

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

O/U SHOTGUN:

DAILY SUPPORT OF PRODUCTION IS ONGOING. INSPECTIONS ON THE VARIOUS COMPONENTS PRODUCED IN FMS ARE BEING MONITORED FOR REPEATABILITY AND COMPLIANCE WITH DRAWING TOLERANCES. SOME ADJUSTMENTS ARE FOUND TO BE NECESSARY AS WE GAIN EXPERIENCE. FMS CYCLE TIMES ARE BEING RECORDED AGAIN AS CHANGES HAVE OCCURRED SINCE THEY WERE LAST DONE. AN UPDATED CAPACITY STUDY FOR REQUIRED FIXTURING AND MACHINERY TO OBTAIN FORTY (40) PARTS PER DAY WILL BE PREPARED USING THIS DATA. STILL DUE TO BE COMPLETED ARE THE FRAME "B" LOAD PROGRAM FOR T-10 #12 AND AN EIGHT PART MONOBLOCK PROGRAM TO ALLOW FOR SPLITTING THE FIXTURES IF REQUIRED.

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. APPROXIMATELY ONE THOUSAND (1000) PARTS HAVE BEEN PRODUCED WITHOUT ANY NOTICEABLE DIFFERENCE IN FINAL PERFORMANCE FROM THE FMS PARTS. SPECIAL ATTENTION TO GAGING WILL CONTINUE TO BE ESSENTIAL TO PRODUCING FUNCTIONAL PARTS FROM THIS LINE AS MANY OF THE OPERATIONS ARE NOT CONTROLLABLE. MACHINE REPAIR PROBLEMS AND TRAINING OF NEW OPERATORS HAVE BEEN DETRIMENTAL TO FULL PRODUCTION TO DATE.

FLAT RECEIVER MACHINING TRANSFER LINE:

THE REQUEST FOR QUOTE IS BEING CIRCULATED FOR REVIEW PRIOR TO SENDING IT OUT TO THE VENDORS.

M/870 EXPRESS RECEIVER FINISH:

REPAIRING OF BROACH LINES HAS REACHED AN ALL TIME HIGH. POLISHING OF THE SIDE PANELS IS THE ACCEPTED REPAIR WHICH LOOKS BETTER THAN THE NORMALLY ACCEPTABLE EXPRESS FINISH. SAMPLES HAVE BEEN REVIEWED TO GAIN FEEDBACK FOR A PROPOSAL TO ROUGH POLISH ALL EXPRESS RECEIVERS AND REDUCE THE BLAST TIME. A BY-PRODUCT OF THE REDUCED BLAST IS EXPECTED TO DECREASE THE AMOUNT OF DEFORMATION OF THE BARREL HOLE CAUSING THEM TO BE UNDERSIZE IN SOME CASES. FURTHER STUDY OF THIS AND ECONOMICS RELATED TO ADDITIONAL COSTS WILL BE DONE IN NOVEMBER.

M/870 DUCKS UNLIMITED OFFERING FOR 1994:

A ROLL MARK WITH THE "DU" LOGO WAS DESIGNED AND PROCURED; AND SAMPLES PRODUCED FOR MARKETING AND "DUCKS" ORGANIZATION APPROVAL DURING OCTOBER.

JACK