

ESTIMATE

TO: ANDREW J. COOPER
 COPIES TO: J. HUTTON
 D. C. BROOKS
 J. HUTTON
 H. P. COOPER

Title M1700-788 XP100 RIVETLESS EXTRACTOR
 Date 6-20-80
 Estimated by R. BATTINI

G. CAMPBELL
W. H. KEE

ALL FIGURES IN \$		CAP.	OPER.
DEVELOPMENT			
Investigation			
Design			
Model Making			
Design testing			
Models, for test			
Development - Design Unit			
Development - Mold			
Development - Tooling			
PRODUCT ENGINEERING			
Process eng. & trial run			
Pilot lot testing			
TOOLING			
Design		4000-	11000-
Fixtures & Gages		16000-	50000-
Molds			
Perishable tools			
Tool revisions			15000-
Vendors tooling			39000-
SPECIAL MACHINES			
Construction			
Design			
Tooling			
Perishable tooling			
Operations			
REMINGTON MACHINES			
Construction			
Design			
Tooling			
Perishable tooling			
Operations			
STANDARD MACHINES & EQUIP.		24000-	
REWORKING AIDS			
Construction			
Operations			
OTHER OPERATIONS			
Machine alterations			3000-
Pilot lot mfg.			3000-
Machine rearrangement			1000-
Comm. obsolescence			
Provision for advancing			
wages & material costs			
-- 220			
-- Plant		4400-	12200-
TOTAL		42400-	134200-
GRAND TOTAL		196600-	

MILITARY

00138, BBL, 002/14

FINGERLESS EXTRACTOR

6-20-80

COMPONENTS # OPERATIONS	TOOL		DESIGN		TOOL BUILD		3RD. MORN.		MACH. COST		MACH. ACT.		MACH. COST		MACH. ACT.		MACH. COST		MACH. ACT.	
	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.	OF IN.
M1700 BOLT HEAD																				
10 BURNING CLIP. CUT	40	104	156	4/16	12000	500	100	500	500	500	500	500	500	500	500	500	500	500	500	500
47 MILL CREATOR CLIP. CUT	257	705	705	1/16	12000	500	100	500	500	500	500	500	500	500	500	500	500	500	500	500
50 (CAN) MILL	90	360	360	2/16	12000	500	100	500	500	500	500	500	500	500	500	500	500	500	500	500
M1700 BOLT HEAD																				
10 BURNING CLIP. CUT	40	104	156	4/16	12000	500	100	500	500	500	500	500	500	500	500	500	500	500	500	500
30 (CAN) MILL	90	360	360	2/16	12000	500	100	500	500	500	500	500	500	500	500	500	500	500	500	500
M1700 BOLT HEAD																				
10 BURNING CLIP. CUT	40	104	156	4/16	12000	500	100	500	500	500	500	500	500	500	500	500	500	500	500	500
30 (CAN) MILL	90	360	360	2/16	12000	500	100	500	500	500	500	500	500	500	500	500	500	500	500	500
M1700 BOLT HEAD																				
10 BURNING CLIP. CUT	40	104	156	4/16	12000	500	100	500	500	500	500	500	500	500	500	500	500	500	500	500
30 (CAN) MILL	90	360	360	2/16	12000	500	100	500	500	500	500	500	500	500	500	500	500	500	500	500
M1700 BOLT HEAD																				
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30 (CAN) MILL	90	360	360	2/16	12000	500	100	500	500	500	500	500	500	500	500	500	500	500	500	500
M1700 BOLT HEAD																				
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30 (CAN) MILL	90	360	360	2/16	12000	500	100	500	500	500	500	500	500	500	500	500	500	500	500	500
M1700 BOLT HEAD																				
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30 (CAN) MILL	90	360	360	2/16	12000	500	100	50												