

TO: R.J. ORF
FROM: J.J. FITZER
SUBJECT: MONTHLY REPORT FOR AUGUST 1993

O/U SHOTGUN:

DAILY SUPPORT OF PRODUCTION IS ONGOING. FMS PRODUCTION HAS NOT BEEN UP TO THE RATES WE HAD EXPERIENCED EARLY IN THE PROJECT; AND ANTICIPATED IMPROVEMENTS HAVE NOT BEEN MADE, MOSTLY DUE TO UNSATISFACTORY COOLANT IN THE PHASE I SYSTEM. TOOLING PERFORMANCE IS MARGINAL AT BEST, TOOL LIVES ARE ALMOST IMPOSSIBLE TO PREDICT, AND REPAIRS ARE BEING MADE TO ALMOST EVERY LOAD OF WORK PRODUCED. THE SYSTEM IS BEING PUMPED, CLEANED, AND RECHARGED THE WEEK OF 8/30/93. THE COOLANT BEING USED FOR RECHARGE HAS BEEN RUN IN T-10 #12, THE NEW STAND ALONE MACHINE, FOR TWO WEEKS AND HAS SHOWN PROMISING RESULTS.

A NEW VIBRATORY FINISHING RACK HAS BEEN DESIGNED FOR FRAMES TO IMPROVE HOLDING ABILITY AND OPERATOR ATTACHMENT EFFECTIVENESS. IT SHOULD BE BUILT WITHIN THE MONTH OF SEPTEMBER.

NEW VIBRATORY FINISHING SYSTEM:

IN CONJUNCTION WITH TOM HAWKINS A STUDY OF MODERNIZING OUR VIBRATORY FINISHING METHODS FOR RECEIVERS AND BARRELS HAS LED TO PROPOSING A PROJECT OF REPLACING THE PRESENT ALMCO EQUIPMENT WITH A NEW SYSTEM FROM ALMCO. FINAL SPECIFICATIONS WILL BE PREPARED FOLLOWING A VISIT TO THEIR FACILITY IN SEPTEMBER.

M/7400-7600 (NON-FMS) RECEIVER PRODUCTION:

START UP OF THE CONVENTIONAL MACHINING LINE TO PRODUCE THESE RECEIVERS HAS BEEN PROPOSED TO ADD CAPACITY TO FMS. SEVERAL PIECES OF MACHINERY HAD BEEN REMOVED FROM THE AREA SINCE LAST USED AND THE POOR QUALITY EXPERIENCED FROM RECEIVERS PRODUCED ON THIS LINE HAD TO BE ADDRESSED. THE BOLT CARRIER ROUGH AND FINISH CUTS ARE BEING CONVERTED TO 360 DEGREE PROFILERS TO BOTH SUPPLEMENT MISSING MACHINERY AND IMPROVE QUALITY. MANY MAINTENANCE SITUATIONS EXISTED DUE TO THE MACHINES NOT BEING RUN FOR AN EXTENDED TIME AND SOME GAGES AND FIXTURES HAD TO BE MADE OR REPAIRED WHICH DELAYED THE ORIGINAL SCHEDULE. PRODUCTION OF ONE HUNDRED PIECES TO PROVE OUT THE RELIABILITY OF THE LINE SHOULD BEGIN WITHIN THE NEXT WEEK.

FLAT RECEIVER MACHINING TRANSFER LINE:

THE NEXT GENERATION OF PRODUCING FLAT RECEIVERS IS PROPOSED TO INCORPORATE NC CONTROLLED MACHINING HEADS WITH AUTOMATICALLY CONVEYED PARTS FROM ONE TO THE NEXT STATION. JASON BAUMGART HAS BEEN ASSIGNED TO COLLECTING THE DATA NECESSARY TO PUBLISH A SPECIFICATION PACKAGE OF WHAT WE THINK SUCH A SYSTEM SHOULD INCLUDE. I HAVE COORDINATED HIS ORIENTATION TO OUR CURRENT PRODUCTION METHODS AND ASSISTED HIM IN THE DIRECTIONS REQUIRED TO COMPLETE THIS PROPOSAL. IT IS EXPECTED THAT DURING SEPTEMBER THE SPECIFICATIONS WILL BE READY FOR RELEASE TO VENDORS FOR THEIR EVALUATION OF FEASIBILITY AND QUOTATION.

JACK 8/31/93