

08/13/98 THU 13:48 FAX 336 548 8742

REMINGTON

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FAX***Remington.***

*Remington Arms Co, Inc.
870 Remington Drive
Madison, NC 27025-0700*

TO: Jim Ackley**DATE:** 8/13/1998**PHONE:****FAX:** 502-765-4420**FROM:** Ron Bristol**PHONE:** (336) 548-8875**FAX:** (336) 548-7875**TOTAL PAGES** 14
(INCLUDING THIS COVER SHEET)

Jim,

I have reduced the legal pages to regular 8 1/2 by 11 sheets. If you cannot read them let me know. I did not know if the machine could receive legal fax pages.

Linda Blackard

ET36084

ComparisonM/700 ADL Synthetic .30-06 cal. 05 Costing

Description	Part #	Material	Labor	Overhead	Total
Overall Gun	927478	\$ 32.99	\$ 23.28	\$ 67.31	\$ 123.58
Receiver	99304	\$ 2.35	\$ 4.39	\$ 14.29	\$ 21.03
Barrel	26291	\$ 2.05	\$ 2.45	\$ 8.81	\$ 13.39
Bolt Assy	94097	\$ 6.71	\$ 3.19	\$ 8.92	\$ 18.83
Stock	106153	\$ 6.12	\$ 0.51	\$ 1.06	\$ 7.69
Firecontrol	26345	\$ 2.15	\$ 2.80	\$ 6.69	\$ 11.64

M/710 Synthetic .30-06 Flat-Panel Receiver Option Estimated Cost

Description	Material	Labor	Overhead	Total
Overall Gun	\$ 44.86	\$ 21.85	\$ 60.53	\$ 127.24
Receiver	\$ 4.87	\$ 1.58	\$ 5.48	\$ 11.93
Barrel	\$ 2.44	\$ 5.61	\$ 19.81	\$ 27.86
Bolt Assy	\$ 11.13	\$ 2.14	\$ 7.16	\$ 20.43
Stock/Fore end	\$ 6.16	\$ -	\$ -	\$ 6.16
Firecontrol	\$ 9.09	\$ 1.59	\$ 3.40	\$ 14.09

Comparison: M/700 ADL minus M/710

Description	Material	Labor	Overhead	Total
Overall Gun	\$ (11.87)	\$ 1.43	\$ 6.78	\$ (3.66)
Receiver	\$ (2.52)	\$ 2.81	\$ 8.81	\$ 9.10
Barrel	\$ (0.39)	\$ (3.16)	\$ (11.08)	\$ (14.56)
Bolt Assy	\$ (4.42)	\$ 1.05	\$ 1.76	\$ (1.60)
Stock	\$ (0.04)	\$ 0.51	\$ 1.06	\$ 1.53
Firecontrol	\$ (6.94)	\$ 1.21	\$ 3.29	\$ (2.45)

BARBER-522-0670009079

to Bottom Receiver - 12.106
to Turn
to Roof Receiver
to RIF Head. ?
to S&P to P&O, etc. Ass'y

