M710 - Tang

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
	Blank Material								$ 0.50			$ 0
10	Injection Mold		$ 25,000.00	$ 1,000.00	8162	$ 15.54	284%	0.008000		$ 0.12	$ 0.35	$ 0
			$ 25,000.00	$ 1,000.00					$ 0.50	$ 0.12	$ 0.35	$ 0.95
	Totals		$ 50,000.00	$ 2,000.00				0.008000	$ 1.00	$ 0.25	$ 0.71	$ 1.95

REV2-EST.XLS

M710 - Fire Control Housing

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
	Blank Material								$ 0.12			$ 0.1
10	Injection Mold		$ 15,000.00	$ 1,000.00	8162	$ 15.54	284%	0.008000		$ 0.12	$ 0.35	$ 0.4
			$ 15,000.00	**$ 1,000.00**					**$ 0.12**	**$ 0.12**	**$ 0.35**	**$ 0.6**
	Totals		**$ 30,000.00**	**$ 2,000.00**				**0.008000**	**$ 0.24**	**$ 0.25**	**$ 0.71**	**$ 1.19**

REV2-EST.XLS

M710 - Fire Control Assembly

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
1	Issue From Crib				9132							
10	Demagnetize Metal Components				8772	$ 15.56	190.19%	0.000404		$ 0.01	$ 0.01	$ 0
20	Assemble - Stage 1				8772	$ 15.56	190.19%	0.018634		$ 0.29	$ 0.55	$ 0
30	Assemble - Stage 2				8772	$ 15.56	190.19%	0.031275		$ 0.49	$ 0.93	$ 1
40	Adjust on Comparator				8772	$ 15.56	190.19%	0.018929		$ 0.29	$ 0.56	$ 0.85
50	Assemble - Stage 3				8772	$ 15.56	190.19%	0.02412		$ 0.38	$ 0.71	$ 1.09
60	Function Check Complete				8772	$ 15.56	190.19%	0.009917		$ 0.15	$ 0.29	$ 0.45
70	Stamp Identification			$ 500.00	8772	$ 15.56	190.19%	0.001908		$ 0.03	$ 0.06	$ 0.09
	Deliver to Crib											
	Totals		$ -	$ 500.00				0.105187	$ -	$ 1.64	$ 3.11	$ 4.75

REV2-EST XLS

M710 - Bolt Handle

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
	Blank Material - Screw Machine								$ 1.47			$ 1.47
	Gaging (vendor and Remington)		$ 1,000.00	$ 500.00	Vendor							
	Totals		$ 1,000.00	$ 500.00				0.000000	$ 1.47	$ -	$ -	$ 1.47

Allen Bear Hunter Corp

M710 - Bolt Head

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
	Blank Material								$ 1.60			$ 1.60
15	Mill Lugs				8560	$ 15.40	285%		$ -	$ -	$ -	$ -
	Machine	Cinn 100	$ 70,000.00									
	Fixtures		$ 4,000.00					Time included in Mazak Run Time				
	Tools		$ 4,000.00	$ 500.00								
	Gaging		$ 1,000.00									
25	Mazak				8560	$ 15.40	285%	0.041000	$ -	$ 0.63	$ 1.80	$ 2.43
	Fixtures	New Tombstones/Collets	$ 60,000.00									
	Gaging		$4,000									
30	Chamfer Lugs (May Not Be Required)				8560	$ 15.40	285%	0.018860	$ -	$ 0.29	$ 0.83	$ 1.12
	Machine	Rem Spec	$ 45,000.00									
	Fixtures		$ 5,000.00									
56	Ream Extractor Rivit Hole				8560	$ 15.40	285%	0.006880	$ -	$ 0.11	$ 0.30	$ 0.41
	Fixtures		$ 1,000.00									
57	Coin Anti-Rotation Dimple				8560	$ 15.40	285%	0.006380	$ -	$ 0.10	$ 0.28	$ 0.38
	Fixtures		$ 1,000.00									
60	Ream Ejt /Ejt Retaining Hole				8560	$ 15.40	285%	0.007100	$ -	$ 0.11	$ 0.31	$ 0.42
	Fixtures		$ 1,000.00									
65	Ream & C' Sink Extractor				8560	$ 15.40	285%	0.015110	$ -	$ 0.23	$ 0.66	$ 0.90
	Rivet Hole Ream Ejt Cross											
	Pin Hole											
	Fixtures		$ 1,000.00									
70	Deburr Extractor Rivet				8560	$ 15.40	285%	0.015110	$ -	$ 0.23	$ 0.66	$ 0.90
	Dimple & Ejector Hole											
	Fixtures		$ 1,000.00									
	Totals		**$ 198,000.00**	**$ 500.00**				**0.110440**	**$ 1.60**	**$ 1.70**	**$ 4.85**	**$ 8.15**

