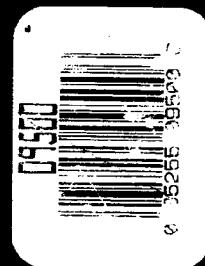
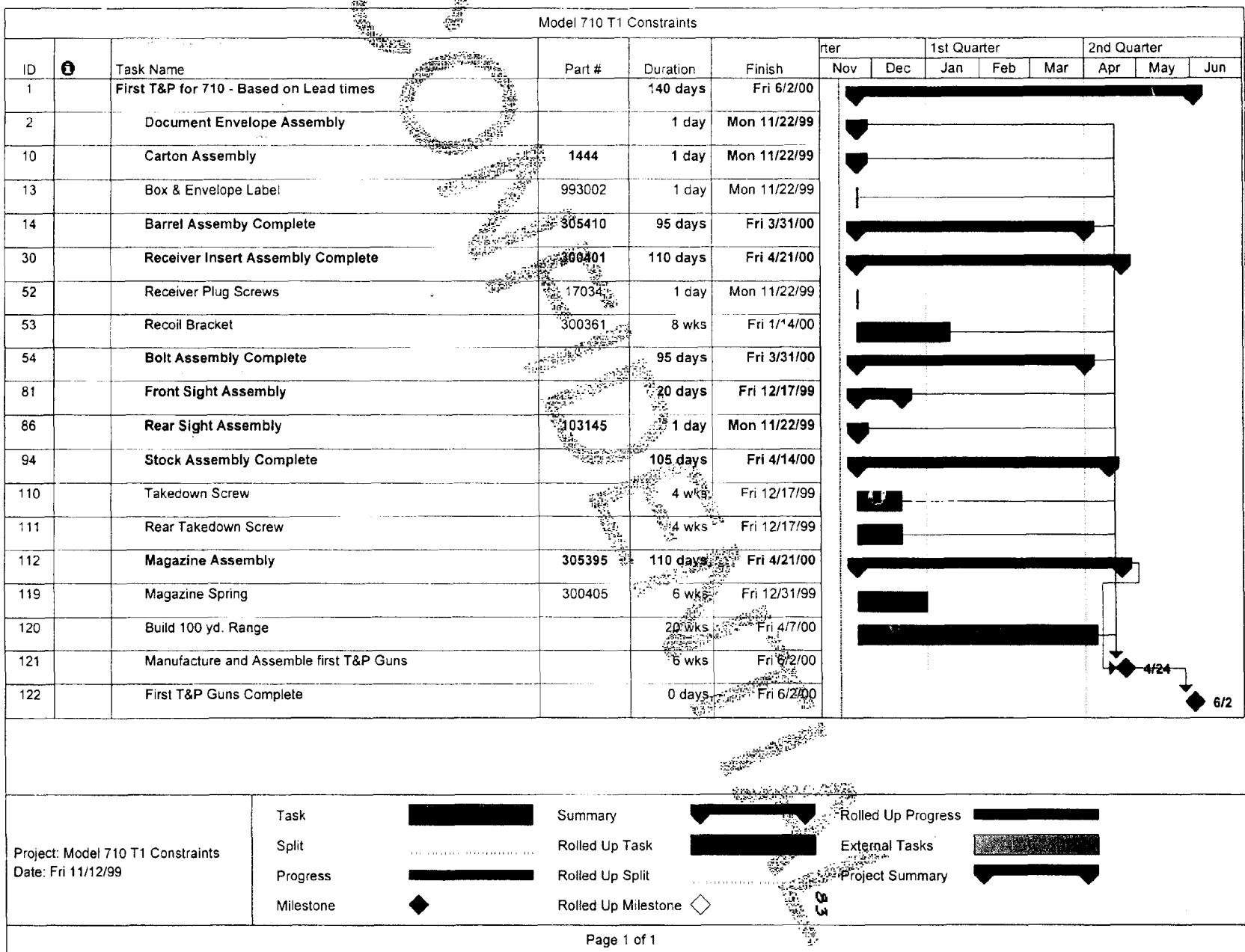


M710 ESTIMATE  
DATA



MF0001



MF0002

Confidential - Subject - 5.22.06r0009952 Order

Williams v. Remington

# November 12, 1999

## Friday

November 1999

| S  | M  | T  | W  | T  | F  | S  |
|----|----|----|----|----|----|----|
|    | 1  | 2  | 3  | 4  | 5  | 6  |
| 7  | 8  | 9  | 10 | 11 | 12 | 13 |
| 14 | 15 | 16 | 17 | 18 | 19 | 20 |
| 21 | 22 | 23 | 24 | 25 | 26 | 27 |
| 28 | 29 | 30 |    |    |    |    |

December 1999

| S  | M  | T  | W  | T  | F  | S  |
|----|----|----|----|----|----|----|
|    |    |    | 1  | 2  | 3  | 4  |
| 5  | 6  | 7  | 8  | 9  | 10 | 11 |
| 12 | 13 | 14 | 15 | 16 | 17 | 18 |
| 19 | 20 | 21 | 22 | 23 | 24 | 25 |
| 26 | 27 | 28 | 29 | 30 | 31 |    |

| TaskPad                                                               |                                              |
|-----------------------------------------------------------------------|----------------------------------------------|
| <input checked="" type="checkbox"/>                                   | TaskPad                                      |
| <input checked="" type="checkbox"/>                                   | scrap graph                                  |
| <input checked="" type="checkbox"/>                                   | pert chart for bunting on product lead ti... |
| <input checked="" type="checkbox"/>                                   | review quality and delivery with marley ...  |
| <input checked="" type="checkbox"/>                                   | Vendor grading system/review with Kipp       |
| <input checked="" type="checkbox"/>                                   | get electrical comparisons                   |
| <input checked="" type="checkbox"/>                                   | Win Mag bolt fixture for mill rails          |
| <p><i>ORDER CHAIRS FOR ASSEMBLY</i></p> <p><b>CONFIDENTIAL</b> 83</p> |                                              |
| Notes                                                                 |                                              |
| <p><i>CONFIDENTIAL</i></p>                                            |                                              |

Golemboski, Matt R.

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11/11/99

MF0003

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/11/99

C:\data\DC\Mayfield\New Products\710 estimate rev5.xls\710 capital by operation (2)

|                            | High    | Expected | Nov-99  | Dec-99  | Jan-00  | Feb-00  | Mar-00  | Apr-00  | May-00 |
|----------------------------|---------|----------|---------|---------|---------|---------|---------|---------|--------|
| Carton Assembly            | 19,000  | 19,000   |         |         | 6,333   |         | 6,333   | 6,333   |        |
| <b>Barrel</b>              |         |          |         |         |         |         |         |         |        |
| cones                      | 9,960   |          |         |         |         |         |         |         |        |
| Ream Bore                  |         | 6,080    | 6,080   |         |         |         |         |         |        |
| Rifle Bore                 |         | 15,900   | 7,950   |         | 7,950   |         |         |         |        |
| Press Barrel to Receiver   |         | 11,000   | 11,000  |         |         |         |         |         |        |
| gages & fixtures           | 73,100  | 43,600   |         | 20,000  | 21,600  | 2,000   |         |         |        |
| baskets                    | 6,900   | 7,000    |         | 7,000   |         |         |         |         |        |
| machine                    | 222,880 | 189,448  | 63,149  |         |         |         | 63,149  |         | 63,149 |
| chuck                      | 15,000  | 15,000   |         |         |         | 15,000  |         |         |        |
| machine                    | 75,000  | 104,500  |         | 34,833  |         | 34,833  | 34,833  |         |        |
| machine                    | 166,000 | 175,000  |         | 58,333  |         | 58,333  | 58,333  |         |        |
| machine                    | 12,000  | 15,000   |         |         |         | 15,000  |         |         |        |
| Roll Mark                  |         | 6,300    |         |         | 6,300   |         |         |         |        |
| Straighten                 |         | 3,500    |         | 3,500   |         |         |         |         |        |
| Glass Bead Blast           |         | 2,500    |         | 2,500   |         |         |         |         |        |
| racks                      | 6,000   | 6,000    |         | 6,000   |         |         |         |         |        |
| Total                      | 586,840 | 600,828  | 88,179  | 132,166 | 35,850  | 125,166 | 156,315 | -       | 63,149 |
| <b>Bolt Head</b>           |         |          |         |         |         |         |         |         |        |
| fix & gage                 | 42,500  | 47,400   |         | 20,000  | 4,100   | 23,300  |         |         |        |
| Superabrasive Grind Lugs   | 43,800  | 43,800   |         | 21,900  |         | 21,900  |         |         |        |
| CNC Machine                | 174,784 | 174,800  | 69,920  |         |         | 104,880 |         |         |        |
| Total                      | 261,084 | 266,000  | 69,920  | 41,900  | 4,100   | 150,080 | -       | -       | -      |
| <b>Bolt Body</b>           |         |          |         |         |         |         |         |         |        |
| gage & Fixture             | 4,500   | 2,500    |         |         |         | 2,500   |         |         |        |
| machine                    | 90,000  | 98,000   |         | 32,667  |         | 32,667  | 32,667  |         |        |
| tanks                      | 9,500   | 9,500    |         |         |         | 9,500   |         |         |        |
| Total                      | 104,000 | 110,000  |         | 32,667  | -       | 44,667  | 32,667  | -       | -      |
| <b>Receiver</b>            |         |          |         |         |         |         |         |         |        |
| fix & gage                 | 2,500   | 2,500    |         |         | 2,500   |         |         |         |        |
| CMM                        | 45,000  | 45,000   |         |         | 22,500  |         | 22,500  |         |        |
| Computer & fixtures        |         | 12,000   |         | 2,000   | 2,000   | 8,000   |         |         |        |
| Ultra Sonic Weld           |         | 4,000    |         |         | 4,000   |         |         |         |        |
| machine                    | 168,831 | 436,756  | 145,585 |         |         |         | 145,585 | 145,585 |        |
| Total                      | 516,331 | 500,256  | 145,585 | 2,000   | 31,000  | 8,000   | 168,085 | 145,585 | -      |
| <b>Final Assembly</b>      |         |          |         |         |         |         |         |         |        |
| 100yd Range                | 265,000 | 285,000  |         | 100,000 | 140,000 | 45,000  |         |         |        |
| snails                     | 30,000  | 25,000   |         |         |         | 25,000  |         |         |        |
| HVAC                       | 25,000  |          |         |         |         |         |         |         |        |
| other                      | 10,000  | 15,000   | 15,000  |         |         |         |         |         |        |
| Total                      | 330,000 | 325,000  | 15,000  | 100,000 | 140,000 | 70,000  | -       | -       | -      |
| <b>Purchased Parts</b>     |         |          |         |         |         |         |         |         |        |
| Receiver Insert            | 48,000  | 48,000   |         |         | 48,000  |         |         |         |        |
| Side Plate                 | 10,000  | 13,000   |         |         | 4,333   |         | 4,333   | 4,333   |        |
| Safety Arm                 | 23,880  | 25,552   |         |         | 12,776  |         |         | 12,776  |        |
| Bolt Stop                  | 6,820   | 6,820    |         |         | 6,820   |         |         |         |        |
| Trigger                    |         | 15,225   |         |         | 7,613   |         |         | 7,613   |        |
| Trigger Connector          |         | 3,000    |         |         | 1,500   |         | 1,500   |         |        |
| Rear Sight Aperture Blank  |         | 9,000    |         |         | 4,000   | 5,000   |         |         |        |
| Lock Tumbler               |         | 35,000   |         | 17,500  |         |         | 17,500  |         |        |
| Front Screw Bushing        |         | 12,000   |         |         | 4,000   |         | 4,000   | 4,000   |        |
| Recoil Bracket             | 2,225   |          |         |         |         |         |         |         |        |
| Bolt Handle Blank          | 12,800  | 12,575   | 6,288   |         |         | 6,288   |         |         |        |
| Bolt Plug                  | 38,088  | 38,088   | 12,696  |         | 12,696  | 12,696  |         |         |        |
| Front Sight Assembly Press |         | 4,200    |         |         |         | 4,200   |         |         |        |
| Firing pin head            | 23,000  | 37,500   |         | 12,500  |         | 12,500  | 12,500  |         |        |
| Mag Latch                  | 33,480  | 33,480   | 11,160  |         | 11,160  | 11,160  |         |         |        |
| Magazine Box               | 28,000  | 46,500   | 15,500  |         | 15,500  | 15,500  |         |         |        |

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/11/99

C:\data\DC\Mayfield\New Products\I[M710 estimate rev5.xls]710 capital by operation (2)

|                   | High      | Expected  | Nov-99  | Dec-99  | Jan-00  | Feb-00  | Mar-00  | Apr-00  | May-00 |
|-------------------|-----------|-----------|---------|---------|---------|---------|---------|---------|--------|
| Carton Assembly   | 19,000    | 19,000    |         |         | 6,333   |         | 6,333   | 6,333   |        |
| Magazine Follower | 33,300    | 78,786    | 26,262  |         | 26,262  | 26,262  |         |         |        |
| Magazine Bottom   | 47,880    |           |         |         |         |         |         |         |        |
| Stock Fixture     |           | 2,800     |         |         |         |         | 2,800   |         |        |
| Stock             | 150,300   | 150,300   | 50,100  |         | 50,100  | 50,100  |         |         |        |
| PPI               | 41,500    | 54,300    |         | 18,700  | 21,650  | 2,250   | 10,200  | 1,500   |        |
| Total             | 499,273   | 626,126   | 122,006 | 48,700  | 226,410 | 145,956 | 52,833  | 30,222  | -      |
| Installation      | 61,000    | 61,000    |         |         |         |         |         | 61,000  |        |
| Total Capital     | 2,377,528 | 2,508,210 | 440,690 | 357,433 | 443,693 | 543,869 | 416,233 | 243,140 | 63,149 |

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| M/710 Estimate                           |                       |        |              |         |             |          |               |             |               |                       |
|------------------------------------------|-----------------------|--------|--------------|---------|-------------|----------|---------------|-------------|---------------|-----------------------|
| PART DESCRIPTION                         | Proposed Process      | Part # | Print #      | Rev #   | Material \$ | Labor \$ | Fixed O.H. \$ | Var O.H. \$ | Total O.H. \$ | Estimated Piece Price |
| <b>Carton Assembly</b>                   | Purchase              | 1444   | 1444         |         |             |          |               |             |               |                       |
| Corrugated Box                           | Purchase              |        |              |         |             |          |               |             |               |                       |
| Bed                                      | Purchase              |        |              |         |             |          |               |             |               |                       |
| <b>Document Envelope Assembly</b>        | Purchase              | 1649   | 1649         |         |             |          |               |             |               |                       |
| Document Envelope                        | Purchase              | 1649   | 1649         |         |             |          |               |             |               |                       |
| Instruction Book                         | Purchase              | 1426   | 1426         |         |             |          |               |             |               |                       |
| Product Owners Card                      | Purchase              | 3413   | 3413         |         |             |          |               |             |               |                       |
| Remington Authorized Gunsmith            | Purchase              | 3499   | 3499         |         |             |          |               |             |               |                       |
| Safety Booklet                           | Purchase              | 3475   | 3475         |         |             |          |               |             |               |                       |
| Remington Museum Flyer                   | Purchase              | 3491   | 3491         |         |             |          |               |             |               |                       |
| Oval Label                               | Purchase              |        |              |         |             |          |               |             |               |                       |
| <b>Box and Envelope Label (710)</b>      | Purchase              | 993002 | 993002       |         |             |          |               |             |               |                       |
| <b>Barrel Assembly Complete</b>          | Assemble              | 305410 | C-305410     | No Rev. |             |          |               |             |               |                       |
| <b>Barrel Assembly</b>                   | Assemble & Machine    | 305400 | C-305400     | No Rev. |             |          |               |             |               |                       |
| Barrel                                   | Machine               | 305315 | E-305315     | 5       |             |          |               |             |               |                       |
| Receiver                                 | Purchase              | 300340 | E-300340     | 6       | \$0.000     |          |               | \$          |               |                       |
| <b>Receiver Insert Assembly Complete</b> | Assemble              | 300401 | D-300401     | No Rev. |             |          |               |             |               |                       |
| <b>Receiver Insert Assembly</b>          | Ultrasonic Weld       | 300400 | C-300400     | No Rev. |             |          |               |             |               |                       |
| Receiver Insert                          | Purchase              | 300327 | E-300327-1-2 | 1-2     |             |          |               |             |               |                       |
| Threaded Insert                          | Purchase              | 300347 | A-300347     | A       | \$0.036     |          |               |             |               |                       |
| Side Plate                               | Purchase & Color      | 300333 | C-300333     | No Rev. | \$0.090     |          |               |             |               |                       |
| Side Plate Pin (2)                       | Purchase & Color      | 300328 | A-300328     | No Rev. | \$0.160     |          |               |             |               |                       |
| Sear Safety Cam                          | AU M/700              | 15666  | C-15666      | 24      | \$0.760     |          |               |             |               |                       |
| Pivot Pin (3)                            | Purchase & Heat Treat | 300351 | B-300351     | No Rev. | \$0.180     |          |               |             |               |                       |
| Sear Spring                              | AU M/700              | 17047  | A-17047      | 26      | \$0.047     |          |               |             |               |                       |
| Trigger                                  | AU M/700              | 15280  | C-15280      | 31      | \$0.738     |          |               |             |               |                       |
| Trigger Connector                        | AU M/700              | 19461  | C-19461      | 21      |             |          |               |             |               |                       |
| Trigger Screw Front                      | AU M/700              | 17053  | B-17053      | 32      | \$0.043     |          |               |             |               |                       |
| Trigger Engagement Screw                 | AU M/700              | 91128  | B-91128      | 7       | \$0.043     |          |               |             |               |                       |
| Trigger Spring                           | AU M/700              | 15400  | A-15400      | 11      | \$0.076     |          |               |             |               |                       |
| Trigger Stop Screw                       | AU M/700              | 15481  | B-17053      | 32      | \$0.042     |          |               |             |               |                       |
| Safety Arm                               | Assemble & Heat Treat | 300408 | D-300408     | 1       | \$0.230     |          |               |             |               |                       |
| Safety Detent Spring                     |                       | 300407 | C-300407     | 1       | \$0.068     |          |               |             |               |                       |
| Lock tumbler                             | Purchase              | ??     | ???          | ??      |             |          |               |             |               |                       |
| Lock Detent                              | AU M/7                | ???    | ???          | ???     |             |          |               |             |               |                       |
| Safety Pivot Pin                         | Purchase & Heat Treat | 300352 | B-300352     | 1       | \$0.440     |          |               |             |               |                       |
| Snap Washer                              |                       | 17044  | B-17044      | 26      |             |          |               |             |               |                       |
| Bolt Stop                                | PM/Heat Treat/Color   | 300345 | C-300345     | 2       | \$0.219     |          |               |             |               |                       |
| Receiver Plug Screws (4)                 | AU M/700              | 17034  | B-17034      | 34      |             |          |               |             |               |                       |
| Recoil Bracket                           | Purchase & Color      | 300361 | B-300361     | No Rev. | \$0.123     |          |               |             |               |                       |
| <b>Bolt Assembly Complete</b>            |                       | ???    | ???          | ??      |             |          |               |             |               |                       |

MF0006

| M/710 Estimate                 |                      |        |          |         |             |          |               |             |               |                       |
|--------------------------------|----------------------|--------|----------|---------|-------------|----------|---------------|-------------|---------------|-----------------------|
| PART DESCRIPTION               | Proposed Process     | Part # | Print #  | Rev #   | Material \$ | Labor \$ | Fixed O.H. \$ | Var O.H. \$ | Total O.H. \$ | Estimated Piece Price |
| <b>Bolt Body Assembly</b>      | Braze & Finish       | 300403 | D-300403 | No Rev. |             |          |               |             |               |                       |
| Bolt Body                      | Purchase             | 300339 | D-300339 | 1       | \$2.050     |          |               | \$ 0.17     |               |                       |
| Bolt Handle                    | Bend to Form         | 300370 | C-300370 | No Rev. | \$1.630     |          |               |             |               |                       |
| Bolt Handle Blank              | Purchase             | 300360 | C-300360 | No Rev. |             |          |               |             |               |                       |
| Bolt Handle Pin                | Purchase             | 300329 | A-300329 | 1       | \$0.100     |          |               |             |               |                       |
| <b>Bolt Head Assembly</b>      | Assemble             | 305390 | B-305390 | No Rev. |             |          |               |             |               |                       |
| Bolt Head                      | Machined             | 300338 | E-300338 | 14      |             |          |               |             |               |                       |
| Extractor                      | A/U M/700            | 93712  | C-93712  | 2       |             |          |               |             |               |                       |
| Ejector                        | Purchase & Color     | 300342 | B-300342 | 1       | \$0.110     |          |               |             |               |                       |
| Ejector Spring                 | Purchase             | 300367 | A-300367 | No Rev. | \$0.015     |          |               |             |               |                       |
| Ejector Pin                    | A/U M/700            | 94555  | A-94555  | 1       | \$0.040     |          |               |             |               |                       |
| Bolt Assembly Pin              | Purchase & Color     | 300330 | B-300330 | No Rev. | \$0.150     |          |               |             |               |                       |
| <b>Firing Pin Assembly</b>     | Assemble             | 300404 | B-300404 | No Rev. |             |          |               |             |               |                       |
| Bolt Plug                      | Purchase             | 300368 | C-300368 | 1       | \$0.215     |          |               |             |               |                       |
| Bolt Plug Insert               | Purchase             | 300346 | B-300346 | No Rev. | \$0.808     |          |               |             |               |                       |
| Firing Pin                     | Purchase & Color     | 300334 | C-300334 | No Rev. | \$1.190     |          |               |             |               |                       |
| Firing Pin Tip                 | Purchase & Heat Trea | 300335 | B-300335 | No Rev. | \$0.230     |          |               |             |               |                       |
| Firing Pin Head                | MIM                  | 300336 | C-300336 | No Rev. | \$1.753     |          |               |             |               |                       |
| Firing Pin Spring              | Purchase             | 300399 | A-300399 | No Rev. | \$0.101     |          |               |             |               |                       |
| <b>Front Sight Assembly</b>    |                      |        |          |         |             |          |               |             |               |                       |
| Front Sight                    | A/U M/700            | 94084  | C-15373  | 26      |             |          |               |             |               |                       |
| Front Sight Ramp               | A/U M/700            | 94657  | B-28510  | 33      |             |          |               |             |               |                       |
| Front Sight Ramp Screws (2)    | A/U M/700            | 28505  | B-28505  | 21      |             |          |               |             |               |                       |
| <b>Rear Sight Assembly</b>     | A/U M/700            | 103145 | B-103145 | 11      |             |          |               |             |               |                       |
| Elevation Screw                | A/U M/700            | 90906  | A-90906  | 19      | \$0.036     |          |               |             |               |                       |
| Rear Sight Aperture            | A/U M/700            | 97681  | C-93905  | 9       | \$0.140     |          |               |             |               |                       |
| Rear Sight Aperture Blank      |                      | 93906  | C-93906  | 6       |             |          |               |             |               |                       |
| Rear Sight Base                | A/U M/700            | 103531 | C-103530 | 3       | \$0.968     |          |               |             |               |                       |
| Rear Sight Slide               | A/U M/700            | 94335  | C-93904  | 7       | \$1.200     |          |               |             |               |                       |
| Windage Screw                  | A/U M/700            | 300026 | B-300026 | 5       | \$0.191     |          |               |             |               |                       |
| Rear Sight Base Screw (2)      | A/U M/700            | 28505  | B-28505  | 21      |             |          |               |             |               |                       |
| <b>Stock Assembly Complete</b> | Purchase             | ???    | ???      | ??      |             |          |               |             |               |                       |
| <b>Stock Assembly</b>          | Purchase             | ???    | ???      | ??      |             |          |               |             |               |                       |
| Stock                          | Purchase             | ???    | ???      | ??      |             |          |               |             |               |                       |
| Front Screw Bushing            | A/U M/700            | 15161  | B-15161  | ??      |             |          |               |             |               |                       |
| Front Screw Bushing Blank      |                      | 91915  | ???      | ???     |             |          |               |             |               |                       |
| Middle Screw Bushing           | Purchase             | ???    | ???      | ???     |             |          |               |             |               |                       |
| Rear Screw Bushing             | Purchase             | ???    | ???      | ??      |             |          |               |             |               |                       |

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MF0007

Confidential - SHARPER - 5.22.06r0009957ye Order

Williams v. Remington

| M/710 Estimate             |                  |        |            |         |             |          |               |             |               |                       |
|----------------------------|------------------|--------|------------|---------|-------------|----------|---------------|-------------|---------------|-----------------------|
|                            | Proposed Process | Part # | Print #    | Rev #   | Material \$ | Labor \$ | Fixed O.H. \$ | Var O.H. \$ | Total O.H. \$ | Estimated Piece Price |
| PART DESCRIPTION           |                  |        |            |         |             |          |               |             |               |                       |
| Grip Cap                   | A/U M/700        | 97971  | C-97971    | No Rev. |             |          |               |             |               |                       |
| Recoil Pad                 | A/U M/700        | 97972  | D-97973    | 26      |             |          |               |             |               |                       |
| Backer Plate               |                  | 97972  | B-97972    | No Rev. |             |          |               |             |               |                       |
| Recoil Pad Screw (2)       | A/U M/700        | 98008  | A-98008    | 7       | \$0.022     |          |               |             |               |                       |
| Magazine Latch             | Purchase         | 300362 | C-300362   | 2       | \$0.191     |          |               |             |               |                       |
| Magazine Latch Spring      | Purchase         | 300398 | B-300398   | No Rev. | \$0.026     |          |               |             |               |                       |
| Magazine Latch Pin         | Purchase & Color | 300371 | B-300371   | No Rev. | \$0.070     |          |               |             |               |                       |
| Sling Swivel Stud (2)      | Purchase         | 300096 | B-300096   | 4       |             |          |               |             |               |                       |
| Takedown Screw (2)         | Purchase         | ???    | ???        | ???     |             |          |               |             |               |                       |
| Rear Takedown Screw        | Purchase         | ???    | ???        | ???     |             |          |               |             |               |                       |
| Magazine Assembly          | Assemble         | 305395 | B-305395   | No Rev. |             |          |               |             |               |                       |
| Magazine Box               | Purchase & Color | 300363 | B-300363   | 5       | \$2.790     |          |               |             |               |                       |
| Magazine Follower          | Purchase         | 300364 | B-300364   | 1       | \$0.093     |          |               |             |               |                       |
| Magazine Bottom            | Purchase         | 300365 | B-300365   | No Rev. | \$0.105     |          |               |             |               |                       |
| Magazine Spring            | A/U M/700        | 300405 | C-300405   | No Rev. |             |          |               |             |               |                       |
| Value Added Cost of:       |                  |        |            |         |             |          |               |             |               |                       |
| Proof/Gallery/Inspect/Pack |                  |        |            |         | \$0.000     | \$ -     | \$ -          | \$ -        | \$ -          | \$ -                  |
|                            |                  |        | Total Cost |         | \$22.584    | \$ -     | \$ -          | \$ 0.17     | \$ -          | \$ -                  |

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MF0008

| Quoted Parts                      |        |              |                |                  |                |                      |                         |                       |                    |                      |
|-----------------------------------|--------|--------------|----------------|------------------|----------------|----------------------|-------------------------|-----------------------|--------------------|----------------------|
| PART DESCRIPTION                  | Part # | Print #      | Rev #          | Price/part<br>\$ | Order Qty<br>M | Eng.<br>Charge<br>\$ | Vendor<br>Capital<br>\$ | Vendor<br>Gages<br>\$ | PPI<br>Gages<br>\$ | Comments             |
| Carton Assembly                   | 1444   | 1444         | ?              |                  |                |                      |                         |                       | \$ -               |                      |
|                                   |        |              |                |                  |                |                      |                         |                       | \$ -               |                      |
|                                   |        |              |                |                  |                |                      |                         |                       | \$ -               |                      |
| Document Envelope Assembly        | ????   | ????         | ?              |                  |                |                      |                         |                       | \$ -               |                      |
| Document Envelope                 | 1649   | 1649         | ?              |                  |                |                      |                         |                       | \$ -               |                      |
| Instruction Book                  | ????   | ????         | ?              |                  |                |                      |                         |                       | \$ -               |                      |
| Product Owners Card               | 1426   | 1426         | ?              |                  |                |                      |                         |                       | \$ -               |                      |
| Remington Authorized Gunsmith     | 3413   | 3413         | ?              |                  |                |                      |                         |                       | \$ -               |                      |
| Safety Booklet                    | 3499   | 3499         | ?              |                  |                |                      |                         |                       | \$ -               |                      |
| Remington Museum Flyer            | 3475   | 3475         | ?              |                  |                |                      |                         |                       | \$ -               |                      |
| Oval Label                        | 3491   | 3491         | ?              |                  |                |                      |                         |                       | \$ -               |                      |
|                                   |        |              |                |                  |                |                      |                         |                       | \$ -               |                      |
| Box and Envelope Label (710)      | 993002 | 993002       | ?              |                  |                |                      |                         |                       | \$ -               |                      |
|                                   |        |              |                |                  |                |                      |                         |                       | \$ -               |                      |
| Barrel Assembly Complete          | 305410 | C-305410     | No Rev.        |                  |                |                      |                         |                       | \$ -               |                      |
| Barrel Assembly                   | 305400 | C-305400     | No Rev.        |                  |                |                      |                         |                       | \$ -               |                      |
| Barrel                            | 305315 | E-305315     | 5              |                  |                |                      |                         |                       | \$ -               |                      |
| Receiver                          | 300340 | E-300340     | 6              | \$               | 0              |                      |                         |                       | \$ -               | Federal Steel--Quot  |
| Receiver Insert Assembly Complete | 300401 | D-300401     | No Rev.        |                  |                |                      |                         |                       | \$ -               |                      |
| Receiver Insert Assembly          | 300400 | C-300400     | No Rev.        |                  |                |                      |                         |                       | \$ -               |                      |
| Receiver Insert                   | 300327 | E-300327-1-2 | (1E)-5 (2E)-23 |                  |                |                      |                         |                       | \$ 5,650.00        |                      |
| Threaded Insert                   | 300347 | A-300347     | A              | \$ 0.036         | 20             |                      |                         |                       | \$ 200.00          | Precision Fasteners  |
| Side Plate                        | 300333 | C-300333     | No Rev.        | \$ 0.090         | 20             |                      |                         |                       | \$ 1,500.00        | Historical Data      |
| Side Plate Pin (2)                | 300328 | A-300328     | No Rev.        | \$ 0.160         | 60             | \$ 225.00            |                         |                       | \$ -               | Iseli--Quote:        |
| Sear Safety Cam                   | 15666  | C-15666      | 24             | \$ 0.760         | 20             |                      | \$ 11,300.00            |                       | \$ 3,000.00        | Sterling Sintered T  |
| Pivot Pin (3)                     | 300351 | B-300351     | No Rev.        | \$ 0.180         | 60             | \$ 450.00            |                         |                       | \$ -               | Automatic Swiss C    |
| Sear Spring                       | 17047  | A-17047      | 26             | \$ 0.047         | 20             |                      |                         |                       | \$ -               | Midstate--Quote: 9/  |
| Trigger                           | 15280  | C-15280      | 31             | \$ 0.738         | 20             |                      | \$ 19,750.00            |                       | \$ 3,000.00        | Sterling Sintered Te |
| Trigger Connector                 | 19461  | C-19461      | 21             |                  |                |                      |                         |                       | \$ 3,000.00        |                      |
| Trigger Screw Front               | 17053  | B-17053      | 32             | \$ 0.040         | 0.10           |                      |                         |                       | \$ 300.00          | Fastenal--Quote: 8/  |
| Trigger Engagement Screw          | 91128  | B-91128      | 7              | \$ 0.043         | 0.10           |                      |                         |                       | \$ 300.00          | Fastenal--Quote:     |
| Trigger Spring                    | 15400  | A-15400      | 11             | \$ 0.076         | 20             |                      |                         |                       | \$ -               | Midstate Spring Inc  |
| Trigger Stop Screw                | 15481  | B-17053      | 32             | \$ 0.042         | 20             |                      |                         |                       | \$ 300.00          | Fastenal--Quote:     |
| Safety Arm                        | 300408 | D-300408     | 1              | \$ 0.230         | 20             |                      | \$ 25,552.00            |                       | \$ 2,400.00        | New Hampshire Sta    |
| Safety Detent Spring              | 300407 | C-300407     | 1              | \$ 0.058         | 20             |                      |                         |                       | \$ -               | Midstate Spring Inc  |
| Lock tumbler                      | ??     | ???          | ??             |                  |                |                      |                         |                       | \$ -               |                      |
| Lock Detent                       | ???    | ???          | ???            |                  |                |                      |                         |                       | \$ -               |                      |
| Safety Pivot Pin                  | 300352 | B-300352     | 1              | \$ 0.140         | 20             | \$ 225.00            |                         |                       | \$ -               | Iseli Company--Qu    |
| Snap Washer                       | 17044  | B-17044      | 26             |                  |                |                      |                         |                       | \$ 120.00          |                      |
| Bolt Stop                         | 300345 | C-300345     | 2              | \$ 0.219         | 20             |                      | \$ 6,820.00             |                       | \$ 1,500.00        | Sterling Sintered    |
|                                   | 0      | 0            | 0              |                  |                |                      |                         |                       | \$ 0               |                      |
| Receiver Plug Screws (4)          | 17034  | B-17034      | 34             |                  |                |                      |                         |                       | \$ -               |                      |
| Recoil Bracket                    | 300361 | B-300361     | No Rev.        | \$ 0.123         | 20             | \$ 550.00            |                         |                       | \$ -               | Square Stamping Q    |
| Bolt Assembly Complete            | ????   | ????         | ??             |                  |                |                      |                         |                       | \$ -               |                      |