710-high-spot.xls

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ET36085

30,000 - 80,000 Units

Estimate - High Spot

06 Cost Figure

M710 ESTIMATE - HIGH SPOT ONLY

PART DESCRIPTION	Engineer Purchasing Vendor	Proposed Process	Ref. Part No.	Machine Purchase	Rem. Tooling	Rem. Fixed Tooling	Vendor Set-up Charge	Vendor Oage Tooling	Oper. Materials	Material	Labor	Over Head	Estimated Price
97478 Barrel Assembly	Fidelity	Assemble	103129	see process	\$ 2,000.00	\$ 491.00	\$ 18,600.00		\$ 950.00	\$	\$ 0.15	\$ 1.17	\$ 1.71
Barrel	Perhart	Machined											
Front Sight Assembly	Fidelity	Assemble											
Take Down Screws (1)	Fidelity	Screw Mach.	218101						\$ 500.00	\$	\$ 0.15	\$ 19.81	\$ 27.86
Ramp	Swenson	Synthetic	14317										
Port	Fidelity	Screw Mach.	53501						\$ 400.00	\$	\$ 0.17	\$ 0.36	\$ 0.51
Rear Sight Assembly	Fidelity	Assemble	103146										
Take Down Screws (1)	Fidelity	Screw Mach.	218101										
Rear	Swenson	Synthetic	14317										
Sight	Swenson	Synthetic											
Aperture	Swenson	Synthetic											
Elevation Screw	Fidelity	Screw Mach.	90906										
Windage Screw	Fidelity	Screw Mach.	90904										
Ball Assembly Complete	Fidelity	Assemble	90904										
Ball Body Assembly	Zarnoch	Assemble	94097	see process	\$ 7,000.00	\$ 87,500.00			\$ 500.00	\$	\$ 0.47	\$ 1.53	\$ 2.00
Ball Body (20200)	Zarnoch	Assemble	94097	see process	\$ 14,500.00	\$ 710.00			\$ 600.00	\$	\$ 0.31	\$ 1.14	\$ 1.47
Ball Handle	Fidelity	Invert. Cast	26330										
Ball Head	Zarnoch	Screw Mach.	94097	see process	\$ 151,800.00	\$ 3,500.00			\$ 500.00	\$	\$ 3.15	\$ 0.07	\$ 3.24
Ball Pin	Swenson	Synthetic											
Ball Head Retaining Pin	Fidelity	Screw Mach.	18758										
Ball Striking	Fidelity	Screw Mach.											
Ball Cocking Pin	Fidelity	Reamed Part	19673										
Extractor	Fidelity	Stamping - AU	57112										
Firing Pin Head	Fidelity	Stamping - AU	57112										
Firing Pin Head Blank	Ogrosnik	MIM	94094										
Firing Pin	Fidelity	Screw Mach.	27975						\$ 5,500.00	\$	\$ 0.09	\$ 0.01	\$ 0.73
Firing Pin Spring	Fidelity	Compression Sp.	20020										
3 Index Pin	Swenson	Synthetic	17029										

① Cost for CINCINNATI PURCHASE

② MOWCO FOR STAFFS - NOT AN ABUSO PART

③ BARNES PISTOL - 10

④ MAREK ASSAULT RIFLE

⑤ Bear Paw Gun

710 High Spot

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422000

ET36086

30,000 - 60,000 Units

Estimate - High Spot

05 Cost Figure

PART DESCRIPTION	Engineer	Research	Part No.	Machine	Rem.	Fixed	Rem.	Gap	Vendor	Vendor	Material	Over Head	Estimated
	Purchasing	Process		Purchasing	Tooling	Tooling	Tooling	Tooling	Change	Yield			Price
Fire Control Assembly	Facility	Assemble	26345	see process	\$ 70,500.00	\$ 3,000.00							
Sear	Facility	Machined	97029		\$ 2,000.00	\$ 750.00							
Sear Wheel	Facility	Machined			\$ 42,000.00								
Sear Wheel	Facility	Screw Mach.			\$ 18,000.00	\$ 750.00							
System Return	Facility	Fin. Blank Stamp	91484		\$ 3,000.00	\$ 750.00							
Trigger	Facility	Machined	97029		\$ 2,000.00	\$ 750.00							
Trigger	Facility	Machined	97029		\$ 5,000.00	\$ 750.00							
Trigger	Facility	Machined	97029		\$ 45,000.00								
Primary Piston # 3	Facility	Drive-ink	0243										
Secondary Piston # 4	Facility	Drive-ink	0248										
Set Screw One (Safety)	Facility	Screw Mach.	91128										
Set Screw Two (Chamber Part 1)	Facility	Screw Mach.	91128										
Set Screw Three (Over Travel)	Facility	Screw Mach.	91128										
Safety Broom	Facility	Machined			\$ 2,000.00								
Safety Lock	Facility	Stamping			\$ 10,000.00	\$ 950.00							
Safety Link First (2 Drive Lock)	Facility	Drive-ink	0252		\$ 12,500.00	\$ 750.00							
Safety Armature & Bolt Lock	Facility	Stamp with ass.			\$ 300.00								
Safety Armature Pin	Facility	Screw Mach.	24477		\$ 350.00	\$ 300.00							
Safety Detent Ball	Facility	Ball Bearing	23222										
Safety Detent Spring	Facility	Stamping	97493		\$ 8,000.00	\$ 750.00							
Trigger Spring	Facility	Compression Spr.	17047										
Sear Spring	Facility	Compression Spr.	17047										
Trigger Housing	Facility	Brithelle	99129		\$ 65,000.00	\$ 1,250.00							
Trigger Housing Blank	Facility	Stamping	30781		\$ 6,000.00	\$ 1,250.00							
Right Side Piece													

