9/30/93

PROGRESS REPORT FOR SEPTEMBER
  TO: RICHARD JACKSON
FROM: GARY BARNES

*M/700 DM - Cedarville Manufacturing was machining the DM latches
            but with M.I.M. close to having a coining tool that will
            provide us with a latch which no secondary machining is
            required, we have since halted their operation. They will
            however continue to machine the follower until M.I.M.
            comes on line with that component.

          The process record operation detail has been written and
          submitted to AMAPS for the latches and the follower.

        - Magazine assembly fixture is near completion to enable the
          assembly of the phase II trial pilot boxes scheduled for
          3rd week of October.

        - Tri-Ordinate cams for the TR-133 have been altered to bring
          the receiver to gage and are at the heat treaters getting
          flame hardened. They are scheduled for October 5 delivery.
          The TR-124 cams are being modifieD and should be delivered
          before the 18th of October. Modifications were necessary
          because of machine deflection resulting in excessive
          material for the finisher to remove.
          The short action cams are scheduled for October 25 delivery.

*CLASSIC - The chamber tooling and gage designs are complete with
           build deliveries the first week of November. The marking
           roll is being expedited to meet the gun writers seminar
           in mid October.

*DEHOFF -- S.O.P. is now complete and the process record is being
            worked on. The training of operators has started and will
            be on going.

*CROWN   -- The cutoff and crown has been grouped with the centerless
            polish operation. The work center will be run as a cell.
            The new mountain rifle crown will be implemented as the
            training progresses.

*M700   Changes to the second pass broach design will improve the
          tool life of the third pass broach as new broaches are
          received. The second pass broach was allowing the regrind
          to take it above the allowable chip load per tooth of the
          third pass broach.

*M/7 SS - The barrel, firing pin and bolt assemblies are complete
          and ready for assembly. The trial and pilot will take place
          the first week of October.

R2521260