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ME0009

Confidential - Subject - 5.22.0610009959 Order

Williams v. Remington

| Quoted Parts                |        |          |         |                  |                |                      |                         |                       |                    |                      |
|-----------------------------|--------|----------|---------|------------------|----------------|----------------------|-------------------------|-----------------------|--------------------|----------------------|
| PART DESCRIPTION            | Part # | Print #  | Rev#    | Price/part<br>\$ | Order Qty<br>M | Eng.<br>Charge<br>\$ | Vendor<br>Capital<br>\$ | Vendor<br>Gages<br>\$ | PPI<br>Gages<br>\$ | Comments             |
| Bolt Body Assembly          | 300403 | D-300403 | No Rev. |                  |                |                      |                         | \$                    | -                  |                      |
| Bolt Body                   | 300339 | D-300339 | No Rev. | \$ 2.050         | 20             |                      |                         | \$                    | -                  | Ken-Mar Tools--Q     |
|                             | 0      | 0        | 0       |                  |                |                      |                         | \$                    | -                  |                      |
|                             | 0      | 0        | 0       |                  |                |                      |                         | \$                    | -                  |                      |
| Bolt Handle                 | 300370 | C-300370 | No Rev. | \$ 1.630         | 20             |                      | \$12,575.00             | \$                    | -                  | Fansteel--Quote: 8/  |
| Bolt Handle Blank           | 300360 | C-300360 | No Rev. |                  |                |                      |                         | \$                    | 2,500.00           |                      |
| Bolt Handle Pin             | 300329 | A-300329 | 1       | \$ 0.100         | 20             | \$ 450.00            |                         | \$                    | -                  | Automatic Swiss Cor  |
|                             |        |          |         |                  |                |                      |                         | \$                    | -                  |                      |
| Bolt Head Assembly          | 305390 | B-305390 | No Rev. |                  |                |                      |                         | \$                    | -                  |                      |
| Bolt Head                   | 300338 | E-300338 | 14      |                  |                |                      |                         | \$                    | 120.00             |                      |
| Extractor                   | 93712  | C-93712  | 2       |                  |                |                      |                         | \$                    | 3,300.00           |                      |
| Ejector                     | 300342 | B-300342 | 1       | \$ 0.110         | 20             | \$ 400.00            |                         | \$                    | 3,000.00           | Iselis--Quote: 8/25  |
| Ejector Spring              | 300367 | A-300367 | No Rev. | \$ 0.015         | 20             |                      |                         | \$                    | -                  | Midstate Spring, In  |
| Ejector Pin                 | 94555  | A-94555  | 1       | \$ 0.040         | 20             |                      |                         | \$                    | -                  |                      |
| Bolt Assembly Pin           | 300330 | B-300330 | No Rev. | \$ 0.150         | 20             | \$ 450.00            |                         | \$                    | -                  | Automatic Swiss C    |
| Firing Pin Assembly         | 300404 | B-300404 | No Rev. |                  |                |                      |                         | \$                    | -                  |                      |
| Bolt Plug                   | 300368 | C-300368 | 1       | \$ 0.15          | 20             |                      | \$ 36,000.00            | \$                    | 800.00             | Kellems & Coe--Q     |
| Bolt Plug Insert            | 300346 | B-300346 | No Rev. | \$ 0.888         | 60             |                      | \$0.00                  | \$                    | 3,000.00           | Swiss Precision Ma   |
| Firing Pin                  | 300334 | C-300334 | No Rev. | \$ 1.150         | 20             | \$ 400.00            |                         | \$                    | 200.00             | Iseli--Quote: 8/16/9 |
| Firing Pin Tip              | 300335 | B-300335 | No Rev. | \$ 0.230         | 20             | \$ 225.00            |                         | \$                    | 3,300.00           | Iseli--Quote: 8/16/9 |
| Firing Pin Head             | 300336 | C-300336 | No Rev. | \$ 1.753         | 20             |                      | \$ 17,500.00            | \$                    | 1,500.00           | Megamet Industries   |
|                             |        |          |         |                  |                |                      |                         | \$                    | -                  |                      |
| Firing Pin Spring           | 300399 | A-300399 | No Rev. | \$ 0.101         | 20             |                      |                         | \$                    | -                  | Midstate Spring--Q   |
| Front Sight Assembly        | 0      | 0        | 0       |                  |                |                      |                         | \$                    | -                  |                      |
| Front Sight                 | 94084  | C-15373  | 26      |                  |                |                      |                         | \$                    | -                  |                      |
| Front Sight Ramp            | 94657  | B-28510  | 33      |                  |                |                      |                         | \$                    | 400.00             |                      |
| Front Sight Ramp Screws (2) | 28505  | B-28505  | 21      |                  |                |                      |                         | \$                    | -                  |                      |
| Rear Sight Assembly         | 103145 | B-103145 | 11      |                  |                |                      |                         | \$                    | -                  |                      |
| Elevation Screw             | 90906  | A-90906  | 19      | \$ 0.036         | 20             |                      |                         | \$                    | -                  | Fastenal--Quote:     |
| Rear Sight Aperture         | 97681  | C-93905  | 9       | \$ 0.140         | 20             |                      |                         | \$                    | -                  | Ilion Quote          |
| Rear Sight Aperture Blank   | 93906  | C-93906  | 6       |                  |                |                      |                         | \$                    | -                  |                      |
| Rear Sight Base             | 103531 | C-103530 | 3       | \$ 0.968         | 80             |                      | \$17,500.00             | \$                    | -                  | Ilion: Quote         |
| Rear Sight Slide            | 94335  | C-93904  | 7       | \$ 1.200         | 80             |                      | \$17,500.00             | \$                    | -                  | Megamet Industries   |
| Windage Screw               | 300026 | B-300026 | 5       | \$ 0.191         | 25             | \$ 400.00            |                         | \$                    | -                  | Swiss Precision Ma   |
| Rear Sight Base Screw (2)   | 28505  | B-28505  | 21      |                  |                |                      |                         | \$                    | -                  |                      |
| Stock Assembly Complete     | ???    | ???      | ??      |                  |                |                      |                         | \$                    | -                  |                      |
| Stock Assembly              | ???    | ???      | ??      |                  |                |                      |                         | \$                    | 0                  |                      |
| Stock                       | ???    | ???      | 0       | \$ 5.380         | 20             |                      | \$19,300.00             | \$                    | 4,500.00           | Par 4 Plastics, Inc. |
|                             | 0      | 0        | 0       |                  |                |                      |                         | \$                    | -                  |                      |
| Front Screw Bushing         | 15161  | B-15161  | ??      |                  |                |                      |                         | \$                    | -                  |                      |
|                             | 91915  | ???      | ???     |                  |                |                      |                         | \$                    | -                  |                      |
| Middle Screw Bushing        | ???    | ???      | ???     |                  |                |                      |                         | \$                    | -                  |                      |
| Rear Screw Bushing          | ???    | ???      | ??      |                  |                |                      |                         | \$                    | -                  |                      |

| Quoted Parts          |        |          |            |                  |                |                      |                         |                       |                    |                       |
|-----------------------|--------|----------|------------|------------------|----------------|----------------------|-------------------------|-----------------------|--------------------|-----------------------|
| PART DESCRIPTION      | Part # | Print #  | Rev#       | Price/part<br>\$ | Order Qty<br>M | Eng.<br>Charge<br>\$ | Vendor<br>Capital<br>\$ | Vendor<br>Gages<br>\$ | PPI<br>Gages<br>\$ | Comments              |
| Grip Cap              | 97971  | C-97971  | No Rev.    |                  |                |                      |                         |                       | \$ -               |                       |
| Recoil Pad            | 97973  | D-97973  |            |                  |                |                      |                         |                       | \$400.00           |                       |
| Backer Plate          | 97972  | C-97972  | No Rev.    |                  |                |                      |                         |                       | \$ -               |                       |
| Recoil Pad Screw (2)  | 98008  | A-98008  | 2          | \$ 0.022         | 20             |                      |                         |                       | \$ -               | Fastenal--Quote:      |
| Magazine Latch        | 300362 | C-300362 | 2          | \$ 0.191         | 20             |                      | \$39,000.00             |                       | \$0.00             | Kellems & Coe--Q      |
| Magazine Latch Spring | 300398 | B-300398 | No Rev.    | \$ 0.036         | 20             |                      |                         |                       | \$ -               | Industrial Spring--   |
| Magazine Latch Pin    | 300371 | B-300371 | No Rev.    | \$ 0.070         | 20             | \$ 225.00            |                         |                       | \$ -               | Iseli--Quote: 8/25/   |
|                       | 0      | 0        | 0          |                  |                |                      |                         |                       | \$ -               |                       |
| Sling Swivel Stud (2) | 300096 | B-300096 | 4          |                  |                |                      |                         |                       | \$ -               |                       |
| Takedown Screw (2)    | ????   | ????     | ???        |                  |                |                      |                         |                       | \$200.00           |                       |
| Rear Takedown Screw   | ????   | ????     | ???        |                  |                |                      |                         |                       | \$200.00           |                       |
| Magazine Assembly     | 305395 | B-305395 | No Rev.    |                  |                |                      |                         |                       | \$ -               |                       |
| Magazine Box          | 300363 | B-300363 | 5          | \$ 2,790         | 20             |                      |                         |                       | \$ 4,500.00        | Historical Data Use   |
| Magazine Follower     | 300364 | B-300364 | 1          | \$ 0.093         | 20             |                      | \$ 78,786.00            |                       | \$ 3,000.00        | Par 4 Plastics, Inc.- |
| Magazine Bottom       | 300365 | B-300365 | No Rev.    | \$ 0.105         | 20             |                      | \$ -                    |                       | \$ -               | Par 4 Plastics, Inc.- |
| Magazine Spring       | 300405 | C-300405 | No Rev.    |                  |                |                      |                         |                       | \$ 3,000.00        |                       |
|                       |        |          |            |                  |                |                      |                         |                       |                    |                       |
|                       |        |          |            |                  |                |                      |                         |                       |                    |                       |
|                       |        |          | Total Cost | \$ 22.58         | 1045.20        | \$ 4,000.00          | \$ 432,583.00           | \$ -                  | \$ 55,190.00       |                       |

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| In House Processing           |        |              |                |                |                |                         |                         |               |                            |          |
|-------------------------------|--------|--------------|----------------|----------------|----------------|-------------------------|-------------------------|---------------|----------------------------|----------|
| PART DESCRIPTION              | Part # | Print #      | Rev.           | Material<br>\$ | Labor<br>(hrs) | Variable<br>Tools<br>\$ | Pre-Op<br>Startup<br>\$ | Capital<br>\$ | Material<br>Handling<br>\$ | Comments |
| Carton Assembly               | ????   | ????         | 0              |                |                |                         |                         |               |                            |          |
| Document Envelope Assembly    | ????   | ????         | 0              |                |                |                         |                         |               |                            |          |
| Document Envelope             | 1426   | 1426         | 0              |                |                |                         |                         |               |                            |          |
| Instruction Book              | 3413   | 3413         | 0              |                |                |                         |                         |               |                            |          |
| Product Owners Card           | 3499   | 3499         | 0              |                |                |                         |                         |               |                            |          |
| Remington Authorized Gunsmi   | 3475   | 3475         | 0              |                |                |                         |                         |               |                            |          |
| Safety Booklet                | 3491   | 3491         | 0              |                |                |                         |                         |               |                            |          |
| Remington Museum Flyer        | 0      | 0            | 0              |                |                |                         |                         |               |                            |          |
| Oval Label                    | 993002 | 993002       | 0              |                |                |                         |                         |               |                            |          |
| Box and Envelope Label (710)  | 305410 | C-305410     | No Rev.        |                |                |                         |                         |               |                            |          |
|                               | 305400 | C-305400     | No Rev.        |                |                |                         |                         |               |                            |          |
| Barrel Assembly Complete      | 305315 | E-305315     | 5              |                |                |                         |                         |               |                            |          |
| Barrel Assembly               | 300340 | E-300340     | 6              |                |                |                         |                         |               |                            |          |
| Barrel                        | 300401 | D-300401     | No Rev.        |                |                |                         |                         |               |                            |          |
| Receiver                      | 300400 | C-300400     | No Rev.        |                |                |                         | \$ -                    | \$ 563,556.90 |                            |          |
| Receiver Insert Assembly Comp | 300327 | E-300327-1-2 | (1E)-5 (2E)-23 |                |                |                         |                         |               |                            |          |
| Receiver Insert Assembly      | 300347 | A-300347     | A              |                |                |                         |                         |               |                            |          |
| Receiver Insert               | 300333 | C-300333     | No Rev.        |                |                |                         |                         |               |                            |          |
| Threaded Insert               | 300328 | A-300328     | No Rev.        |                |                |                         |                         |               |                            |          |
| Side Plate                    | 15666  | C-15666      | 24             |                |                |                         |                         |               |                            |          |
| Side Plate Pin (2)            | 300351 | B-300351     | No Rev.        |                |                |                         |                         |               |                            |          |
| Sear Safety Cam               | 17047  | A-17047      | 26             |                |                |                         |                         |               |                            |          |
| Pivot Pin (3)                 | 15280  | C-15280      | 31             |                |                |                         |                         |               |                            |          |
| Sear Spring                   | 19461  | C-19461      | 21             |                |                |                         |                         |               |                            |          |
| Trigger                       | 17053  | B-17053      | 32             |                |                |                         |                         |               |                            |          |
| Trigger Connector             | 91128  | B-91128      | 7              |                |                |                         |                         |               |                            |          |
| Trigger Screw Front           | 15400  | A-15400      | 11             |                |                |                         |                         |               |                            |          |
| Trigger Engagement Screw      | 15481  | B-17053      | 32             |                |                |                         |                         |               |                            |          |
| Trigger Spring                | 300408 | D-300408     | 1              |                |                |                         |                         |               |                            |          |
| Trigger Stop Screw            | 300407 | C-300407     | 1              |                |                |                         |                         |               |                            |          |
| Safety Arm                    | ??     | ???          | ??             |                |                |                         |                         |               |                            |          |
| Safety Detent Spring          | ???    | ???          | ???            |                |                |                         |                         |               |                            |          |
| Lock tumbler                  | 300352 | B-300352     | 1              |                |                |                         |                         |               |                            |          |
| Lock Detent                   | 17044  | B-17044      | 26             |                |                |                         |                         |               |                            |          |
| Safety Pivot Pin              | 300345 | C-300345     | 2              |                |                |                         |                         |               |                            |          |
| Snap Washer                   | 0      | 0            | 0              |                |                |                         |                         |               |                            |          |
| Bolt Stop                     | 17034  | B-17034      | 34             |                |                |                         |                         |               |                            |          |
|                               | 300361 | B-300361     | No Rev.        |                |                |                         |                         |               |                            |          |
| Receiver Plug Screws (4)      | ???    | ???          | ??             |                |                |                         |                         |               |                            |          |
| Recoil Bracket                | 300403 | D-300403     | No Rev.        |                |                |                         |                         |               |                            |          |

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MF0012

Confidential - Subject - 5.22.0610009962 Order

Williams v. Remington

| In House Processing         |          |          |         |             |             |                   |                   |             |                      |          |
|-----------------------------|----------|----------|---------|-------------|-------------|-------------------|-------------------|-------------|----------------------|----------|
| PART DESCRIPTION            | Part #   | Print #  | Rev #   | Material \$ | Labor (hrs) | Variable Tools \$ | Pre-Op Startup \$ | Capital \$  | Material Handling \$ | Comments |
| Bolt Assembly Complete      | 300339   | D-300339 | 0       |             |             |                   |                   |             |                      |          |
| Bolt Body Assembly          | 0        | 0        | 0       |             |             |                   |                   |             |                      |          |
| Bolt Body                   | 0        | 0        |         |             |             | \$ 79.95          | \$ 5,403.50       | \$ 4,500.00 |                      |          |
|                             | 300370   | C-300370 | No Rev. |             |             |                   |                   |             |                      |          |
|                             | 300360   | C-300360 | No Rev. |             |             |                   |                   |             |                      |          |
| Bolt Handle                 | 300329   | A-300329 |         |             |             |                   |                   |             |                      |          |
| Bolt Handle Blank           | 0        | 0        |         |             |             |                   |                   |             |                      |          |
| Bolt Handle Pin             | 305390   | B-305390 | No Rev. |             |             |                   |                   |             |                      |          |
| Bolt Head Assembly          | 93712    | C-93712  | 2       |             |             |                   |                   |             |                      |          |
| Bolt Head                   | 300342   | B-300342 | 1       |             |             |                   |                   |             |                      |          |
| Extractor                   | 300367   | A-300367 | No Rev. |             |             |                   |                   |             |                      |          |
| Ejector                     | 94555    | A-94555  | 1       |             |             |                   |                   |             |                      |          |
| Ejector Spring              | 300330   | B-300330 | No Rev. |             |             |                   |                   |             |                      |          |
| Ejector Pin                 | 300404   | B-300404 | No Rev. |             |             |                   |                   |             |                      |          |
| Bolt Assembly Pin           | 300368   | C-300368 | 1       |             |             |                   |                   |             |                      |          |
| Firing Pin Assembly         | 300346   | B-300346 | No Rev. |             |             |                   |                   |             |                      |          |
| Bolt Plug                   | 300334   | C-300334 | No Rev. |             |             |                   |                   |             |                      |          |
| Bolt Plug Insert            | 300335   | B-300335 | No Rev. |             |             |                   |                   |             |                      |          |
| Firing Pin                  | 300336   | C-300336 | No Rev. |             |             |                   |                   |             |                      |          |
| Firing Pin Tip              | B-300335 | No Rev.  | 0       |             |             |                   |                   |             |                      |          |
| Firing Pin Head             | 300399   | A-300399 | No Rev. |             |             |                   |                   |             |                      |          |
|                             | 0        | 0        | 0       |             |             |                   |                   |             |                      |          |
| Firing Pin Spring           | 94084    | C-15373  | 26      |             |             |                   |                   |             |                      |          |
| Front Sight Assembly        | 94657    | B-28510  | 33      |             |             |                   |                   |             |                      |          |
| Front Sight                 | 28505    | B-28505  | 21      |             |             |                   |                   |             |                      |          |
| Front Sight Ramp            | 103145   | B-103145 | 11      |             |             |                   |                   |             |                      |          |
| Front Sight Ramp Screws (2) | 90906    | A-90906  | 19      |             |             |                   |                   |             |                      |          |
| Rear Sight Assembly         | 97681    | C-93905  | 9       |             |             |                   |                   |             |                      |          |
| Elevation Screw             | 93906    | C-93906  | 6       |             |             |                   |                   |             |                      |          |
| Rear Sight Aperture         | 103531   | C-103530 | 3       |             |             |                   |                   |             |                      |          |
| Rear Sight Aperture         | 94335    | C-93904  | 7       |             |             |                   |                   |             |                      |          |
| Rear Sight Base             | 300026   | B-300026 | 5       |             |             |                   |                   |             |                      |          |
| Rear Sight Slide            | 28505    | B-28505  | 21      |             |             |                   |                   |             |                      |          |
| Windage Screw               | ???      | ???      | ??      |             |             |                   |                   |             |                      |          |
| Rear Sight Base Screw (2)   | ???      | ???      | ??      |             |             |                   |                   |             |                      |          |
| Stock Assembly Complete     | ???      | ???      | 0       |             |             |                   |                   |             |                      |          |
| Stock Assembly              | 0        | 0        | 0       |             |             |                   |                   |             |                      |          |
| Stock                       | 15161    | B-15161  | ??      |             |             |                   |                   |             |                      |          |
|                             | 91915    | ???      | ???     |             |             |                   |                   |             |                      |          |
| Front Screw Bushing         | ???      | ???      | ???     |             |             |                   |                   |             |                      |          |
|                             | ???      | ???      | ??      |             |             |                   |                   |             |                      |          |
| Middle Screw Bushing        | 97971    | C-97971  | No Rev. |             |             |                   |                   |             |                      |          |

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MF0013

Confidential - Subject - 5.22.0610009963 - Order

Williams v. Remington

[illegible]

ME0014

**Golemboski, Matt R.**

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**From:** Chamblee, Danny  
**Sent:** Saturday, August 28, 1999 10:53 AM  
**To:** Golemboski, Matt R.; Zajk, Joseph J  
**Subject:** M710 estimate rev4.xls

Only a few points

- 1) Capital installation costs added \$60,000 to model
- 2) Capital included 2nd cavity on receiver insert. What is piece price impact
- 3) Press from Ilion what is depreciation
- 4) Detail of 1999 and 2000 start up costs

Thanks  
Danny



M710 estimate rev4.xls

CONFIDENTIAL

NEED TO ADD TO TIME:

*NOT ON ORIGINAL ESTIMATE*

|                          |            |
|--------------------------|------------|
| trigger grind- 21 sec.   | 0.00583333 |
| stamp F + S - 7 sec.     | 0.00194444 |
| orbital rivet- 28 sec.   | 0.00777777 |
| assemble safety- 53 sec. | 0.01472222 |

CONFIDENTIAL

MF0016

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/05/99

C:\windows\TEMP\m710 estimate rev4.xls\m710 est Mayfield run times

| PART DESCRIPTION                  | Part #  | M/710 Estimate 8/30/99 |                      |             |                  |                |                  | Total   |
|-----------------------------------|---------|------------------------|----------------------|-------------|------------------|----------------|------------------|---------|
|                                   |         | Material<br>\$         | Run Rate<br>(hrs/pc) | Labor<br>\$ | Fixed<br>O.H. \$ | Var<br>O.H. \$ | Total<br>O.H. \$ |         |
| Document Envelope Assembly        | 1721    | \$ 0.09                |                      | \$ -        | \$ -             | \$ -           | \$ -             | \$ 0.09 |
| Document Envelope                 | 1649    | 0.08                   |                      | -           | -                | -              | -                | 0.08    |
| Users manual                      | 3391    | 0.15                   |                      | -           | -                | -              | -                | 0.15    |
| Product Owners Card               | 1426    | 0.03                   |                      | -           | -                | -              | -                | 0.03    |
| Remington Authorized Gunsmith     | 3413    | 0.07                   |                      | -           | -                | -              | -                | 0.07    |
| Safety Booklet                    | 3499    | 0.10                   |                      | -           | -                | -              | -                | 0.10    |
| Oval Label                        | 3491    | 0.01                   |                      | -           | -                | -              | -                | 0.01    |
| Carton Assembly                   | 1444    | 2.05                   |                      | -           | -                | -              | -                | 2.05    |
| Box and Envelope Label (710)      | 993002  | 0.04                   |                      | -           | -                | -              | -                | 0.04    |
| Shelf Talker                      |         | 0.14                   |                      | -           | -                | -              | -                | 0.14    |
| Barrel Assembly Complete          | 305410  |                        | 0.0790               | 0.71        | 1.27             | 2.27           | 3.55             | 4.25    |
| Barrel Assembly                   | 3305400 |                        |                      | -           | -                | -              | -                | -       |
| Barrel                            | 305315  | 4.80                   | 0.3866               | 4.09        | 7.37             | 13.14          | 20.51            | 29.40   |
| Receiver                          | 300340  | 1.76                   | 0.0055               | 0.06        | 0.10             | 0.19           | 0.29             | 2.11    |
| Receiver Insert Assembly Complete | ????    |                        | 0.0530               | 0.47        | 0.85             | 1.52           | 2.38             | 2.85    |
| Receiver Insert Assembly          | ????    |                        | 0.0050               | 0.04        | 0.08             | 0.14           | 0.22             | 0.27    |
| Receiver Insert                   | 300327  | 0.62                   |                      | -           | -                | -              | -                | 0.62    |
| Threaded Insert                   | 300347  | 0.04                   |                      | -           | -                | -              | -                | 0.04    |
| Side Plate                        | 300333  | 0.09                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.15    |
| Side Plate Pin (2)                | 300328  | 0.12                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.18    |
| Sear Safety Cam                   | 15666   | 0.94                   |                      | -           | -                | -              | -                | 0.94    |
| Pivot Pin (3)                     | 300351  | 0.18                   |                      | -           | -                | -              | -                | 0.18    |
| Sear Spring                       | 17047   | 0.02                   |                      | -           | -                | -              | -                | 0.02    |
| Trigger                           | 15280   | 1.53                   |                      | -           | -                | -              | -                | 1.53    |
| Trigger Connector                 | 19461   | 1.03                   |                      | -           | -                | -              | -                | 1.03    |
| Trigger Screw Front               | 17053   | 0.10                   |                      | -           | -                | -              | -                | 0.10    |
| Trigger Engagement Screw          | 91128   | 0.03                   |                      | -           | -                | -              | -                | 0.03    |
| Trigger Spring                    | 15400   | 0.03                   |                      | -           | -                | -              | -                | 0.03    |
| Trigger Stop Screw                | 15481   | 0.06                   |                      | -           | -                | -              | -                | 0.06    |
| Safety                            | 300408  | 0.31                   |                      | -           | -                | -              | -                | 0.31    |
| Safety Pivot Pin                  | 300352  | 0.06                   |                      | -           | -                | -              | -                | 0.06    |
| Safety Spring                     | 300343  | 0.05                   |                      | -           | -                | -              | -                | 0.05    |
| Bolt Stop                         | 300345  | 0.19                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.25    |
| Receiver Plug Screws (4)          | 17034   | 0.12                   |                      | -           | -                | -              | -                | 0.12    |
| Recoil Bracket                    | 300361  | 0.19                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.25    |
| Bolt Assembly Complete            | ????    |                        |                      | -           | -                | -              | -                | -       |
| Bolt Body Assembly                | ????    |                        | 0.0275               | 0.29        | 0.53             | 0.94           | 1.46             | 1.75    |
| Bolt Body                         | 300339  | 0.74                   | 0.0032               | 0.03        | 0.06             | 0.11           | 0.17             | 0.94    |
| Bolt Handle                       | 300370  |                        | 0.0120               | 0.13        | 0.23             | 0.41           | 0.64             | 0.76    |
| Bolt Handle Blank                 | 300360  | 1.63                   |                      | -           | -                | -              | -                | 1.63    |
| Bolt Handle Pin                   | 300329  | 0.06                   |                      | -           | -                | -              | -                | 0.06    |
| Bolt Head Assembly                | 305390  |                        | 0.0580               | 0.52        | 0.94             | 1.67           | 2.60             | 3.12    |
| Bolt Head                         | 300338  | 1.75                   | 0.0809               | 0.86        | 1.54             | 2.75           | 4.29             | 6.90    |
| Extractor                         | 93712   | 0.77                   |                      | -           | -                | -              | -                | 0.77    |
| Ejector                           | 300342  | 0.16                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.22    |
| Ejector Spring                    | ????    | 0.03                   |                      | -           | -                | -              | -                | 0.03    |
| Ejector Pin                       | 94555   | 0.01                   |                      | -           | -                | -              | -                | 0.01    |

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MF0017

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/05/99

C:\windows\TEMP\M710 estimate rev4.xls\m710 est Mayfield run times

|                             |        | M/710 Estimate 8/30/99 |                      |             |                  |                |                  |          |
|-----------------------------|--------|------------------------|----------------------|-------------|------------------|----------------|------------------|----------|
| PART DESCRIPTION            | Part # | Material<br>\$         | Run Rate<br>(hrs/pc) | Labor<br>\$ | Fixed<br>O.H. \$ | Var<br>O.H. \$ | Total<br>O.H. \$ | Total    |
| Bolt Assembly Pin           | 300330 | 0.10                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.16     |
| Firing Pin Assembly         | ????   |                        | 0.0070               | 0.06        | 0.11             | 0.20           | 0.31             | 0.38     |
| Bolt Plug                   | 300368 | 0.25                   |                      | -           | -                | -              | -                | 0.25     |
| Bolt Plug Insert            | 300346 | 0.29                   |                      | -           | -                | -              | -                | 0.29     |
| Firing Pin                  | 300334 | 0.27                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.33     |
| Firing Pin Tip              | 300335 | 1.60                   | 0.0015               | 0.02        | 0.03             | 0.05           | 0.08             | 1.70     |
| Firing Pin Head             | 300336 | 1.50                   | 0.0020               | 0.02        | 0.04             | 0.07           | 0.11             | 1.63     |
| Firing Pin Spring           | ????   | 0.14                   |                      | -           | -                | -              | -                | 0.14     |
| Front Sight                 | 94084  | 0.82                   |                      | -           | -                | -              | -                | 0.82     |
| Front Sight Ramp            | 94657  | 1.13                   | 0.0020               | 0.02        | 0.04             | 0.07           | 0.11             | 1.26     |
| Front Sight Ramp Screws (2) | 28505  | 0.09                   |                      | -           | -                | -              | -                | 0.09     |
| Rear Sight Assembly         | 103146 |                        |                      | -           | -                | -              | -                | -        |
| Elevation Screw             | 90906  | 0.02                   |                      | -           | -                | -              | -                | 0.02     |
| Rear Sight Aperture         | 94333  | 0.14                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.20     |
| Rear Sight Base             | 103531 | 0.97                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 1.03     |
| Rear Sight Slide            | 94335  | 0.47                   | 0.0050               | 0.05        | 0.10             | 0.17           | 0.27             | 0.79     |
| Windage Screw               | 90904  | 0.02                   |                      | -           | -                | -              | -                | 0.02     |
| Rear Sight Base Screw (2)   | 28505  | 0.09                   |                      | -           | -                | -              | -                | 0.09     |
| Stock Assembly Complete     | ????   |                        | 0.0160               | \$ 0.14     | 0.26             | 0.46           | 0.72             | 0.86     |
| Stock Assembly              | ????   |                        |                      | -           | -                | -              | -                | -        |
| Stock                       | ????   | 5.38                   |                      | -           | -                | -              | -                | 5.38     |
| Front Screw Bushing         | 15161  | 0.13                   |                      | -           | -                | -              | -                | 0.13     |
| Middle Screw Bushing        | ????   | 0.05                   |                      | -           | -                | -              | -                | 0.05     |
| Rear Screw Bushing          | ????   | 0.05                   |                      | -           | -                | -              | -                | 0.05     |
| Grip Cap                    | 97971  | 0.18                   |                      | -           | -                | -              | -                | 0.18     |
| Recoil Pad                  | 97973  | 1.63                   |                      | -           | -                | -              | -                | 1.63     |
| Recoil Pad Screw (2)        | 98008  | 0.05                   |                      | -           | -                | -              | -                | 0.05     |
| Magazine Latch              | 300362 | 0.25                   |                      | -           | -                | -              | -                | 0.25     |
| Magazine Latch Spring       | ????   | 0.02                   |                      | -           | -                | -              | -                | 0.02     |
| Magazine Latch Pin          | 300371 | 0.04                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.10     |
| Sling Swivel Stud (2)       | 300096 | 0.14                   |                      | -           | -                | -              | -                | 0.14     |
| Takedown Screw (2)          | ????   | 0.16                   |                      | -           | -                | -              | -                | 0.16     |
| Rear Takedown Screw         | ????   | 0.08                   |                      | -           | -                | -              | -                | 0.08     |
| Magazine Assembly           | ????   |                        | 0.0083               | 0.07        | 0.13             | 0.24           | 0.37             | 0.45     |
| Magazine Box                | 300363 | 2.79                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.04             | 2.84     |
| Magazine Follower           | 300364 | 0.26                   |                      | -           | -                | -              | -                | 0.26     |
| Magazine Bottom             | 300365 | 0.26                   |                      | -           | -                | -              | -                | 0.26     |
| Magazine Spring             | 17028  | 0.42                   |                      | -           | -                | -              | -                | 0.42     |
| Freight on Parts            |        | 0.25                   |                      |             |                  |                |                  | 0.25     |
| Value Added Cost of:        |        |                        |                      |             |                  |                |                  |          |
| Proof/Gallery/Inspect/Pack  |        | 1.15                   | 0.1500               | 1.34        | 2.42             | 4.31           | 6.73             | 9.22     |
| Total Cost                  |        | \$ 41.38               | 0.9136               | \$ 9.05     | \$ 16.31         | \$ 29.07       | \$ 45.38         | \$ 95.81 |

**Golemboski, Matt R.**

---

**From:** Chamblee, Danny  
**Sent:** Thursday, September 30, 1999 4:33 PM  
**To:** Bristol, II Ronald H.  
**Cc:** Golemboski, Matt R.  
**Subject:** M710 estimate rev5

Ron,

Attached is latest version of 710 costs at different plant production levels. The incremental costing includes changes to 597 overhead allocation based on plant overhead rate changes.

Please let me know if you have any questions.