710-high spot ass

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ET36087

30,000 - 40,000 Lines

Estimate - High Spot

Do Not Figure

PART DESCRIPTION	Engineer Purchasing Vendor	Research Proposed Process	Part No.	Mechanical Purchase	Item Floor Tooling	Item Case Tooling	Vendor Set-Up Charge	Vendor Tooling	Oper Estimate	Material	Labor	Over Head	Enclosed Piece Price
Receiver Assembly	Fidelity	Assembly	100198										
Receiver (Automatic)	Zarnoch	Alum. Forging			\$ 21,000.00				\$ 7,100.00	\$ 4.87	\$ 1.49	\$ 1.51	\$ 7.00
Bolt Guide/Bolt Release	Cymotuk	Powder Metal			\$ 6,500.00				\$ 2,100.00	\$ 0.35	\$ 0.01	\$ 0.02	\$ 11.95
Bolt Guide/Bolt Release Spr	Fidelity	Tension Spr.	91433						\$ 0.04	\$ 0.04	-	-	\$ 0.39
Barrel Clamp Screws (2)	Fidelity	Screw 1/4-34							\$ 0.10	\$ 0.10	-	-	\$ 0.04
Barrel Clamp Nut (2)	Fidelity	Screw 1/4-34							\$ 0.10	\$ 0.10	-	-	\$ 0.10
Barrel Release Lever	Swenson	Synthetic							\$ 400.00	\$ 0.03	\$ 0.03	\$ 0.13	\$ 0.23
Magazine Release Pin	Fidelity	Screw Wash			\$ 10,000.00		\$ 150.00			\$ 0.05	-	-	\$ 0.05
Magazine Release Spring	Fidelity	Tension Spr	91433							\$ 0.04	-	-	\$ 0.04
Form End Iron	Fidelity	Stamping	57793		\$ 24,000.00	\$ 450.00		\$ 810.00		\$ 2.10	\$ 0.10	\$ 0.30	\$ 2.57
Magazine Assembly	Fidelity	Assembly	106406						\$ 1,000.00	-	\$ 0.27	\$ 0.56	\$ 0.83
Magazine Body	Swenson	Synthetic	58939		\$ 31,000.00	\$ 2,000.00			\$ 400.00	\$ 1.80	\$ 0.25	\$ 0.70	\$ 2.73
Magazine Bottom	Swenson	Synthetic			\$ 12,000.00	\$ 1,000.00				\$ 0.01	\$ 0.04	\$ 0.13	\$ 0.20
Followers	Swenson	Synthetic			\$ 10,000.00	\$ 1,000.00				\$ 0.01	\$ 0.04	\$ 0.13	\$ 0.20
Followers Spring	Fidelity	Stamping	170026			\$ 350.00		\$ 710.00	\$ 2,000.00	\$ 0.39	-	-	\$ 0.39
Bolt Stock Assembly	Fidelity	Assembly	102845		\$ 25,000.00				\$ 400.00	\$ 3.30	\$ 0.51	\$ 1.53	\$ 2.26
Bolt Stock	Swenson	Synthetic	106083							\$ 0.61	\$ 1.74	-	\$ 2.35
Recoil Pad	Fidelity	Add Use	97973							\$ 0.06	-	-	\$ 0.06
Recoil Pad Screws (2)	Fidelity	Add Use	98006							\$ 0.18	\$ 0.00	\$ 0.01	\$ 0.19
Bolt Stock Releasing Bolt	Fidelity	Add Use	979022							\$ 0.03	\$ 0.00	\$ 0.01	\$ 0.04
Bolt Stock Res. Bolt Washer	Fidelity	Add Use	18173							\$ 0.00	-	-	\$ 0.00
Bolt Stock Res. Lock Washer	Fidelity	Add Use	18172							\$ 0.15	-	-	\$ 0.15
Switched Bolt	Fidelity	Add Use	13158							\$ 0.15	-	-	\$ 0.15
Fore-end Stock Assembly	Fidelity	Assembly											
Fore-end	Swenson	Synthetic	108090		\$ 43,000.00				\$ 400.00	\$ 2.96	\$ 0.10	\$ 0.30	\$ 2.96
Fore-end Releasing Lever	Fidelity	Screw Wash	91871							\$ 0.30	-	-	\$ 0.30
Switched Bolt	Fidelity	Add Use	13158							\$ 0.15	-	-	\$ 0.15

