

REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



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"CONFINE YOUR LETTER TO ONE SUBJECT ONLY"

Ilion, New York  
Sept. 4, 1974

LIMITED DISTRIBUTION

TO: W. E. LEEK  
FROM: C. W. STEPHAN  
SUBJECT: TECHNICAL SERVICES STAFF MEETING - SEPT. 9, 1974  
(Last Meeting Held August 26, 1974)

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.

The mylar tape punch has been received and was sent to General Electric for interfacing to the 4020. The punch with interface should be installed approximately October 15, 1974.

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).

Preliminary testing shows that Program 27 now stores data correctly. All related programs are being modified to comply with Program 27. Modification of these programs will continue as time permits.

A program that will control and monitor the 1100 dry cycle machine has been written. Further program development will continue upon installation of necessary hardware by test lab personnel.

The 2 million word disc for the GE/Pac 4020 has been ordered, delivery is expected approximately Jan. 1, 1975.

Technical Services Staff Meeting - Sept. 9, 1974  
(Last meeting held August 26, 1974)

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UNIAPT AND POST-PROCESSOR STATUS

UDS

United Computing is working on solutions to the system problems we have encountered. These problems include page skipping in the Post-Processors, and automatic program turn-off in the event of a card reader failure.

UNIAPT

Uniapt 2 has been received. Erroneous output has been discovered when using ellipses for drive surfaces. Until a correction is received, Uniapt 1 will be available in the event an error occurs in Uniapt 2. A correction for Uniapt 2 should be received by Sept. 30, 1974.

MILWAUKEE-MATIC POST-PROCESSOR

It was discovered that the wrong preparatory functions are being output for circular contouring in the Y-Z and Z-Y planes. A correction should be received by Sept. 15, 1974.

RICHARDSON ROUTER POST-PROCESSOR

Errors in this Post-Processor are as follows:

- Will not contour in planes other than the X-Y plane.
- K values being output are incorrect.
- Incorrect depth calculations when using cycle/mill.
- First X-Y departure not being output in same block with cutter compensation right or left code.

All of the above errors have been verbally reported to United Computing. Written error reports will be sent as soon as documentation is complete. Corrections for this Post-Processor should be received by October 1, 1974.

EX-CELL-O POST-PROCESSOR

At present there are no known errors in this Post-Processor.

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UNIAPT AND POST-PROCESSOR STATUS (Cont'd)

EOSTOMATIC POST-PROCESSOR

The specifications for this Post-Processor are due to be shipped approximately Sept. 15, 1974. Delivery of the Post-Processor is scheduled for approximately October 25, 1974.

POSITOOL POST-PROCESSOR

At present there are no known errors in this Post-Processor.

ADAPT AND POST-PROCESSOR

COMPUDYNE POST-PROCESSOR

An error was detected in this Post-Processor in which in certain cases, the points output when contouring are rounded improperly. Since we are beyond the warranty period, Remington will be charged for any work done on this Post-Processor. Apparently, there are two options available for correction. The first option involves approximately 3 man days of work at \$250/day and would be warranted for 90 days. The second option would cost \$200 and would carry no warranty. No work is to be done until a Purchase Order is issued.

BCP:sse

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N/C MAINTENANCE

Additional Spares For All N/C Systems:

N/C machine systems spare parts are being ordered at random  
with cost savings being a primary consideration.

REPORTS ATTACHED

N/C Status Report

Model Shop Work Load

Numerical Control Work in Progress

WMC:sse  
Ilion Research Division  
Attached