

26B 10-1-51

Assumptions:

- The three prerequisite requirements will be waived, on critical tooling, in order to take advantage of favorable delivery if necessary.
- Trial and Pilot cutters will be purchased from Valeron if necessary to get delivery times bettered.
- The design will be firm when transmitted and there will not be changed significantly between Trial and Pilot and production.

Machining Operations	Machines	Tooling	
		Design	Wash
Spok drill, drill, etc		5	15
Mill tang crosswise, etc		30	80
Mill angle on tang		125	370
Tri-ordinate operation		5	80
Mill Safety clearance		118	350
Drill & tap rear guard screw hole		90	270
Rollmark		20	60
Stamp "S" & "F"	ROM. SPAC. \$5000.00	100	90
		493	1315
	\$5000.00	\$10,850	\$36,200

total \$13,550

Trial and Pilot

Stroke & Stroke Assembly

medium gloss finish

L-46 10-1-51

This write-up covers a Walnut Stroke bearing a ~~Model III~~ finish, the same as the present ~~Model III~~ and N/C checkering.

Assumptions:

- There is capacity on the hand spray and N/C checkering equipment to handle this model.
- Design will be firm at the time advance pricing is authorized.
- There will not be significant design changes between Trial and Pilot and production.

Machining Operations	Vendor Tooling	Machine	Tooling design	build
Joint & plane			4	20
Shape top & bottom			132	256
Shape top only			132	256
Shape butt, etc.			156	134
Inlet top & rest etc.			1578	3424
Profile		RICHARDSON COPY LATHE \$30,000 ⁰⁰	148	964
Mill Tang Margin		NICHOLS K&F MILL \$22,000 ⁰⁰	170	642
Inlet bottom, etc.		RYAN SPG. No. 1 \$71,000 ⁰⁰	515	620
Mill bottom of Grip, etc.		RYAN SPG. No. 2 \$74,000 ⁰⁰	280	1060
Saw Line - End Tip		ENCO SAW \$3,000 ⁰⁰	45	164
Shape Line - End Tip		TRAVIS MILL \$25,000 ⁰⁰	156	530
Butt Plate mold	\$15000 ⁰⁰			
Sand complete		2 vertical spindles \$14,000 ⁰⁰ 1 flat sanders \$7,000 ⁰⁰ 1 horizontal spindles \$5,000 ⁰⁰		

Advance authorization to be requested:

Advance authorization
Transmittal of drugs
Tool and mach. design
Research
Trial and Pilot

(3)

Film Plate Base Assembly

SAB 10-1-51

This assembly is made of two components: the Film Plate Base, and the Trigger Guard Plate which are brazed together.

Assumptions:

- The design will be firm when transmitted.
- There will not be significant design changes between Trial and Pilot and production.

Machining Operations	Machines	Tooling	
		Design	Build
Induction Bore		150	315
Straighten		50	150
B drill reamed screw hole, etc.		93	271
Totals in: Dollars		293	736
		\$6500 ⁰⁰	\$20,200 ⁰⁰

Advance authorization to be requested

Tool design

\$6500

Cancellation charges

0

Total

\$6500⁰⁰

Advance authorization

Transmitted of days

Tool design

Tool procurement

Trial and Pilot

	0	4	8	12	16	20	24	28	32	36	40	44	48
Advance authorization													
Transmitted of days													
Tool design													
Tool procurement													
Trial and Pilot													

Floor Plate Pack

This component is a molded nylon part which will be used at Final Assembly.

Assumptions:

- Design will be firm when transmitted
- There will not be significant design changes between Trial and pilot and production.

Operations

Injection mold

Vendor tooling

290 hours design & build

\$8000⁰⁰ cost for design & build

Advance authorization to be requested:

Mold design & build

\$8000⁰⁰

Cancellation charges

2400⁰⁰

total

10400⁰⁰

Advance authorization

Transmittal of specs

Mold design and build

Trial and Pilot

	0	4	8	12	16	20	24	28	32	36	40	44	48
Advance authorization													
Transmittal of specs													
Mold design and build													
Trial and Pilot													

This is a steel stamping, requiring secondary machining operations, which becomes part of the Floor Plate Base Assembly.

- Design will be firm when transmitted
- There will not be significant design changes between Trial and Pilot and production.

