

Remington Arms Company, Inc.
Elion Research Division

November 1, 1976

MODEL 700 ADL 30-06 CALIBER

COST ANALYSIS

	Standard Labor		Total Expense		Standard Material
	Cost Per Gun	% of Total Std. Labor	Cost Per Gun	% of Total Expense	Cost Per Gun
1. Std. material cost - all components including purchase parts					17.48
2. Purchase Part Inspection					.08
3. Packaging Material					.55
4. Assembly Operations	2.03	15.5	.44	6.2	
5. Heat Treating	.19	1.5	.11	1.6	
6. Surface Finishing - Metal	2.06	15.7	.48	6.8	
" " - Wood	3.17	24.2	.79	11.2	
7. Machining - Metal	3.24	24.7	3.03	43.0	
" - Wood	.84	6.4	1.12	15.9	
8. Molding - Plastic	.01	.1	.02	.3	
9. Miscellaneous Machining Operations	.59	4.5	.24	3.4	
10. Tests - Mfg.	.04	.3	.01	.1	
" - Shooting	.32	2.4	.79	11.2	
11. Inspection (less purchase parts inspection)	.44	3.4	.01	.1	
12. Packing	.17	1.3	.02	.3	
Totals	13.10		7.06		18.11

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Cost Analysis

	<u>Machine</u>		<u>Manual</u>	
	<u>Standard Labor/C</u>	<u>Total Expense/C</u>	<u>Standard Labor/C</u>	<u>Total Expense/C</u>
<u>Assembly</u>			203.083	44.327
<u>Heat Treat</u>				
Anneal			3.289	.770
Austemper			4.130	2.115
Carbo-nitride			1.798	.921
Cyanide Harden			1.051	.881
Draw			4.494	1.450
Micro-carb			1.754	4.375
Neutral Salt			<u>2.505</u>	<u>.310</u>
			19.021	10.822
<u>Surface Finishing (metal)</u>				
Alumillite			2.665	1.400
Black Oxide			5.672	5.731
Nitre Black			7.440	2.800
Almco			7.194	2.905
Glass Bead Blast			.849	.070
Tumblast	2.902	.717		
Tumble			.489	.692
Vibrate			.585	.269
Supersheen	4.168	.941		
Spin Finish	20.809	4.809		
Polish/Buf	11.729	6.517	73.577	8.523
Jewel Finish	3.513	9.604		
Mico Bond			1.361	.387
File, Scrape, Deburr			61.471	2.345
Belt Sanding			<u>1.115</u>	<u>.027</u>
	<u>43.121</u>	<u>22.588</u>	162.418	25.149
<u>Surface Finishing (wood)</u>				
Sanding			210.820	53.936
Stain, Fill, Wipe, Brush, Mask			91.394	7.061
Spray	<u>2.776</u>	<u>5.625</u>	<u>12.365</u>	<u>13.185</u>
	2.776	5.625	314.579	73.642

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	<u>Machine</u>		<u>Manual</u>	
	<u>Standard Labor/C</u>	<u>Total Expense/C</u>	<u>Standard Labor/C</u>	<u>Total Expense/C</u>
<u>Machining (wood)</u>				
Drill, C'bore			17.490	.906
Saw	4.030	.443		
Joint, Plane	2.785	9.141		
Shape	11.751	34.076		
Profile	7.136	39.615		
Inlet	20.165	22.921		
Routing	8.781	1.837		
Hand Mill	5.021	1.177		
Checkering	7.146	1.462		
	66.815	110.672	17.490	.906
<u>Machining (metal)</u>				
Broach	13.068	19.225		
Shave	3.694	4.709		
Grinding	22.745	6.598		
Cut-off	14.584	12.530		
Turning	34.312	28.482		
Power Mill	72.074	58.620		
Hand Mill	7.199	5.543		
Drill, Ream, Tap, C'Bore	85.755	52.692	24.994	52.020
Screw Machine	16.662	37.824		
Tri-ordinate Mill	14.568	18.320		
Rem Special	14.462	6.434		
	299.123	250.977	24.994	52.020
<u>Molding (plastic)</u>			1.321	1.589

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	<u>Standard Labor/C</u>	<u>Total Expense/C</u>	<u>Standard Labor/C</u>	<u>Total Expense/C</u>
<u>Miscellaneous</u>				
Rollmark, Stamp	5.711	.789		
Heat Upset, Trim	6.108	3.104		
GFM Form	11.333	13.751		
Forming	2.524	.745		
Straightening	3.663	.098		
Brazing			9.784	2.660
Projection Weld			1.808	.085
Magnaflux			10.680	1.583
Wash, Degrease, Oil, Cleaning, Steelgard			7.611	.765
	29.339	18.487	29.883	5.093
<u>Tests - Mfg.</u>				
			3.925	.156
<u>Tests - Shooting</u>				
			31.932	79.487
<u>Inspection (less purchase parts inspection)</u>				
			43.902	.663
<u>Packing</u>				
			16.549	1.604
Standard Material cost - all components including purchase parts	1748.280/C			
Purchase Parts (no Remington operations)	71.606/C			
Purchase Parts Inspection	8.000/C			
Packaging Material	55.041/C			

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