Thanks,  
Danny



M710 estimate rev5.xls

CONFIDENTIAL 83

Remington Arms Company  
710 Production Model  
Mayfield Plant

05-Oct-99

|                                           | 69,000 597s<br>0 710s | 51,300 597s<br>20,000 710s | 58,400 597s<br>20,000 710s | 58,400 597s<br>30,000 710s |
|-------------------------------------------|-----------------------|----------------------------|----------------------------|----------------------------|
| Total Units Produced to the Warehouse     | 69,000                | 71,300                     | 78,400                     | 88,400                     |
| Total Standard Hours Earned               | 71,162                | 71,359                     | 78,682                     | 87,907                     |
| Sales Value of Units Warehoused           | \$ 10,065,381         | \$ 11,883,392              | \$ 12,919,105              | \$ 15,119,105              |
| <b>Standard Cost of Goods Warehoused</b>  |                       |                            |                            |                            |
| Direct Material Costs                     | 3,703,154             | 3,614,297                  | 3,995,346                  | 4,425,888                  |
| Direct Labor Costs                        | 697,358               | 701,387                    | 773,144                    | 864,602                    |
| Variable Overhead Costs                   | 2,182,089             | 2,273,570                  | 2,360,250                  | 2,515,661                  |
| Fixed Overhead Costs                      | 948,241               | 1,251,438                  | 1,278,173                  | 1,321,347                  |
| Total Overhead                            | 3,130,330             | 3,525,008                  | 3,638,423                  | 3,837,008                  |
| Total Standard Cost of Production         | 7,530,842             | 7,840,693                  | 8,406,914                  | 9,127,498                  |
| Standard Cost of Production per Gun       | 109.14                | 109.97                     | 107.23                     | 103.25                     |
| Standard Mfg. Contribution Margin         | \$ 2,534,539          | \$ 4,042,699               | \$ 4,512,191               | \$ 5,991,607               |
| Standard Mfg. Contribution Margin per Gun | \$ 36.73              | \$ 56.70                   | \$ 57.55                   | \$ 67.78                   |
|                                           | 25.2%                 | 34.0%                      | 34.9%                      | 39.6%                      |

**710 Costing on Mayfield Plant Overhead Rate**

|          |     |          |          |          |
|----------|-----|----------|----------|----------|
| Material | N/A | \$ 43.05 | \$ 43.05 | \$ 43.05 |
| Labor    | N/A | 9.15     | 9.15     | 9.15     |
| Overhead | N/A | 45.96    | 43.04    | 40.59    |
| Total    | N/A | \$ 98.16 | \$ 95.24 | \$ 92.79 |

**710 Incremental Costs**

|                                                                         |     |          |          |          |
|-------------------------------------------------------------------------|-----|----------|----------|----------|
| Material                                                                | N/A | \$ 43.05 | \$ 43.05 | \$ 43.05 |
| Labor                                                                   | N/A | 9.15     | 9.15     | 9.15     |
| 710 Incremental Overhead                                                | N/A | 32.94    | 32.94    | 28.58    |
| 597 Overhead Increase/(Decrease) due to<br>Changes in production Levels | N/A | 13.92    | 6.41     | (1.00)   |
| Total                                                                   | N/A | \$ 99.06 | \$ 91.54 | \$ 79.77 |

**710 Overhead Per Gun**

|                                     |     |         |         |         |
|-------------------------------------|-----|---------|---------|---------|
| Incremental Overhead related to 710 | N/A | 658,724 | 658,724 | 857,308 |
| Per 710 Units                       | N/A | 32.94   | 32.94   | 28.58   |

MF0020

|                                   | Items                          |              | Total Capital | Vendor                      | Nov     | Dec    | Jan      | Feb    | Mar     | Apr     | May    | Jun | July | Aug |
|-----------------------------------|--------------------------------|--------------|---------------|-----------------------------|---------|--------|----------|--------|---------|---------|--------|-----|------|-----|
| Carton Assembly                   |                                | 1444         |               |                             |         |        |          |        |         |         |        |     |      |     |
|                                   | Carton Dies                    | 0            |               |                             |         |        | 0        |        | 0       | 0       |        |     |      |     |
|                                   | Insert Dies                    | 0            | \$19,000      |                             |         |        | 6,333    |        | 6,333   | 6,333   |        |     |      |     |
| Box and Envelope Label (710)      |                                | 993002       |               |                             |         |        |          |        |         |         |        |     |      |     |
|                                   |                                | 0            |               |                             |         |        |          |        |         |         |        |     |      |     |
| Barrel Assembly Complete          |                                | 305410       |               |                             |         |        |          |        |         |         |        |     |      |     |
| Barrel Assembly                   |                                | 305400       | \$0           |                             |         |        |          |        |         |         |        |     |      |     |
| Barrel                            | Machine & gages                | 305315       |               |                             |         |        |          |        |         |         |        |     |      |     |
|                                   | Cut to length                  |              |               |                             |         |        |          |        |         |         |        |     |      |     |
|                                   | Gundrill Bore                  |              |               |                             |         |        |          |        |         |         |        |     |      |     |
|                                   | Ream Bore                      | hyd pump     |               |                             | 6,080   |        |          |        |         |         |        |     |      |     |
|                                   | Rifle Bore                     |              | \$15,000      |                             | 7,950   |        | 7,950    |        |         |         |        |     |      |     |
|                                   | Stress Relieve                 | baskets      | \$7,000       |                             |         | 7,000  |          |        |         |         |        |     |      |     |
|                                   | Turn OD                        | gages        | \$5,000       |                             |         | 5,000  |          |        |         |         |        |     |      |     |
|                                   | Face and Chamber               | gages        | \$31,000      |                             |         | 15,000 | 14,000   | 2,000  |         |         |        |     |      |     |
|                                   | Face and Chamber               | machine      | \$189,448     |                             | 63,149  |        |          |        | 63,149  |         | 63,149 |     |      |     |
|                                   | Cut off and crown Muzzle       | chuck head   | \$15,000      |                             |         |        |          | 15,000 |         |         |        |     |      |     |
|                                   | Drill and Tap Holes, Mill Slot | fixture&gage | \$7,600       |                             |         |        | 7,600    |        |         |         |        |     |      |     |
|                                   | Wash                           | 0            | \$0           |                             |         |        |          |        |         |         |        |     |      |     |
|                                   | Heat Treat                     |              | 175,000       |                             |         | 58,333 |          | 58,333 | 58,333  |         |        |     |      |     |
|                                   | Acid Wash                      | 0            | 0             |                             |         |        |          |        |         |         |        |     |      |     |
|                                   | Centerless Polish              | 0            | 0             |                             |         |        |          |        |         |         |        |     |      |     |
|                                   | Eddy Current Test              |              | 104,500       |                             |         | 34,833 |          | 34,833 | 34,833  |         |        |     |      |     |
|                                   | Press Barrel to Receiver       |              | 11,000        |                             | 11,000  |        |          |        |         |         |        |     |      |     |
|                                   | Rollmark                       |              | 6,300         |                             |         | 6,300  |          |        |         |         |        |     |      |     |
|                                   | Angularity Straighten          |              | 3,500         |                             |         | 3,500  |          |        |         |         |        |     |      |     |
|                                   | Centerless Polish              |              | 0             |                             |         |        |          |        |         |         |        |     |      |     |
|                                   | Glass Bead Blast               |              | 2,500         |                             |         | 2,500  |          |        |         |         |        |     |      |     |
|                                   | Black Oxide                    |              | 6,000         |                             |         | 16,000 |          |        |         |         |        |     |      |     |
| Receiver                          | LT15                           | 300340       | \$507,201     | Federal Steel--Quote        | 169,067 |        |          |        | 169,067 | 169,067 |        |     |      |     |
|                                   | CMM                            |              | \$0           |                             |         |        |          |        |         |         |        |     |      |     |
|                                   | CMM Gage                       |              |               |                             |         |        |          |        |         |         |        |     |      |     |
|                                   | Vibratory Deburr               |              |               |                             |         |        |          |        |         |         |        |     |      |     |
| Receiver Insert Assembly Complete | Comparator and fixture         | 300401       | \$12,000      | 0                           |         | 2,000  | 2,000    | 8,000  |         |         |        |     |      |     |
| Receiver Insert Assembly          | ultrasonic weld fixture        | 300400       | \$4,000       | 0                           |         |        | 4,000    |        |         |         |        |     |      |     |
| Receiver Insert                   | Hanson Mold                    | 300327       | \$48,000      | 0                           |         |        | \$48,000 |        |         |         |        |     |      |     |
|                                   | PPI Fixture                    |              | \$2,500       |                             |         |        | 2,500    |        |         |         |        |     |      |     |
| Side Plate                        | Stamping Die                   | 300333       | \$13,000      | Historical Data             |         |        | 4,333    |        | 4,333   | 4,333   |        |     |      |     |
|                                   | PPI Fixture                    |              | \$1,500       |                             |         |        |          |        | 1,500   |         |        |     |      |     |
| Sear Safety Cam                   | PPI Fixture                    | 15666        | \$0           | Requ's Stamp Die Aug 11, 99 |         |        |          |        |         |         |        |     |      |     |
|                                   | PPI Fixture                    |              | \$ 3,000.00   |                             |         |        | 1,500    |        |         | 1,500   |        |     |      |     |
| Trigger                           | PM Mold                        | 15280        | \$15,225      | Requ's Stamp Die Aug 11, 99 |         |        | 7,613    |        |         | 7,613   |        |     |      |     |
|                                   | PPI Fixture                    |              | \$ 3,000.00   |                             |         |        | 1,500    |        | 1,500   |         |        |     |      |     |
| Trigger Connector                 | PPI Fixture                    | 19461        | \$ 3,000.00   | 0                           |         |        | 1,500    |        | 1,500   |         |        |     |      |     |
| Safety Arm                        | Stamping Die                   | 300408       | \$25,552      | Requ's Stamp Die Aug 11, 99 |         |        | 12,776   |        |         | 12,776  |        |     |      |     |
|                                   | PPI Fixture                    |              | \$2,400       |                             |         |        | 2,400    |        |         |         |        |     |      |     |
| Lock tumbler                      | MJM Mold                       | ??           | \$35,000      | 0                           |         | 17,500 |          |        | 17,500  |         |        |     |      |     |
| Safety Snap Washer                | Stamping Die                   | 17044        | \$0           | Ilion Quote SAP             |         |        |          |        |         |         |        |     |      |     |
|                                   | PPI Fixture                    |              | \$2,400       |                             |         |        | 1,200    |        | 1,200   |         |        |     |      |     |
| Bolt Stop                         | PM Die                         | 300345       | \$6,820       | Requ's Stamp Die Aug 11, 99 |         |        | 6,820    |        |         |         |        |     |      |     |
|                                   | PPI Fixture                    | 0            | \$1,500       | 0                           |         |        |          |        | 1,500   |         |        |     |      |     |
| Recoil Bracket                    | Stamping Die                   | 300361       | \$0           | Requ's Stamp Die Aug 11, 99 |         |        |          |        |         |         |        |     |      |     |
| Bolt Assembly Complete            |                                | ???          | \$0           | 0                           |         |        |          |        |         |         |        |     |      |     |
| Bolt Body Assembly                | Brazing Machine                | 300403       | \$98,000      | 0                           |         | 32,667 |          | 32,667 | 32,667  |         |        |     |      |     |
|                                   | Deplate Tanks                  |              | \$9,500       |                             |         |        |          | 8,000  |         |         |        |     |      |     |

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MF0021

Confidential - SHARPER - 522P606009971e Order

Williams v. Remington

|                           | Items                       |        | Total Capital | Vendor                               | Nov     | Dec     | Jan     | Feb     | Mar     | Apr     | May    | Jun | July | Aug |
|---------------------------|-----------------------------|--------|---------------|--------------------------------------|---------|---------|---------|---------|---------|---------|--------|-----|------|-----|
|                           | glass head blast            |        | \$2,500       |                                      |         |         |         | 2,500   |         |         |        |     |      |     |
| Bolt Body                 | Gages at Machining          | 300339 | \$4,500       |                                      |         |         | 1,500   |         | 3,500   |         |        |     |      |     |
| Bolt Handle               | Machining Fixtures & Gage   | 300370 | \$12,500      |                                      |         | 6,000   | 6,000   |         |         |         |        |     |      |     |
| Bolt Handle Blank         | Investment Cast Mold        | 300360 | \$12,475      | 0                                    | 6,288   |         |         | 6,288   |         |         |        |     |      |     |
|                           | PPI Fixture                 | 0      | \$2,500       |                                      |         | 1,200   | 1,300   |         |         |         |        |     |      |     |
| Bolt Head Assembly        | Assy Fixture                | 305390 | \$4,100       | 0                                    |         |         | 4,100   |         |         |         |        |     |      |     |
| Bolt Head                 | Edgetek Grind               | 43800  | \$43,800      |                                      |         | 21,900  |         | 21,900  |         | 10,950  |        |     |      |     |
|                           | Machining Fixtures          | 174800 | \$174,800     |                                      | 69,920  |         |         | 104,880 |         |         |        |     |      |     |
|                           | Machine Ejector Retaining   |        | \$15,000      |                                      |         | 7,500   |         | 7,500   |         |         |        |     |      |     |
|                           | Machine Retaining Pin Hole  |        | \$15,000      |                                      |         | 7,500   |         | 7,500   |         |         |        |     |      |     |
|                           | Punch Form Ejector          |        | \$10,000      |                                      |         | 5,000   |         | 5,000   |         |         |        |     |      |     |
| Extractor                 | PPI Fixture                 | 93712  | \$3,800       | Ilion Quote SAP                      |         |         |         | 3,300   |         |         |        |     |      |     |
| Firing Pin Assembly       | Assy Fixture                | 300404 | \$4,500       |                                      |         | 4,500   |         |         |         |         |        |     |      |     |
| Bolt Plug                 | Plastic Mold                | 300368 | \$38,088      | Historical Data Used                 | 12,696  |         | 12,696  |         |         |         |        |     |      |     |
| Bolt Plug Insert          | PPI Fixture                 | 300346 | \$3,000       |                                      |         |         | 1,500   |         | 1,500   |         |        |     |      |     |
| Firing Pin Head           | MIM Mold                    | 300336 | \$37,500      | Ilion: Quote                         |         | 12,500  |         | 12,500  |         |         |        |     |      |     |
|                           | PPI Fixture                 |        | \$1,500       |                                      |         |         | 1,500   |         |         |         |        |     |      |     |
| Front Sight Assembly      | Assembly Press              |        | \$4,200       |                                      |         | 2,000   | 4,200   |         |         |         |        |     |      |     |
| Front Sight               | PM Mold                     | 94084  | \$0           | Ilion Quote SAP                      |         |         |         |         |         |         |        |     |      |     |
| Front Sight Ramp          | PM Mold                     | 94657  | \$0           | Ilion Quote SAP                      |         |         |         |         |         |         |        |     |      |     |
| Rear Sight Assembly       |                             | 103145 | \$0           | Ilion Quote SAP                      |         |         |         |         |         |         |        |     |      |     |
| Rear Sight Aperture       | Machining Fixture           | 97681  | \$9,000       | Ilion Quote SAP                      |         |         | 4,000   | 5,000   |         |         |        |     |      |     |
| Rear Sight Aperture Blank | MIM Mold                    | 93906  | \$0           | 0                                    |         |         |         |         |         |         |        |     |      |     |
| Rear Sight Base           | MIM Mold                    | 103531 | \$0           | Ilion: Quote                         |         |         |         |         |         |         |        |     |      |     |
| Rear Sight Slide          | MIM Mold                    | 94335  | \$0           | Ilion: Quote                         |         |         |         |         |         |         |        |     |      |     |
| Stock Assy                |                             |        |               |                                      |         |         |         |         |         |         |        |     |      |     |
| Stock Assembly            | Fixture                     | ????   | \$2,800       | 0                                    |         |         |         |         | 2,800   |         |        |     |      |     |
| Stock                     | Plastic Mold                | ????   | \$150,300     | Par 4 Plastics, Inc.                 | 50,100  |         | 50,100  | 50,100  |         |         |        |     |      |     |
|                           | PPI Fixture                 | 0      | \$4,500       | 0                                    |         | 4,500   |         |         |         |         |        |     |      |     |
| Front Screw Bushing       | Family plastic mold         | 15161  | \$12,000      | Par 4 Plastics, Inc.                 |         |         | 4,000   |         | 4,000   | 4,000   |        |     |      |     |
| Middle Screw Bushing      | see front screw bushing     | ????   | \$0           | 0                                    |         |         |         |         |         |         |        |     |      |     |
| Rear Screw Bushing        | see front screw bushing     | ????   | \$0           | 0                                    |         |         |         |         |         |         |        |     |      |     |
| Magazine Latch            | Plastic Mold                | 300362 | \$33,480      | Historical Data Used                 | 11,160  |         | 11,160  | 11,160  |         |         |        |     |      |     |
|                           | PPI Fixture                 |        | \$0           |                                      |         |         |         |         |         |         |        |     |      |     |
| Magazine Assembly         |                             | 305395 | \$0           | 0                                    |         |         |         |         |         |         |        |     |      |     |
| Magazine Box              | Stamping Die                | 300363 | \$46,500      | Historical Data Used                 | 15,500  |         | 15,500  | 15,500  |         |         |        |     |      |     |
|                           | PPI fixture                 |        | \$4,500       |                                      |         |         |         |         |         |         |        |     |      |     |
| Magazine Follower         | Plastic Mold (family w/ bot | 300364 | \$78,786      | Par 4 Plastics, Inc. - Quote 8/27/06 | 26,262  |         | 26,262  | 26,262  |         |         |        |     |      |     |
|                           | PPI fixture                 |        | \$3,000       |                                      |         |         | 3,000   |         |         |         |        |     |      |     |
| Magazine Bottom           | Plastic Mold (family w/ fol | 300365 | \$0           | Par 4 Plastics, Inc. - Quote 8/27/06 |         |         |         |         |         |         |        |     |      |     |
|                           | PPI fixture                 |        | \$0           |                                      |         |         |         |         |         |         |        |     |      |     |
| Magazine Spring           | Stamping Die                | 300405 | \$0           | 0                                    |         |         |         |         |         |         |        |     |      |     |
|                           | PPI fixture                 |        | \$0           |                                      |         |         |         |         |         |         |        |     |      |     |
| Gallery                   | Design                      |        | \$15,000      |                                      | 15,000  |         |         |         |         |         |        |     |      |     |
|                           | 1st installment             |        | \$100,000     |                                      |         | 100,000 |         |         |         |         |        |     |      |     |
|                           | 2nd installment             |        | \$140,000     |                                      |         |         | 140,000 |         |         |         |        |     |      |     |
|                           | 3rd installment             |        | \$45,000      |                                      |         |         |         | 45,000  |         |         |        |     |      |     |
|                           | Snails                      |        | \$25,000      |                                      |         |         |         | 25,000  |         |         |        |     |      |     |
|                           |                             |        |               |                                      |         |         |         |         |         |         |        |     |      |     |
|                           |                             |        |               |                                      |         |         |         |         |         |         |        |     |      |     |
|                           |                             |        |               |                                      |         |         |         |         |         |         |        |     |      |     |
| TOTAL                     |                             |        | \$2,451,575   |                                      | 464,172 | 356,933 | 425,143 | 525,119 | 447,748 | 216,572 | 63,149 | 0   | 0    | 0   |

Remington Arms Company  
710 Production Model  
Mayfield Plant

05-Oct-99

|                                                        |                         | 69,000 597s<br>0 710s | 51,300 597s<br>20,000 710s | 58,400 597s<br>20,000 710s | 58,400 597s<br>30,000 710s |
|--------------------------------------------------------|-------------------------|-----------------------|----------------------------|----------------------------|----------------------------|
| Per Unit Margins Based on Mayfield Plant Overhead Rate |                         |                       |                            |                            |                            |
| NSP                                                    |                         |                       |                            |                            |                            |
|                                                        | 597 (2000 budgeted Mix) | 145.88                | 145.88                     | 145.88                     | 145.88                     |
|                                                        | 710                     | N/A                   | 220.00                     | 220.00                     | 220.00                     |
| Material Cost                                          |                         |                       |                            |                            |                            |
|                                                        | 597 (2000 budgeted Mix) | 53.67                 | 53.67                      | 53.67                      | 53.67                      |
|                                                        | 710                     | N/A                   | 43.05                      | 43.05                      | 43.05                      |
| Labor                                                  |                         |                       |                            |                            |                            |
|                                                        | 597 (2000 budgeted Mix) | 10.11                 | 10.11                      | 10.11                      | 10.11                      |
|                                                        | 710                     | N/A                   | 9.15                       | 9.15                       | 9.15                       |
| Overhead Rate                                          |                         | 448.9%                | 502.6%                     | 470.6%                     | 443.8%                     |
| Overhead Costs                                         |                         |                       |                            |                            |                            |
|                                                        | 597                     | 45.37                 | 50.79                      | 47.56                      | 44.85                      |
|                                                        | 710                     | N/A                   | 45.06                      | 43.04                      | 40.59                      |
| Total Costs                                            |                         |                       |                            |                            |                            |
|                                                        | 597                     | 109.14                | 114.57                     | 111.34                     | 108.63                     |
|                                                        | 710                     | N/A                   | 98.16                      | 95.24                      | 92.79                      |
| Margin                                                 |                         |                       |                            |                            |                            |
|                                                        | 597                     | 36.73                 | 31.31                      | 34.54                      | 37.25                      |
|                                                        | 710                     | N/A                   | 121.84                     | 124.76                     | 127.21                     |
| Other Assumptions                                      |                         |                       |                            |                            |                            |
| Capital                                                |                         | N/A                   | 2,358,528                  | 2,358,528                  | 2,358,528                  |
| Startup Costs                                          |                         | N/A                   | 417,135                    | 417,135                    | 417,135                    |
| Working Capital (excluding A/R)                        |                         | N/A                   | 326,393                    | 326,393                    | 466,067                    |
| Head Count                                             |                         | 37.9                  | 38.0                       | 41.9                       | 46.8                       |

MF0023

Remington Arms Company  
710 Production Model  
Mayfield Plant

05-Oct-99

|                                       | 69,000 597s<br>0 710s | 51,300 597s<br>20,000 710s | 58,400 597s<br>20,000 710s | 58,400 597s<br>30,000 710s |
|---------------------------------------|-----------------------|----------------------------|----------------------------|----------------------------|
| Total Units Produced to the Warehouse | 69,000                | 71,300                     | 78,400                     | 88,400                     |
| Total Standard Hours Earned           | 71,162                | 71,359                     | 78,682                     | 87,907                     |
| Sales Value of Units Warehoused       | \$ 10,065,381         | \$ 11,883,392              | \$ 12,919,105              | \$ 15,119,105              |

**Standard Cost of Goods Warehoused**

|                                           |              |              |              |              |
|-------------------------------------------|--------------|--------------|--------------|--------------|
| Direct Material Costs                     | 3,703,154    | 3,614,297    | 3,995,346    | 4,425,888    |
| Direct Labor Costs                        | 697,358      | 701,387      | 773,144      | 864,602      |
| Variable Overhead Costs                   | 2,182,089    | 2,273,570    | 2,360,250    | 2,515,661    |
| Fixed Overhead Costs                      | 948,241      | 1,251,438    | 1,278,173    | 1,321,347    |
| Total Overhead                            | 3,130,330    | 3,525,008    | 3,638,423    | 3,837,008    |
| Total Standard Cost of Production         | 7,530,842    | 7,840,693    | 8,406,914    | 9,127,498    |
| Standard Cost of Production per Gun       | 109.14       | 109.97       | 107.23       | 103.25       |
| Standard Mfg. Contribution Margin         | \$ 2,534,539 | \$ 4,042,699 | \$ 4,512,191 | \$ 5,991,607 |
| Standard Mfg. Contribution Margin per Gun | \$ 36.73     | \$ 56.70     | \$ 57.55     | \$ 67.78     |
|                                           | 25.2%        | 34.0%        | 34.9%        | 39.6%        |

**710 Costing on Mayfield Plant Overhead Rate**

|          |     |          |          |          |
|----------|-----|----------|----------|----------|
| Material | N/A | \$ 43.05 | \$ 43.05 | \$ 43.05 |
| Labor    | N/A | 9.15     | 9.15     | 9.15     |
| Overhead | N/A | 45.96    | 43.04    | 40.59    |
| Total    | N/A | \$ 98.16 | \$ 95.24 | \$ 92.79 |

**710 Incremental Costs**

|                                                                         |     |          |          |          |
|-------------------------------------------------------------------------|-----|----------|----------|----------|
| Material                                                                | N/A | \$ 43.05 | \$ 43.05 | \$ 43.05 |
| Labor                                                                   | N/A | 9.15     | 9.15     | 9.15     |
| 710 Incremental Overhead                                                | N/A | 32.94    | 32.94    | 28.58    |
| 597 Overhead Increase/(Decrease) due to<br>Changes in production Levels | N/A | 13.92    | 6.41     | (1.00)   |
| Total                                                                   | N/A | \$ 99.06 | \$ 91.54 | \$ 79.77 |

**710 Overhead Per Gun**

|                                     |     |         |         |         |
|-------------------------------------|-----|---------|---------|---------|
| Incremental Overhead related to 710 | N/A | 658,724 | 658,724 | 857,308 |
| Per 710 Units                       | N/A | 32.94   | 32.94   | 28.58   |

MF0024

Remington Arms Company  
710 Production Model  
Mayfield Plant

05-Oct-99

|                                                               |                         | 69,000 597s<br>0 710s | 51,300 597s<br>20,000 710s | 58,400 597s<br>20,000 710s | 58,400 597s<br>30,000 710s |
|---------------------------------------------------------------|-------------------------|-----------------------|----------------------------|----------------------------|----------------------------|
| <b>Per Unit Margins Based on Mayfield Plant Overhead Rate</b> |                         |                       |                            |                            |                            |
| NSP                                                           |                         |                       |                            |                            |                            |
|                                                               | 597 (2000 budgeted Mix) | 145.88                | 145.88                     | 145.88                     | 145.88                     |
|                                                               | 710                     | N/A                   | 220.00                     | 220.00                     | 220.00                     |
| Material Cost                                                 |                         |                       |                            |                            |                            |
|                                                               | 597 (2000 budgeted Mix) | 53.67                 | 53.67                      | 53.67                      | 53.67                      |
|                                                               | 710                     | N/A                   | 43.05                      | 43.05                      | 43.05                      |
| Labor                                                         |                         |                       |                            |                            |                            |
|                                                               | 597 (2000 budgeted Mix) | 10.11                 | 10.11                      | 10.11                      | 10.11                      |
|                                                               | 710                     | N/A                   | 9.15                       | 9.15                       | 9.15                       |
| Overhead Rate                                                 |                         | 448.9%                | 502.6%                     | 470.6%                     | 443.8%                     |
| Overhead Costs                                                |                         |                       |                            |                            |                            |
|                                                               | 597                     | 45.37                 | 50.79                      | 47.56                      | 44.85                      |
|                                                               | 710                     | N/A                   | 45.96                      | 43.04                      | 40.59                      |
| Total Costs                                                   |                         |                       |                            |                            |                            |
|                                                               | 597                     | 109.14                | 114.57                     | 111.34                     | 108.63                     |
|                                                               | 710                     | N/A                   | 98.16                      | 95.24                      | 92.79                      |
| Margin                                                        |                         |                       |                            |                            |                            |
|                                                               | 597                     | 36.73                 | 31.31                      | 34.54                      | 37.25                      |
|                                                               | 710                     | N/A                   | 121.84                     | 124.76                     | 127.21                     |
| <b>Other Assumptions</b>                                      |                         |                       |                            |                            |                            |
| Capital                                                       |                         | N/A                   | 2,358,528                  | 2,358,528                  | 2,358,528                  |
| Startup Costs                                                 |                         | N/A                   | 417,135                    | 417,135                    | 417,135                    |
| Working Capital (excluding A/R)                               |                         | N/A                   | 326,393                    | 326,393                    | 466,067                    |
| Head Count                                                    |                         | 37.9                  | 38.0                       | 41.9                       | 46.8                       |

MF0025

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/05/99

C:\windows\TEMP\{M710 estimate rev5.xls}m710 51,300 597 20,000 710

|                                   |         | 710 Costing Model 51,300 597s & 20,000 710s |                      |             |                  |                |                  |         |
|-----------------------------------|---------|---------------------------------------------|----------------------|-------------|------------------|----------------|------------------|---------|
| PART DESCRIPTION                  | Part #  | Material<br>\$                              | Run Rate<br>(hrs/pc) | Labor<br>\$ | Fixed<br>O.H. \$ | Var<br>O.H. \$ | Total<br>O.H. \$ | Total   |
| Document Envelope Assembly        | 1721    | \$ 0.09                                     |                      | \$ -        | \$ -             | \$ -           | \$ -             | \$ 0.09 |
| Document Envelope                 | 1649    | 0.08                                        |                      | -           | -                | -              | -                | 0.08    |
| Users manual                      | 3391    | 0.15                                        |                      | -           | -                | -              | -                | 0.15    |
| Product Owners Card               | 1426    | 0.03                                        |                      | -           | -                | -              | -                | 0.03    |
| Remington Authorized Gunsmith     | 3413    | 0.07                                        |                      | -           | -                | -              | -                | 0.07    |
| Safety Booklet                    | 3499    | 0.10                                        |                      | -           | -                | -              | -                | 0.10    |
| Oval Label                        | 3491    | 0.01                                        |                      | -           | -                | -              | -                | 0.01    |
| Carton Assembly                   | 1444    | 2.05                                        |                      | -           | -                | -              | -                | 2.05    |
| Box and Envelope Label (710)      | 993002  | 0.04                                        |                      | -           | -                | -              | -                | 0.04    |
| Shelf Talker                      |         | 0.14                                        |                      | -           | -                | -              | -                | 0.14    |
| Barrel Assembly Complete          | 305410  |                                             | 0.0790               | 0.71        | 1.26             | 2.29           | 3.65             | 4.26    |
| Barrel Assembly                   | 3305400 |                                             |                      | -           | -                | -              | -                | -       |
| Barrel                            | 305315  | 4.80                                        | 0.3866               | 4.09        | 7.30             | 13.26          | 20.56            | 29.45   |
| Receiver 6.6" + Ren / S           | 300340  | 2.17                                        | 0.00507              | 0.06        | 0.10             | 0.19           | 0.29             | 2.11    |
| Receiver Insert Assembly Complete | ????    |                                             | 0.0530               | 0.47        | 0.85             | 1.54           | 2.38             | 2.86    |
| Receiver Insert Assembly          | ????    |                                             | 0.0050               | 0.04        | 0.08             | 0.15           | 0.22             | 0.27    |
| Receiver Insert                   | 300327  | 0.62                                        |                      | -           | -                | -              | -                | 0.62    |
| Threaded Insert                   | 300347  | 0.04                                        |                      | -           | -                | -              | -                | 0.04    |
| Side Plate                        | 300333  | 0.09                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.15    |
| Side Plate Pin (2)                | 300328  | 0.16                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.22    |
| Sear Safety Cam                   | 35666   | 0.94                                        |                      | -           | -                | -              | -                | 0.94    |
| Pivot Pin (3)                     | 300351  | 0.27                                        |                      | -           | -                | -              | -                | 0.27    |
| Sear Spring                       | 17047   | 0.05                                        |                      | -           | -                | -              | -                | 0.05    |
| Trigger                           | 15280   | 1.53                                        |                      | -           | -                | -              | -                | 1.53    |
| Trigger Connector                 | 19461   | 1.03                                        |                      | -           | -                | -              | -                | 1.03    |
| Trigger Screw Front               | 17053   | 0.07                                        |                      | -           | -                | -              | -                | 0.07    |
| Trigger Engagement Screw          | 91128   | 0.06                                        |                      | -           | -                | -              | -                | 0.06    |
| Trigger Spring                    | 15400   | 0.05                                        |                      | -           | -                | -              | -                | 0.05    |
| Trigger Stop Screw                | 15481   | 0.04                                        |                      | -           | -                | -              | -                | 0.04    |
| Safety                            | 300408  | 0.23                                        |                      | -           | -                | -              | -                | 0.23    |
| Safety Detent Spring              | 300407  | 0.06                                        |                      | -           | -                | -              | -                | 0.06    |
| Safety Pivot Pin                  | 300352  | 0.14                                        |                      | -           | -                | -              | -                | 0.14    |
| Safety Spring                     | 300343  | 0.05                                        |                      | -           | -                | -              | -                | 0.05    |
| Safety Button                     |         | 0.41                                        | 0.0050               | 0.05        | 0.09             | 0.17           | 0.27             | 0.73    |
| Safety Plunger                    |         | 0.07                                        |                      | -           | -                | -              | -                | 0.07    |
| Safety Key/Cap/Bushing            |         | 0.69                                        |                      | -           | -                | -              | -                | 0.69    |
| Bolt Stop                         | 300345  | 0.22                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.28    |
| Receiver Plug Screws (4)          | 17034   | 0.12                                        |                      | -           | -                | -              | -                | 0.12    |
| Recoil Bracket                    | 300361  | 0.19                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.25    |
| Bolt Assembly Complete            | ????    |                                             |                      | -           | -                | -              | -                | -       |
| Bolt Body Assembly                | ????    |                                             | 0.0275               | 0.29        | 0.52             | 0.94           | 1.46             | 1.76    |
| Bolt Body (40.24 \$0.285)         | 300339  | 0.74                                        | 0.0031               | 0.03        | 0.06             | 0.11           | 0.17             | 0.94    |
| Bolt Handle                       | 300370  |                                             | 0.0120               | 0.13        | 0.23             | 0.41           | 0.64             | 0.77    |
| Bolt Handle Blank                 | 300360  | 1.63                                        |                      | -           | -                | -              | -                | 1.63    |
| Bolt Handle Pin                   | 300329  | 0.10                                        |                      | -           | -                | -              | -                | 0.10    |
| Bolt Head Assembly                | 305390  |                                             | 0.0580               | 0.52        | 0.93             | 1.68           | 2.61             | 3.13    |
| Bolt Head                         | 300338  | 1.75                                        | 0.0809               | 0.86        | 1.53             | 2.77           | 4.30             | 6.91    |

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REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/05/99

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|                             |        | 710 Costing Model 51,300 597s & 20,000 710s |                      |             |                  |                |                  |          |
|-----------------------------|--------|---------------------------------------------|----------------------|-------------|------------------|----------------|------------------|----------|
| PART DESCRIPTION            | Part # | Material<br>\$                              | Run Rate<br>(hrs/pc) | Labor<br>\$ | Fixed<br>O.H. \$ | Var<br>O.H. \$ | Total<br>O.H. \$ | Total    |
| Extractor                   | 93712  | 0.77                                        | -                    | -           | -                | -              | -                | 0.77     |
| Ejector                     | 300342 | 0.11                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.17     |
| Ejector Spring              | ????   | 0.02                                        | -                    | -           | -                | -              | -                | 0.02     |
| Ejector Pin                 | 94555  | 0.04                                        | -                    | -           | -                | -              | -                | 0.04     |
| Bolt Assembly Pin           | 300330 | 0.15                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.21     |
| Firing Pin Assembly         | ????   | 0.25                                        | 0.0070               | 0.06        | 0.11             | 0.20           | 0.31             | 0.38     |
| Bolt Plug                   | 300368 | 0.25                                        | -                    | -           | -                | -              | -                | 0.25     |
| Bolt Plug Insert            | 300346 | 0.80                                        | -                    | -           | -                | -              | -                | 0.80     |
| Firing Pin                  | 300334 | 1.19                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 1.25     |
| Firing Pin Tip              | 300335 | 0.33                                        | 0.0015               | 0.02        | 0.03             | 0.05           | 0.08             | 0.53     |
| Firing Pin Head             | 300336 | 1.50                                        | 0.0020               | 0.02        | 0.04             | 0.07           | 0.11             | 1.63     |
| Firing Pin Spring           | ????   | 0.10                                        | -                    | -           | -                | -              | -                | 0.10     |
| Front Sight                 | 94084  | 0.82                                        | -                    | -           | -                | -              | -                | 0.82     |
| Front Sight Ramp            | 94657  | 1.13                                        | 0.0020               | 0.02        | 0.04             | 0.07           | 0.11             | 1.26     |
| Front Sight Ramp Screws (2) | 28505  | 0.09                                        | -                    | -           | -                | -              | -                | 0.09     |
| Rear Sight Assembly         | 103146 | 3.72                                        | -                    | -           | -                | -              | -                | -        |
| Elevation Screw             | 90906  | 0.04                                        | -                    | -           | -                | -              | -                | 0.04     |
| Rear Sight Aperture         | 94333  | 0.14                                        | 0.0030               | 0.03        | 0.06             | 0.10           | 0.16             | 0.33     |
| Rear Sight Base             | 103530 | 0.97                                        | 0.0030               | 0.03        | 0.06             | 0.10           | 0.16             | 1.16     |
| Rear Sight Slide            | 94335  | 0.47                                        | 0.0050               | 0.05        | 0.09             | 0.17           | 0.27             | 0.79     |
| Windage Screw               | 90904  | 0.02                                        | -                    | -           | -                | -              | -                | 0.02     |
| Rear Sight Base Screw (2)   | 28505  | 0.09                                        | -                    | -           | -                | -              | -                | 0.09     |
| Stock Assembly Complete     | ????   | -                                           | 0.0160               | 0.14        | 0.26             | 0.46           | 0.72             | 0.86     |
| Stock Assembly              | ????   | -                                           | -                    | -           | -                | -              | -                | -        |
| Stock                       | ????   | 5.38                                        | -                    | -           | -                | -              | -                | 5.38     |
| Front Screw Bushing         | 15161  | 0.13                                        | -                    | -           | -                | -              | -                | 0.13     |
| Middle Screw Bushing        | ????   | 0.05                                        | -                    | -           | -                | -              | -                | 0.05     |
| Rear Screw Bushing          | ????   | 0.05                                        | -                    | -           | -                | -              | -                | 0.05     |
| Gun Cap                     | 97971  | 0.18                                        | -                    | -           | -                | -              | -                | 0.18     |
| Recoil Pad                  | 97973  | 1.63                                        | -                    | -           | -                | -              | -                | 1.63     |
| Recoil Pad Screw (2)        | 98008  | 0.02                                        | -                    | -           | -                | -              | -                | 0.02     |
| Magazine Latch              | 300362 | 0.19                                        | -                    | -           | -                | -              | -                | 0.19     |
| Magazine Latch Spring       | ????   | 0.03                                        | -                    | -           | -                | -              | -                | 0.03     |
| Magazine Latch Pin          | 300371 | 0.07                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.13     |
| Sling Swivel Stud (2)       | 300096 | 0.14                                        | -                    | -           | -                | -              | -                | 0.14     |
| Takedown Screw (2)          | ????   | 0.16                                        | -                    | -           | -                | -              | -                | 0.16     |
| Rear Takedown Screw         | ????   | 0.08                                        | -                    | -           | -                | -              | -                | 0.08     |
| Magazine Assembly           | ????   | -                                           | 0.0083               | 0.07        | 0.13             | 0.24           | 0.37             | 0.45     |
| Magazine Box                | 300363 | 2.90                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.04             | 2.95     |
| Magazine Follower           | 300364 | 0.26                                        | -                    | -           | -                | -              | -                | 0.26     |
| Magazine Bottom             | 300365 | 0.26                                        | -                    | -           | -                | -              | -                | 0.26     |
| Magazine Spring             | 47028  | 0.42                                        | -                    | -           | -                | -              | -                | 0.42     |
| Freight on Parts            | 300405 | 0.25                                        | -                    | -           | -                | -              | -                | 0.25     |
| Value Added Cost of:        |        |                                             |                      |             |                  |                |                  |          |
| Proof/Gallery/Inspect/Pack  |        | 1.15                                        | 0.1500               | 1.34        | 2.40             | 4.35           | 6.75             | 9.24     |
| Total Cost                  |        | \$ 43.05                                    | 0.9226               | \$ 9.15     | \$ 16.32         | \$ 29.65       | \$ 45.96         | \$ 98.16 |

