

To: Richard Jackson
From: Gary Barnes
Subject: Progress Report (10-30-93)

M/700 Detachable Magazine

The magazine assembly fixture was completed for the Phase II trial and pilot. Minor alterations to the fixture were required before assembly could begin. Engineering provided training to the operator both in assembling the box and in function testing. The assembly fixture has just recently been moved to its assigned location in bldg.50-4. The process routings and operation detail are complete for this operation.

The receiver cams were received for both Tri-Ordinates in time for the October production schedule. The receivers ran well on both machines after cutter diameter changes were implemented. The new roughing cams are expected in late November and will allow use of the original cutter.

The short action receiver cams are due November 1. The cams will be used without heat treatment for the first run of receivers.

The Phase II trial and pilot final assembly experienced a few over rides and magazine follower binds with a full magazine on the bench. The gallery experienced similiar over rides during function testing. The malfunction cause has not been determined at the present time.

M/700 Classic 6.5 X 55 Swedish

The chamber tooling is currently on plant and ready for trial and pilot. The chamber air gages were received October 18 and the dial depth gages are due November 1. The classic cartridge is nominally .007" larger by design at the rim than normal ammunition and may require additional bolt shroud clearance.

DeHoff Project

The multi-spindle gundrilling machines are currently operating two shifts. The machines are experiencing startup problems, mainly in the automated loading system. The magazine clutch brake system has been malfunctioning during the drill cycle. The manufacturer sent in a service engineer to observe the application. DeHoff is awaiting their recommendations.

M/7LWT Stainless Steel

The final assembly and gallery test and target went very well during the trial and pilot. The components fit and appearance was aesthetically pleasing as an assembly.

M/541T and M/581S Bolt Head Manufacturing Relocation

The relocation of the bolt head milling fixture from the rimfire focus factory to dept. 8560 intent was to reduce burden on the M/522 barrel cell. G. Ucasz, L. Brooks and myself successfully manufactured the bolt head in dept. 8560. The process record and routers curenly reflect this move.