

11/17/98

M/710 DESIGN & ESTIMATE REVIEW NOTES**8:00 AM: Jeff Swanson****I. Receiver Insert****A. Material**

1. Questioned Rev. 4 estimate material cost - Rev. 5 estimate changed to \$.47
2. Questioned material to be quoted - Glass filled Nylon - Need specifics

B. Tooling - Goal is to mold part complete w/o secondary op's

1. Quote 2 cavity mold - Rev. 5 estimate to reflect cycle time change
2. Can TRT pull adjustment screw holes as designed?
 - change screw holes to open faced to eliminate secondary op's.

3. Need positional tolerance >.003**4. O tolerance in question due to shrink, etc.****5. Need to sink threaded insert in tang - Rev. 5 estimate to reflect this****C. E'town Estimates:**

- Material = \$3/lb.
- Part Volume = 1.8 in³
- Cycle Time = 20.7 sec
- Part Cost = \$.40 ea.

D. Mold Flow Analysis - Needed to be done to determine accurate cycle time, material, cavitation, etc.**II. Bolt Head****A. Oper. 80 (Drill Cross Pin Hole) - Eliminated, redundant****B. Oper. 30 (Chamfer Lugs) - Eliminated, incorporated into barrel chamber****III. Bolt Plug****A. Lugs**

1. Need to determine if current design is strong enough to support loading
2. Need to determine material to be used - Can we flow glass into this area

B. Mold Cycle Time - Rev. 4 estimate high, potential \$ savings

1. Revisited & corrected in Rev. 5 estimate

IV. Stock Ass'y - Rev. 5 estimate to reflect stock w/ recoil pad**A. Recoil Pad Cost - Rev. 5 estimate to reflect M/700 outsource \$****B. Stock Cost - Rev. 5 estimate to reflect M/700 outsource \$**

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