MF0027

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/05/99

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|                                   |         | 710 Costing Model 58,300 597s & 30,000 710s |                      |             |                  |                |                  |         |
|-----------------------------------|---------|---------------------------------------------|----------------------|-------------|------------------|----------------|------------------|---------|
| PART DESCRIPTION                  | Part #  | Material<br>\$                              | Run Rate<br>(hrs/pc) | Labor<br>\$ | Fixed<br>O.H. \$ | Var<br>O.H. \$ | Total<br>O.H. \$ | Total   |
| Document Envelope Assembly        | 1721    | \$ 0.09                                     |                      | \$ -        | \$ -             | \$ -           | \$ -             | \$ 0.09 |
| Document Envelope                 | 1649    | 0.08                                        |                      | -           | -                | -              | -                | 0.08    |
| Users manual                      | 3391    | 0.15                                        |                      | -           | -                | -              | -                | 0.15    |
| Product Owners Card               | 1426    | 0.03                                        |                      | -           | -                | -              | -                | 0.03    |
| Remington Authorized Gunsmith     | 3413    | 0.07                                        |                      | -           | -                | -              | -                | 0.07    |
| Safety Booklet                    | 3499    | 0.10                                        |                      | -           | -                | -              | -                | 0.10    |
| Oval Label                        | 3491    | 0.01                                        |                      | -           | -                | -              | -                | 0.01    |
| Carton Assembly                   | 1444    | 2.05                                        |                      | -           | -                | -              | -                | 2.05    |
| Box and Envelope Label (710)      | 993002  | 0.04                                        |                      | -           | -                | -              | -                | 0.04    |
| Shelf Talker                      |         | 0.14                                        |                      | -           | -                | -              | -                | 0.14    |
| Barrel Assembly Complete          | 305410  |                                             | 0.0790               | 0.71        | 1.08             | 2.06           | 3.14             | 3.84    |
| Barrel Assembly                   | 3305400 |                                             |                      | -           | -                | -              | -                | -       |
| Barrel                            | 305315  | 4.80                                        | 0.3866               | 4.09        | 6.25             | 11.90          | 18.15            | 27.04   |
| Receiver                          | 300340  | 1.76                                        | 0.0055               | 0.06        | 0.09             | 0.17           | 0.26             | 2.08    |
| Receiver Insert Assembly Complete | ????    |                                             | 0.0530               | 0.47        | 0.72             | 1.38           | 2.11             | 2.58    |
| Receiver Insert Assembly          | ????    |                                             | 0.0050               | 0.04        | 0.07             | 0.13           | 0.20             | 0.24    |
| Receiver Insert                   | 300327  | 0.62                                        |                      | -           | -                | -              | -                | 0.62    |
| Threaded Insert                   | 300347  | 0.04                                        |                      | -           | -                | -              | -                | 0.04    |
| Side Plate                        | 300333  | 0.09                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.15    |
| Side Plate Pin (2)                | 300328  | 0.16                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.22    |
| Sear Safety Cam                   | 15666   | 0.54                                        |                      | -           | -                | -              | -                | 0.94    |
| Pivot Pin (3)                     | 300361  | 0.27                                        |                      | -           | -                | -              | -                | 0.27    |
| Sear Spring                       | 17047   | 0.05                                        |                      | -           | -                | -              | -                | 0.05    |
| Trigger                           | 15280   | 1.53                                        |                      | -           | -                | -              | -                | 1.53    |
| Trigger Connector                 | 19461   | 1.03                                        |                      | -           | -                | -              | -                | 1.03    |
| Trigger Screw Front               | 17053   | 0.07                                        |                      | -           | -                | -              | -                | 0.07    |
| Trigger Engagement Screw          | 91128   | 0.06                                        |                      | -           | -                | -              | -                | 0.06    |
| Trigger Spring                    | 15400   | 0.05                                        |                      | -           | -                | -              | -                | 0.05    |
| Trigger Stop Screw                | 15481   | 0.04                                        |                      | -           | -                | -              | -                | 0.04    |
| Safety                            | 300408  | 0.23                                        |                      | -           | -                | -              | -                | 0.23    |
| Safety Detent Spring              | 300407  | 0.06                                        |                      | -           | -                | -              | -                | 0.06    |
| Safety Pivot Pin                  | 300352  | 0.14                                        |                      | -           | -                | -              | -                | 0.14    |
| Safety Spring                     | 300343  | 0.05                                        |                      | -           | -                | -              | -                | 0.05    |
| Safety Button                     |         | 0.41                                        | 0.0050               | 0.05        | 0.08             | 0.15           | 0.23             | 0.70    |
| Safety Plunger                    |         | 0.07                                        |                      | -           | -                | -              | -                | 0.07    |
| Safety Key/Cap/Bushing            |         | 0.69                                        |                      | -           | -                | -              | -                | 0.69    |
| Bolt Stop                         | 300345  | 0.22                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.28    |
| Receiver Plug Screws (4)          | 17034   | 0.12                                        |                      | -           | -                | -              | -                | 0.12    |
| Recoil Bracket                    | 300361  | 0.19                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.25    |
| Bolt Assembly Complete            | ????    |                                             |                      | -           | -                | -              | -                | -       |
| Bolt Body Assembly                | ????    |                                             | 0.0275               | 0.29        | 0.45             | 0.85           | 1.29             | 1.58    |
| Bolt Body                         | 300339  | 0.74                                        | 0.0032               | 0.03        | 0.05             | 0.10           | 0.15             | 0.92    |
| Bolt Handle                       | 300370  |                                             | 0.0120               | 0.13        | 0.19             | 0.37           | 0.56             | 0.69    |
| Bolt Handle Blank                 | 300360  | 1.63                                        |                      | -           | -                | -              | -                | 1.63    |
| Bolt Handle Pin                   | 300329  | 0.10                                        |                      | -           | -                | -              | -                | 0.10    |
| Bolt Head Assembly                | 305390  |                                             | 0.0580               | 0.52        | 0.79             | 1.51           | 2.30             | 2.82    |
| Bolt Head                         | 300338  | 1.75                                        | 0.0809               | 0.86        | 1.31             | 2.49           | 3.80             | 6.40    |

MF0028

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/05/99

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|                             |        | 710 Costing Model 58,300 597s & 30,000 710s |                      |             |                  |                |                  |          |
|-----------------------------|--------|---------------------------------------------|----------------------|-------------|------------------|----------------|------------------|----------|
| PART DESCRIPTION            | Part # | Material<br>\$                              | Run Rate<br>(hrs/pc) | Labor<br>\$ | Fixed<br>O.H. \$ | Var<br>O.H. \$ | Total<br>O.H. \$ | Total    |
| Extractor                   | 93712  | 0.77                                        |                      | -           | -                | -              | -                | 0.77     |
| Ejector                     | 300342 | 0.11                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.17     |
| Ejector Spring              | ????   | 0.02                                        |                      | -           | -                | -              | -                | 0.02     |
| Ejector Pin                 | 94555  | 0.04                                        |                      | -           | -                | -              | -                | 0.04     |
| Bolt Assembly Pin           | 300330 | 0.15                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.21     |
| Firing Pin Assembly         | ????   |                                             | 0.0070               | 0.06        | 0.10             | 0.18           | 0.28             | 0.34     |
| Bolt Plug                   | 300368 | 0.25                                        |                      | -           | -                | -              | -                | 0.25     |
| Bolt Plug Insert            | 300346 | 0.80                                        |                      | -           | -                | -              | -                | 0.80     |
| Firing Pin                  | 300334 | 1.19                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 1.25     |
| Firing Pin Tip              | 300335 | 0.33                                        | 0.0015               | 0.02        | 0.02             | 0.05           | 0.07             | 0.42     |
| Firing Pin Head             | 300336 | 1.50                                        | 0.0020               | 0.02        | 0.03             | 0.06           | 0.09             | 1.62     |
| Firing Pin Spring           | ????   | 0.10                                        |                      | -           | -                | -              | -                | 0.10     |
| Front Sight                 | 94084  | 0.82                                        |                      | -           | -                | -              | -                | 0.82     |
| Front Sight Ramp            | 94657  | 1.13                                        | 0.0020               | 0.02        | 0.03             | 0.06           | 0.09             | 1.25     |
| Front Sight Ramp Screws (2) | 28505  | 0.09                                        |                      | -           | -                | -              | -                | 0.09     |
| Rear Sight Assembly         | 103146 |                                             |                      | -           | -                | -              | -                | -        |
| Elevation Screw             | 90906  | 0.04                                        |                      | -           | -                | -              | -                | 0.04     |
| Rear Sight Aperture         | 94333  | 0.14                                        | 0.0030               | 0.03        | 0.05             | 0.09           | 0.14             | 0.31     |
| Rear Sight Base             | 103531 | 0.97                                        | 0.0030               | 0.03        | 0.05             | 0.09           | 0.14             | 1.14     |
| Rear Sight Slide            | 94335  | 0.47                                        | 0.0050               | 0.05        | 0.08             | 0.15           | 0.23             | 0.76     |
| Windage Screw               | 90904  | 0.02                                        |                      | -           | -                | -              | -                | 0.02     |
| Rear Sight Base Screw (2)   | 28505  | 0.09                                        |                      | -           | -                | -              | -                | 0.09     |
| Stock Assembly Complete     | ????   |                                             | 0.0160               | 0.14        | 0.22             | 0.42           | 0.64             | 0.78     |
| Stock Assembly              | ????   |                                             |                      | -           | -                | -              | -                | -        |
| Stock                       | ????   | 5.38                                        |                      | -           | -                | -              | -                | 5.38     |
| Front Screw Bushing         | 15161  | 0.13                                        |                      | -           | -                | -              | -                | 0.13     |
| Middle Screw Bushing        | ????   | 0.05                                        |                      | -           | -                | -              | -                | 0.05     |
| Rear Screw Bushing          | ????   | 0.05                                        |                      | -           | -                | -              | -                | 0.05     |
| Tip Cap                     | 97971  | 0.18                                        |                      | -           | -                | -              | -                | 0.18     |
| Recoil Pad                  | 97973  | 1.63                                        |                      | -           | -                | -              | -                | 1.63     |
| Recoil Pad Screw (2)        | 98008  | 0.02                                        |                      | -           | -                | -              | -                | 0.02     |
| Magazine Latch              | 300362 | 0.19                                        |                      | -           | -                | -              | -                | 0.19     |
| Magazine Latch Spring       | ????   | 0.03                                        |                      | -           | -                | -              | -                | 0.03     |
| Magazine Latch Pin          | 300371 | 0.07                                        | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.13     |
| Sling Swivel Stud (2)       | 300096 | 0.14                                        |                      | -           | -                | -              | -                | 0.14     |
| Takedown Screw (2)          | ????   | 0.16                                        |                      | -           | -                | -              | -                | 0.16     |
| Rear Takedown Screw         | ????   | 0.08                                        |                      | -           | -                | -              | -                | 0.08     |
| Magazine Assembly           | ????   |                                             | 0.0083               | 0.07        | 0.11             | 0.22           | 0.33             | 0.40     |
| Magazine Box                | 300363 | 2.90                                        | 0.0010               | 0.01        | 0.01             | 0.03           | 0.04             | 2.95     |
| Magazine Follower           | 300364 | 0.26                                        |                      | -           | -                | -              | -                | 0.26     |
| Magazine Bottom             | 300365 | 0.26                                        |                      | -           | -                | -              | -                | 0.26     |
| Magazine Spring             | 17028  | 0.42                                        |                      | -           | -                | -              | -                | 0.42     |
| Freight on Parts            |        | 0.25                                        |                      |             |                  |                |                  | 0.25     |
| Value Added Cost of:        |        |                                             |                      |             |                  |                |                  |          |
| Proof/Gallery/Inspect/Pack  |        | 1.15                                        | 0.1500               | 1.34        | 2.05             | 3.91           | 5.96             | 8.45     |
| Total Cost                  |        | \$ 43.05                                    | 0.9226               | \$ 9.15     | \$ 13.98         | \$ 26.61       | \$ 40.59         | \$ 92.79 |

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

710 Operating Model: Overhead Summary

|                                            | Based on<br>58,400 597<br>Before 7,250<br>710 add on |            | Based on<br>No 710s<br>Add 10,600<br>597 |                      | Add 710s<br>20,000<br>Reduce 597<br>7,100 |                     | Add 710s<br>20,000<br>No change<br>to 597 |                   | Add 710s<br>30,000<br>No change<br>to 597 |                      | Assumptions                                                                       |
|--------------------------------------------|------------------------------------------------------|------------|------------------------------------------|----------------------|-------------------------------------------|---------------------|-------------------------------------------|-------------------|-------------------------------------------|----------------------|-----------------------------------------------------------------------------------|
|                                            | Budgeted<br>Overhead                                 | 710<br>Adj | 597<br>Adj                               | Total 59,000<br>597s | 710<br>Adj                                | 597<br>Adj          | Total 58,400<br>597s                      | 710<br>Adj        | 597<br>Adj                                | Total 58,400<br>597s |                                                                                   |
| <b>Overhead Costs</b>                      |                                                      |            |                                          |                      |                                           |                     |                                           |                   |                                           |                      |                                                                                   |
| <b>Staffing Costs</b>                      |                                                      |            |                                          |                      |                                           |                     |                                           |                   |                                           |                      |                                                                                   |
| 7110500 Salaries - Exempt                  | 484,994                                              |            |                                          | 484,994              |                                           |                     | 484,994                                   |                   |                                           | 484,994              |                                                                                   |
| 7130002 Indirect Labor                     | 257,439                                              |            |                                          | 257,439              |                                           |                     | 257,439                                   |                   |                                           | 257,439              |                                                                                   |
| 7130005 Overtime Premium                   | 14,678                                               |            |                                          | 14,678               |                                           |                     | 14,678                                    |                   |                                           | 14,678               |                                                                                   |
| 7150501 Employee Benefits                  | 621,408                                              |            | 62,138                                   | 683,546              | 106,092                                   | (41,619)            | 685,881                                   | 106,092           |                                           | 727,500              | 58% Wage 25% Salary                                                               |
| 7455001 Training                           | 14,400                                               |            |                                          | 14,400               |                                           |                     | 14,400                                    |                   |                                           | 14,400               |                                                                                   |
| 7455010 Tuition Refund                     | 11,200                                               |            |                                          | 11,200               |                                           |                     | 11,200                                    |                   |                                           | 11,200               |                                                                                   |
| 7510500 Employee Recreation Expense        | 8,000                                                |            |                                          | 8,000                |                                           |                     | 8,000                                     |                   |                                           | 8,000                |                                                                                   |
| 7550500 Travel Expense                     | 18,090                                               |            |                                          | 18,090               |                                           |                     | 18,090                                    |                   |                                           | 18,090               |                                                                                   |
| 7580500 Entertainment Expense              | 2,010                                                |            |                                          | 2,010                |                                           |                     | 2,010                                     |                   |                                           | 2,010                |                                                                                   |
| 7660500 Subscriptions & Publications       | 1,600                                                |            |                                          | 1,600                |                                           |                     | 1,600                                     |                   |                                           | 1,600                |                                                                                   |
| 8880500 Memberships                        | 1,630                                                |            |                                          | 1,630                |                                           |                     | 1,630                                     |                   |                                           | 1,630                |                                                                                   |
| <b>Total Staffing</b>                      | <b>1,435,450</b>                                     |            | <b>62,138</b>                            | <b>1,497,588</b>     | <b>106,092</b>                            | <b>(41,619)</b>     | <b>1,499,922</b>                          | <b>106,092</b>    |                                           | <b>1,541,542</b>     |                                                                                   |
| <b>Materials and Supplies</b>              |                                                      |            |                                          |                      |                                           |                     |                                           |                   |                                           |                      |                                                                                   |
| 7650500 Operating Supplies                 | 24,268                                               |            | 4,405                                    | 28,673               | 8,810                                     | (2,929)             | 30,149                                    | 8,810             |                                           | 33,078               | Variable Cost by # guns Produced                                                  |
| 7840500 Safety Costs                       | 6,728                                                |            |                                          | 6,728                |                                           |                     | 6,728                                     |                   |                                           | 6,728                |                                                                                   |
| 8230150 Prototype Work                     | 18,720                                               |            |                                          | 18,720               | 4,680                                     |                     | 23,400                                    | 4,680             |                                           | 28,080               | 25% increase related to 710                                                       |
| 8710002 Variable Tools                     | 17,656                                               |            |                                          | 17,656               | 6,900                                     |                     | 24,556                                    | 6,900             |                                           | 31,456               | Increase proportional to 597                                                      |
| 8710120 Essential Materials                | 303,826                                              |            | 81,120                                   | 384,946              | 138,000                                   | (36,920)            | 404,908                                   | 138,000           |                                           | 441,828              | \$5.20/597 + \$6.90/710                                                           |
| 8710122 Tool/Cutpiece/Fixtures             | 10,003                                               |            |                                          | 10,003               | 2,899                                     |                     | 12,902                                    | 2,899             |                                           | 15,801               |                                                                                   |
| 8710505 Vendor Rework                      | 6,835                                                |            |                                          | 6,835                | 1,981                                     |                     | 8,816                                     | 1,981             |                                           | 10,797               | Increase proportional to 597                                                      |
| 7670500 Maintenance Other                  | 53,574                                               |            |                                          | 53,574               | 10,715                                    |                     | 64,289                                    | 10,715            |                                           | 75,004               | Based on # of Machines 20% increase                                               |
| 8710550 Maintenance Material Consumption   | 63,341                                               |            |                                          | 63,341               | 18,360                                    |                     | 81,701                                    | 18,360            |                                           | 100,061              | Proportional increase                                                             |
| 8710560 Maintenance Material Non Inventory | 41,102                                               |            |                                          | 41,102               | 11,914                                    |                     | 53,016                                    | 11,914            |                                           | 64,930               | Proportional increase                                                             |
| <b>Total Materials and Supplies</b>        | <b>546,062</b>                                       |            | <b>85,525</b>                            | <b>631,577</b>       | <b>204,268</b>                            | <b>(39,849)</b>     | <b>710,471</b>                            | <b>204,268</b>    |                                           | <b>750,320</b>       |                                                                                   |
| <b>Facilities and Utilities</b>            |                                                      |            |                                          |                      |                                           |                     |                                           |                   |                                           |                      |                                                                                   |
| 7720500 Contract Services - Net Maint      | 20,105                                               |            |                                          | 20,105               | 1,000                                     |                     | 21,105                                    | 1,000             |                                           | 22,105               | Unfunded for new 710s                                                             |
| 7720503 Contract Services - Maint          | 40,408                                               |            |                                          | 40,408               | 8,082                                     | (8,082)             | 40,408                                    | 8,082             |                                           | 48,490               |                                                                                   |
| 7810500 Equipment Rental & Lease           | 2,520                                                |            |                                          | 2,520                |                                           |                     | 2,520                                     |                   |                                           | 2,520                |                                                                                   |
| 8710132 Waste Disposal                     | 22,195                                               |            |                                          | 22,195               | 6,124                                     |                     | 28,319                                    | 6,124             |                                           | 34,443               |                                                                                   |
| <b>Total Facilities and Utilities</b>      | <b>85,228</b>                                        |            |                                          | <b>85,228</b>        | <b>15,206</b>                             | <b>(8,082)</b>      | <b>92,352</b>                             | <b>15,206</b>     |                                           | <b>107,558</b>       |                                                                                   |
| <b>Other</b>                               |                                                      |            |                                          |                      |                                           |                     |                                           |                   |                                           |                      |                                                                                   |
| 7620500 Non Capital Equipment              | 16,439                                               |            |                                          | 16,439               | 3,288                                     |                     | 19,727                                    | 3,288             |                                           | 23,015               | 20% increase due to Machine increase                                              |
| 8820502 Postage                            | 3,389                                                |            |                                          | 3,389                |                                           |                     | 3,389                                     |                   |                                           | 3,389                |                                                                                   |
| 8670500 Contributions & Donations          | 2,198                                                |            |                                          | 2,198                |                                           |                     | 2,198                                     |                   |                                           | 2,198                |                                                                                   |
| 8640500 Environmental fees                 | 250                                                  |            |                                          | 250                  |                                           |                     | 250                                       |                   |                                           | 250                  |                                                                                   |
| 8660500 Miscellaneous Expenses             | 3,600                                                |            |                                          | 3,600                |                                           |                     | 3,600                                     |                   |                                           | 3,600                |                                                                                   |
| Kreda Credits                              | (53,894)                                             |            | (4,285)                                  | (58,179)             | (7,317)                                   |                     | (65,496)                                  | (7,317)           |                                           | (72,813)             | 4% of total payroll                                                               |
| <b>Total Other</b>                         | <b>(28,017)</b>                                      |            | <b>(4,285)</b>                           | <b>(32,303)</b>      | <b>(4,029)</b>                            |                     | <b>(28,305)</b>                           | <b>(4,029)</b>    |                                           | <b>(32,334)</b>      |                                                                                   |
| <b>Costs</b>                               |                                                      |            |                                          |                      |                                           |                     |                                           |                   |                                           |                      |                                                                                   |
| 500 Telephone                              | 21,648                                               |            |                                          | 21,648               |                                           |                     | 21,648                                    |                   |                                           | 21,648               | Budget \$1,000 increase for 7,250 710.                                            |
| 9080500 Water Utilities                    | 7,800                                                |            |                                          | 7,800                | 2,759                                     | (2,000)             | 8,559                                     | 2,759             |                                           | 11,318               | Rate treated as variable                                                          |
| 9090500 Electrical Utilities               | 178,433                                              |            | 7,255                                    | 185,688              | 68,898                                    | (21,535)            | 225,796                                   | 68,898            |                                           | 294,694              | 16% increase in usage and 45% increase in peak treated as variable                |
| 8130500 Depreciation                       | 705,905                                              |            |                                          | 705,905              | 259,530                                   |                     | 965,435                                   | 259,530           |                                           | 1,224,965            | Increase Capital to produce 710                                                   |
| 9440501 Property Taxes                     | 27,200                                               |            |                                          | 27,200               | 6,000                                     |                     | 33,200                                    | 6,000             |                                           | 39,200               | \$3,000 related to increased fixed assets balance related to increase inventories |
| <b>Total Fixed</b>                         | <b>940,986</b>                                       |            | <b>7,255</b>                             | <b>948,241</b>       | <b>337,187</b>                            | <b>(26,735)</b>     | <b>1,251,438</b>                          | <b>337,187</b>    |                                           | <b>1,588,625</b>     |                                                                                   |
| <b>Totals</b>                              | <b>\$12,918,700</b>                                  |            | <b>\$1,079,330</b>                       | <b>\$13,998,030</b>  | <b>\$ 658,724</b>                         | <b>\$ (113,415)</b> | <b>\$ 525,006</b>                         | <b>\$ 658,724</b> |                                           | <b>\$ 3,638,423</b>  |                                                                                   |
| <b>Direct Labor Payments</b>               | <b>\$1,560,227</b>                                   |            |                                          | <b>\$1,560,227</b>   | <b>\$ 162,917</b>                         | <b>(71,757)</b>     | <b>\$ 701,387</b>                         | <b>\$ 162,917</b> |                                           | <b>\$ 773,144</b>    |                                                                                   |
| <b>Overhead Rates</b>                      |                                                      |            |                                          |                      |                                           |                     |                                           |                   |                                           |                      |                                                                                   |
| Variable Costs                             |                                                      |            |                                          | 312.9%               |                                           |                     | 324.2%                                    |                   |                                           | 305.3%               | 291.0%                                                                            |
| Fixed Costs                                |                                                      |            |                                          | 136.0%               |                                           |                     | 178.4%                                    |                   |                                           | 185.3%               | 152.8%                                                                            |
| <b>Total</b>                               |                                                      |            |                                          | <b>448.9%</b>        |                                           |                     | <b>502.6%</b>                             |                   |                                           | <b>470.5%</b>        | <b>443.8%</b>                                                                     |
| <b>Overhead Increase/(Decrease) to 597</b> |                                                      |            |                                          | <b>N/A</b>           |                                           |                     | <b>\$ 5.43</b>                            |                   |                                           | <b>\$ 2.19</b>       | <b>\$ (0.52)</b>                                                                  |
| <b>Overhead 710s</b>                       |                                                      |            |                                          |                      |                                           |                     |                                           |                   |                                           |                      |                                                                                   |
| 7107 Overhead based on 2000 Budget         |                                                      |            |                                          | 3,130,330            |                                           |                     | 919,297                                   |                   |                                           | 850,808              | 1,217,648                                                                         |
| 7108 Overhead based on 2000 Budget         |                                                      |            |                                          |                      |                                           |                     | 2,327,332                                 |                   |                                           | 2,649,439            | 2,649,439                                                                         |
| 7109 Overhead based on 2000 Budget         |                                                      |            |                                          |                      |                                           |                     | 278,379                                   |                   |                                           | 128,177              | (30,077)                                                                          |
| <b>Total 710s</b>                          |                                                      |            |                                          | <b>3,130,330</b>     |                                           |                     | <b>3,525,006</b>                          |                   |                                           | <b>3,628,423</b>     | <b>3,837,008</b>                                                                  |

MF0030

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/05/99

C:\windows\TEMP\M710 estimate rev5.xls\Start Up Costs

|                                                  | 8/31/99  | 9/30/99   | 10/31/99  | 11/30/99  | 12/31/99  | Total 1999 | 1/31/00   | 2/29/00   | 3/31/00   | 4/30/00   | 5/31/00   | 6/30/00   | 7/31/00   | Total 2000 | Project<br>Total |
|--------------------------------------------------|----------|-----------|-----------|-----------|-----------|------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|------------|------------------|
| Direct Labor                                     | 1,183.96 | 3,188.64  | 3,188.64  | 4,555.20  | 3,471.92  | 15,988.36  |           |           | 7,109.76  | 8,809.92  | 10,200.96 | 6,800.64  |           | 32,921.28  | 48,909.64        |
| From Overhead                                    |          |           |           |           |           |            |           |           |           |           |           |           |           |            |                  |
| Setters                                          | 198.45   | -         | -         | -         | -         | 198.45     | 3,625.60  | 8,565.48  | 5,349.80  | 1,767.76  |           | 3,070.32  | 3,535.52  | 25,914.48  | 26,112.93        |
| Maintenance                                      | -        | -         | -         | -         | -         | -          | 2,582.40  | 5,084.10  | 5,717.34  | 4,198.24  | 3,148.68  | 4,253.48  | 2,099.12  | 27,083.36  | 27,083.36        |
| EBs                                              | 801.79   | 1,849.41  | 1,849.41  | 2,642.02  | 2,245.71  | 9,388.35   | 8,600.64  | 7,916.76  | 10,542.60 | 8,570.03  | 7,742.79  | 8,192.18  | 3,268.09  | 49,833.09  | 59,221.44        |
| Other Costs                                      |          |           |           |           |           |            |           |           |           |           |           |           |           |            |                  |
| Material for Receiver/Bolt Body                  |          | 10,500.00 | 10,500.00 | 10,500.00 | 10,500.00 | 42,000.00  |           |           |           |           |           |           |           |            | 42,000.00        |
| Material for 1,000 Learning<br>Guns (\$43.86/ea) |          |           |           |           |           |            |           |           | 21,930.00 | 21,930.00 |           |           |           | 43,860.00  | 43,860.00        |
| Material for 60 T&P<br>Guns (\$43.86/ea)         |          |           |           |           |           |            |           |           |           | 1,315.80  | 1,315.80  |           |           | 2,631.60   | 2,631.60         |
| Material for 30 DAT<br>Guns (\$43.86/ea)         |          |           |           |           |           |            |           |           |           |           |           | 1,315.80  |           | 1,315.80   | 1,315.80         |
| 15,000 rns of Ammo                               |          |           |           |           |           |            |           |           | 600.00    | 1,200.00  | 600.00    | 600.00    |           | 3,000.00   | 3,000.00         |
| Disassembly & Rearrange                          |          |           |           |           |           |            |           |           | 6,000.00  |           |           |           |           | 6,000.00   | 6,000.00         |
| Tooling & Inspection                             |          | 16,250.00 | 16,250.00 | 16,250.00 | 16,250.00 | 65,000.00  |           |           |           |           |           |           |           |            | 65,000.00        |
| Prototype Parts                                  |          |           |           |           |           |            | 8,000.00  | 8,000.00  | 8,000.00  | 8,000.00  |           |           |           | 32,000.00  | 32,000.00        |
| Material Handling Purchases                      |          |           |           |           |           |            |           |           |           |           | 19,333.33 | 19,333.33 | 19,333.33 | 58,000.00  | 58,000.00        |
| Miscellaneous                                    |          |           |           |           |           |            | 286.00    | 286.00    | 286.00    | 286.00    | 286.00    | 286.00    | 286.00    | 2,000.00   | 2,000.00         |
| 1999 startup Costs                               | 2,184.20 | 31,788.05 | 31,788.05 | 33,947.22 | 32,867.63 | 132,575.15 | 18,094.35 | 29,852.05 | 65,535.22 | 58,077.47 | 42,627.28 | 43,851.46 | 28,521.78 | 284,559.61 | 417,134.76       |

MF0031

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/05/99

C:\windows\TEMP\[M710 estimate rev5.xls]Head Count

|                                                 | 69,000 597s<br>0 710s | 51,300 597s<br>20,000 710s | 58,400 597s<br>20,000 710s | 58,400 597s<br>30,000 710s |
|-------------------------------------------------|-----------------------|----------------------------|----------------------------|----------------------------|
| Guns Produced                                   | 69,000                | 71,300                     | 78,400                     | 88,400                     |
| Guns Per Day                                    | 285                   | 295                        | 324                        | 365                        |
| Hours Earned                                    | 71,162                | 71,359                     | 78,682                     | 87,907                     |
| Hours Per Head Count<br>(242*8 hrs)             | 1,936                 | 1,936                      | 1,936                      | 1,936                      |
| Head count Required with no time off or OT      | 36.8                  | 36.9                       | 40.6                       | 45.4                       |
| Vacation and Floating Holidays<br>(3/242=1.23%) | 0.5                   | 0.5                        | 0.5                        | 0.6                        |
| Sick and Other 1.8%                             | 0.7                   | 0.7                        | 0.7                        | 0.8                        |
| Add 3% inefficiency                             | 1.1                   | 1.1                        | 1.2                        | 1.4                        |
| Less 3% OT                                      | (1.1)                 | (1.1)                      | (1.2)                      | (1.4)                      |
| Required Head Count                             | 37.9                  | 38.0                       | 41.9                       | 46.8                       |
| Actual Head Count                               | 37.5                  | 37.5                       | 37.5                       | 37.5                       |
| Over/(Under) Staffing                           | (0.4)                 | (0.5)                      | (4.4)                      | (9.3)                      |

MF0032

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/05/99

C:\windows\TEMP\{M710 estimate rev5.xls}710 capital by operation

## In House Capital

| Part Name                  | Operation                  | Equipment              | Capital Required |         | Useful Lif  | Depreciation |     |
|----------------------------|----------------------------|------------------------|------------------|---------|-------------|--------------|-----|
| Barrel                     | Cut off                    |                        | \$0              |         |             |              |     |
|                            | Drill                      | cones                  | \$9,960          | Dec-99  | 10          | 996          |     |
|                            | Ream                       |                        | \$0              |         | 10          | -            |     |
|                            | Rifle                      | gages                  | \$9,800          | Feb-00  | 10          | 980          |     |
|                            | Wash & Stress Relieve      | baskets                | \$6,900          | Feb-00  | 10          | 690          |     |
|                            | Turn                       | gages                  | \$10,100         | Feb-00  | 10          | 1,010        |     |
|                            | Face & Chamber             | gages                  | \$33,300         | Apr-00  | 10          | 3,330        |     |
|                            | Face & Chamber             | machine                | \$222,880        | Mar-00  | 10          | 22,288       |     |
|                            | Cut off and Crown          | chuck                  | \$15,000         | Jan-00  | 10          | 1,500        |     |
|                            | wash and eddy current test | machine                | \$75,000         | Mar-00  | 10          | 7,500        |     |
|                            | Induction Harden           | machine                | \$166,000        | Mar-00  | 10          | 16,600       |     |
|                            | Inspect Hardness           | machine                | \$12,000         | Mar-00  | 10          | 1,200        |     |
|                            | Drill and tap sight        | fix & gages            | \$7,600          | Feb-00  | 10          | 760          |     |
|                            | Roll mark                  | fix & gages            | \$6,300          | Apr-00  | 10          | 630          |     |
|                            | Angularity Straighten      | fix & gages            | \$3,500          | Feb-00  | 10          | 350          |     |
|                            | Centerless Polish          |                        | \$0              |         | 10          | -            |     |
|                            | Glass Bead Blast           | fixtures               | \$2,500          | Jan-00  | 10          | 250          |     |
|                            | Color                      | racks                  | \$6,000          | Jan-00  | 10          | 600          |     |
|                            | Bolt Head                  | Inspect Purchased Part |                  |         |             |              |     |
|                            |                            | Blank                  | gage             | \$2,500 | Feb-00      | 10           | 250 |
| Superabrasive Grind Lugs   |                            | fix & gage             | \$43,800         | Feb-00  | 10          | 4,380        |     |
| CNC Machine Bolt Face      |                            |                        |                  |         |             |              |     |
| Complete                   |                            | fix & gage             | \$174,784        | Mar-00  | 10          | 17,478       |     |
| CNC Machine Cam Cuts       |                            |                        |                  |         |             |              |     |
| Ejector Retaining Pin Hole |                            | fix & gage             | \$15,000         | Mar-00  | 10          | 1,500        |     |
| CNC Machine Bolt Head      |                            |                        |                  |         |             |              |     |
| Retaining Pin Hole         |                            | fix & gage             | \$15,000         | Mar-00  | 10          | 1,500        |     |
| Punch Form Extractor       |                            |                        |                  |         |             |              |     |
| Rotation Notch             |                            | fix & gage             | \$10,000         | Jan-00  | 10          | 1,000        |     |
| Venadr Heat Treat          |                            |                        | \$0              |         | 10          | -            |     |
| Inspect for Hardness       |                            |                        | \$0              |         | 10          | -            |     |
| Black Oxide                |                            | \$0                    |                  | 10      | -           |              |     |
| Bolt Body                  | Inspect Purchased Part     |                        |                  |         |             |              |     |
|                            | Blank                      | gage                   | \$2,000          | Jan-00  | 10          | 200          |     |
|                            | Machine Cam Cuts           | machine                | \$0              | Feb-00  | 10          | -            |     |
|                            | Assemble Braze Bolt        | machine                | \$90,000         | Mar-00  | 10          | 9,000        |     |
|                            | Deplate                    | tanks                  | \$9,500          | Jan-00  | 10          | 950          |     |
|                            | Eddy Current Test          |                        | \$0              |         | 10          | -            |     |
|                            | Glass Bead Blast           | fix                    | \$2,500          | Jan-00  | 10          | 250          |     |
|                            | Black Oxide                |                        | \$0              |         | 10          | -            |     |
| Receiver                   | Inspect Purchased Part     |                        |                  |         |             |              |     |
|                            | Blank                      | gage                   | \$2,500          | Jan-00  | 10          | 250          |     |
|                            | Machine A-load             | machine & CM           | \$513,831        | Feb-00  | 10          | 51,383       |     |
|                            | Machine B-load             |                        | \$0              | Feb-00  | 10          | -            |     |
|                            | Vibratory tumble deburr    |                        | \$0              |         | 10          | -            |     |
| Barrel Assembly            | Press Receiver to Barrel   | fixture                | \$0              | Dec-99  | Ilion Equip | 10           | -   |