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BARBER - 5.22.06r0009059

M710 - Bolt Body Blank

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
	Blank Material								$ 0.45			$ 0
10	Cutoff, Lap	CNC Lathe	$ 85,000.00	$ 500.00	8173	$ 15.89	397%	0.008330		$ 0.13	$ 0.53	$ 0.66
			$ 85,000.00	$ 500.00					$ 0.45	$ 0.13	$ 0.53	$ 1.11
	Totals		$ 170,000.00	$ 1,000.00				0.008330	$ 0.90	$ 0.26	$ 1.05	$ 2.22

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M710 - Barrel Blank

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
	Material (Blank 94523)								$ 3.35			$3
16	Cutoff, Heat, Manual upset				8173	$ 15.89	397.98%	0.034889		$ 0.55	$ 2.21	$ 2
	Tooling		$ 13,000.00	$ 1,500.00								
18	Machine straighten				8173	$ 15.89	397.98%	0.007991		$ 0.13	$ 0.51	$ 0
			$ 13,000.00	$ 1,500.00					$ 3.35	$ 0.68	$ 2.71	$6.74

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M710 - Bolt Plug

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
	Blank Material								$ 0.03			$ 0
10	Injection Mold		$ 28,500.00	$ 1,000.00	8162	$ 15.54	284%	0.012000		$ 0.19	$ 0.53	$ 0
			$ 28,500.00	$ 1,000.00					$ 0.03	$ 0.19	$ 0.53	$ 0.
	Totals		$ 57,000.00	$ 2,000.00				0.012000	$ 0.06	$ 0.37	$ 1.06	$ 1.49

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M710 - Stock Assy

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
10	Injection Mold Butt Plate				Vendor							$ 0
20	Synthetic Stock (Mold/Assy)				Vendor							$ 6
	Tooling		$ 120,000.00									
	Fixtures		$ 5,000.00									
	Stock Assy. with Butt Plate		**$ 125,000.00**									**$ 6.72**
10	Injection Mold Recoil Pad											$ 3.15
	Tooling (Recoil Pad/Backer)		$ 35,000.00		Vendor							
20	Synthetic Stock (Mold/Assy)				Vendor							$ 7.15
	Tooling		$ 120,000.00									
	Fixtures		$ 5,000.00									
	Stock Assy. with Recoil Pad		**$ 160,000.00**									**$ 10.30**
	Totals		**$ 570,000.00**	$ -				0.000000	$ -	$ -	$ -	$ 34.04

MM 0083

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OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper Cost
10	mill ejection port, firecontrol slot											
	machine	vmc	65000.00	$ 850.00	xxxx	$ 15.80	350%	0.021000	$ 1.68	$ 0.33	$ 1.16	$ 3.17
	gages		2280.00									
	fixture	haas quad indexer	28000.00									
20	mill mag port											
	machine	vmc										
	cbore drill, tap cam screw				xxxx	$ 15.80	350%	0.029000	$ -	$ 0.46	$ 1.60	$ 2.06
	gages		2900.00									
	fixture											
50	Metasilicate wash				xxxx	$ 15.80	350%	0.000010	$ -	$ 0.00	$ 0.00	$ 0.00
60	Finish File				xxxx	$ 15.80	350%	0.006300	$ -	$ 0.10	$ 0.35	$ 0.45
70	Roll mark Remington & model	Schmidt	5000.00	$ 600.00	xxxx	$ 15.80	350%	0.003600	$ -	$ 0.06	$ 0.20	$ 0.26
80	Stamp serial number	Schmidt	5000.00	$ 600.00	xxxx	$ 15.80	350%	0.003600	$ -	$ 0.06	$ 0.20	$ 0.26
90												
	Totals		108180.00	2050.00				0.06	$ 1.68	$ 1.00	$ 3.51	$ 6.20