710-411-401-25

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ET36088

M710-Process.xls

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$	Over Head \$	Oper. Cost
	Blank Material								\$ 4.87	\$ -	\$ -	\$ 4.87
5	Ream bolt hole and btl hole	Rem Special	\$ 75,000.00	\$ 800.00	XXXX	\$ 15.80	350%	0.012000	\$ -	\$ 0.19	\$ 0.66	\$ 0.85
10	Drill and tap scope holes	Rem Special	\$ 125,000.00	\$ 800.00	XXXX	\$ 15.80	350%	0.012000	\$ -	\$ 0.19	\$ 0.66	\$ 0.85
20	Drill and tap takedown holes and magazine latch pivot	Rem Special	\$ 125,000.00	\$ 800.00	XXXX	\$ 15.80	350%	0.012000	\$ -	\$ 0.19	\$ 0.66	\$ 0.85
30	Butt mill and ream firecontrol holes and barrel clamp holes	Rem Special	\$ 125,000.00	\$ 800.00	XXXX	\$ 15.80	350%	0.012000	\$ -	\$ 0.19	\$ 0.66	\$ 0.85
40	Mill Slot	O-12	\$ 13,000.00	\$ 800.00	XXXX	\$ 15.80	350%	0.013500	\$ -	\$ 0.21	\$ 0.75	\$ 0.96
50	Metasilicate wash				XXXX	\$ 15.80	350%	0.000001	\$ -	\$ 0.00	\$ 0.00	\$ 0.00
60	Finish File				XXXX	\$ 15.80	350%	0.005000	\$ -	\$ 0.08	\$ 0.28	\$ 0.36
70	Roll mark Remington & model	Schmidt	\$ 5,000.00	\$ 600.00	XXXX	\$ 15.80	350%	0.003600	\$ -	\$ 0.06	\$ 0.20	\$ 0.26
80	Stamp serial number	Rem Special	\$ 5,000.00	\$ 600.00	XXXX	\$ 15.80	350%	0.003600	\$ -	\$ 0.06	\$ 0.20	\$ 0.26
90	Stamp "S" and "F"	Rem Special	\$ 20,000.00	\$ 250.00	XXXX	\$ 15.80	350%	0.003600	\$ -	\$ 0.06	\$ 0.20	\$ 0.26
100	Fixture Finish - wet & destone		\$ 15,000.00	\$ 850.00	XXXX	\$ 15.80	350%	0.012500	\$ -	\$ 0.20	\$ 0.69	\$ 0.89
110	Glass Bead Blast		\$ 10,000.00	\$ 500.00	8158	\$ 15.79	359%	0.007034	\$ -	\$ 0.11	\$ 0.40	\$ 0.51
120	Powder Coat		\$ 5,000.00	\$ 500.00	8301	\$ 15.55	249%	0.003000	\$ -	\$ 0.03	\$ 0.12	\$ 0.16
	Totals		\$ 523,000.00	\$ 7,300.00				0.099835	\$ 4.87	\$ 1.58	\$ 5.48	\$ 11.93

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M710 - Bolt Head

[illegible]

M710-Process.xls

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ET36091

~~Confidential - Subject's Private Order~~

Williams v. Remington

M710 - Bolt Handle

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops \$	Depart. Number	Dept. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$	Over Head \$	Oper. Cost
	Blank Material		\$ 10,000.00						\$ 2.75			\$ 2.75
	Mold											
	Caging (vendor and Remanage)		\$ 2,000.00	\$ 300.00								
10	Roun .700 diameter Gaging		\$ 2,500.00	\$ 500.00	xxxxx	\$ 15.80	350%	0.008336		\$ 0.13	\$ 0.46	\$ 0.59
20	Rough Polish				xxxxx	\$ 15.80	350%	0.005000		\$ 0.08	\$ 0.28	\$ 0.36
30	Hest Treat				4551	\$ 15.78	278%	0.001500		\$ 0.02	\$ 0.07	\$ 0.09
40	Insect				8551	\$ 15.78	278%	0.000001		\$ 0.00	\$ 0.00	\$ 0.00
50	Finish Polish				xxxxx	\$ 15.80	350%	0.005000		\$ 0.08	\$ 0.28	\$ 0.36
Totals			\$ 14,500.00	\$ 1,000.00				10.019431	\$ 2.74	\$ 0.31	\$ 1.08	\$ 4.14