MF0033

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/05/99

C:\windows\TEMP\M710 estimate rev5.xls]710 capital by operation  
Inspect for straightness gage \$3,500

Dec-99 10 350

| Final Assembly | Gallery | 100yd range | \$100,000 | Dec-99 | 25 | 4,000 |
|----------------|---------|-------------|-----------|--------|----|-------|
|                |         | snails      | \$30,000  | Jul-00 | 25 | 1,200 |
|                |         | HVAC        | \$25,000  | Jun-00 | 10 | 2,500 |
|                |         | other       | \$10,000  | Mar-00 | 25 | 400   |
|                |         |             |           |        | 25 | -     |
|                |         |             | \$100,000 | Mar-00 | 25 | 4,000 |
|                |         |             | \$65,000  | Jul-00 | 25 | 2,600 |

\$1,801,755

## Purchased Parts

| Part #   | Part Name          | Capital   | Tool            | Vendor         | Jun-99 | 5 | 8,600  | Payments | 83     |
|----------|--------------------|-----------|-----------------|----------------|--------|---|--------|----------|--------|
| 300327 ✓ | Receiver Insert    | 48,000    | Mold            | Hanson         | Dec-99 | 5 | 2,000  | Mar-00   | Apr-00 |
| 300333 ✓ | Side Plate         | 10,000    | Stamping Die    |                | Dec-99 | 5 | 4,776  | Mar-00   | Apr-00 |
| 300334 ✓ | Safety Arm         | 23,880    | Stamping Die    | NH Stamping    | Dec-99 | 5 | 1,354  | Mar-00   | Apr-00 |
| 300345   | Bolt Stop          | 6,820     | PM              | Sterling       | Dec-99 | 5 | 445    | Mar-00   | Apr-00 |
| 300361   | Recoil Bracket     | 2,225     | Stamping Die    | NH Stamping    | Dec-99 | 5 | 2,560  | Mar-00   | Apr-00 |
| 300360   | Bolt Handle Blank  | 12,800    | Invest Cast Die | Faststeel      | Dec-99 | 5 | -      | Mar-00   | Apr-00 |
| 300366   | Bolt H. Braze Shim | 0         | Use Paste       | Lucas Milhaupt | Dec-99 | 5 | 7,618  | Mar-00   | Apr-00 |
| 300368   | Bolt Plug          | 38,088    | Mold            | Par 4          | Dec-99 | 5 | 4,600  | Mar-00   | Apr-00 |
| 300336   | Firing pin head    | 23,000    | MM Mold         | Megamet        | Dec-99 | 5 | 6,896  | Mar-00   | Apr-00 |
| 300362   | Mag Latch          | 33,480    | Mold            | Par 4          | Dec-99 | 5 | 5,600  | Mar-00   | Apr-00 |
| 300363   | Magazine Box       | 28,000    | Mold            | Morrissey      | Dec-99 | 5 | 6,660  | Mar-00   | Apr-00 |
| 300364   | Magazine Follower  | 433,300   | Mold            | Par 4          | Dec-99 | 5 | 9,576  | Mar-00   | Apr-00 |
| 300365   | Magazine Bottom    | 47,880    | Mold            | Par 4          | Dec-99 | 5 | 30,060 | Mar-00   | Apr-00 |
|          | Stock              | 150,300   | Mold            | Par 4          | Dec-99 | 5 | -      | Mar-00   | Apr-00 |
|          | Styrofoam Bed      | 0         | Die             | Tuscorora      | Dec-99 | 5 | -      | Mar-00   | Apr-00 |
|          | PPI                | 38000     |                 |                |        |   |        |          |        |
|          |                    | \$495,773 |                 |                |        |   |        |          |        |

|              |                    |                |
|--------------|--------------------|----------------|
| Total        | \$2,297,528        | 253,430        |
| Installation | \$61,000           | 10 6,100       |
|              | <u>\$2,358,528</u> | <u>259,530</u> |

Add:

TRIGGER → \$ \_\_\_\_\_ CAPITAL → \$ \_\_\_\_\_ PART  
 SAFETY BUTTON → \$ \_\_\_\_\_ CAPITAL → \$ \_\_\_\_\_ PART  
 MAGAZINE GLIDE → \$ \_\_\_\_\_ CAPITAL → \$ \_\_\_\_\_ PART  
 BOLT

FIREARM FOR ASS FIX \$ 5000  
 BOLT HANDLE FOR FIX \$ 2000  
 MAGAZINE BODY CRACKED. PRINTER \$ 9000  
 COMPARTMENT \$ 10,000

Page 11

MF0034

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

10/05/99

C:\windows\TEMP\[M710 estimate rev5.xls]Working Capital

|                                               |         |         |
|-----------------------------------------------|---------|---------|
| Units of 710                                  | 20,000  | 30,000  |
| Stores                                        |         |         |
| Theses are primarily specialty Cutters Assume |         |         |
| 3 months in Inventory                         | 34,500  | 51,750  |
| Raw Material                                  |         |         |
| 597 Raw material approaching 6 turns          |         |         |
| 2 months in Inventory                         | 143,514 | 215,271 |
| Work In Process                               |         |         |
| 597 WIP approaching 18 turns                  |         |         |
| .75 Months in Inventory                       | 111,157 | 156,654 |
| Finished Goods                                |         |         |
| Sale better than 597                          |         |         |
| 1 Month in Inventory                          | 163,608 | 231,970 |
| Total Inventory                               | 452,778 | 655,645 |
| Increase in A/P                               |         |         |
| 45 Days of Stores & Raw Material              | 126,385 | 189,578 |
| Increase in Working Capital                   | 326,393 | 466,067 |

MF0035

**Golemboski, Matt R.**

---

**From:** Chamblee, Danny  
**Sent:** Thursday, October 14, 1999 8:53 AM  
**To:** Golemboski, Matt R.  
**Subject:** FW: carton cost

**Importance:** High

.....  
**From:** Krol, Richard J.  
**Sent:** Thursday, October 14, 1999 8:56 AM  
**To:** Bristol, II Ronald H.  
**Cc:** Chamblee, Danny; Tucker, Peter L.  
**Subject:** FW: carton cost  
**Importance:** High

Ron,  
Attached analysis per your request.

.....  
**From:** Tucker, Peter L.  
**Sent:** Wednesday, October 13, 1999 5:52 PM  
**To:** Krol, Richard J.  
**Subject:** carton cost



carton cost 2.xls

Check before you send

CONFIDENTIAL 83

Remington Arms Company, Inc  
Carton Costs

10/15/99 11:33

|                  | 25287 | 25791 | 25568 | 24720 | Ilion SKU |
|------------------|-------|-------|-------|-------|-----------|
| Model            | Model | Model | Model | Model |           |
| 597              | 1187  | 700   | 870   | 7     |           |
| Overpack         | 0.16  |       |       |       |           |
| Carton           | 0.49  | 1.21  | 1.21  | 1.21  | 1.21      |
| Styrofoam Bed    | 0.90  | 0.76  | 0.75  | 0.76  | 0.75      |
| Box end Label    |       | 0.01  | 0.01  | 0.01  | 0.01      |
| Build to Label   |       | 0.01  | 0.01  | 0.01  | 0.01      |
| Assembly Charge* | 0.31  | *     | *     | *     | *         |
|                  | 1.86  | 1.99  | 1.98  | 1.99  | 1.98      |

\* included in carton Price

|                   |      |      |      |      |      |
|-------------------|------|------|------|------|------|
| Document Inserts  |      |      |      |      |      |
| Museum/Store card |      | 0.01 | 0.01 | 0.01 | 0.01 |
| Envelope          | 0.08 | 0.08 | 0.08 | 0.08 | 0.08 |
| Users Manual      | 0.15 | 0.70 | 0.63 | 0.68 | 0.72 |
| Gun Smith List    | 0.06 | 0.07 | 0.07 | 0.07 | 0.07 |
| Safety Guide      | 0.11 | 0.10 | 0.10 | 0.10 | 0.10 |
| Label             | 0.01 | 0.01 | 0.01 | 0.01 | 0.01 |
| Shotgun guide     |      |      |      | 0.01 |      |
| Owners Card       | 0.03 | 0.03 | 0.03 | 0.03 | 0.03 |
| Assembly Charge   | 0.08 | 0.08 | 0.08 | 0.08 | 0.08 |
|                   | 0.51 | 1.08 | 1.01 | 1.05 | 1.09 |
| Total Box         | 2.37 | 3.07 | 2.99 | 3.05 | 3.07 |

**Note:**

Overpack - This item is expensed in Ilion; not used as extensively as in Mayfield

Carton Cost - Need to combine carton cost + assembly charge for comparative purposes; appears that buying practices are different between sites, which accounts for Mayfield's lower piece price, but may be somewhat offset with inventory carrying cost

User Manuals - Ilion's are "trilingual"

MF0037

**Golemboski, Matt R.**

---

**From:** Chamblee, Danny  
**Sent:** Tuesday, October 12, 1999 2:10 PM  
**To:** Bristol, II Ronald H.  
**Cc:** Brueckmann, William R.; Golemboski, Matt R.  
**Subject:** M710 estimate rev5.xls

Ron,

Attached is updated model 710 costing with changes to the startup cost schedule and Revised Capital-Capital Spend out sheet.

If you have any questions or comments, please let me or Matt know.

Thanks,  
Danny



M710 estimate rev5

CONFIDENTIAL

Golemboski, Matt R.

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**From:** Chamblee, Danny  
**Sent:** Wednesday, October 13, 1999 2:23 PM  
**To:** Golemboski, Matt R.  
**Subject:** FW: Model 710 - Option Y

FYI

.....  
**From:** Brueckmann, William R.  
**Sent:** Wednesday, October 13, 1999 2:21 PM  
**To:** Bristol, II Ronald H.  
**Cc:** Chamblee, Danny  
**Subject:** Model 710 - Option Y

Attached are worksheets showing the results of Mayfield's re-evaluation of the Model 710 economics. In summary, an additional \$159,000 of capital was added from Option X which increased Cost of Manufacturing from \$92.79 to \$93.17 due to the additional depreciation.

ROIC (with startup costs) decreased from 29.9% to 28.0%  
ROIC (without startup costs) decreased from 46.6% to 43.9%  
IRR decreased from 20.7% to 19.4%  
NPV decreased from \$729,000 to \$648,000  
Cash Flow Payback Month increased from 49 to 53

I need to point out that these calculations do not consider the effect of the additional overhead that allion products will have to absorb due to the 700 ADL replacement volume.

I am available to review or discuss this with you at your convenience.

  
M710OPTY.xls

  
M710 Y Comparison.xls

  
M710 Assumptions  
Option Y.doc

Remington Arms Company, Inc.  
 Sportsman Model 710 Centerfire Rifle - Option Y  
 Mayfield Manufactured  
 Sales Volume and Selling Prices  
 (Dollars per Gun)

|                                                    | Sales Volume and Selling Prices |           |           |           |
|----------------------------------------------------|---------------------------------|-----------|-----------|-----------|
|                                                    | 2000                            | 2001      | 2002      | 2003      |
| Sales Volume (Guns)<br>All SKU's                   | 6,000                           | 30,000    | 38,000    | 38,000    |
| Manufacturer's Suggested Retail Price<br>All SKU's | \$ 355.00                       | \$ 355.00 | \$ 355.00 | \$ 355.00 |
| Manufacturer's Selling Price<br>All SKU's          | \$ 269.00                       | \$ 269.00 | \$ 269.00 | \$ 269.00 |
| Net Selling Price<br>All SKU's                     | \$ 221.41                       | \$ 217.51 | \$ 217.51 | \$ 217.51 |

10/15/99

MF0040

October 13, 1999

Remington Arms Company, Inc.  
Sportsman Model 710 Centerfire Rifle  
Financial Model Assumptions

Options

Option Y – 6,000 unit volume in 4<sup>th</sup> quarter, 2000. 30,000 unit volume in 2001 and 38,000 unit volume in 2002 and 2003. 50% replacement volume. 1 Selling price. Mayfield manufactured. Assumed that scope combo would be a pass-through of cost only with no impact on margin

Capital Investment

Provided by plants. Additional \$809,000 required for manufacturing at Mayfield versus Ilion

Sales Volume

Provided by Marketing. See option variations above. Assumed sales begin in October, 2000

Manufacturers Selling Price

Provided by Marketing. Assumed no price increase in each of the next four years for either the Model 710 or the replacement volume. Pricing assumed that all sales would be Wal\*Mart in 2000 and then all channels in 2001 – 2003.

Manufacturers Suggested Retail Price

Assumed MSP x 1.32

Net Selling Price

Assumed standard discounts and terms from 2000 Budget calculation for 2001 – 2003. All sales to Wal\*Mart in 2000

Standard Cost

Provided by Mayfield. Assumed 1.5% cost increase overall per unit per year

Period Expense and Manufacturing Cost Variances

No manufacturing cost variances included. 3.08% of standard cost included in period expense for scrap and warranty. Startup costs provided by plant and are included in Cash Flow calculation. Startup costs also include \$100,000 of Marketing Expense. An additional \$100,000 of startup costs required for Mayfield options for machinery relocations.

Distribution Expense

Used \$2.25 x Sales Volume

MF0041

Commission Expense  
Used 1.0% x Net Sales

Bad Debt  
Used 0.7% x Net Sales

Marketing Expense  
Used \$1.00 x Sales Volume

Product Related Expense  
Used \$2.00 x Sales Volume

Interest Expense  
Used 8.0% annual interest rate and applied it to Capital Investment and the Average Annual Working Capital

Depreciation  
Provided by Mayfield

Inventory  
Raw Material – Assumed 5.3 turns. Based on Cost of Mfg 3<sup>rd</sup> month in future  
Semifinished – Assumed 8.2 turns. Based on Cost of Mfg 2<sup>nd</sup> month in future  
Finished Product – Assumed 12.0 turns. Based on Cost of Mfg 1<sup>st</sup> month in future

Accounts Receivable  
Assumed standard Firearms programs

Cash Flow  
Startup Costs are included in the first year. No impact for the positive impact of reducing other products' overhead costs.

Cash Flow Measures  
Discounted at an assumed 12% Cost of Capital using a five-year stream of cash flows

ROIC Calculation  
Assumed 20% of Inventory and Accounts Receivable would be Liabilities and credited to Investment. ROIC calculated with and without the effect of Startup Expense

MF0042

**Golemboski, Matt R.**

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**From:** Chamblee, Danny  
**Sent:** Tuesday, October 05, 1999 10:26 AM  
**To:** Golemboski, Matt R.  
**Subject:** FW: Model 710 Projection - Option X

FYI

**From:** Brueckmann, William R.  
**Sent:** Tuesday, October 05, 1999 10:24 AM  
**To:** Bristol, II Ronald H.  
**Cc:** Chamblee, Danny  
**Subject:** Model 710 Projection - Option X

Using the information you provided me from Danny Chamblee last Friday, I have recalculated the Model 710 project returns.

The project assumes 6,000 units will be sold in 4<sup>th</sup> quarter, 2000 and 30,000 units in 2001 and 38,000 units in 2002 and 2003 with a 50% replacement volume of the Model 700 ADL Synthetic. MSP is \$269

The last iteration of this project was completed on August 5. This version requires an additional \$459,000 of capital and \$194,000 of startup costs. Cost of Manufacturing has increased \$2.12 per unit. Finished Product Turns were decreased to 12.0 from 14.1. IRR is now 20.7% versus 24.5% 2 months ago. NPV is now \$729,000 versus \$937,000 with payback at 49 months versus 36 months. ROIC with startup costs is 29.9% versus 42.6%. ROIC without startup costs is 46.6% versus 54.9%

Summary files are attached. I'm available to review any of this at your convenience



M710OPTX.xls



M710 X Comparison.xls



M710 Assumptions  
Option X.doc

October 5, 1999

Remington Arms Company, Inc.  
Sportsman Model 710 Centerfire Rifle  
Financial Model Assumptions

Options

Option X – 6,000 unit volume in 4<sup>th</sup> quarter, 2000. 30,000 unit volume in 2001 and 38,000 unit volume in 2002 and 2003. 50% replacement volume. 1 Selling price. Mayfield manufactured. Assumed that scope combo would be a pass-through of cost only with no impact on margin

Capital Investment

Provided by plants. Additional \$809,000 required for manufacturing at Mayfield versus Ilion

Sales Volume

Provided by Marketing. See option variations above. Assumed sales begin in October, 2000

Manufacturers Selling Price

Provided by Marketing. Assumed no price increase in each of the next four years for either the Model 710 or the replacement volume. Pricing assumed that all sales would be Wal\*Mart in 2000 and then all channels in 2001 – 2003.

Manufacturers Suggested Retail Price

Assumed MSP x 1.32

Net Selling Price

Assumed standard discounts and terms from 2000 Budget calculation for 2001 – 2003. All sales to Wal\*Mart in 2000.

Standard Cost

Provided by Mayfield. Assumed 1.5% cost increase overall per unit per year

Period Expense and Manufacturing Cost Variances

No manufacturing cost variances included. 3.08% of standard cost included in period expense for scrap and warranty. Startup costs provided by plant and are included in Cash Flow calculation. Startup costs also include \$100,000 of Marketing Expense. An additional \$100,000 of startup costs required for Mayfield options for machinery relocations.

Distribution Expense

Used \$2.25 x Sales Volume

MF0044

Commission Expense  
Used 1.0% x Net Sales

Bad Debt  
Used 0.7% x Net Sales

Marketing Expense  
Used \$1.00 x Sales Volume

Product Related Expense  
Used \$2.00 x Sales Volume

Interest Expense  
Used 8.0% annual interest rate and applied it to Capital Investment and the Average Annual Working Capital

Depreciation  
Provided by Mayfield

Inventory  
Raw Material – Assumed 5.3 turns. Based on Cost of Mfg 3<sup>rd</sup> month in future  
Semifinished – Assumed 8.2 turns. Based on Cost of Mfg 2<sup>nd</sup> month in future  
Finished Product – Assumed 12.0 turns. Based on Cost of Mfg 1<sup>st</sup> month in future

Accounts Receivable  
Assumed standard Firearms programs

Cash Flow  
Startup Costs are included in the first year. No impact for the positive impact of reducing other products' overhead costs

Cash Flow Measures  
Discounted at an assumed 12% Cost of Capital using a five-year stream of cash flows

ROIC Calculation  
Assumed 20% of Inventory and Accounts Receivable would be Liabilities and credited to Investment. ROIC calculated with and without the effect of Startup Expense

MF0045

**Chamblee, Danny**

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**From:** Zajk, Joseph J  
**Sent:** Saturday, August 28, 1999 1:08 PM  
**To:** Golemboski, Matt R.  
**Cc:** Chamblee, Danny  
**Subject:** Model 710 Variable Tooling Costs

I reviewed the tooling cost of the barrel chamber operation. Based on that review, I made the following changes:

- Reviewed Ilion chamber tooling costs in SAP, using the actual tool dwg. #'s from Vaxcamps process. All of our chamber tooling estimates were very high (my fault; I think I gave Jason some prototype tooling costs by accident). Since our tooling will not differ markedly from Ilion's, and some will be essentially identical, I used the SAP cost for our tooling where applicable.
- Made some other minor corrections, like taking into account that a turning insert will have 4 sides, so tool life would be 4X, etc.

The net result was a reduction in the chamber tooling cost by app. \$1.25. The new variable tooling cost for barrel chamber is about \$2.82. By far the majority of this cost came from applying the Ilion prices to our special chamber tooling.

The receiver #'s look OK.

The bolt body #'s may change. I couldn't find Jason's & Scott's turning center information for the bolt body. The tooling cost will probably be the same, but the pre-op & startup may change due to replacing CV-40 toolholders with the turning center tooling. I'll have to get that stuff Monday morning from them.

J. Z.

Remington Arms Company, Inc.  
August 16, 1999

CONFIDENTIAL

Research and Development Technology Center  
Elizabethtown, Kentucky

Trip Report  
M/710 Manufacturing/Assembly Review  
Mayfield Facility  
August 12, 1999

Following the July 20 design review, the Mayfield facility received multiple samples of M/710 receiver insert assembly components. Throughout the past month, the assemblers have been working with the components to generate an understanding of the functional aspects as well as assembly times for estimating purposes. All other departments have been developing proposed processes and estimates. This review was scheduled to discuss recent concerns and suggestions for design/cost improvements. The following is a list of the issues discussed during the review.

**Trigger Adjustment** -- Several assemblies were noted as difficult to adjust.

**Side Plate Retention** -- Adjustment screws force the side plate to tilt away from the receiver insert. A third rivet may be required to properly retain the side plate.

**Stock Design** -- Mayfield requested a barrel contact pad at fore end of stock. Based on issues with M/597 barrel free floating, a contact pad will ensure proper barrel/stock margins.

**Ejection Port Margins** -- Allowable margin between steel receiver and synthetic receiver insert needs to be specified.

**Front Sight** -- Mayfield suggested using the one piece M/597 sight versus the proposed two piece M/700 front sight. M/597 sight is .100" shorter than M/700, not able to add use.

**Barrel Length** -- Mayfield would like 22" long action/24" magnum barrel lengths if Marketing must have a 24" magnum barrel. Otherwise make all barrels common length either 20" or 22" based on Marketing direction. They do not want to make 20" long action/22" magnum combination.

**Final Inspection** -- Minimum inspections required to include trig pull, safety function, seat lift, head space, and firing pin lock.

**Receiver Concentricity** -- Mayfield requested concentricity specification for receiver, .010 concentricity to be added to drawing.

**Bolt Head** -- Alter C datum lug specification due to ejector retaining pin hole location.

Other topics discussed during review:

Mayfield will investigate a common carton for the M/710 and M/597.

The DAT rifles will be assembled in Mayfield.

Design change of the Receiver Insert to cover the gap between the safety arm/rec. insert/stock, also include "F" and "S" designations molded into rec. insert.

Discussed/reviewed the M/700 firing pin lock design and incorporating into M/710.

Michael D. Keeney  
Staff Engineer

Page 1 of 1

TrpRpt8-12-99

MF0047

## NEW PRODUCT PROPOSAL

### PRODUCT DESCRIPTION: Sportsman Model 710 Bolt Action Rifle

This proposal is to develop a low cost, high margin, centerfire bolt action rifle targeted at the economy price market. Development of the Model 710 should be based on:

- Reduced Cost Of Manufacture
- Reduced Manufacturing Lead Time
- Ease Of Use
- Low Development Cost
- Low Capital Investment
- Above Average Gross Profit (45%)

The Model 710 should provide the following features:

- Short, Long And Magnum Calibers
- Standard Barrel Lengths (22" & 24")
- Synthetic And Wood Stock Versions
- Floor Plate Or Magazine Box (Lowest Cost)
- Reasonable Bolt Action Trigger
- Scope Base Mounting Capability
- Optional Iron Sights
- Low Cost Metal Finish
- Right And Left Hand Configurations

Along with the standard configurations, scope combo packages will also be offered. These would include mounting and bore sighting a low cost 3-9 power scope on the rifle.

### MARKET OVERVIEW:

Remington is currently the market share leader in the centerfire bolt action market. However, this position has been threatened as a result of aggressive competitive pricing, expanding competitive offerings and a saturation of high-end niche markets.

Significant volume in this market has migrated to the economy segment where Savage and USRAC have carved a niche and gained share. Remington is not positioned with the Model 700 family to compete effectively in this segment which is controlled by the mass merchants. A new introduction in the form of the Sportsman Model 710 will provide the opportunity for Remington to capture a share of this emerging market segment while maintaining a significant presence in the high-end segment with the Model 700.

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MF0048

PROPOSED TIMING: 2000 Catalog

VOLUME:

| <u>Year 1</u> | <u>Year 2</u> | <u>Year 3</u> |
|---------------|---------------|---------------|
| 40,000        | 50,000        | 55,000        |

Replacement volume detail: 15,000 Replacement of the current M/700 ADL Syn

PRICING:

MSP: \$229

Target Std. Gross Profit: 45%

NSP: \$188

Target Cost: \$103

PROJECT RESPONSIBILITY: E-Town - D. Diaz

PREPARED BY: \_\_\_\_\_ APPROVED BY: \_\_\_\_\_

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MF0049

CONFIDENTIAL

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ESTIMATE AND  
NORAD 057 64X

MF0050

| Description                       | Items                          | Part #       | Vendor | Lead time | Total Capital | Nov     | Dec    | Jan      | Feb    | Mar     | Apr     | May    | Jun | July | Aug |
|-----------------------------------|--------------------------------|--------------|--------|-----------|---------------|---------|--------|----------|--------|---------|---------|--------|-----|------|-----|
| Carton Assembly                   |                                | 1444         |        |           |               |         |        |          |        |         |         |        |     |      |     |
|                                   | Carton Dies                    | 0            |        |           |               |         |        | 0        |        | 0       | 0       |        |     |      |     |
|                                   | Insert Dies                    | 0            |        |           | \$19,000      |         |        | 6,333    |        | 6,333   | 6,333   |        |     |      |     |
| Box and Envelope Label (710)      |                                | 993002       |        |           |               |         |        |          |        |         |         |        |     |      |     |
|                                   |                                | 0            |        |           |               |         |        |          |        |         |         |        |     |      |     |
| Barrel Assembly Complete          |                                | 305410       |        |           | \$0           |         |        |          |        |         |         |        |     |      |     |
| Barrel Assembly                   |                                | 305400       |        |           | \$0           |         |        |          |        |         |         |        |     |      |     |
| Barrel                            | Machine & gages                | 305315       |        |           |               |         |        |          |        |         |         |        |     |      |     |
|                                   | Cut to length                  |              |        |           |               |         |        |          |        |         |         |        |     |      |     |
|                                   | Gundrill Bore                  |              |        |           |               |         |        |          |        |         |         |        |     |      |     |
|                                   | Ream Bore                      | hyd pump     |        |           | \$5,080       | 6,080   |        |          |        |         |         |        |     |      |     |
|                                   | Rifle Bore                     |              |        |           | \$15,900      | 7,950   |        | 7,950    |        |         |         |        |     |      |     |
|                                   | Stress Relieve                 | baskets      |        |           | \$7,000       |         | 7,000  |          |        |         |         |        |     |      |     |
|                                   | Turn OD                        | gages        |        |           | \$5,000       |         | 5,000  |          |        |         |         |        |     |      |     |
|                                   | Face and Chamber               | gages        |        |           | \$31,000      |         | 15,000 | 14,000   | 2,000  |         |         |        |     |      |     |
|                                   | Face and Chamber               | machine      |        |           | \$189,448     | 63,149  |        |          |        | 63,149  |         | 63,149 |     |      |     |
|                                   | Cut off and crown Muzzle       | chuck head   |        |           | \$15,800      |         |        |          | 15,000 |         |         |        |     |      |     |
|                                   | Drill and Tap Holes, Mill Slot | fixture&gage |        |           | \$7,600       |         |        | 7,600    |        |         |         |        |     |      |     |
|                                   | Wash                           | 0            |        |           | \$0           |         |        |          |        |         |         |        |     |      |     |
|                                   | Heat Treat                     |              |        |           | \$75,000      |         | 58,333 |          | 58,333 | 58,333  |         |        |     |      |     |
|                                   | Inspect Hardness               |              |        |           | \$15,000      |         |        |          | 15,000 |         |         |        |     |      |     |
|                                   | Acid Wash                      | 0            |        |           | 0             |         |        |          |        |         |         |        |     |      |     |
|                                   | Centerless Polish              | 0            |        |           | 0             |         |        |          |        |         |         |        |     |      |     |
|                                   | Eddy Current Test              |              |        |           | \$84,500      |         | 34,833 |          | 34,833 | 34,833  |         |        |     |      |     |
|                                   | Press Barrel to Receiver       |              |        |           | \$11,000      | 11,000  |        |          |        |         |         |        |     |      |     |
|                                   | Rollmark                       |              |        |           | 6,300         |         |        | 6,300    |        |         |         |        |     |      |     |
|                                   | Angularity Straighten          |              |        |           | 3,500         |         | 3,500  |          |        |         |         |        |     |      |     |
|                                   | Centerless Polish              |              |        |           |               |         |        |          |        |         |         |        |     |      |     |
|                                   | Glass Bead Blast               |              |        |           | 2,500         |         | 2,500  |          |        |         |         |        |     |      |     |
|                                   | Black Oxide                    |              |        |           | 6,000         |         | 6,000  |          |        |         |         |        |     |      |     |
| Receiver                          | LT15                           | 300340       |        |           | \$436,756     | 145,585 |        |          |        | 145,585 | 145,585 |        |     |      |     |
|                                   | CMM                            |              |        |           | \$45,000      |         |        | 22,500   |        | 22,500  |         |        |     |      |     |
|                                   | CMM Gage                       |              |        |           |               |         |        |          |        |         |         |        |     |      |     |
|                                   | Vibratory Deburr               |              |        |           |               |         |        |          |        |         |         |        |     |      |     |
| Receiver Insert Assembly Complete | Comparator and fixture         | 300401       |        |           | \$12,000      |         | 2,800  | 2,800    | 8,000  |         |         |        |     |      |     |
| Receiver Insert Assembly          | ultrasonic weld fixture        | 300400       |        |           | \$4,000       |         |        | 4,000    |        |         |         |        |     |      |     |
| Receiver Insert                   | Hanson Mold                    | 300327       |        |           | \$48,000      |         |        | \$48,000 |        |         |         |        |     |      |     |
|                                   | PPI Fixture                    |              |        |           | \$2,500       |         |        | 2,500    |        |         |         |        |     |      |     |
| Side Plate                        | Stamping Die                   | 300333       |        |           | \$13,000      |         |        | 4,333    |        | 4,333   | 4,333   |        |     |      |     |
|                                   | PPI Fixture                    |              |        |           | \$1,500       |         |        |          |        | 1,500   |         |        |     |      |     |
| Sear Safety Cam                   |                                | 15666        |        |           | \$0           |         |        |          |        |         |         |        |     |      |     |
|                                   | PPI Fixture                    |              |        |           | \$ 3,000.00   |         |        | 1,500    |        |         | 1,500   |        |     |      |     |
| Trigger                           | PM Mold                        | 15280        |        |           | \$15,225      |         |        | 7,613    |        |         | 7,613   |        |     |      |     |
|                                   | PPI Fixture                    |              |        |           | \$ 3,000.00   |         |        | 1,500    |        | 1,500   |         |        |     |      |     |
| Trigger Connector                 |                                | 19461        |        |           | \$ 3,000.00   |         |        | 1,500    |        | 1,500   |         |        |     |      |     |
| Safety Arm                        | Stamping Die                   | 300408       |        |           | \$25,552      |         |        | 12,776   |        |         | 12,776  |        |     |      |     |
|                                   | PPI Fixture                    |              |        |           | \$2,400       |         |        | 2,400    |        |         |         |        |     |      |     |
| Lock tumbler                      | MIM Mold                       | ??           |        |           | \$35,000      |         | 17,500 |          |        | 17,500  |         |        |     |      |     |
| Safety Snap Washer                | Stamping Die                   | 17044        |        |           | \$0           |         |        |          |        |         |         |        |     |      |     |
|                                   | PPI Fixture                    |              |        |           | \$2,400       |         |        | 1,200    |        | 1,200   |         |        |     |      |     |
| Bolt Stop                         | PM Die                         | 300345       |        |           | \$6,820       |         |        | 6,820    |        |         |         |        |     |      |     |
|                                   | PPI Fixture                    | 0            |        |           | \$1,500       |         |        |          |        | 1,500   |         |        |     |      |     |

| Description               | Items                        | Part # | Vendor | Lead time | Total Capital | Nov    | Dec    | Jan    | Feb     | Mar    | Apr   | May | Jun | July | Aug |
|---------------------------|------------------------------|--------|--------|-----------|---------------|--------|--------|--------|---------|--------|-------|-----|-----|------|-----|
| Recoil Bracket            | Stamping Die                 | 300361 |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Bolt Assembly Complete    |                              | ????   |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Bolt Body Assembly        | Brazing Machine              | 300403 |        |           | \$98,000      |        | 32,667 |        | 32,667  | 32,667 |       |     |     |      |     |
|                           | Deplate Tanks                |        |        |           | \$9,500       |        |        |        | 9,500   |        |       |     |     |      |     |
|                           | glass bead blast             |        |        |           | \$2,500       |        |        |        | 2,500   |        |       |     |     |      |     |
| Bolt Body                 | Gages at Machining           | 300339 |        |           | \$4,500       |        |        | 1,500  |         | 3,000  |       |     |     |      |     |
| Bolt Handle               | Machining Fixtures& Gages    | 300370 |        |           | \$12,500      |        | 6,250  | 6,250  |         |        |       |     |     |      |     |
| Bolt Handle Blank         | Investment Cast Mold         | 300360 |        |           | \$12,575      | 6,288  |        |        | 6,288   |        |       |     |     |      |     |
|                           | PPI Fixture                  | 0      |        |           | \$2,500       |        | 1,200  | 1,300  |         |        |       |     |     |      |     |
| Bolt Head Assembly        | Assy Fixture                 | 305390 |        |           | \$9,100       |        |        | 4,100  |         |        |       |     |     |      |     |
| Bolt Head                 | Edgetek Grind                | 43800  |        |           | \$43,800      |        | 21,900 |        | 21,900  |        |       |     |     |      |     |
|                           | Machining Fixtures           | 174800 |        |           | \$174,800     | 69,920 |        |        | 104,880 |        |       |     |     |      |     |
|                           | Machine Ejector Retaining    |        |        |           | \$15,000      |        | 7,500  |        | 7,500   |        |       |     |     |      |     |
|                           | Machine Retaining Pin Hole   |        |        |           | \$15,000      |        | 7,500  |        | 7,500   |        |       |     |     |      |     |
|                           | Punch Form Ejector           |        |        |           | \$10,000      |        | 5,000  |        | 5,000   |        |       |     |     |      |     |
| Extractor                 | PPI Fixture                  | 93712  |        |           | \$3,300       |        |        |        | 3,300   |        |       |     |     |      |     |
| Firing Pin Assembly       | Assy Fixture                 | 300404 |        |           | \$4,500       |        | 4,500  |        |         |        |       |     |     |      |     |
| Bolt Plug                 | Plastic Mold                 | 300368 |        |           | \$38,080      | 12,696 |        | 12,696 | 12,696  |        |       |     |     |      |     |
| Bolt Plug Insert          | PPI Fixture                  | 300346 |        |           | \$3,000       |        |        | 1,500  |         | 1,500  |       |     |     |      |     |
| Firing Pin Head           | MIM Mold                     | 300336 |        |           | \$37,500      |        | 12,500 |        | 12,500  | 12,500 |       |     |     |      |     |
|                           | PPI Fixture                  |        |        |           | \$1,500       |        |        | 1,500  |         |        |       |     |     |      |     |
| Front Sight Assembly      | Assembly Press               |        |        |           | \$4,200       |        |        |        | 4,200   |        |       |     |     |      |     |
| Front Sight               | PM Mold                      | 94084  |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Front Sight Ramp          | PM Mold                      | 94657  |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Rear Sight Assembly       |                              | 103145 |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Rear Sight Aperture       | Machining Fixture            | 97681  |        |           | \$9,000       |        |        | 4,000  | 5,000   |        |       |     |     |      |     |
| Rear Sight Aperture Blank | MIM Mold                     | 93906  |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Rear Sight Base           | MIM Mold                     | 103531 |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Rear Sight Slide          | MIM Mold                     | 94335  |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Stock Assy                |                              |        |        |           |               |        |        |        |         |        |       |     |     |      |     |
| Stock Assembly            | Fixture                      | ????   |        |           | \$2,800       |        |        |        |         | 2,800  |       |     |     |      |     |
| Stock                     | Plastic Mold                 | ????   |        |           | \$150,300     | 50,100 |        | 50,100 | 50,100  |        |       |     |     |      |     |
|                           | PPI Fixture                  | 0      |        |           | \$4,500       |        |        |        |         |        |       |     |     |      |     |
| Front Screw Bushing       | Family plastic mold          | 15161  |        |           | \$12,000      |        |        | 4,000  |         | 4,000  | 4,000 |     |     |      |     |
| Middle Screw Bushing      | see front screw bushing      | ????   |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Rear Screw Bushing        | see front screw bushing      | ????   |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Magazine Latch            | Plastic Mold                 | 300362 |        |           | \$33,480      | 11,160 |        | 11,160 | 11,160  |        |       |     |     |      |     |
|                           | PPI Fixture                  |        |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Magazine Assembly         |                              | 305395 |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Magazine Box              | Stamping Die                 | 300363 |        |           | \$46,500      | 15,500 |        | 15,500 | 15,500  |        |       |     |     |      |     |
|                           | PPI fixture                  |        |        |           | \$4,500       |        | 2,250  |        | 2,250   |        |       |     |     |      |     |
| Magazine Follower         | tic Mold (family w/ bottom)  | 300364 |        |           | \$78,796      | 26,262 |        | 26,262 | 26,262  |        |       |     |     |      |     |
|                           | PPI fixture                  |        |        |           | \$3,000       |        |        | 3,000  |         |        |       |     |     |      |     |
| Magazine Bottom           | ic Mold (family w/ follower) | 300365 |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
|                           | PPI fixture                  |        |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
| Magazine Spring           | Stamping Die                 | 300405 |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |
|                           | PPI fixture                  |        |        |           | \$0           |        |        |        |         |        |       |     |     |      |     |

