

J W Books

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REMINGTON ARMS COMPANY, INC.

INTER-DEPARTMENTAL CORRESPONDENCE



"CONFINE YOUR LETTER TO ONE SUBJECT ONLY" _____

October 14, 1980

G.E. Fletcher

RE: M/700 - 17 Cal. Stainless Steel Barrel
Process Problems Encountered

*How do I know
how many were drilled
at this point?*

3000 barrels were started at the beginning of the line:

- 1) 80% of the barrels were bent coming from heat treat. This was not brought to supervision's attention until all barrels were drilled.
- 2) 118 barrels were lost at drill due to broken drills. Cost of scrap at this point \$1282.34 - Cost of drills $25 \times 118 = \underline{\$2950.00}$.
- 3) 293 pieces were lost at the ream operation. Cost \$3217.81 - Cost of reamers $60 \times 293 = \underline{\$17,580.00}$.
- 4) 27 barrels were charged-back to Dept. 66 for drill ring and poor ream. Cost \$302.13.
- 5) Barrels lost at the turning lathes and GFM in Dept. 73 amounted to 128 pieces at a scrap charge of \$1421.15.
- 6) In Dept. 58, 7 barrels were scrapped at chamber, 31 at magnaflux and 6 at heading - a total of 44 barrels at a cost of \$809.07.

The stainless barrel assemblies are still being returned to Dept. 58 to strip the color from the barrel and re-polish. (Color is done in Dept. 51, using a special process). Some of these barrels have been through Polish three times. After three times, the barrel bracket is deformed from harper buff and must be replaced through select assembly at a cost of 18 hours per 100 barrel assemblies.

Also, during the GFM forging operation, a great amount of time was spent by our Engineering Department working out details to get an acceptable barrel from the process.

Stainless Steel Barrel

The point I am trying to make is: we have spent \$27,562.50 in scrap barrels and tooling and I am sure there will be more before the coloring and gallery tests are done. (These figures do not reflect any of the repair or select assembly charges). I feel the use of the stainless steel barrel is not the best choice and the whole process should be investigated by engineering.

G.E. Schineller, Supervisor
Centerfire Bbl. Mfg. Area

dcw