pin spring, firing pin head for dry cycle.
15. Request pattern evaluation of choke/matic device.
16. Assisted with plant safety program. (Provide video tape system)
17. Conducted departmental safety program (Electrical Safety).
18. Ordered 20 Ga. Proof Test Ammo.
19. Conducted housekeeping inspection.
20. Prepare list of work activity for summer shutdown scheduling.

AAH:bd

SPECIFICATIONS, TECHNICAL INFORMATION & SERVICE

1. Owner's Manual for models 40XR - 40XC has been started.
2. Change to M/700 Owner's Manual copy being held by Custom Shop pending change requested by Legal Dept.
3. All Owner's Manuals have been revised to include copy RE: Use of shooting glasses as requested by Marketing.
4. Personal safety interviews were held for March.
5. Drawing files inspected for misfiled or obsolete drawings.
6. All package label mechanicals are now in Research files.
7. Multilined or otherwise unsatisfactory drawings are being pulled and redrawn as time permits.
8. Alter 3200 Owner's Manual exploded view and parts list to latest revisions. (Summer printing).

FGH:B

N/C MAINTENANCE

Eb Extended Warranty

All warranty work complete.

See N/C Status Report

REPORTS ATTACHED

Model Shop Work Load .

Numerical Control Work in Progress.

Plastic Research Lab.

C. B. Workman:bd  
Ilion Research Division  
Attached

# M/C STATUS REPORT

ELION R+D

TWO WEEKS FROM 3/15/76 TO 3/31/76	MON	TUE	WED	THUR	FRI	SAT	MON	TUE	WED	THUR	FRI	SAT	SA
ELI H.P.C.	X	X	X	X	V	NA							NA
XLO H.P.C.		BUTT				"							"
Pos. Tool Comp						"							"
Pos. Tool						"							"
Compi dyn #2						"	←		BUTT		→		"
INSPE-TAN Mach. & Fluo						"							"
Inspection Comp						"							"

EQUIPMENT FAILURE - X = 1 hr  
 PMS - O = 1 hr  
 INSTALLATION or MODIFICATIONS - V = 1 hr  
 MACHINING TIME AVAILABLE -   
 EQUIPMENT NOT IN USE -

ELION RD

TWO WEEKS FROM 4/8/70 - 4/15/70	MON	TUE	WED	THUR	FRI	SAT	MON	TUE	WED	THUR	FRI	SAT	MON	TUE	WED	THUR	FRI	SAT	
FL HING.						NA						NA							
XLO HING.						"						"							
POS. TOOL 900						"						"							
POS. LATHE						"						"							
COND. UNIT #2						"						"							
INSPECTION MACH. & IF100						"						"							
OPTICAL COMPENSATOR						"						"							

EQUIPMENT FAILURE - X = 1 Hr  
 PMS - O = 1 Hr  
 Installation or Modifications - V = 1 Hr  
 MACHING TIME AVAILABLE -   
 EQUIPMENT NOT IN USE -