Secondary Operations	Vendor Tooling	Machines	Tooling	
			designs	builds
Purchase Insp.			101	318
Mill slot in hinge			126	308
Beam hole in hinge			42	84
total in: hours			269	710
dollars	\$ 21,200 ⁰⁰		\$ 6000	\$ 19500

Tool design	\$6000
Vendor tooling - cancellation	6400
Machine cancellation charges	<u>0</u>
Total	\$12400 ⁰⁰

Floor Plate Cover Assembly

This assembly is made by spotwelding the Magazine Spring Retainer to the Floor Plate Cover.

Assumptions:

- Design will be firm when transmitted
- There will not be significant design changes between Trial and Pilot and production.

Operations:

Spot weld

Polish and buff bottom

totals in : hours
dollars

Tooling	
design	build
100	250
10	20
110	270
\$2400	\$7500

Advance authorization to be requested:

Tool design	\$2400 ⁰⁰
Cancellation charges	0
total	\$2400⁰⁰

Advance authorization
Transmittal of design
Tool design
Tool procurement
Trial and Pilot

	0	4	8	12	16	20	24	28	32	36	40	44	48
Advance authorization													
Transmittal of design													
Tool design													
Tool procurement													
Trial and Pilot													

Miscellaneous Components

The components and/or assemblies listed in this write-up are grouped together as there are no new machines involved and the processes are relatively slack or are addressed from current processes.

Assumptions:

- Design will be firm when transmitted
- There will not be significant design changes between Trial and Pilot and production.

Component or Assembly	Vendor Tooling	Tooling	
		Design	Build
Front Sight Ramp Screw	\$150 ⁰⁰	4	
Rear Guard Screw	200 ⁰⁰	6	
Bolt Stop Release	3850 ⁰⁰	32	60
Safety Assembly		25	40
Safety	725 ⁰⁰	54	70
Safety Button (P/M)	4800 ⁰⁰		
Trigger Guard Plate	3700 ⁰⁰	12	
Magazine Spring Retainer	6300 ⁰⁰	36	50
Slide Plate Latch (P/M)	5725 ⁰⁰		
Slide Plate Latch Spring	5700 ⁰⁰	36	30
Trigger Guard	5000 ⁰⁰	44	115
Barrel Assembly		5	10
Bolt Assembly			
Bolt Final Assembly			
Final Assembly		10	30
Totals in: hours		264	405
dollars	\$36200 ⁰⁰	\$58	

Advance authorization to be requested:

Tool design

\$ 5800⁰⁰

Vendor tooling - cancellation

11000⁰⁰

Machine cancellation charges

0⁰⁰

total

\$ 16800⁰⁰

Advance authorization

Transmittal of drawings

Tool design

Tool procurement

Vendor tooling & samples

Trial and Pilot

	0	4	8	12	16	20	24	28	32	36	40	44	48
Advance authorization													
Transmittal of drawings													
Tool design													
Tool procurement													
Vendor tooling & samples													
Trial and Pilot													

Magazine Followers

This component is to be a new design steel stamping, hardened and chrome plated.

Assumptions:

- Design will be firm when transmitted.
- There will not be significant design changes between trial and Pilot and production.

		Tooling	
		Design	Build
Vendor tooling (for 2 parts)	\$30,000 ⁰⁰		
Purchase Imp. Jages		240	720
Machine: Lones		240	720
: Dollars	\$30,000 ⁰⁰	\$5300	\$20,000

Advance authorization to be requested:

Tool design	\$5300
Vendor tooling (cancellation)	9000
Machine cancellation	
total	\$14,300 ⁰⁰

Advance authorization
Transmittal of drawings
Tool design
Tool procurement
Vendor tooling & samples
Trial and pilot

	0	4	8	12	16	20	24	28	32	36	40	44	48
Advance authorization													
Transmittal of drawings													
Tool design													
Tool procurement													
Vendor tooling & samples													
Trial and pilot													

Bolt handle - Status of casting vendor
 Stock - Status of master stock
 Bolt plug - add polish ~~stuff~~ sampler
 Bolt handle - add polish
 Follows - add polish.

Cast triggers & trigger guard up update
 original ~~cast~~ casts

Need write up on AOL - BDL Status of items

MISS 2 Blown cases at proof - story

Receiver Castings are they running.