M710 - Bolt Assembly

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper Cost
10	press body on head				xxxx	$ 15 80	350%	0 012000		$ 0 19	$ 0 66	$ [illegible]
	machine	Mead press	$ 12,000 00	$ 600 00								
	fixture		$ 2,200 00									
	gage		$ 1,700 00									
20	drill and pin											
	machine	drill press	$ 8,500 00	600 00	xxxx	$ 15 80	350%	0 015000		$ 0 24	$ 0 83	$ [illegible]
		mead press	$ 12,000 00									
	fixtures		$ 3 900 00									
	gages		$ 1,500 00									
30	Mill Cam Cut & cocking notch				xxxx	$ 15 80	350%	0 032158	$ -	$ 0 51	$ 1.78	$ 2 29
	cbore drill,tap bolt handle hole											
	Machine	vmc	$ 65,000 00	$ 950 00								
	Fixtures	haas quad indexer	$ 2,900 00									
	Gaging		$ 28 000 00									
40	attach handle											
	fixture		$ 2,700 00	$ 200 00	xxxx	$ 15 80	350%	0 01479		$ 0 23	$ 0 82	$ 1 05
50	blast				xxxx	$ 15 00	350%	0.005300		$ 0.08	$ 0.28	$ 0.36
60	Color		$ 3,000 00	$ 200.00	xxxx	$ 15.78	278%	0.004000		$ 0 06	$ 0 18	$ 0 24
	racks											
	Totals		$ 143,000 00	$ 2 550 00				0 083248	$ -	$ **1.31**	$ **4.54**	$ **5.85**

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M710 - Barrel

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
1	Issue from crib (105550)				9132			0.000001				
5	Drill bore - upset barrels		$ 3,500		8158	$ 15.76	359.44%	0.021468		$ 0.34	$ 1.22	$ 1
15	Form Turn NFT form		$ 6,000	$ 2,000	8158	$ 15.76	359.44%	0.034860		$ 0.55	$ 1.97	$ 2
20	Bore ream to remove drill rings		$ 3,000		8158	$ 15.76	359.44%	0.010416		$ 0.16	$ 0.59	$ 0
30	GFM form and finish		$ 10,000	$ 500	8158	$ 15.76	359.44%	0.025976		$ 0.41	$ 1.47	$ 1.88
56	Load furnace baskets				8105	$ 15.38	333.86%	0.001680		$ 0.03	$ 0.09	$ 0.11
57	De-grease				8105	$ 15.38	333.86%	0.001720		$ 0.03	$ 0.09	$ 0.11
58	Load work on furnace base				8105	$ 15.38	333.86%	0.002510		$ 0.04	$ 0.13	$ 0.17
59	Stress relieve				8105	$ 15.38	333.86%	0.000001		$ 0.00	$ 0.00	$ 0.00
60	Cool work				8105	$ 15.38	333.86%	0.000001		$ 0.00	$ 0.00	$ 0.00
61	Unload work from furnace base				8105	$ 15.38	333.86%	0.007590		$ 0.12	$ 0.39	$ 0.51
63	Unload furnace baskets				8105	$ 15.38	333.86%	0.001890		$ 0.03	$ 0.10	$ 0.13
65	Cut-off muzzle end and crown				8158	$ 15.76	359.44%	0.025000		$ 0.39	$ 1.42	$ 1.81
85	Turn and face breech chamber, and polish chamber	CNC Chucker	$ 450,000		8158	$ 15.76	359.44%	0.091660		$ 1.44	$ 5.19	$ 6.64
		Tooling		$ 10,000								
		Gaging	$ 12,000									

M710 - Barrel

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
120	Magnaflux				8158	$ 15.76	359.44%	0.015500		$ 0.24	$ 0.88	$ 1.12
125	Straighten and inspect				8157	$ 15.43	325.91%	0.012000		$ 0.19	$ 0.60	$ 0.79
130	Rough and finish centerless polish				8157	$ 15.43	325.91%	0.014400		$ 0.22	$ 0.72	$ 0.95
145	Akaline clean				8157	$ 15.43	325.91%	0.000001		$ 0.00	$ 0.00	$ 0.00
150	Induction Harden Barrel Locking Lugs (Not Required - For.)		$ 4,000		8157	$ 15.43	325.91%	0.006000		$ 0.09	$ 0.30	$ 0.39
165	Angularity Straighten				8157	$ 15.43	325.91%	0.005744		$ 0.09	$ 0.29	$ 0.38
	Totals		$ 488,500	$ 12,500				0.278418	$ -	$ 4.37	$ 15.45	$ 19.82

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