

TO : R. A. JACKSON
FROM : GAYLE M. UCASZ
SUBJECT : PROGRESS REPORT (11-30-93)

M/700 SUB-ASSEMBLY AREA

IT WAS BROUGHT TO ENGINEERING'S ATTENTION THAT THE M/700 RH/LH CONNECTORS WERE BEING FILED TO GET RID OF A PROMINENT RIDGE WHICH DID NOT ALLOW THE CONNECTOR TO WORK FREELY. THE QUESTIONABLE CONNECTORS WERE CHECKED AGAINST THE SAMPLES IN PURCHASE PARTS AND IT APPEARS THAT THE VENDORS TOOL MAY HAVE BEEN WORN WHEN MANUFACTURING THE CONNECTORS WITH RIDGES. JOHN MROZ IS CONTACTING THE VENDOR TO MAKE THEM AWARE OF THE PROBLEM, AND THE CONNECTORS WE HAVE ON SITE, THAT HAVE THE RIDGES, ARE BEING ALTERED IN THE SUB-ASSEMBLY AREA BY A STONING PROCESS RATHER THAN A FILING PROCESS.

M/700 BOLT AREA

THE BOLT BODY POLISHING MACHINE (SPIN POLISHING) HAS NOT BEEN GIVING SATISFACTORY RESULTS SO IT HAS BEEN TAKEN APART AND THE WORN PARTS REPLACED. THE FINISH ON THE BOLT BODIES HAVE IMPROVED BUT WE ARE ALSO GOING TO TRY USING A MORE AGGRESSIVE POLISHING PAPER TO ACHIEVE AN EVEN BETTER SURFACE FINISH.

OPERATORS USING THE FIXTURE FOR THE MILL GUIDE SLOT OPERATION IN THE M/700 BOLT BODY ASSEMBLY AREA HAD BEEN COMPLAINING ABOUT THE MOTION NECESSARY TO LOCK PARTS IN PLACE. THE FIXTURE HAS SINCE BEEN ALTERED TO MAKE IT ERGONOMICALLY CORRECT.

AN OBSOLETE DIAL GAGE USED AT THE BRAZING OPERATION IS IN THE PROCESS OF BEING REDESIGNED.

M/700 RECEIVER AREA

WE HAVE BEEN FINDING CHATTER MARKS INSIDE THE RECEIVERS AFTER THE BROACHING OPERATION. THE MARKS ARE BELIEVED TO BE CAUSED WHEN THE BROACHES CUTTING TEETH ARE NOT DIRECTLY ACROSS FROM ONE ANOTHER AND THEREFORE OPPOSING TEETH ARE NOT CUTTING AT THE SAME TIME. THE BAD ALIGNMENT OF THE TEETH MAY BE OCCURRING AT THE MANUFACTURING OF THE BROACH OR AT OUR OWN REGRIND PROCESS. BROACHES INC. IS LOOKING INTO MANUFACTURING THE BROACHES WITH TIGHTER TOLERANCES WITH REGARDS TO THE TEETH BEING OPPOSITE ONE ANOTHER, THEREFORE MAKING IT EASIER FOR CUTTER GRIND TO KEEP THE TEETH THAT WAY DURING REGRIND.

M/700 CLASSIC 6.5 X 55 SWEDISH

THE THROAT GAGE WAS RECEIVED FOR THE CHAMBER OPERATION AND WAS REJECTED AT INSPECTION. BROOKFIELD IS CURRENTLY REWORKING THE GAGE. THE AIR GAGE FOR THE CHAMBER OPERATION HAS ALSO BEEN REJECTED AND IS ON ITS WAY BACK TO THE COMPANY THAT MANUFACTURED IT FOR ALTERATION.