M/710 Capital Summary Rev 10

| Description | Items           | Part # | Vendor | Lead time | Total Capital | Nov     | Dec     | Jan     | Feb     | Mar     | Apr     | May    | Jun | July | Aug |
|-------------|-----------------|--------|--------|-----------|---------------|---------|---------|---------|---------|---------|---------|--------|-----|------|-----|
| Gallery     | Design          |        |        |           | \$15,000      | 15,000  |         |         |         |         |         |        |     |      |     |
|             | 1st installment |        |        |           | \$100,000     |         | 100,000 |         |         |         |         |        |     |      |     |
|             | 2nd installment |        |        |           | \$140,000     |         |         | 140,000 |         |         |         |        |     |      |     |
|             | 3rd installment |        |        |           | \$45,000      |         |         |         | 45,000  |         |         |        |     |      |     |
|             | Snails          |        |        |           | \$25,000      |         |         |         | 25,000  |         |         |        |     |      |     |
|             |                 |        |        |           |               |         |         |         |         |         |         |        |     |      |     |
|             |                 |        |        |           |               |         |         |         |         |         |         |        |     |      |     |
|             |                 |        |        |           |               |         |         |         |         |         |         |        |     |      |     |
| TOTAL       |                 |        |        |           | \$2,437,210   | 440,690 | 357,433 | 443,693 | 543,869 | 416,235 | 182,141 | 63,149 | 0   | 0    | 0   |

MF0053

Confidential - ~~Subsequent~~ - 522-06r000003e Order  
Williams v. Remington

| Model 710 T1 Constraints |                                         |        |          |              |         |     |             |     |     |             |     |     |
|--------------------------|-----------------------------------------|--------|----------|--------------|---------|-----|-------------|-----|-----|-------------|-----|-----|
| ID                       | Task Name                               | Part # | Duration | Finish       | Quarter |     | 1st Quarter |     |     | 2nd Quarter |     |     |
|                          |                                         |        |          |              | Nov     | Dec | Jan         | Feb | Mar | Apr         | May | Jun |
| 1                        | First T&P for 710 - Based on Lead times |        | 140 days | Fri 6/2/00   |         |     |             |     |     |             |     |     |
| 2                        | Document Envelope Assembly              |        | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 3                        | Document Envelope                       | 1649   | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 4                        | Instruction Book                        |        | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 5                        | Product Owners Card                     | 1426   | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 6                        | Remington Authorized Gunsmith           | 18413  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 7                        | Safety Booklet                          | 3499   | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 8                        | Remington Museum Flyer                  | 3475   | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 9                        | Oval Label                              | 3491   | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 10                       | Carton Assembly                         | 1444   | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 11                       | Corrugated Box                          |        | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 12                       | Bed                                     |        | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 13                       | Box & Envelope Label                    | 993002 | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 14                       | Barrel Assembly Complete                | 305410 | 95 days  | Fri 3/31/00  |         |     |             |     |     |             |     |     |
| 15                       | Barrel Assembly                         | 305400 | 95 days  | Fri 3/31/00  |         |     |             |     |     |             |     |     |
| 16                       | Barrel                                  | 305315 | 95 days  | Fri 3/31/00  |         |     |             |     |     |             |     |     |
| 17                       | LB-300 MY Chamber Machine               |        | 10 wks   | Fri 3/31/00  |         |     |             |     |     |             |     |     |
| 18                       | Induction Hardening Machine             |        | 10 wks   | Fri 1/23/00  |         |     |             |     |     |             |     |     |
| 19                       | New Chuck for Cut-off & Crown Machine   |        | 4 wks    | Fri 12/17/99 |         |     |             |     |     |             |     |     |
| 20                       | Barrel Material                         |        | 16 wks   | Fri 3/10/00  |         |     |             |     |     |             |     |     |
| 21                       | Heat treat Baskets                      |        | 6 wks    | Fri 12/31/99 |         |     |             |     |     |             |     |     |

|                                                         |           |   |                     |   |                    |  |
|---------------------------------------------------------|-----------|---|---------------------|---|--------------------|--|
| Project: Model 710 T1 Constraints<br>Date: Fri 11/12/99 | Task      |   | Summary             |   | Rolled Up Progress |  |
|                                                         | Split     |   | Rolled Up Task      |   | External Tasks     |  |
|                                                         | Progress  |   | Rolled Up Split     |   | Project Summary    |  |
|                                                         | Milestone | ◆ | Rolled Up Milestone | ◇ |                    |  |
|                                                         |           |   |                     |   |                    |  |

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ME0054

| Model 710 T2 Constraints                                |                                            |           |          |                     |         |     |             |     |     |             |     |     |
|---------------------------------------------------------|--------------------------------------------|-----------|----------|---------------------|---------|-----|-------------|-----|-----|-------------|-----|-----|
| ID                                                      | Task Name                                  | Part #    | Duration | Finish              | Quarter |     | 1st Quarter |     |     | 2nd Quarter |     |     |
|                                                         |                                            |           |          |                     | Nov     | Dec | Jan         | Feb | Mar | Apr         | May | Jun |
| 22                                                      | Color Racks                                |           | 6 wks    | Fri 12/31/99        |         |     |             |     |     |             |     |     |
| 23                                                      | Machining Fixture & Gages - Design & Build |           | 12 wks   | Fri 2/11/00         |         |     |             |     |     |             |     |     |
| 24                                                      | Receiver                                   | 300340    | 95 days  | Fri 3/31/00         |         |     |             |     |     |             |     |     |
| 25                                                      | Receiver Material                          |           | 7 wks    | Fri 1/7/00          |         |     |             |     |     |             |     |     |
| 26                                                      | LT-15 MY Machine                           |           | 10 wks   | Fri 3/31/00         |         |     |             |     |     |             |     |     |
| 27                                                      | Cylindrical Grinder                        |           | 4 wks    | Fri 12/17/99        |         |     |             |     |     |             |     |     |
| 28                                                      | CMM for Receiver, Bolt Body & Bolt Head    |           | 6 wks    | Fri 12/31/99        |         |     |             |     |     |             |     |     |
| 29                                                      | Fixtures & Gages                           |           | 10 wks   | Fri 1/28/00         |         |     |             |     |     |             |     |     |
| 30                                                      | Receiver Insert Assembly Complete          | 300401    | 110 days | Fri 4/21/00         |         |     |             |     |     |             |     |     |
| 31                                                      | Receiver Insert Assembly                   | 300400    | 20 days  | Fri 12/17/99        |         |     |             |     |     |             |     |     |
| 32                                                      | Receiver Insert                            | 300327    | 3 wks    | Fri 12/10/99        |         |     |             |     |     |             |     |     |
| 33                                                      | Threaded Insert                            | 300347    | 4 wks    | Fri 12/17/99        |         |     |             |     |     |             |     |     |
| 34                                                      | Side Plate                                 | 300333    | 1 day    | Mon 11/22/99        |         |     |             |     |     |             |     |     |
| 35                                                      | Side Plate Pin                             | 300328    | 3 wks    | Fri 1/14/00         |         |     |             |     |     |             |     |     |
| 36                                                      | Sear Safety Cam                            | 15666     | 1 day    | Mon 11/22/99        |         |     |             |     |     |             |     |     |
| 37                                                      | Pivot Pin                                  | 300351    | 6 wks    | Fri 12/31/99        |         |     |             |     |     |             |     |     |
| 38                                                      | Sear Spring                                | 17047     | 4 wks    | Fri 12/17/99        |         |     |             |     |     |             |     |     |
| 39                                                      | Trigger                                    | 15280     | 1 day    | Mon 11/22/99        |         |     |             |     |     |             |     |     |
| 40                                                      | Trigger Connector                          | 19461     | 1 day    | Mon 11/22/99        |         |     |             |     |     |             |     |     |
| 41                                                      | Trigger Screw Front                        | 17053     | 1 day    | Mon 11/22/99        |         |     |             |     |     |             |     |     |
| 42                                                      | Trigger Engagement Screw                   | 90028     | 1 day    | Mon 11/22/99        |         |     |             |     |     |             |     |     |
| Project: Model 710 T2 Constraints<br>Date: Fri 11/12/99 |                                            | Task      |          | Summary             |         |     |             |     |     |             |     |     |
|                                                         |                                            | Split     |          | Rolled Up Task      |         |     |             |     |     |             |     |     |
|                                                         |                                            | Progress  |          | Rolled Up Split     |         |     |             |     |     |             |     |     |
|                                                         |                                            | Milestone | ◆        | Rolled Up Milestone | ◇       |     |             |     |     |             |     |     |
| Page 2 of 6                                             |                                            |           |          |                     |         |     |             |     |     |             |     |     |

ME0055

| Model 710 T3 Constraints |                                   |        |          |              |         |     |             |     |     |             |     |     |
|--------------------------|-----------------------------------|--------|----------|--------------|---------|-----|-------------|-----|-----|-------------|-----|-----|
| ID                       | Task Name                         | Part # | Duration | Finish       | Quarter |     | 1st Quarter |     |     | 2nd Quarter |     |     |
|                          |                                   |        |          |              | Nov     | Dec | Jan         | Feb | Mar | Apr         | May | Jun |
| 43                       | Trigger Spring                    | 15400  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 44                       | Trigger Stop Screw                | 15481  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 45                       | Safety Arm                        | 300408 | 22 wks   | Fri 4/21/00  |         |     |             |     |     |             |     |     |
| 46                       | Safety Detent Spring              | 300407 | 4 wks    | Fri 12/17/99 |         |     |             |     |     |             |     |     |
| 47                       | Lock Tumbler                      | 300420 | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 48                       | Lock Detent                       |        | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 49                       | Safety Pivot Pin                  | 300352 | 8 wks    | Fri 1/14/00  |         |     |             |     |     |             |     |     |
| 50                       | Snap Washer                       | 17044  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 51                       | Bolt Stop                         | 300345 | 22 wks   | Fri 4/21/00  |         |     |             |     |     |             |     |     |
| 52                       | Receiver Plug Screws              | 17034  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 53                       | Recoil Bracket                    | 300361 | 8 wks    | Fri 1/14/00  |         |     |             |     |     |             |     |     |
| 54                       | Bolt Assembly Complete            |        | 95 days  | Fri 3/31/00  |         |     |             |     |     |             |     |     |
| 55                       | Bolt Body Assembly                | 300403 | 95 days  | Fri 3/31/00  |         |     |             |     |     |             |     |     |
| 56                       | Induction Braze Equipment         |        | 10 wks   | Fri 1/28/00  |         |     |             |     |     |             |     |     |
| 57                       | Bolt Body                         | 300339 | 50 days  | Fri 1/28/00  |         |     |             |     |     |             |     |     |
| 58                       | Bolt Body Material                |        | 7 wks    | Fri 1/7/00   |         |     |             |     |     |             |     |     |
| 59                       | LT-15 MY Delivery                 |        | 10 wks   | Fri 1/28/00  |         |     |             |     |     |             |     |     |
| 60                       | Induction Braze                   |        | 10 wks   | Fri 1/28/00  |         |     |             |     |     |             |     |     |
| 61                       | Gages & Fixtures - Design & Build |        | 10 wks   | Fri 1/28/00  |         |     |             |     |     |             |     |     |
| 62                       | Bolt Handle                       | 300370 | 95 days  | Fri 3/31/00  |         |     |             |     |     |             |     |     |
| 63                       | Bolt Handle Mold                  |        | 19 wks   | Fri 3/31/00  |         |     |             |     |     |             |     |     |

|                                                         |           |   |                     |   |                    |  |
|---------------------------------------------------------|-----------|---|---------------------|---|--------------------|--|
| Project: Model 710 T3 Constraints<br>Date: Fri 11/12/99 | Task      |   | Summary             |   | Rolled Up Progress |  |
|                                                         | Split     |   | Rolled Up Task      |   | External Tasks     |  |
|                                                         | Progress  |   | Rolled Up Split     |   | Project Summary    |  |
|                                                         | Milestone | ◆ | Rolled Up Milestone | ◇ |                    |  |
|                                                         |           |   |                     |   |                    |  |

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| Model 710 T4 Constraints                                |                      |           |          |                     |         |                    |             |     |     |             |     |     |
|---------------------------------------------------------|----------------------|-----------|----------|---------------------|---------|--------------------|-------------|-----|-----|-------------|-----|-----|
| ID                                                      | Task Name            | Part #    | Duration | Finish              | Quarter |                    | 1st Quarter |     |     | 2nd Quarter |     |     |
|                                                         |                      |           |          |                     | Nov     | Dec                | Jan         | Feb | Mar | Apr         | May | Jun |
| 64                                                      | Bolt Handle Pin      | 300329    | 6 wks    | Fri 12/31/99        |         |                    |             |     |     |             |     |     |
| 65                                                      | Bolt head Assembly   | 305390    | 40 days  | Fri 1/14/00         |         |                    |             |     |     |             |     |     |
| 66                                                      | Bolt Head            | 300338    | 8 wks    | Fri 1/14/00         |         |                    |             |     |     |             |     |     |
| 67                                                      | Extractor            | 93712     | 1 day    | Mon 11/22/99        |         |                    |             |     |     |             |     |     |
| 68                                                      | Ejector              | 300342    | 8 wks    | Fri 1/14/00         |         |                    |             |     |     |             |     |     |
| 69                                                      | Ejector Spring       | 300357    | 6 wks    | Fri 12/31/99        |         |                    |             |     |     |             |     |     |
| 70                                                      | Ejector Pin          | 94555     | 2 wks    | Fri 12/3/99         |         |                    |             |     |     |             |     |     |
| 71                                                      | Bolt Assembly Pin    | 300330    | 8 wks    | Fri 1/14/00         |         |                    |             |     |     |             |     |     |
| 72                                                      | Firing Pin Assembly  | 300404    | 90 days  | Fri 3/24/00         |         |                    |             |     |     |             |     |     |
| 73                                                      | Bolt Plug            | 300368    | 60 days  | Fri 2/11/00         |         |                    |             |     |     |             |     |     |
| 74                                                      | Bolt Plug Mold       |           | 12 wks   | Fri 2/11/00         |         |                    |             |     |     |             |     |     |
| 75                                                      | Bolt Plug insert     | 300346    | 8 wks    | Fri 1/14/00         |         |                    |             |     |     |             |     |     |
| 76                                                      | Firing Pin           | 300334    | 10 wks   | Fri 1/28/00         |         |                    |             |     |     |             |     |     |
| 77                                                      | Firing Pin Tip       | 300339    | 8 wks    | Fri 1/14/00         |         |                    |             |     |     |             |     |     |
| 78                                                      | Firing Pin Head      | 300336    | 90 days  | Fri 3/24/00         |         |                    |             |     |     |             |     |     |
| 79                                                      | Firing Pin Head Mold |           | 18 wks   | Fri 3/24/00         |         |                    |             |     |     |             |     |     |
| 80                                                      | Firing Pin Spring    | 300399    | 5 wks    | Fri 12/24/99        |         |                    |             |     |     |             |     |     |
| 81                                                      | Front Sight Assembly |           | 20 days  | Fri 12/17/99        |         |                    |             |     |     |             |     |     |
| 82                                                      | Front Sight          | 94084     | 1 day    | Mon 11/22/99        |         |                    |             |     |     |             |     |     |
| 83                                                      | Front Sight Ramp     | 94657     | 20 days  | Fri 12/17/99        |         |                    |             |     |     |             |     |     |
| 84                                                      | Assembly Machine     |           | 4 wks    | Fri 12/17/99        |         |                    |             |     |     |             |     |     |
| Project: Model 710 T4 Constraints<br>Date: Fri 11/12/99 |                      | Task      |          | Summary             |         | Rolled Up Progress |             |     |     |             |     |     |
|                                                         |                      | Split     |          | Rolled Up Task      |         | External Tasks     |             |     |     |             |     |     |
|                                                         |                      | Progress  |          | Rolled Up Split     |         | Project Summary    |             |     |     |             |     |     |
|                                                         |                      | Milestone | ◆        | Rolled Up Milestone | ◇       |                    |             |     |     |             |     |     |
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ME0057

| Model 710 T5 Constraints |                            |        |          |              |         |     |             |     |     |             |     |     |
|--------------------------|----------------------------|--------|----------|--------------|---------|-----|-------------|-----|-----|-------------|-----|-----|
| ID                       | Task Name                  | Part # | Duration | Finish       | Quarter |     | 1st Quarter |     |     | 2nd Quarter |     |     |
|                          |                            |        |          |              | Nov     | Dec | Jan         | Feb | Mar | Apr         | May | Jun |
| 85                       | Front Sight Ramp Screw     | 28505  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 86                       | Rear Sight Assembly        | 103145 | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 87                       | Elevation Screw            | 90906  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 88                       | Rear Sight Aperature       | 97681  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 89                       | Rear Sight Aperature Blank | 93906  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 90                       | Rear Sight Base            | 103631 | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 91                       | Rear Sight Slide           | 94335  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 92                       | Windage Screw              | 300026 | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 93                       | Rear Sight Base Screw      | 28505  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 94                       | Stock Assembly Complete    |        | 105 days | Fri 4/14/00  |         |     |             |     |     |             |     |     |
| 95                       | Stock Assembly             |        | 105 days | Fri 4/14/00  |         |     |             |     |     |             |     |     |
| 96                       | Stock                      |        | 105 days | Fri 4/14/00  |         |     |             |     |     |             |     |     |
| 97                       | Stock Mold                 |        | 21 wks   | Fri 4/14/00  |         |     |             |     |     |             |     |     |
| 98                       | Front Screw Bushing        | 15161  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 99                       | Front Screw Bushing Blank  | 91915  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 100                      | Middle Screw Bushing       |        | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 101                      | Rear Screw Bushing         |        | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 102                      | Grip Cap                   | 97971  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 103                      | Recoil Pad                 | 97973  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 104                      | Backer Plate               | 97972  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |
| 105                      | Recoil Pad Screw           | 98008  | 1 day    | Mon 11/22/99 |         |     |             |     |     |             |     |     |

|                                                         |           |  |                     |  |                    |  |
|---------------------------------------------------------|-----------|--|---------------------|--|--------------------|--|
| Project: Model 710 T5 Constraints<br>Date: Fri 11/12/99 | Task      |  | Summary             |  | Rolled Up Progress |  |
|                                                         | Split     |  | Rolled Up Task      |  | External Tasks     |  |
|                                                         | Progress  |  | Rolled Up Split     |  | Project Summary    |  |
|                                                         | Milestone |  | Rolled Up Milestone |  |                    |  |

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| Model 710 T6 Constraints |   |                                         |        |          |              |         |     |             |     |     |             |     |     |
|--------------------------|---|-----------------------------------------|--------|----------|--------------|---------|-----|-------------|-----|-----|-------------|-----|-----|
| ID                       | i | Task Name                               | Part # | Duration | Finish       | Quarter |     | 1st Quarter |     |     | 2nd Quarter |     |     |
|                          |   |                                         |        |          |              | Nov     | Dec | Jan         | Feb | Mar | Apr         | May | Jun |
| 106                      |   | Magazine Latch                          | 300362 | 14 wks   | Fri 2/25/00  |         |     |             |     |     |             |     |     |
| 107                      |   | Magazine Latch Spring                   | 300398 | 6 wks    | Fri 12/31/99 |         |     |             |     |     |             |     |     |
| 108                      |   | Magazine Latch Pin                      | 300371 | 8 wks    | Fri 1/14/00  |         |     |             |     |     |             |     |     |
| 109                      |   | Sling Swivel Stud                       | 300096 | 4 wks    | Fri 12/17/99 |         |     |             |     |     |             |     |     |
| 110                      |   | Takedown Screw                          |        | 4 wks    | Fri 12/17/99 |         |     |             |     |     |             |     |     |
| 111                      |   | Rear Takedown Screw                     |        | 4 wks    | Fri 12/17/99 |         |     |             |     |     |             |     |     |
| 112                      |   | Magazine Assembly                       | 305395 | 110 days | Fri 4/21/00  |         |     |             |     |     |             |     |     |
| 113                      |   | Magazine Box                            | 300363 | 110 days | Fri 4/21/00  |         |     |             |     |     |             |     |     |
| 114                      |   | Magazine Box Tool                       |        | 22 wks   | Fri 4/21/00  |         |     |             |     |     |             |     |     |
| 115                      |   | Magazine Follower                       | 300364 | 80 days  | Fri 3/10/00  |         |     |             |     |     |             |     |     |
| 116                      |   | Magazine Follower Tool                  |        | 16 wks   | Fri 3/10/00  |         |     |             |     |     |             |     |     |
| 117                      |   | Magazine Bottom                         | 300365 | 80 days  | Fri 3/10/00  |         |     |             |     |     |             |     |     |
| 118                      |   | Magazine Bottom Tool                    |        | 16 wks   | Fri 3/10/00  |         |     |             |     |     |             |     |     |
| 119                      |   | Magazine Spring                         | 300405 | 5 wks    | Fri 12/31/99 |         |     |             |     |     |             |     |     |
| 120                      |   | Build 100 yd. Range                     |        | 20 wks   | Fri 4/7/00   |         |     |             |     |     |             |     |     |
| 121                      |   | Manufacture and Assemble first T&P Guns |        | 6 wks    | Fri 6/2/00   |         |     |             |     |     |             |     |     |
| 122                      |   | First T&P Guns Complete                 |        | 0 days   | Fri 6/2/00   |         |     |             |     |     |             |     |     |

Project: Model 710 T6 Constraints  
Date: Fri 11/12/99

Task

Split

Progress

Milestone

Summary

Rolled Up Task

Rolled Up Split

Rolled Up Milestone

Rolled Up Progress

External Tasks

Project Summary

Page 6 of 6

Remington Arms Company  
2000 Budget  
Mayfield Plant

30-Aug-99

|                                          | 69,000 597s<br>0 710s | 51,300 597s<br>20,000 710s | 58,400 597s<br>20,000 710s | 58,400 597s<br>30,000 710s |
|------------------------------------------|-----------------------|----------------------------|----------------------------|----------------------------|
| Total Units Produced to the Warehouse    | 69,000                | 71,300                     | 78,400                     | 88,400                     |
| Total Standard Hours Earned              | 71,162                | 71,279                     | 78,602                     | 87,787                     |
| Sales Value of Units Warehoused          | 10,065,381            | 11,883,392                 | 12,919,105                 | 15,119,105                 |
| <b>Standard Cost of Goods Warehoused</b> |                       |                            |                            |                            |
| Direct Material Costs                    | 3,703,154             | 3,604,201                  | 3,985,250                  | 4,410,743                  |
| Direct Labor Costs                       | 697,358               | 700,541                    | 772,298                    | 863,333                    |
| Variable Overhead Costs                  | 2,182,089             | 2,265,885                  | 2,351,372                  | 2,499,110                  |
| Fixed Overhead Costs                     | 948,241               | 1,260,535                  | 1,282,228                  | 1,321,584                  |
| Total Overhead                           | 3,130,330             | 3,526,420                  | 3,633,600                  | 3,820,694                  |
| Total Standard Cost of Production        | 7,530,842             | 7,831,161                  | 8,391,147                  | 9,094,769                  |
| Standard Cost of Production per Gun      | 109.14                | 109.83                     | 107.03                     | 102.88                     |
| Standard Mfg. Contribution Margin        | 2,534,539             | 4,052,230                  | 4,527,957                  | 6,024,336                  |
|                                          | 25.2%                 | 34.1%                      | 35.0%                      | 39.8%                      |
| Assumptions                              |                       |                            |                            |                            |
| Head Count                               | 37.9                  | 37.9                       | 41.8                       | 46.7                       |
| NSP                                      |                       |                            |                            |                            |
| 597 (2000 budgeted Mix)                  | 145.88                | 145.88                     | 145.88                     | 145.88                     |
| 710                                      | N/A                   | 220.00                     | 220.00                     | 220.00                     |
| Material Cost                            |                       |                            |                            |                            |
| 597 (2000 budgeted Mix)                  | 53.67                 | 53.67                      | 53.67                      | 53.67                      |
| 710                                      | N/A                   | 42.55                      | 42.55                      | 42.55                      |
| Labor                                    |                       |                            |                            |                            |
| 597 (2000 budgeted Mix)                  | 10.11                 | 10.11                      | 10.11                      | 10.11                      |
| 710                                      | N/A                   | 9.10                       | 9.10                       | 9.10                       |
| Overhead Rate                            | 448.9%                | 503.4%                     | 470.5%                     | 442.6%                     |
| Overhead Costs                           |                       |                            |                            |                            |
| 597                                      | 45.37                 | 50.88                      | 47.55                      | 44.73                      |
| 710                                      | N/A                   | 45.83                      | 42.83                      | 40.29                      |
| Total Costs                              |                       |                            |                            |                            |
| 597                                      | 109.14                | 114.65                     | 111.33                     | 108.50                     |
| 710                                      | N/A                   | 97.48                      | 94.48                      | 91.94                      |
| Margin                                   |                       |                            |                            |                            |
| 597                                      | 36.73                 | 31.22                      | 34.55                      | 37.37                      |
| 710                                      | N/A                   | 122.52                     | 125.52                     | 128.06                     |
| Capital                                  | N/A                   | 2,358,528                  | 2,358,528                  | 2,358,528                  |
| Startup Costs                            | N/A                   | -                          | -                          | -                          |
| Working Capital (excluding A/R)          | N/A                   | 323,957                    | 323,957                    | 461,707                    |

MF0060

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

C:\windows\TEMP\m710 estimate rev4.xls\m710 est Mayfield run times

|                                   |         | M/710 Estimate 8/30/99 |                      |             |                  |                |                  |         |
|-----------------------------------|---------|------------------------|----------------------|-------------|------------------|----------------|------------------|---------|
| PART DESCRIPTION                  | Part #  | Material<br>\$         | Run Rate<br>(hrs/pc) | Labor<br>\$ | Fixed<br>O.H. \$ | Var<br>O.H. \$ | Total<br>O.H. \$ | Total   |
| Document Envelope Assembly        | 1721    | \$ 0.09                |                      | \$ -        | \$ -             | \$ -           | \$ -             | \$ 0.09 |
| Document Envelope                 | 1649    | 0.08                   |                      | -           | -                | -              | -                | 0.08    |
| Users manual                      | 3391    | 0.15                   |                      | -           | -                | -              | -                | 0.15    |
| Product Owners Card               | 1426    | 0.03                   |                      | -           | -                | -              | -                | 0.03    |
| Remington Authorized Gunsmith     | 3413    | 0.07                   |                      | -           | -                | -              | -                | 0.07    |
| Safety Booklet                    | 3499    | 0.10                   |                      | -           | -                | -              | -                | 0.10    |
| Oval Label                        | 3491    | 0.01                   |                      | -           | -                | -              | -                | 0.01    |
| Carton Assembly                   | 1444    | 2.05                   |                      | -           | -                | -              | -                | 2.05    |
| Box and Envelope Label (710)      | 993002  | 0.04                   |                      | -           | -                | -              | -                | 0.04    |
| Shelf Talker                      |         | 0.14                   |                      | -           | -                | -              | -                | 0.14    |
| Barrel Assembly Complete          | 305410  |                        | 0.0790               | 0.71        | 1.27             | 2.27           | 3.55             | 4.25    |
| Barrel Assembly                   | 3305400 |                        |                      | -           | -                | -              | -                | -       |
| Barrel                            | 305315  | 4.80                   | 0.3866               | 4.09        | 7.37             | 13.14          | 20.51            | 29.40   |
| Receiver                          | 300340  | 1.76                   | 0.0055               | 0.06        | 0.10             | 0.19           | 0.29             | 2.11    |
| Receiver Insert Assembly Complete | ????    |                        | 0.0530               | 0.47        | 0.85             | 1.52           | 2.38             | 2.85    |
| Receiver Insert Assembly          | ????    |                        | 0.0050               | 0.04        | 0.08             | 0.14           | 0.22             | 0.27    |
| Receiver Insert                   | 300327  | 0.62                   |                      | -           | -                | -              | -                | 0.62    |
| Threaded Insert                   | 300347  | 0.04                   |                      | -           | -                | -              | -                | 0.04    |
| Side Plate                        | 300333  | 0.09                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.15    |
| Side Plate Pin (2)                | 300328  | 0.12                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.18    |
| Sear Safety Cam                   | 15666   | 0.94                   |                      | -           | -                | -              | -                | 0.94    |
| Pivot Pin (3)                     | 300351  | 0.18                   |                      | -           | -                | -              | -                | 0.18    |
| Sear Spring                       | 17047   | 0.02                   |                      | -           | -                | -              | -                | 0.02    |
| Trigger                           | 15280   | 1.53                   |                      | -           | -                | -              | -                | 1.53    |
| Trigger Connector                 | 19461   | 1.03                   |                      | -           | -                | -              | -                | 1.03    |
| Trigger Screw Front               | 17053   | 0.10                   |                      | -           | -                | -              | -                | 0.10    |
| Trigger Engagement Screw          | 91128   | 0.03                   |                      | -           | -                | -              | -                | 0.03    |
| Trigger Spring                    | 15400   | 0.03                   |                      | -           | -                | -              | -                | 0.03    |
| Trigger Stop Screw                | 15481   | 0.06                   |                      | -           | -                | -              | -                | 0.06    |
| Safety                            | 300408  | 0.31                   |                      | -           | -                | -              | -                | 0.31    |
| Safety Pivot Pin                  | 300352  | 0.06                   |                      | -           | -                | -              | -                | 0.06    |
| Safety Spring                     | 300343  | 0.05                   |                      | -           | -                | -              | -                | 0.05    |
| Bolt Stop                         | 300345  | 0.19                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.25    |
| Receiver Plug Screws (4)          | 17034   | 0.12                   |                      | -           | -                | -              | -                | 0.12    |
| Recoil Bracket                    | 300361  | 0.19                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.25    |
| Bolt Assembly Complete            | ????    |                        |                      | -           | -                | -              | -                | -       |
| Bolt Body Assembly                | ????    |                        | 0.0275               | 0.29        | 0.53             | 0.94           | 1.46             | 1.75    |
| Bolt Body                         | 300339  | 0.74                   | 0.0032               | 0.03        | 0.06             | 0.11           | 0.17             | 0.94    |
| Bolt Handle                       | 300370  |                        | 0.0120               | 0.13        | 0.23             | 0.41           | 0.64             | 0.76    |
| Bolt Handle Blank                 | 300360  | 1.63                   |                      | -           | -                | -              | -                | 1.63    |
| Bolt Handle Pin                   | 300329  | 0.06                   |                      | -           | -                | -              | -                | 0.06    |
| Bolt Head Assembly                | 305390  |                        | 0.0580               | 0.52        | 0.94             | 1.67           | 2.60             | 3.12    |
| Bolt Head                         | 300338  | 1.75                   | 0.0809               | 0.86        | 1.54             | 2.75           | 4.29             | 6.90    |
| Extractor                         | 93712   | 0.77                   |                      | -           | -                | -              | -                | 0.77    |
| Ejector                           | 300342  | 0.16                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.22    |
| Ejector Spring                    | ????    | 0.03                   |                      | -           | -                | -              | -                | 0.03    |
| Ejector Pin                       | 94555   | 0.01                   |                      | -           | -                | -              | -                | 0.01    |

