

## REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE

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"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York  
June 19, 1974

TO: W. E. LEEK

FROM: C. W. STEPHAN

SUBJECT: TECHNICAL SERVICES STAFF MEETING - JUNE 24  
(Last Meeting held June 10, 1974)

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COMPUTER AIDED DESIGN

The high speed range has been used but preliminary runs indicate that peak pressures don't agree with oscilloscope readings. Therefore, a calibrated signal device has been designed which can be used for set-up and check-out. Two new features have been added to the high speed range. Peak values are printed for every shot and, if required, available impulse is also printed.

Mylar tape punch should be delivered approximately June 25, 1974.

The utilization of RAMPS has been postponed indefinitely.

The gun-motion program is waiting for empirical data from the test lab. (Shoulder force, pressure-time, and displacement curves for a heavy-shoulder shooter firing M/870 12 Ga. shotgun with a heavy load).

A revision has been made to the target measuring program to allow rotation of the horizontal and vertical axes. This is a console switch option, and a message is printed to that effect.

A problem still exists in contour measuring program 27. This is a streamlined version of program 26. Work is being continued on a solution as time permits. Until a solution is finalized it is necessary to use program 26 for all contour measuring.

A program that will control and monitor the 1100 dry-cycle machine is being written. Due to heavy computer usage, little computer time has been available for debugging.

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### UNIAPT AND POST-PROCESSOR STATUS

#### UDS

At present, the only problem with UDS occurs when a UNIAPT program is being executed through a post-processor. The problem is that a page of paper is being skipped for each page that is printed. More pressure is being applied to United Computing for a solution. It is hoped that a solution is found by July 15, 1974.

#### MILWAUKEE-MATIC POST-PROCESSOR

- (1) United Computing has completed debugging of the X - Z and Y - Z circular contouring tests, and have found errors in both the post-processor and programming technique. As yet no date has been set for the receipt of the corrected post-processor. With proper programming technique, this problem can be worked around. A copy of a test program showing this technique should be received by June 24, 1974.
- (2) A revised tape with the 2 axis circular contouring with third axis linear contouring capability has been received. Preliminary tests show correct output.

#### 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.
- (2) Post-processor won't output circular motion along an inclined plate 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 RETRACT 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 (G92 Fxxxxxx) before the cutter compensation is used for the first time in the program.

All of the above changes and additions should be received by June 21, 1974.

The information pertains to the Milwaukee-Matic Post-processor. Item (1) also applies to the Richardson Router.

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UNIAPT AND POST-PROCESSOR STATUS (Con't)

EX-CELL-O POST-PROCESSOR

The revised tape with the 2 axis circular contouring with third axis linear contouring capability has been received. Preliminary tests show correct output.

BOSTOMATIC POST-PROCESSOR

The up-dated and more detailed quote for this Post-Processor has been received. A purchase order should be issued after review by P.E. & C. Delivery will be 180 days after receipt of order.

POSITOOL POST-PROCESSOR

A report was sent to United Computing citing all obvious errors. In addition, a few revisions are required for simplified programming. The delivery of this Post-Processor is expected July 1, 1974.

BCP:s

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SPECIFICATIONS, TECHNICAL INFORMATION & SERVICES

1. Owner's Manual for Models 40XR - 40XC -- 90% complete.
2. Safety copy change for M/700 Owner's Manual has been requested and written by Legal Department. Inserts with this information have been printed in plant to use up manuals already printed. The new copy will be incorporated into manuals at next reprint. This has again been revised by Legal and will be printed as soon as possible.
3. Mutilated or otherwise unsatisfactory drawings are being redrawn when time permits.
4. Alter 3200 Owner's Manual exploded view and parts list to latest revision.
5. Upgrading of microfilm cards has been started.
6. Wonder Trap service manual has been revised to "B" Model and has been delivered to printer.
7. Suggestion re: unloading of M/700 BDL Magazine by Legal Dept. has been approved by Custom Shop. Will be used in next reprinting.
8. Review all Remington Logo marking drawings and alter if necessary.
9. Wood identification label for 552 - 572 -- Completed.
10. Mechanicals for hang tags requested by planning are complete.
11. Quote submitted to M. E. d3Mayo for preparation of mechanicals for Union contract booklet.
12. Drawings and numbers for alternate wood have been provided and included in parts lists.
13. M/540XR Owner's Manual has been sent to Marketing-Legal for approval.
14. Prepare new mechanicals for extra barrels package labels. Requested by Legal Dept. to include new Remington logo.
15. Signs for Las Vegas Gun Show completed.

FCM:is

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N/C MAINTENANCE

Debugging XLO and Positool machine and control systems is in process.

Additional Spares For All N/C Systems:  
Price shopping for these components is continuing.

Misc.

Shut down work - Non skid 84-1 Floor.  
Revamp 84-1 heat control.

REPORTS ATTACHED

N/C Status Report

Model Shop Work Load

Numerical Control Work in Progress

Plastic Research Lab

WMC's  
Illion Research Division  
Attached