M710-Process.xls

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M710-Process.xls

[illegible]

M710 - Barrel

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$	Over Head \$	Oper. Cost
	Material (Blank 97651)								\$ 2.44			\$2.44
1	Issue from crib				9290							
5	Cut to length (need 26')			\$ 600.00	8173	\$ 15.89	397.98%	0.012437		\$ 0.20	\$ 0.79	\$ 0.98
16	Heat, Manual upset and trim			\$ 1,000.00	8173	\$ 15.89	397.98%	0.012437		\$ 0.20	\$ 0.79	\$ 0.98
18	Machine straighten				8173	\$ 15.89	397.98%	0.007991		\$ 0.13	\$ 0.51	\$ 0.63
20	Load furnace baskets				8105	\$ 15.38	333.86%	0.001680		\$ 0.03	\$ 0.09	\$ 0.11
22	Load furnace heat and quench				8105	\$ 15.38	333.86%	0.000001		\$ 0.00	\$ 0.00	\$ 0.00
23	Unload furnace and wash				8105	\$ 15.38	333.86%	0.001470		\$ 0.02	\$ 0.08	\$ 0.10
24	Load draw furnace and draw barrels				8105	\$ 15.38	333.86%	0.006667		\$ 0.10	\$ 0.34	\$ 0.44
25	Unload draw furnace				8105	\$ 15.38	333.86%	0.000850		\$ 0.01	\$ 0.04	\$ 0.06
29	Unload furnace baskets				8105	\$ 15.38	333.86%	0.000520		\$ 0.01	\$ 0.03	\$ 0.03
30	Tumble				8105	\$ 15.38	333.86%	0.001600		\$ 0.02	\$ 0.08	\$ 0.11
31	Inspect for hardness				8105	\$ 15.38	333.86%	0.004900		\$ 0.08	\$ 0.25	\$ 0.33
	Crib							0.000001				

M710-Process.xls

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ET36095

Confidential - ~~Subject~~ - 5.22.06P0009089 Order

Williams v. Remington

M710 - Barrel

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Opi. \$	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 - upper barrels		\$ 1,500.00		8158	\$ 15.76	359.44%	0.019516		\$ 0.31	\$ 1.11	\$ 1.41
15	Form Turn NFT form		\$ 3,500.00		8158	\$ 15.76	359.44%	0.025162		\$ 0.40	\$ 1.43	\$ 1.82
20	Bore ream to remove drill rings		\$ 3,000.00		8158	\$ 15.76	359.44%	0.009469		\$ 0.15	\$ 0.54	\$ 0.69
30	GFM form and finish		\$ 10,000.00		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 Tooling Gaging	\$ 450,000.00 \$ 12,000.00	\$ 10,000.00	8158	\$ 15.76	359.44%	0.091660		\$ 1.44	\$ 5.19	\$ 6.64

M710-Process.xls

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ET36096

Confidential - SHARRET-5.22.06r0009090 Order

Williams v. Remington

M710 - Firecontrol! Assy

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Opr. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Sid. Run Hours	Oper. Cost
	Mill Actuator and Bolt Lock 2 places								
	Safety Button machining ??								
	Rear Holes								
	Trigger Housing Maching (if required)								
	Machine	N/C VMC 4 - axis	\$ 47,500.00						
	Fixtures		\$ 10,000.00						
	Gaging		\$ 5,000.00						
	Tools			\$ 500.00					
	Assemble Firecontrol Bench/action holders			\$ 2,900.00					
	Trigger pull measuring/settings fixtures (2)		\$ 8,000.00						
	Totals		\$ 78,500.00	\$ 3,000.00					

M1710-Process.xls

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CONFIDENTIAL

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