MF0061

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

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|                             |        | M/710 Estimate 8/30/99 |                      |             |                  |                |                  |          |
|-----------------------------|--------|------------------------|----------------------|-------------|------------------|----------------|------------------|----------|
| PART DESCRIPTION            | Part # | Material<br>\$         | Run Rate<br>(hrs/pc) | Labor<br>\$ | Fixed<br>O.H. \$ | Var<br>O.H. \$ | Total<br>O.H. \$ | Total    |
| Bolt Assembly Pin           | 300330 | 0.10                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.16     |
| Firing Pin Assembly         | ????   |                        | 0.0070               | 0.06        | 0.11             | 0.20           | 0.31             | 0.38     |
| Bolt Plug                   | 300368 | 0.25                   |                      | -           | -                | -              | -                | 0.25     |
| Bolt Plug Insert            | 300346 | 0.29                   |                      | -           | -                | -              | -                | 0.29     |
| Firing Pin                  | 300334 | 0.27                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.33     |
| Firing Pin Tip              | 300335 | 1.60                   | 0.0015               | 0.02        | 0.03             | 0.05           | 0.08             | 1.70     |
| Firing Pin Head             | 300336 | 1.50                   | 0.0020               | 0.02        | 0.04             | 0.07           | 0.11             | 1.63     |
| Firing Pin Spring           | ????   | 0.14                   |                      | -           | -                | -              | -                | 0.14     |
| Front Sight                 | 94084  | 0.82                   |                      | -           | -                | -              | -                | 0.82     |
| Front Sight Ramp            | 94657  | 1.13                   | 0.0020               | 0.02        | 0.04             | 0.07           | 0.11             | 1.26     |
| Front Sight Ramp Screws (2) | 28505  | 0.09                   |                      | -           | -                | -              | -                | 0.09     |
| Rear Sight Assembly         | 103146 |                        |                      | -           | -                | -              | -                | -        |
| Elevation Screw             | 90906  | 0.02                   |                      | -           | -                | -              | -                | 0.02     |
| Rear Sight Aperture         | 94333  | 0.14                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.20     |
| Rear Sight Base             | 103531 | 0.97                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 1.03     |
| Rear Sight Slide            | 94335  | 0.47                   | 0.0050               | 0.05        | 0.10             | 0.17           | 0.27             | 0.79     |
| Windage Screw               | 90904  | 0.02                   |                      | -           | -                | -              | -                | 0.02     |
| Rear Sight Base Screw (2)   | 28505  | 0.09                   |                      | -           | -                | -              | -                | 0.09     |
| Stock Assembly Complete     | ????   |                        | 0.0160               | \$ 0.14     | 0.26             | 0.46           | 0.72             | 0.86     |
| Stock Assembly              | ????   |                        |                      | -           | -                | -              | -                | -        |
| Stock                       | ????   | 5.38                   |                      | -           | -                | -              | -                | 5.38     |
| Front Screw Bushing         | 15161  | 0.13                   |                      | -           | -                | -              | -                | 0.13     |
| Middle Screw Bushing        | ????   | 0.05                   |                      | -           | -                | -              | -                | 0.05     |
| Rear Screw Bushing          | ????   | 0.05                   |                      | -           | -                | -              | -                | 0.05     |
| Grip Cap                    | 97971  | 0.18                   |                      | -           | -                | -              | -                | 0.18     |
| Recoil Pad                  | 97973  | 1.63                   |                      | -           | -                | -              | -                | 1.63     |
| Recoil Pad Screw (2)        | 98008  | 0.05                   |                      | -           | -                | -              | -                | 0.05     |
| Magazine Latch              | 300362 | 0.25                   |                      | -           | -                | -              | -                | 0.25     |
| Magazine Latch Spring       | ????   | 0.02                   |                      | -           | -                | -              | -                | 0.02     |
| Magazine Latch Pin          | 300371 | 0.04                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.05             | 0.10     |
| Sling Swivel Stud (2)       | 300096 | 0.14                   |                      | -           | -                | -              | -                | 0.14     |
| Takedown Screw (2)          | ????   | 0.16                   |                      | -           | -                | -              | -                | 0.16     |
| Rear Takedown Screw         | ????   | 0.08                   |                      | -           | -                | -              | -                | 0.08     |
| Magazine Assembly           | ????   |                        | 0.0083               | 0.07        | 0.13             | 0.24           | 0.37             | 0.45     |
| Magazine Box                | 300363 | 2.79                   | 0.0010               | 0.01        | 0.02             | 0.03           | 0.04             | 2.84     |
| Magazine Follower           | 300364 | 0.26                   |                      | -           | -                | -              | -                | 0.26     |
| Magazine Bottom             | 300365 | 0.26                   |                      | -           | -                | -              | -                | 0.26     |
| Magazine Spring             | 17028  | 0.42                   |                      | -           | -                | -              | -                | 0.42     |
| Freight on Parts            |        | 0.25                   |                      |             |                  |                |                  | 0.25     |
| Value Added Cost of:        |        |                        |                      |             |                  |                |                  |          |
| Proof/Gallery/Inspect/Pack  |        | 1.15                   | 0.1500               | 1.34        | 2.42             | 4.31           | 6.73             | 9.22     |
| Total Cost                  |        | \$ 41.38               | 0.9136               | \$ 9.05     | \$ 16.31         | \$ 29.07       | \$ 45.38         | \$ 95.81 |

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

## 2000 Budget Overhead Summary

|             | Based on<br>58,400 597<br>Before 7,250<br>710 add on | Add 10,600<br>597 |                      | Add<br>20,000<br>710s<br>Reduce 597<br>7100 |                                    | Add<br>20,000<br>710s |                                     | Add<br>30,000<br>710s |                                     |
|-------------|------------------------------------------------------|-------------------|----------------------|---------------------------------------------|------------------------------------|-----------------------|-------------------------------------|-----------------------|-------------------------------------|
|             | Budgeted<br>Overhead                                 | Adj               | Total 69,000<br>597s | Adj                                         | Total 51,300<br>597<br>20,000 710s | Adj                   | Total 58,400<br>597s<br>20,000 710s | Adj                   | Total 58,400<br>597s<br>30,000 710s |
| Assumptions |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
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|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |
|             |                                                      |                   |                      |                                             |                                    |                       |                                     |                       |                                     |

MF0063

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

30-Aug-99

## 2000 Budget Electricity

|           | Billing<br>Days | 50% each         |                     | KW Usage  | KW Usage<br>Per Day | KW<br>Charge | Max Usage<br>Interval | Usage<br>Charge | Misc<br>Charge | Taxes<br>9.18% | Total<br>Charge | Average<br>Per KW |
|-----------|-----------------|------------------|---------------------|-----------|---------------------|--------------|-----------------------|-----------------|----------------|----------------|-----------------|-------------------|
|           |                 | Fixed<br>Portion | Variable<br>Portion |           |                     |              |                       |                 |                |                |                 |                   |
| December  | 31              | 126,450          | 126,147             | 252,597   | 8,148               | 8,712.27     | 963.74                | 8,613.30        | 37.00          | 1,593.88       | 18,956.45       | 0.075             |
| January   | 31              | 127,800          | 127,493             | 255,293   | 8,235               | 8,798.64     | 897.06                | 7,966.45        | 37.00          | 1,542.43       | 18,344.53       | 0.072             |
| February  | 28              | 107,100          | 106,843             | 213,943   | 7,641               | 7,474.19     | 908.02                | 8,072.78        | 37.00          | 1,430.61       | 17,014.59       | 0.080             |
| March     | 31              | 127,800          | 127,493             | 255,293   | 8,235               | 8,798.64     | 959.18                | 8,569.00        | 37.00          | 1,597.75       | 19,002.39       | 0.074             |
| April     | 30              | 121,500          | 121,208             | 242,708   | 8,090               | 8,395.55     | 961.00                | 8,586.72        | 37.00          | 1,562.37       | 18,581.64       | 0.077             |
| May       | 31              | 121,050          | 120,759             | 241,809   | 7,800               | 8,366.76     | 979.27                | 8,763.94        | 37.00          | 1,575.99       | 18,743.69       | 0.078             |
| June      | 30              | 131,850          | 131,534             | 263,384   | 8,779               | 9,057.78     | 912.59                | 8,117.09        | 37.00          | 1,580.05       | 18,791.91       | 0.071             |
| July      | 31              | 143,100          | 142,757             | 285,857   | 9,221               | 9,777.59     | 986.58                | 8,834.83        | 37.00          | 1,712.02       | 20,361.43       | 0.071             |
| August    | 31              | 129,150          | 128,840             | 257,990   | 8,322               | 8,885.02     | 1,011.24              | 9,074.07        | 37.00          | 1,652.04       | 19,648.13       | 0.076             |
| September | 30              | 121,500          | 121,208             | 242,708   | 8,090               | 8,395.55     | 966.48                | 8,639.89        | 37.00          | 1,567.25       | 18,639.68       | 0.077             |
| October   | 31              | 114,750          | 114,475             | 229,225   | 7,394               | 7,963.86     | 956.43                | 8,542.41        | 37.00          | 1,518.65       | 18,061.73       | 0.079             |
| November  | 30              | 109,800          | 109,536             | 219,336   | 7,311               | 7,646.95     | 868.74                | 7,691.76        | 38.00          | 1,411.58       | 16,788.29       | 0.077             |
|           | 365             | 1,481,850        | 1,478,294           | 2,960,144 | 8,110               | 102,272.60   |                       | 101,472.24      | 445.00         | 18,744.63      | 222,934.47      | 0.075             |

597 budget

178,433.11

710 usage increase

44,501.36

14% 597 Decline

MF0064

Confidential - Subsequent to the Order

Williams v. Remington

REMINGTON ARMS COMPANY, INC.  
REARMS - MAYFIELD

08/30/99

C:\windows\TEMP\M710 estimate rev4.xls]Start Up Costs

|                             | 1/31/00          | 2/29/00          | 3/31/00          | 4/30/00          | 5/31/00          | 6/30/00          | 7/31/00          | Total                    |
|-----------------------------|------------------|------------------|------------------|------------------|------------------|------------------|------------------|--------------------------|
| Direct Labor                |                  |                  | 7,109.76         | 8,809.92         | 10,200.96        | 6,800.64         |                  | 32,921.28                |
| From Overhead               |                  |                  |                  |                  |                  |                  |                  |                          |
| Setters                     | 3,625.60         | 8,565.48         | 5,349.80         | 1,767.76         |                  | 3,070.32         | 3,535.52         | 25,914.48                |
| Maintenance                 | 2,582.40         | 5,084.10         | 5,717.34         | 4,198.24         | 3,148.68         | 4,253.48         | 2,099.12         | 27,083.36                |
| EBs                         | 3,600.64         | 7,916.76         | 10,542.60        | 8,570.03         | 7,742.79         | 8,192.18         | 3,268.09         | 49,833.09                |
| Other Costs                 |                  |                  |                  |                  |                  |                  |                  |                          |
| Material for 1,000 Learning |                  |                  |                  |                  |                  |                  |                  |                          |
| Guns (\$43.86/ea)           |                  |                  | 21,930.00        | 21,930.00        |                  |                  |                  | 43,860.00                |
| Material for 60 T&P         |                  |                  |                  |                  |                  |                  |                  |                          |
| Guns (\$43.86/ea)           |                  |                  |                  | 1,315.80         | 1,315.80         |                  |                  | 2,631.60                 |
| Material for 30 DAT         |                  |                  |                  |                  |                  |                  |                  |                          |
| Guns (\$43.86/ea)           |                  |                  |                  |                  |                  | 1,315.80         |                  | 1,315.80                 |
| 15,000 rns of Ammo          |                  |                  | 600.00           | 1,200.00         | 600.00           | 600.00           |                  | 3,000.00                 |
| Disassembly & Rearrange     |                  |                  | 6,000.00         |                  |                  |                  |                  | 6,000.00                 |
| Other Costs                 | 14,285.71        | 14,285.71        | 14,285.71        | 14,285.71        | 14,285.71        | 14,285.71        | 14,285.71        | 100,000.00               |
|                             | <u>24,094.35</u> | <u>35,852.05</u> | <u>71,535.22</u> | <u>62,977.47</u> | <u>37,293.95</u> | <u>38,518.13</u> | <u>23,188.45</u> | <u>292,559.61</u>        |
| 1999 startup Costs          |                  |                  |                  |                  |                  |                  |                  | <u>100,000.00</u>        |
|                             |                  |                  |                  |                  |                  |                  |                  | <u><u>392,559.61</u></u> |

MF0065

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

C:\windows\TEMP\M710 estimate rev4.xls]Head Count

|                                                 | 69,000 597s<br>0 710s | 51,300 597s<br>20,000 710s | 58,400 597s<br>20,000 710s | 58,400 597s<br>30,000 710s |
|-------------------------------------------------|-----------------------|----------------------------|----------------------------|----------------------------|
| Guns Produced                                   | 69,000                | 71,300                     | 78,400                     | 88,400                     |
| Guns Per Day                                    | 285                   | 295                        | 324                        | 365                        |
| Hours Earned                                    | 71,162                | 71,179                     | 78,502                     | 87,637                     |
| Hours Per Head Count<br>(242*8 hrs)             | 1,936                 | 1,936                      | 1,936                      | 1,936                      |
| Head count Required with no time off or OT      | 36.8                  | 36.8                       | 40.5                       | 45.3                       |
| Vacation and Floating Holidays<br>(3/242=1.23%) | 0.5                   | 0.5                        | 0.5                        | 0.6                        |
| Sick and Other 1.8%                             | 0.7                   | 0.7                        | 0.7                        | 0.8                        |
| Add 3% inefficiency                             | 1.1                   | 1.1                        | 1.2                        | 1.4                        |
| Less 3% OT                                      | (1.1)                 | (1.1)                      | (1.2)                      | (1.4)                      |
| Required Head Count                             | 37.9                  | 37.9                       | 41.8                       | 46.6                       |
| Actual Head Count                               | 37.5                  | 38.5                       | 39.5                       | 40.5                       |
| Over/(Under) Staffing                           | (0.4)                 | 0.6                        | (2.3)                      | (6.1)                      |

MF0066

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

C:\windows\TEMP\M710 estimate rev4.xls\710 capital by operation

## In House Capital

| Part Name       | Operation                      | Equipment    | Capital Required |        | Useful Lif  | Depreciation |   |
|-----------------|--------------------------------|--------------|------------------|--------|-------------|--------------|---|
| Barrel          | Cut off                        |              | \$0              |        |             |              |   |
|                 | Drill                          | cones        | \$9,960          | Dec-99 | 10          | 996          |   |
|                 | Ream                           |              | \$0              |        | 10          | -            |   |
|                 | Rifle                          | gages        | \$9,800          | Feb-00 | 10          | 980          |   |
|                 | Wash & Stress Relieve          | baskets      | \$6,900          | Feb-00 | 10          | 690          |   |
|                 | Turn                           | gages        | \$10,100         | Feb-00 | 10          | 1,010        |   |
|                 | Face & Chamber                 | gages        | \$33,300         | Apr-00 | 10          | 3,330        |   |
|                 | Face & Chamber                 | machine      | \$222,880        | Mar-00 | 10          | 22,288       |   |
|                 | Cut off and Crown              | chuck        | \$15,000         | Jan-00 | 10          | 1,500        |   |
|                 | wash and eddy current test     | machine      | \$75,000         | Mar-00 | 10          | 7,500        |   |
|                 | Induction Harden               | machine      | \$166,000        | Mar-00 | 10          | 16,600       |   |
|                 | Inspect Hardness               | machine      | \$12,000         | Mar-00 | 10          | 1,200        |   |
|                 | Drill and tap sight            | fix & gages  | \$7,600          | Feb-00 | 10          | 760          |   |
|                 | Roll mark                      | fix & gages  | \$6,300          | Apr-00 | 10          | 630          |   |
|                 | Angularity Straighten          | fix & gages  | \$3,500          | Feb-00 | 10          | 350          |   |
|                 | Centerless Polish              |              | \$0              |        | 10          | -            |   |
|                 | Glass Bead Blast               | fixtures     | \$2,500          | Jan-00 | 10          | 250          |   |
|                 | Color                          | racks        | \$6,000          | Jan-00 | 10          | 600          |   |
| Bolt Head       | Inspect Purchased Part         |              |                  |        |             |              |   |
|                 | Blank                          | gage         | \$2,600          | Feb-00 | 10          | 250          |   |
|                 | Superabrasive Grind Lugs       | fix & gage   | \$43,800         | Feb-00 | 10          | 4,380        |   |
|                 | CNC Machine Bolt Face Complete | fix & gage   | \$174,784        | Mar-00 | 10          | 17,478       |   |
|                 | CNC Machine Cam Cuts           |              |                  |        |             |              |   |
|                 | Ejector Retaining Pin Hole     | fix & gage   | \$15,000         | Mar-00 | 10          | 1,500        |   |
|                 | CNC Machine Bolt Head          |              |                  |        |             |              |   |
|                 | Retaining Pin Hole             | fix & gage   | \$15,000         | Mar-00 | 10          | 1,500        |   |
|                 | Punch Form Extractor           |              |                  |        |             |              |   |
|                 | Rotation Notch                 | fix & gage   | \$10,000         | Jan-00 | 10          | 1,000        |   |
|                 | Vendor Heat Treat              |              | \$0              |        | 10          | -            |   |
|                 | Inspect for Hardness           |              | \$0              |        | 10          | -            |   |
| Black Oxide     |                                | \$0          |                  | 10     | -           |              |   |
| Bolt Body       | Inspect Purchased Part         |              |                  |        |             |              |   |
|                 | Blank                          | gage         | \$2,000          | Jan-00 | 10          | 200          |   |
|                 | Machine Cam Cuts               | machine      | \$0              | Feb-00 | 10          | -            |   |
|                 | Assemble Braze Bolt            | machine      | \$90,000         | Mar-00 | 10          | 9,000        |   |
|                 | Deplate                        | tanks        | \$9,500          | Jan-00 | 10          | 950          |   |
|                 | Eddy Current Test              |              | \$0              |        | 10          | -            |   |
|                 | Glass Bead Blast               | fix          | \$2,500          | Jan-00 | 10          | 250          |   |
|                 | Black Oxide                    |              | \$0              |        | 10          | -            |   |
| Receiver        | Inspect Purchased Part         |              |                  |        |             |              |   |
|                 | Blank                          | gage         | \$2,500          | Jan-00 | 10          | 250          |   |
|                 | Machine A-load                 | machine & CM | \$513,831        | Feb-00 | 10          | 51,383       |   |
|                 | Machine B-load                 |              | \$0              | Feb-00 | 10          | -            |   |
|                 | Vibratory tumble deburr        |              | \$0              |        | 10          | -            |   |
| Barrel Assembly | Press Receiver to Barrel       | fixture      | \$0              | Dec-99 | Ilion Equip | 10           | - |

MF0067

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

C:\windows\TEMP\M710 estimate rev4.xls]710 capital by operation  
Inspect for straightness gage \$3,500

Dec-99 10 350

|                 |         |             |                  |        |    |       |
|-----------------|---------|-------------|------------------|--------|----|-------|
| <b>Final</b>    |         |             |                  |        |    |       |
| <b>Assembly</b> | Gallery | 100yd range | <b>\$100,000</b> | Dec-99 | 25 | 4,000 |
|                 |         | snails      | \$30,000         | Jul-00 | 25 | 1,200 |
|                 |         | HVAC        | \$25,000         | Jun-00 | 10 | 2,500 |
|                 |         | other       | \$10,000         | Mar-00 | 25 | 400   |
|                 |         |             |                  |        | 25 | -     |
|                 |         |             | <b>\$100,000</b> | Mar-00 | 25 | 4,000 |
|                 |         |             | \$65,000         | Jul-00 | 25 | 2,600 |

\$1,801,755

## Purchased Parts

| Part # | Part Name           | Capital            | Tool            | Vendor         |        |    | Payments       | 83            |
|--------|---------------------|--------------------|-----------------|----------------|--------|----|----------------|---------------|
| 300327 | Receiver Insert     | 48,000             | Mold            | Hanson         | Jun-99 | 5  | 9,600          |               |
| 300333 | Side Plate          | 10,000             | Stamping Die    |                | Dec-99 | 5  | 2,000          | Mar-00 Apr-00 |
| 300334 | Safety Arm          | 23,880             | Stamping Die    | NH Stamping    | Dec-99 | 5  | 4,776          | Mar-00 Apr-00 |
| 300345 | Bolt Stop           | 6,820              | PM              | Sterling       | Dec-99 | 5  | 1,364          | Mar-00 Apr-00 |
| 300361 | Recoil Bracket      | 2,225              | Stamping Die    | NH Stamping    | Dec-99 | 5  | 445            | Mar-00 Apr-00 |
| 300360 | Bolt Handle Blank   | 12,800             | Invest Cast Die | Fansteel       | Dec-99 | 5  | 2,560          | Mar-00 Apr-00 |
| 300366 | Bolt H. Braze Shim  | 0                  | Use Paste       | Lucas Milhaupt | Dec-99 | 5  | -              | Mar-00 Apr-00 |
| 300368 | Bolt Plug           | 38,088             | Mold            | Par 4          | Dec-99 | 5  | 7,618          | Mar-00 Apr-00 |
| 300336 | Firing pin head     | 23,000             | Mold            | Megamet        | Dec-99 | 5  | 4,600          | Mar-00 Apr-00 |
| 300362 | Mag Latch           | 33,480             | Mold            | Par 4          | Dec-99 | 5  | 6,696          | Mar-00 Apr-00 |
| 300363 | Magazine Box        | 28,000             | Mold            | Morrissey      | Dec-99 | 5  | 5,600          | Mar-00 Apr-00 |
| 300364 | Magazine Follower   | 33,360             | Mold            | Par 4          | Dec-99 | 5  | 6,660          | Mar-00 Apr-00 |
| 300365 | Magazine Bottom     | 47,860             | Mold            | Par 4          | Dec-99 | 5  | 9,576          | Mar-00 Apr-00 |
|        | Stock               | 150,300            | Mold            | Par 4          | Dec-99 | 5  | 30,060         | Mar-00 Apr-00 |
|        | Styrofoam Bed       | 0                  | Die             | Tuscorora      |        | 5  | -              | Mar-00        |
|        | PPI                 | 38000              |                 |                |        |    |                |               |
|        |                     | \$495,773          |                 |                |        |    |                |               |
|        | <b>Total</b>        | <b>\$2,297,528</b> |                 |                |        |    | 253,430        |               |
|        | <b>Installation</b> | <b>\$61,000</b>    |                 |                |        | 10 | 6,100          |               |
|        |                     | <b>\$2,358,528</b> |                 |                |        |    | <b>259,530</b> |               |

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

C:\windows\TEMP\M710 estimate rev4.xls]Rev 3 vs 4

| PART DESCRIPTION           | (Decrease)/Increase |                 |
|----------------------------|---------------------|-----------------|
|                            | Material            | Run Time        |
| Carton Assembly            | 0.21                |                 |
| Barrel Assembly Complete   |                     | (0.0095)        |
| <b>Barrel</b>              | <b>(0.12)</b>       | <b>0.1395</b>   |
| <b>Receiver</b>            | <b>(3.24)</b>       | <b>(0.0645)</b> |
| Receiver Insert Assembly   |                     | (0.0048)        |
| <b>Trigger</b>             | <b>0.98</b>         |                 |
| Safety                     | (0.01)              | (0.0015)        |
| Safety Pivot Pin           | (0.07)              |                 |
| Snap Washer                | (0.02)              |                 |
| Bolt Stop                  | (0.09)              |                 |
| Recoil Bracket             | (0.01)              |                 |
| <b>Bolt Body</b>           | <b>(1.76)</b>       | <b>(0.0128)</b> |
| Bolt Handle Blank          | 0.13                |                 |
| Bolt Handle Pin            | (0.01)              |                 |
| Bolt Handle Brazing Shim   | (0.05)              |                 |
| Bolt Head Assembly         |                     | 0.0428          |
| <b>Bolt Head</b>           | <b>0.15</b>         | <b>(0.0115)</b> |
| Bolt Assembly Pin          | (0.12)              |                 |
| <b>Bolt Plug</b>           | <b>(0.69)</b>       |                 |
| <b>Firing Pin Assembly</b> |                     | <b>(0.0086)</b> |
| Firing Pin                 | (0.03)              |                 |
| Firing Pin Tip             | 0.32                |                 |
| <b>Firing Pin Head</b>     | <b>1.17</b>         |                 |
| <b>Front Sight</b>         | <b>0.51</b>         |                 |
| Front Sight Ramp           | 0.28                |                 |
| Rear Sight Slide           |                     | 0.0015          |
| <b>Stock</b>               | <b>(0.62)</b>       |                 |
| Middle Screw Bushing       | (0.08)              |                 |
| Rear Screw Bushing         | (0.08)              |                 |
| Magazine Latch             | 0.05                |                 |
| Magazine Latch Pin         | 0.03                |                 |
| Takedown Screw             | 0.08                |                 |
| Rear Takedown Screw        | 0.04                |                 |
| Magazine Box Assembly      |                     | (0.0026)        |
| Magazine Follower          | (0.03)              |                 |
| Magazine Bottom            | (0.03)              |                 |
| Blank Part                 | (0.02)              |                 |
| <b>Black Oxide</b>         |                     | <b>0.0103</b>   |
| <b>Final Assembly</b>      |                     | <b>0.0050</b>   |
|                            | <u>(3.13)</u>       | <u>0.0833</u>   |

**Bold = Material change +/- 0.50  
&/or time change +/- .005**

MF0069

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

C:\windows\TEMP\{M710 estimate rev4.xls}Working Capital

|                                               |         |         |
|-----------------------------------------------|---------|---------|
| Units of 710                                  | 20,000  | 30,000  |
| Stores                                        |         |         |
| Theses are primarily specialty Cutters Assume |         |         |
| 3 months in Inventory                         | 37,500  | 56,250  |
| Raw Material                                  |         |         |
| 597 Raw material approaching 6 turns          |         |         |
| 2 months in Inventory                         | 137,931 | 206,897 |
| Work In Process                               |         |         |
| 597 WIP approaching 18 turns                  |         |         |
| .75 Months in Inventory                       | 108,232 | 157,410 |
| Finished Goods                                |         |         |
| Sale better than 597                          |         |         |
| 1 Month in Inventory                          | 159,682 | 224,989 |
| Total Inventory                               | 443,346 | 639,495 |
| Increase in A/P                               |         |         |
| 45 Days of Raw Material & Cutters             | 122,198 | 183,297 |
| Increase in Working Capital                   | 321,147 | 456,198 |

MF0070

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

C:\data\DC\Mayfield\New Products\I[M710 estimate rev4.xls]Start Up Costs

Matt,  
Start up Costs + O/H with  
new Assumptions.

08/30/99

Thanks  
Denny

|                                 | 8/31/99  | 9/30/99   | 10/31/99  | 11/30/99  | 12/31/99  | Total 1999 | 1/31/00   | 2/29/00   | 3/31/00   | 4/30/00   | 5/31/00   | 6/30/00   | 7/31/00   | Total 2000 | Project<br>Total |
|---------------------------------|----------|-----------|-----------|-----------|-----------|------------|-----------|-----------|-----------|-----------|-----------|-----------|-----------|------------|------------------|
| Direct Labor                    | 1,183.96 | 3,188.64  | 3,188.64  | 4,555.20  | 3,671.92  | 15,988.36  |           |           | 7,109.76  | 8,809.92  | 10,200.96 | 6,800.64  |           | 32,921.28  | 48,909.64        |
| From Overhead                   |          |           |           |           |           |            |           |           |           |           |           |           |           |            |                  |
| Setters                         | 198.45   | -         | -         | -         | -         | 198.45     | 3,625.60  | 8,565.48  | 5,349.80  | 1,767.76  |           | 3,070.32  | 3,535.52  | 25,914.48  | 26,112.93        |
| Maintenance                     | -        | -         | -         | -         | -         | -          | 2,582.40  | 5,084.10  | 5,717.34  | 4,198.24  | 3,148.68  | 4,253.48  | 2,099.12  | 27,083.36  | 27,083.36        |
| EBs                             | 801.79   | 1,849.41  | 1,849.41  | 2,642.02  | 2,245.71  | 9,388.35   | 3,600.64  | 7,916.76  | 10,542.60 | 8,570.03  | 7,742.79  | 8,192.18  | 3,268.09  | 49,833.09  | 59,221.44        |
| Other Costs                     |          |           |           |           |           |            |           |           |           |           |           |           |           |            |                  |
| Material for Receiver/Bolt Body |          | 10,500.00 | 10,500.00 | 10,500.00 | 10,500.00 | 42,000.00  |           |           |           |           |           |           |           |            | 42,000.00        |
| Material for 1,000 Learning     |          |           |           |           |           |            |           |           |           |           |           |           |           |            |                  |
| Guns (\$43.86/ea)               |          |           |           |           |           |            |           |           | 21,930.00 | 21,930.00 |           |           |           | 43,860.00  | 43,860.00        |
| Material for 60 T&P             |          |           |           |           |           |            |           |           |           |           |           |           |           |            |                  |
| Guns (\$43.86/ea)               |          |           |           |           |           |            |           |           |           | 1,315.80  | 1,315.80  |           |           | 2,631.60   | 2,631.60         |
| Material for 30 DAT             |          |           |           |           |           |            |           |           |           |           |           |           |           |            |                  |
| Guns (\$43.86/ea)               |          |           |           |           |           |            |           |           |           |           |           | 1,315.80  |           | 1,315.80   | 1,315.80         |
| 15,000 rns of Ammo              |          |           |           |           |           |            |           |           | 600.00    | 1,200.00  | 600.00    | 600.00    |           | 3,000.00   | 3,000.00         |
| Disassembly & Rearrange         |          |           |           |           |           |            |           |           | 6,000.00  |           |           |           |           | 6,000.00   | 6,000.00         |
| Tooling & Inspection            |          | 16,250.00 | 16,250.00 | 16,250.00 | 16,250.00 | 65,000.00  |           |           |           |           |           |           |           |            | 65,000.00        |
| Prototype Parts                 |          |           |           |           |           |            | 8,000.00  | 8,000.00  | 8,000.00  | 8,000.00  |           |           |           | 32,000.00  | 32,000.00        |
| Material Handling Purchases     |          |           |           |           |           |            |           |           |           |           | 19,333.33 | 19,333.33 | 19,333.33 | 58,000.00  | 58,000.00        |
| Miscellaneous                   |          |           |           |           |           |            | 286       | 286       | 286       | 286       | 286       | 286       | 286       | 2,000.00   | 2,000.00         |
| 1999 startup Costs              | 2,184.20 | 31,788.05 | 31,788.05 | 33,947.22 | 32,867.63 | 132,575.15 | 18,094.35 | 29,852.05 | 65,535.22 | 56,077.47 | 42,627.28 | 43,851.46 | 28,521.78 | 284,559.61 | 417,134.76       |

Looks \$50,000

Shot

392,600 Bnded

24.5

| M/700 Costs - 8/27/99                   |        |                |                      |              |                |                |                  |                | COMMENTS/ASSUMPTIONS                                       |
|-----------------------------------------|--------|----------------|----------------------|--------------|----------------|----------------|------------------|----------------|------------------------------------------------------------|
| PART DESCRIPTION                        | Part # | Material<br>\$ | Run Rate<br>(hrs/pc) | Labor<br>a/o | end or H<br>\$ | Var<br>O.H. \$ | Total<br>O.H. \$ | Piece<br>Price |                                                            |
|                                         |        |                |                      |              |                |                |                  |                |                                                            |
| Document Envelope Assembly              | 1748   | \$ 0.09        |                      |              |                |                |                  |                | M/597 document envelope<br>and box assembly                |
| Document Envelope                       | 1649   | \$ 0.08        |                      |              |                |                |                  |                |                                                            |
| Users manual                            | 3391   | \$ 0.15        |                      |              |                |                |                  |                |                                                            |
| Product Owners Card                     | 1426   | \$ 0.03        |                      |              |                |                |                  |                |                                                            |
| Remington Authorized Gunsmith           | 3413   | \$ 0.07        |                      |              |                |                |                  |                |                                                            |
| Safety Booklet                          | 3499   | \$ 0.10        |                      |              |                |                |                  |                |                                                            |
| Remington Museum Flyer                  | 3475   | \$ -           |                      |              |                |                |                  |                |                                                            |
| Oval Label                              | 3491   | \$ 0.01        |                      |              |                |                |                  |                |                                                            |
| <b>Document Envelope Assembly total</b> |        |                |                      |              |                |                |                  |                |                                                            |
| Carton Assembly Complete                | 330031 | \$ 2.05        |                      |              |                |                |                  |                | Ilion Carton to avoid \$19000 Capital                      |
| Carton                                  | 1640   |                |                      |              |                |                |                  |                |                                                            |
| Styrofoam bed                           | 300185 |                |                      |              |                |                |                  |                |                                                            |
| Box and Envelope Label (710)            | 993002 |                |                      |              |                |                |                  |                |                                                            |
| Barrel Assembly Complete                | 305410 |                | 0.0790               | a            |                |                |                  |                | final assy estimate                                        |
| Barrel Assembly                         | 305400 |                |                      | o            |                |                |                  |                | drawing level                                              |
| Barrel                                  | 305315 | \$4.80         | 0.3866               | o            |                |                |                  |                | 150% of .2577 run time, 8.38lbs/bbl                        |
| Receiver                                | 300340 | \$1.76         | 0.0055               | o            |                |                |                  |                | Assume tubing on LT15 operator of .004 for a 4 min cycle   |
| Receiver Insert Assembly Complete       | 300401 |                | 0.0530               | a            |                |                |                  |                | 150% of estimated 2.13min.                                 |
| Receiver Insert Assembly                | 300400 |                | 0.0050               | a            |                |                |                  |                |                                                            |
| Receiver Insert                         | 300327 | \$0.62         |                      |              |                |                |                  |                | Ilion quote                                                |
| Threaded Insert                         | 300347 | \$0.04         |                      |              |                |                |                  |                |                                                            |
| Side Plate                              | 300333 | \$0.09         | 0.0010               | o            |                |                |                  |                |                                                            |
| Side Plate Pin (2)                      | 300328 | \$0.12         | 0.0010               | o            |                |                |                  |                |                                                            |
| Sear Safety Cam                         | 15666  | \$ 0.94        |                      |              |                |                |                  |                | Ilion PMPD, key features on this make it not easily moved. |
| Pivot Pin (3)                           | 300351 | \$ 0.18        |                      |              |                |                |                  |                |                                                            |
| Sear Spring                             | 17047  | \$ 0.02        |                      |              |                |                |                  |                | Ilion 700                                                  |

| M/700 Costs - 8/27/99    |        |             |                   |           |             |             |               |             | COMMENTS/ASSUMPTIONS                                                                                    |
|--------------------------|--------|-------------|-------------------|-----------|-------------|-------------|---------------|-------------|---------------------------------------------------------------------------------------------------------|
| PART DESCRIPTION         | Part # | Material \$ | Run Rate (hrs/pc) | Labor a/o | end or H \$ | Var O.H. \$ | Total O.H. \$ | Piece Price |                                                                                                         |
| Trigger                  | 15280  | \$ 1.53     |                   |           |             |             |               |             | Ilion 700, quoting issues                                                                               |
| Trigger Connector        | 19461  | \$ 1.03     |                   |           |             |             |               |             | Ilion 700                                                                                               |
| Trigger Screw Front      | 17053  | \$ 0.10     |                   |           |             |             |               |             | Ilion 700                                                                                               |
| Trigger Engagement Screw | 91128  | \$ 0.03     |                   |           |             |             |               |             | Ilion 700                                                                                               |
| Trigger Spring           | 15400  | \$ 0.03     |                   |           |             |             |               |             | Ilion 700                                                                                               |
| Trigger Stop Screw       | 15481  | \$ 0.06     |                   |           |             |             |               |             | Ilion 700                                                                                               |
| Safety                   | 300408 | \$ 0.31     |                   | o         |             |             |               |             | May increase with additional bend \$0.07                                                                |
| Safety Pivot Pin         | 300352 | \$ 0.06     |                   | o         |             |             |               |             |                                                                                                         |
| Safety Spring            | 300407 | \$ 0.05     |                   |           |             |             |               |             | new part                                                                                                |
| Bolt Stop                | 300345 | \$ 0.19     | 0.0010            | o         |             |             |               |             | Assume outside PMPd base on a similar size parts quoted for the m99 and 597.                            |
| Receiver Plug Screws (4) | 17034  | \$ 0.12     |                   |           |             |             |               |             | M597                                                                                                    |
| Recoil Bracket           | 300361 | \$ 0.19     | 0.0010            | o         |             |             |               |             | Square Stamping                                                                                         |
| Bolt Body Assembly       | 300403 |             | 0.0275            | o         |             |             |               |             | Ilion run times due to experience. High -not grouped.                                                   |
| Bolt Body                | 300339 | \$ 0.74     | 0.0032            | o         |             |             |               |             | 5 min bar change                                                                                        |
| Bolt Handle              | 300370 |             | 0.0120            | o         |             |             |               |             | load unload time at machining                                                                           |
| Bolt Handle Blank        | 300360 | \$ 1.63     |                   | o         |             |             |               |             | Investment cast using the m597 bolt @\$1.80 and bolt handle at \$.80 as a guide.                        |
| Bolt Handle Pin          | 300329 | \$ 0.06     |                   | o         |             |             |               |             |                                                                                                         |
| Bolt Head Assembly       | 305390 |             | 0.0580            | a         |             |             |               |             | 150% would be .0875                                                                                     |
| Bolt Head                | 300338 | \$ 1.60     | 0.0809            | o         | \$ 0.15     |             |               |             | Assumed Ilion quoted blank cost. Run time assumes full cut time could drop to .034 depending on machine |
| Extractor                | 93712  | \$ 0.77     |                   | o         |             |             |               |             |                                                                                                         |
| Ejector                  | 300342 | \$ 0.16     | 0.0010            | o         |             |             |               |             |                                                                                                         |
| Ejector Spring           | 300367 | \$ 0.03     |                   | o         |             |             |               |             | 597 \$0.02                                                                                              |
| Ejector Pin              | 94555  | \$ 0.01     |                   | o         |             |             |               |             |                                                                                                         |
| Bolt Assembly Pin        | 300330 | \$ 0.10     | 0.0010            | o         |             |             |               |             | Second loading raises price from a normal pin.                                                          |
| Firing Pin Assembly      | 300404 |             | 0.0070            | a         |             |             |               |             | Added , not in estimates                                                                                |
| Bolt Plug                | 300368 | \$ 0.25     |                   |           |             |             |               |             | Par 4                                                                                                   |
| Bolt Plug Insert         | 300346 | \$ 0.29     |                   |           |             |             |               |             | Higher \$ risk, unquoted part                                                                           |
| Firing Pin               | 300334 | \$ 0.27     | 0.0010            | o         |             |             |               |             |                                                                                                         |

| M/700 Costs - 8/27/99       |        |             |                   |           |            |             |               |                                                            |
|-----------------------------|--------|-------------|-------------------|-----------|------------|-------------|---------------|------------------------------------------------------------|
| PART DESCRIPTION            | Part # | Material \$ | Run Rate (hrs/pc) | Labor a/o | endor H \$ | Var O.H. \$ | Total O.H. \$ | Piece Price                                                |
| Firing Pin Tip              | 300335 | \$ 1.50     | 0.0015            | o         | \$ 0.10    |             |               |                                                            |
| Firing Pin Head             | 300336 | \$ 1.45     | 0.0020            | o         | \$ 0.05    |             |               |                                                            |
| Firing Pin Spring           | 300399 | \$ 0.14     |                   |           |            |             |               |                                                            |
| Front Sight                 | 94084  | \$ 0.82     |                   |           |            |             |               |                                                            |
| Front Sight Ramp            | 94657  | \$ 1.13     | 0.0020            | o         |            |             |               |                                                            |
| Front Sight Ramp Screws (2) | 28505  | \$ 0.09     |                   |           |            |             |               |                                                            |
| Rear Sight Assembly         | 103146 |             |                   | n/a       |            |             |               |                                                            |
| Elevation Screw             | 90906  | \$ 0.02     |                   |           |            |             |               |                                                            |
| Rear Sight Aperture         | 94333  | \$ 0.14     | 0.0010            | o         |            |             |               |                                                            |
| Rear Sight Base             | 103531 | \$ 0.97     | 0.0010            | o         |            |             |               |                                                            |
| Rear Sight Slide            | 94335  | \$ 0.47     | 0.0050            | o         |            |             |               |                                                            |
| Windage Screw               | 90904  | \$ 0.02     |                   |           |            |             |               | 597                                                        |
| Rear Sight Base Screw (2)   | 28505  | \$ 0.09     |                   |           |            |             |               | 597 #                                                      |
| Stock Assembly Complete     | ????   |             |                   | n/a       |            |             |               | level for drawings only                                    |
| Stock Assembly              | ????   |             | 0.0160            | a         |            |             |               | Not in any assumptions: This is for assy of butt plate+50% |
| Stock                       | ????   | \$ 5.38     |                   |           |            |             |               | Par 4                                                      |
| Front Screw Bushing         | 15161  | \$ 0.13     |                   |           |            |             |               |                                                            |
| Middle Screw Bushing        | ????   | \$ 0.05     |                   |           |            |             |               |                                                            |
| Rear Screw Bushing          | ????   | \$ 0.05     |                   |           |            |             |               |                                                            |
| Grip Cap                    | 97971  | \$ 0.18     |                   |           |            |             |               |                                                            |
| Recoil Pad                  | 97973  | \$ 1.63     |                   |           |            |             |               |                                                            |
| Recoil Pad Screw (2)        | 98008  | \$ 0.05     |                   |           |            |             |               |                                                            |
| Magazine Latch              | 300362 | \$ 0.25     |                   |           |            |             |               | Based on similar parts                                     |
| Magazine Latch Spring       | 300398 | \$ 0.02     |                   |           |            |             |               |                                                            |
| Magazine Latch Pin          | 300371 | \$ 0.04     | 0.0010            | o         |            |             |               |                                                            |
| Sling Swivel Stud (2)       | 300096 | \$ 0.14     |                   |           |            |             |               | M/597 Price                                                |
| Takedown Screw (2)          | ????   | \$ 0.16     |                   |           |            |             |               |                                                            |
| Rear Takedown Screw         | ????   | \$ 0.08     |                   |           |            |             |               |                                                            |

| M/700 Costs - 8/27/99 |        |                |                      |              |               |                |                  |                |
|-----------------------|--------|----------------|----------------------|--------------|---------------|----------------|------------------|----------------|
| PART DESCRIPTION      | Part # | Material<br>\$ | Run Rate<br>(hrs/pc) | Labor<br>a/o | endor H<br>\$ | Var<br>O.H. \$ | Total<br>O.H. \$ | Piece<br>Price |
| Magazine Assembly     | 305395 |                | 0.0083               | a            |               |                |                  |                |
| Magazine Box          | 300363 | \$ 2.79        | 0.0010               | a            |               |                |                  |                |
| Magazine Follower     | 300364 | \$ 0.26        |                      |              |               |                |                  |                |
| Magazine Bottom       | 300365 | \$ 0.26        |                      |              |               |                |                  |                |
| Magazine Spring       | 300405 | \$ 0.42        |                      |              |               |                |                  |                |
| Gallery;inspect;pack  |        | 1.15           | 0.1500               | a            |               |                |                  |                |
| Total Cost            |        | \$ 40.65       | 0.9136               |              | \$ 0.30       |                |                  |                |
|                       |        |                |                      |              |               |                |                  |                |
|                       |        |                |                      |              |               |                |                  |                |
|                       |        |                | 51.4688              |              |               |                |                  |                |
|                       |        |                | \$ 0.30              |              |               |                |                  |                |
|                       |        |                | 40.6513              |              |               |                |                  |                |
|                       |        |                | 92.4202              |              |               |                |                  |                |

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## M/710 Capital

## In House Capital

| Part Name | Operation                  | Equipment   | Capital Required |        |
|-----------|----------------------------|-------------|------------------|--------|
|           | Cut off                    |             | \$0              |        |
| Barrel    | Drill                      | cones       | \$9,960          | Dec-99 |
|           | Ream                       |             | \$0              |        |
|           | Rifle                      | gages       | \$9,800          | Feb-00 |
|           | Wash&Stress Relieve        | baskets     | \$6,900          | Feb-00 |
|           | Turn                       | gages       | \$10,100         | Feb-00 |
|           | Face&Chamber               | gages       | \$33,300         | Apr-00 |
|           | Face&Chamber               | machine     | \$222,880        | Mar-00 |
|           | Cut off and Crown          | chuck       | \$15,000         | Jan-00 |
|           | wash and eddy current test | machine     | \$75,000         | Mar-00 |
|           | Induction Harden           | machine     | \$166,000        | Mar-00 |
|           | Inspect Hardness           | machine     | \$12,000         | Mar-00 |
|           | Drill and tap sight        | fix & gages | \$7,600          | Feb-00 |
|           | Roll mark                  | fix & gages | \$6,300          | Apr-00 |
|           | Angularity Straighten      | fix & gages | \$3,500          | Feb-00 |
|           | Centerless Polish          |             | \$0              |        |
|           | Glass Bead Blast           | fixtures    | \$2,500          | Jan-00 |
|           | Color                      | racks       | \$6,000          | Jan-00 |

|           |                                                  |            |           |        |
|-----------|--------------------------------------------------|------------|-----------|--------|
| Bolt Head | Inspect Purchased Part Blank                     | gage       | \$2,500   | Feb-00 |
|           | Superabrasive Grind Logs                         | fix & gage | \$43,800  | Feb-00 |
|           | CNC Machine Bolt Face Complete                   | fix & gage | \$174,784 | Mar-00 |
|           | CNC Machine Cam Cuts, Ejector Retaining Pin Hole | fix & gage | \$15,000  | Mar-00 |
|           | CNC Machine Bolt Head Retaining Pin Hole         | fix & gage | \$15,000  | Mar-00 |
|           | Punch Form Extractor Rotation Notch              | fix & gage | \$10,000  | Jan-00 |
|           | Vendor Heat Treat                                |            | \$0       |        |
|           | Inspect for Hardness                             |            | \$0       |        |
|           | Black Oxide                                      |            | \$0       |        |

|           |                              |         |          |        |
|-----------|------------------------------|---------|----------|--------|
| Bolt Body | Inspect Purchased Part Blank | gage    | \$2,000  | Jan-00 |
|           | Machine Cam Cuts             | machine | \$0      | Feb-00 |
|           | Assemble Braze Bolt          | machine | \$90,000 | Mar-00 |
|           | Deplate                      | tanks   | \$9,500  | Jan-00 |
|           | Eddy Current Test            |         | \$0      |        |
|           | Glass Bead Blast             | fix     | \$2,500  | Jan-00 |
|           | Black Oxide                  |         | \$0      |        |

|          |                         |             |           |        |
|----------|-------------------------|-------------|-----------|--------|
| Receiver | Inspect Purchased Part  |             |           |        |
|          | Blank                   | gage        | \$2,500   | Jan-00 |
|          | Machine A-load          | machine&CMM | \$513,831 | Feb-00 |
|          | Machine B-load          |             | \$0       | Feb-00 |
|          | Vibratory tumble deburr |             | \$0       |        |

|          |                          |         |         |        |              |
|----------|--------------------------|---------|---------|--------|--------------|
| Barrel   | Press Receiver to Barrel | fixture | \$0     | Dec-99 | Illion Equip |
| Assembly | Inspect for straightness | gage    | \$3,500 | Dec-99 |              |

|          |         |             |           |        |
|----------|---------|-------------|-----------|--------|
| Final    | Gallery | 100yd range | \$100,000 | Dec-99 |
| Assembly |         | snails      | \$30,000  | Jul-00 |
|          |         | HVAC        | \$25,000  | Jun-00 |
|          |         | other       | \$10,000  | Mar-00 |
|          |         |             |           |        |
|          |         |             | \$100,000 | Mar-00 |
|          |         |             | \$65,000  | Jul-00 |

| Purchased Parts |                    |             |                 |                |          |        |        |  |
|-----------------|--------------------|-------------|-----------------|----------------|----------|--------|--------|--|
| Part #          | Part Name          | Capital     | Tool            | Vendor         | Payments |        |        |  |
| 300327          | Receiver Insert    | 48,000      | Mold            | Hanson         | Jun-99   |        |        |  |
| 300333          | Side Plate         | 19,000      | Stamping Die    |                | Dec-99   | Mar-00 | Apr-00 |  |
| 300334          | Safety Arm         | 23,880      | Stamping Die    | NH Stamping    | Dec-99   | Mar-00 | Apr-00 |  |
| 300345          | Bolt Stop          | 6,820       | PM              | Sterling       | Dec-99   | Mar-00 | Apr-00 |  |
| 300361          | Recoil Bracket     | 2,225       | Stamping Die    | NH Stamping    | Dec-99   | Mar-00 | Apr-00 |  |
| 300380          | Bolt Handle Blank  | 12,800      | Invest Cast Die | Fansteel       | Dec-99   | Mar-00 | Apr-00 |  |
| 300388          | Bolt H. Braze Shim | 0           | Use Paste       | Lucas Milhaupt | Dec-99   | Mar-00 | Apr-00 |  |
| 300369          | Bolt Plug          | 38,088      | Mold            | Par 4          | Dec-99   | Mar-00 | Apr-00 |  |
| 300386          | Firing pin head    | 23,000      | MIM Mold        | Megamet        | Dec-99   | Mar-00 | Apr-00 |  |
| 300362          | Mag Latch          | 33,480      | Mold            | Par 4          | Dec-99   | Mar-00 | Apr-00 |  |
| 300363          | Magazine Box       | 28,000      | Mold            | Morrissey      | Dec-99   | Mar-00 | Apr-00 |  |
| 300364          | Magazine Follower  | 33,300      | Mold            | Par 4          | Dec-99   | Mar-00 | Apr-00 |  |
| 300365          | Magazine Bottom    | 47,880      | Mold            | Par 4          | Dec-99   | Mar-00 | Apr-00 |  |
|                 | Stock              | 150,300     | Mold            | Par 4          | Dec-99   | Mar-00 | Apr-00 |  |
|                 | Styrofoam Bed      | 0           | Die             | Tuscorora      |          | Mar-00 |        |  |
|                 | PPI                | 38000       |                 |                |          |        |        |  |
|                 |                    | \$495,773   |                 |                |          |        |        |  |
| Total           |                    | \$2,297,528 |                 |                |          |        |        |  |

| Teams | Process   | Nov-99 | Dec-99 | Jan-00 | Feb-00 | Mar-00 | Apr-00 | May-00 | Jun-00 | Jul-00 |
|-------|-----------|--------|--------|--------|--------|--------|--------|--------|--------|--------|
| 1     | Barrel    |        |        |        |        |        |        |        |        |        |
| 2     | Bolt Head |        |        |        |        |        |        |        |        |        |
| 3     | Receiver  |        |        |        |        |        |        |        |        |        |
| 4     | Bolt Body |        |        |        |        |        |        |        |        |        |
| 5     | Assembly  |        |        |        |        |        |        |        |        |        |

|        |          |     |   |     |     |     |   |   |     |   |
|--------|----------|-----|---|-----|-----|-----|---|---|-----|---|
| TOTALS | Direct   |     |   |     |     | 4   | 6 | 6 | 4   |   |
|        | Indirect | 0.5 | 2 | 2.5 | 4.5 | 2.5 | 1 |   | 1.5 | 2 |
|        | Maint.   | 0.5 | 2 | 3   | 4.5 | 4.5 | 4 | 3 | 3.5 | 2 |

 = 0.5 indirect & 0.5 maint.  
 = 1 indirect & 1 maint.  
 = 2 direct & 1 maint.

| New Parts                                              |                       |             |                                 | Add Use from M700   |                         |                   |                            |
|--------------------------------------------------------|-----------------------|-------------|---------------------------------|---------------------|-------------------------|-------------------|----------------------------|
| Part #                                                 | Part Name             | Material \$ | llion<br>Quotes or<br>Estimates | Part #              | Part Name               | Material \$       | Quotes<br>from<br>Mayfield |
| 300327                                                 | Receiver Insert       | 0.62        |                                 | 1444                | Carlton Assy            | 2.05              |                            |
| 300333                                                 | Side Plate            |             | 0.09                            | 15666               | Sear Safety Cam         | 0.94              |                            |
| 300334                                                 | Safety Arm            | 0.31        |                                 | 17047               | Sear Spring             | 0.02              |                            |
| 300345                                                 | Bolt Stop             | 0.19        |                                 | 15280               | Trigger                 | 1.53              |                            |
| 300361                                                 | Recoil Bracket        | 0.193       |                                 | 19461               | Trigger Connector       | 1.48              |                            |
| 300360                                                 | Bolt Handle Blank     | 1.63        |                                 | 17053               | Trigger Front Screw     | 0.11              | 0.032                      |
| 300366                                                 | Bolt H. Braze Shim    | 0           |                                 | 91128               | Engagement Screw        | 0.03              |                            |
| 300368                                                 | Bolt Plug             | 0.25        |                                 | 15400               | Trigger Spring          | 0.03              |                            |
| 300336                                                 | Firing pin head       | 1.45        |                                 | 15481               | Trigger Stop Screw      | 0.06              | 0.032                      |
| 300362                                                 | Mag Latch             | 0.25        |                                 | 17044               | Snap Washer             | 0.09              |                            |
| 300363                                                 | Magazine Box          |             | 2.79                            | 17034               | Receiver Plug Screws    | 0.13              |                            |
| 300364                                                 | Magazine Follower     | 0.259       |                                 | 93712               | Extractor               | 0.78              |                            |
| 300365                                                 | Magazine Bottom       | 0.256       |                                 | 94555               | Ejector Pin             | 0.01              |                            |
|                                                        | Stock                 | 5.38        |                                 | 94084               | Front sight             | 0.82              |                            |
| 300347                                                 | Threaded Insert       | 0.04        |                                 | 94657               | front Sight Ramp        | 1.13              |                            |
| 300328                                                 | Side Plate Pin (2)    | 0.12        |                                 | 28505               | Front Sight Ramp Screws | 0.09              |                            |
| 300351                                                 | Pivot Pins (3)        | 0.18        |                                 | 90906               | Elevation Screw         | 0.02              |                            |
| 300352                                                 | Safety Pivot Pin      | 0.06        |                                 | 94333               | Rear Sight Aperature    | 0.14              | 0.105                      |
| 300407                                                 | Safety Spring         |             | 0.03                            | 103531              | Rear Sight Base         | 0.97              |                            |
| 300329                                                 | Bolt Handle Pin       | 0.06        |                                 | 94335               | Rear Sight Slide        | 0.47              |                            |
| 300342                                                 | Ejector               |             | 0.16                            | 90904               | Windage Screw           | 0.02              |                            |
| 300330                                                 | Bolt Assy Pin         | 0.1         |                                 | 28505               | Rear Sight Base Scre    | 0.08              |                            |
| 300346                                                 | Bolt Plug Insert      |             | 0.29                            | 15161               | Front Screw Bushing     | 0.13              |                            |
| 300346                                                 | Tumbler               |             | 0.41                            | 97971               | Crip Cap                | 0.18              |                            |
|                                                        | lock plunger          |             | 0.05                            | 97973               | Recoil Pad              | 1.63              |                            |
|                                                        | lock spring           |             | 0.01                            | 98008               | Recoil Pad Screws       | 0.05              | 0.012                      |
|                                                        | key                   |             |                                 | 17028               | Magazine Spring         | 0.42              |                            |
| 300334                                                 | Firing Pin            | 0.27        |                                 | Total Add Use Parts |                         | \$13.42           |                            |
| 300335                                                 | Firing Pin Tip        | 1.5         |                                 | Add Use is          |                         | 31.86% % of total |                            |
|                                                        | Firing Pin Spring     |             | 0.14                            |                     |                         |                   |                            |
|                                                        | Middle Screw Bushing  |             | 0.05                            |                     |                         |                   |                            |
|                                                        | Rear Screw Bushing    |             | 0.05                            |                     |                         |                   |                            |
| 300405                                                 | Mag Latch Spring      |             | 0.05                            |                     |                         |                   |                            |
| 300371                                                 | Mag Latch Pin         | 0.04        |                                 |                     |                         |                   |                            |
| 300096                                                 | Sling Swivel Stud (2) |             | 0.14                            |                     |                         |                   |                            |
|                                                        | Take Down Screw R     |             | 0.08                            |                     |                         |                   |                            |
|                                                        | Take Down Screw M     |             | 0.08                            |                     |                         |                   |                            |
|                                                        | Take Down Screw F     |             | 0.08                            |                     |                         |                   |                            |
| 300338                                                 | Bolt Head Blank       |             | 1.6                             |                     |                         |                   |                            |
|                                                        | Barrel Blank          | 4.92        |                                 |                     |                         |                   |                            |
|                                                        | Receiver Blank        | 1.76        |                                 |                     |                         |                   |                            |
|                                                        | Bolt Body             | 0.74        |                                 |                     |                         |                   |                            |
|                                                        | Carlton Assy (llion)  | 2.05        |                                 |                     |                         |                   |                            |
| Total Material \$ New<br>known to date                 |                       | 22.628      |                                 |                     |                         |                   |                            |
| % of Total anticipated                                 |                       | 53.73%      |                                 |                     |                         |                   |                            |
| Total Material \$<br>Estimated or from<br>M700 costing |                       | 6.07        |                                 |                     |                         |                   |                            |
| % of Total anticipated                                 |                       | 14.41%      |                                 |                     |                         |                   |                            |
| Total Add Use Parts                                    |                       | 13.42       |                                 |                     |                         |                   |                            |
| Add Use is                                             |                       | 31.86%      |                                 |                     |                         |                   |                            |
| % of total material<br>cost know by quote              |                       | 85.59%      |                                 |                     |                         |                   |                            |

MF0079

## M710 Capital

## In House Capital

| Part Name | Operation                  | Equipment   | Capital Required | Material | Ext Process | Run Time | Variable Tools | Pre-Op Start Up |        |
|-----------|----------------------------|-------------|------------------|----------|-------------|----------|----------------|-----------------|--------|
| Barrel    | Cut off                    |             | \$0              | \$4,600  |             |          | 0.008          | 0               |        |
|           | Drill                      | cones       | \$9,960          |          |             |          | 0.111          | 1,500           | Dec-99 |
|           | Ream                       |             | \$0              |          |             |          | 0.180          | 2,492           |        |
|           | Rifle                      | gages       | \$9,800          |          |             |          | 0.096          | 576             | Feb-00 |
|           | Wash&Stress Relieve        | baskets     | \$6,900          |          |             | 0.0012   | 0.000          | 0               | Feb-00 |
|           | Turn                       | gages       | \$5,000          |          |             | 0.0277   | 0.111          | 5,161           | Feb-00 |
|           | Face&Chamber               | gages       | \$33,337         |          |             | 0.0000   | 0.000          | 0               | Apr-00 |
|           | Face&Chamber               | machine     | \$290,000        |          |             | 0.0585   | 4.069          | 9,388           | Mar-00 |
|           | Cut off and Crown          | chuck       | \$15,000         |          |             |          | 0.120          | 690             | Jan-00 |
|           | wash and eddy current test | machine     | \$75,000         |          |             |          | 0.000          | 0               | Mar-00 |
|           | Induction Harden           | machine     | \$166,000        |          |             |          | 0.050          | 0               | Mar-00 |
|           | Inspect Hardness           | machine     | \$12,000         |          |             |          | 0.000          | 285             | Mar-00 |
|           | Drill and tap sight        | fix & gages | \$7,600          |          |             | 0.0313   | 0.161          | 5,588           | Feb-00 |
|           | Centerless Polish          | gages       | \$0              |          |             |          | 0.186          | 400             |        |
|           | Roll mark                  | fix & gages | \$6,300          |          |             |          | 0.060          | 300             | Apr-00 |

|           |                                                  |            |           |  |        |        |       |       |        |
|-----------|--------------------------------------------------|------------|-----------|--|--------|--------|-------|-------|--------|
| Bolt Head | Inspect Purchased Part Blank                     | gage       | \$2,500   |  |        |        |       |       | Feb-00 |
|           | Superabrasive Grind Lugs                         | fix & gage | \$31,600  |  |        | 0.0189 | 0.394 | 315   | Feb-00 |
|           | CNC Machine Bolt Face Complete                   | fix & gage | \$154,650 |  |        | 0.0496 | 0.266 | 1,782 | Mar-00 |
|           | CNC Machine Cam Cuts, Ejector Retaining Pin Hole | fix & gage | \$15,000  |  |        | 0.0070 | 0.036 | 1,000 | Mar-00 |
|           | CNC Machine Bolt Head Retaining Pin Hole         | fix & gage | \$15,000  |  |        | 0.0172 | 0.252 | 1,471 | Mar-00 |
|           | Punch Form Extractor Rotation Notch              | fix & gage | \$10,000  |  |        | 0.0064 | 0.025 | 1,500 | Jan-00 |
|           | Vendor Heat Treat                                |            | \$0       |  | \$0.15 |        |       |       |        |
|           | Inspect for Hardness                             |            | \$0       |  |        |        |       |       |        |
|           | Black Oxide                                      |            | \$0       |  |        | 0.0013 |       | 800   |        |

|                  |                              |         |           |        |        |       |       |        |
|------------------|------------------------------|---------|-----------|--------|--------|-------|-------|--------|
| <b>Bolt Body</b> | Inspect Purchased Part Blank | gage    | \$2,000   | \$0.74 |        |       |       | Jan-00 |
|                  | Machine Cam Cuts             | machine | \$425,000 |        | 0.0360 | 0.199 | 6,761 | Feb-00 |
|                  | Assemble Braze Bolt          | machine | \$90,000  |        | 0.0083 | 0.050 | 3,500 | Mar-00 |
|                  | Deplate                      | tanks   | \$9,500   |        | 0.0010 | 0.000 | 0     | Jan-00 |
|                  | Eddy Current Test            |         | \$60,000  |        | 0.0083 | 0.000 | 0     |        |
|                  | Glass Bead Blast             | fix     | \$2,500   |        |        |       |       | Jan-00 |
|                  | Black Oxide                  |         | \$0       |        | 0.0013 | 0.000 | 0     |        |

|                 |                              |      |          |        |        |       |        |        |
|-----------------|------------------------------|------|----------|--------|--------|-------|--------|--------|
| <b>Receiver</b> | Inspect Purchased Part Blank | gage | \$2,500  | \$1.76 |        |       |        | Jan-00 |
|                 | Machine A&B load             |      | \$49,725 |        | 0.0083 | 0.941 | 12,480 | Feb-00 |
|                 | Vibratory tumble deburr      |      | \$0      |        | 0.0050 |       |        | Feb-00 |

|                        |                          |             |         |  |        |       |     |        |             |
|------------------------|--------------------------|-------------|---------|--|--------|-------|-----|--------|-------------|
| <b>Barrel Assembly</b> | Press Receiver to Barrel | fixture     | \$7,500 |  | 0.0273 | 0.150 | 750 | Dec-99 | llion Equip |
|                        | Inspect for straightness | gage        | \$9,530 |  | 0.0120 | 0.005 | 700 | Dec-99 |             |
|                        | Angularity Straighten    | fix & gages | \$1,500 |  | 0.0067 | 0.005 | 229 | Feb-00 |             |
|                        | Glass Bead Blast         | fixtures    | \$2,500 |  |        | 0.000 |     | Jan-00 |             |
|                        | Color                    | racks       | \$6,000 |  | 0.0013 | 0.000 |     | Jan-00 |             |

|                       |               |             |           |  |        |  |  |        |  |
|-----------------------|---------------|-------------|-----------|--|--------|--|--|--------|--|
| <b>Final Assembly</b> | Gallery       | 100yd range | \$100,000 |  |        |  |  | Dec-99 |  |
|                       |               | snails      | \$30,000  |  |        |  |  | Jul-00 |  |
|                       |               | HVAC        | \$25,000  |  |        |  |  | Jun-00 |  |
|                       |               | other       | \$10,000  |  |        |  |  | Mar-00 |  |
|                       |               |             | \$100,000 |  |        |  |  | Mar-00 |  |
|                       |               |             | \$65,000  |  |        |  |  | Jul-00 |  |
|                       | Bolt Head     |             |           |  | 0.0600 |  |  |        |  |
|                       | Bolt Body     |             |           |  | 0.0566 |  |  |        |  |
|                       | Firing Pin    |             |           |  | 0.0000 |  |  |        |  |
|                       | Trigger Plate |             |           |  | 0.0355 |  |  |        |  |
|                       | Gun Build     |             |           |  | 0.0355 |  |  |        |  |
|                       | Pack          |             |           |  | 0.0472 |  |  |        |  |

1884102

## Purchased Parts

| Part # | Part Name          | Tool            | Capital     | Material | Ext Process | Run Time | Variable Tools | Pre-op Start Up | Vendor         | Payments |        |        |
|--------|--------------------|-----------------|-------------|----------|-------------|----------|----------------|-----------------|----------------|----------|--------|--------|
| 300327 | Receiver Insert    | Mold            | 48,000      |          |             |          |                |                 | Hanson         | Jun-99   |        |        |
| 300333 | Side Plate         | Stamping Di     | 10,000      |          |             | 0.0010   |                |                 |                | Dec-99   | Mar-00 | Apr-00 |
| 300334 | Safety Arm         | Stamping Di     | 23,880      |          | \$0.03      | 0.0010   |                |                 | NH Stamping    | Dec-99   | Mar-00 | Apr-00 |
| 300345 | Bolt Stop          | PM              | 6,820       |          | \$0.03      | 0.0010   |                |                 | Sterling       | Dec-99   | Mar-00 | Apr-00 |
| 300361 | Recoil Bracket     | Stamping Di     | 2,225       |          |             | 0.0010   |                |                 | NH Stamping    | Dec-99   | Mar-00 | Apr-00 |
| 300360 | Bolt Handle Blank  | Invest Cast Die | 12,800      |          |             | 0.0083   |                |                 | Fansteel       | Dec-99   | Mar-00 | Apr-00 |
| 300366 | Bolt H. Braze Shim | Use Paste       | 0           |          |             | 0.0000   |                |                 | Lucas Milhaupt | Dec-99   | Mar-00 | Apr-00 |
| 300368 | Bolt Plug          | Mold            | 38,088      |          |             | 0.0000   |                |                 | Par 4          | Dec-99   | Mar-00 | Apr-00 |
| 300336 | Firing pin head    | MIM Mold        | 23,000      |          | \$0.30      | 0.0010   |                |                 | Megamet        | Dec-99   | Mar-00 | Apr-00 |
| 300362 | Mag Latch          | Mold            | 33,480      |          |             | 0.0000   |                |                 | Par 4          | Dec-99   | Mar-00 | Apr-00 |
|        | Mag Box Assy       | 0               | 0           |          | \$0.00      | 0.0055   |                |                 |                |          |        |        |
| 300363 | Magazine Box       | Mold            | 28,000      |          |             | 0.0000   |                |                 | Morrissey      | Dec-99   | Mar-00 | Apr-00 |
| 300364 | Magazine Follower  | Mold            | 33,300      |          |             | 0.0000   |                |                 | Par 4          | Dec-99   | Mar-00 | Apr-00 |
| 300365 | Magazine Bottom    | Mold            | 47,880      |          |             | 0.0000   |                |                 | Par 4          | Dec-99   | Mar-00 | Apr-00 |
|        | Stock              | Mold            | 150,300     |          |             | 0.0000   |                |                 | Par 4          | Dec-99   | Mar-00 | Apr-00 |
|        | Styrofoam Bed      | Die             | 18,200      |          |             | 0.0000   |                |                 | Tuscorora      |          | Mar-00 |        |
|        |                    |                 | \$475,973   |          |             |          |                |                 |                |          |        |        |
| Total  |                    |                 | \$2,360,075 | \$7.10   | \$0.31      | 0.4984   | \$7.47         | \$57,668.00     |                |          |        |        |
| 300366 | Obsolete           |                 |             |          |             |          |                |                 |                |          |        |        |

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M/710 Process Summary  
8/8/99

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## I. Process Summary

### A. Barrel

Currently, the barrel is assumed to be 25 inches long. All calculations to date have been based on a 25 inch barrel. Discussions with marketing are continuing in order to change the barrel length and contour. The preferred barrel length from manufacturing would be 20 inches. The maximum length from a manufacturing standpoint with the least interruption to existing processes would be 23 inches. 83

Review of the gundrills, reamers and rifler shows that a 25 inch plus barrel can be accommodated on all of these machines. Current thinking is to run one drill and one reamer on Model 597 and one drill and one reamer on Model 710. The cutoff saw and rifler will be changed over every other day from one model to the other. This will minimize the amount of on-floor inventory and maximize machine output with minimal change overs. Material handling will be a concern at the cutoff operation. A hoist will be required for the larger bar stock. Minimum quantities and lot sizes from the steel vendor are being reviewed to determine the steel storage requirements in steel storage.

The furnace will require new baskets and each basket will hold 170 pieces versus the 400 currently held in a Model 597 basket. The load on the furnace will be increased slightly due to smaller quantities in each load but slightly off set with the Model 597 schedules.

Currently, two Monarch lathes are being used for the Model 597.

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M/710 Process Summary  
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A current capacity review shows that a single Monarch that is capable of producing all of the 597s leaving one spare for the Model 710. Only additional chucks and tooling will be required to retro fit the machine for Model 710.

Several options are available for the cut off and crown operation. One is to change over the current Okuma lathe from Model 597 to Model 710. Running both models in daily lot sizes. A second option is to buy an additional lathe for crowning and a third option is to crown the barrels on an Okuma LT15 lathe, which will chamber one end while crowning the other. Lay out

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for this operation is not complete. Cost analysis of run time and capital required will be complete by August 20th.

The chamber operation can be done several different ways. The most effective through investigation to this point is to purchase a 4 axis lathe. This lathe could be single spindle for chambering and breech end operations only or a twice spindle for the chamber and crown operations as mentioned above. The single spindle lathe is approximately \$280,000 versus the twin spindle at \$400,000. Regardless of type of machine the tooling and variable tools required have been identified and are complete.

The barrels will be heat treated on the first inch on the breech end. This will be done on an induction heat treating machine that Glenn Sietsima has been developing. The only question at Mayfield was the use of nitrogen to provide an atmosphere for the chamber to prevent scaling. The existing nitrogen generator will provide sufficient amounts of nitrogen for the process. We are reviewing the possibility of a nitrogen storage tank to reduce the burden on the generator.

After the barrel is heat treated, the barrel is eddy current tested for cracks. This is new technology to Remington, which has been developed by Ilion. The fall back is transferring a traditional magnaflux booth from Ilion.

Currently the Model 597 front and rear sight holes are drilled and capped on two Okuma MX45 vertical machining centers. With slight fixture modifications, the 710 can be drilled and tapped on the same fixtures leaving only a work scheduling issue through those machines. Another option is to build a special machine to drill and tap only for

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approximately \$30,000 relieving and constraint. The current burden on the Okuma for the sight operation is about 14 hours.

The barrel will be centerless polished. This can be accomplished only with a new profile requested by manufacturing for approval by marketing. The polish will run out approximately .200-.250 inches under the front of the receiver

The barrel will be glass bead blasted in our current blast machine that will require little modification.

## **B. Bolt Head**

Requests for quotes have been sent to 5 screw machine houses. The quotes are due back between August 19th and August 30th. This will determine the blank cost. Each vendor will be quoting three options. This first option is a turned part with the outside profile complete and parted to length. The second option includes some of the internal geometry and the third option is to machine the bolt head complete.

The first operation will be to grind the lugs on the Edgetek. According to current machine burden, there is approximately 13 open hours on the Edgetek per day. Current estimates will burden the Edgetek approximately 4 hours per day.

Next the bolt head will go through one or possibly two CNC machines depending on the level of completion from the vendor. The angles used to cam the bolt will require at least one of the machines to

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have 4th axis capability. Due to the nature of the cuts in the bolt head and additional CMM will be required.

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The bolt head requires a press formed ejector. This will be done on a simple press similar to the type used in Ilion.

The bolt will be sent of plant for vendor heat treat at a cost of approximately \$.10 per bolt head. This is the only major component that will be sent off plant for processing. The barrel heat treat machine is being reviewed to see if it can be adapted to the bolt

### C. Bolt Body

Requests for quotes have been sent to 5 screw machine houses. The quotes are due back between August 19th and August 30th. This will determine the blank cost. Each vendor will be quoting three options. The first option is a seamless tube with some end geometry provided. The second option includes some of the internal geometry and the third option is to machine the bolt body complete.

The first operation will require a CNC machine with a 4th axis to machine the cam cuts on the bolt body. The same machine will be used for the bolt head and receiver cam cuts.

Once the bolt head is machined and washed, the bolt handle will be brazed on. This will require an induction unit. Once parts are available for development, they will be shipped to two vendors and processed to determine what size of induction transformer is required. Once this is complete, a firm quote can be provided. Estimations based on similar operations resulted in the bolt handle brazing requiring a machine of approximately \$75,000.

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The parts will be processed through a Deplate. This will require the installation of a new stainless steel tank that will be placed between the passivate and black oxide lines. A new tank conducting will be approximately \$3,500. The Deplate operation is to remove an excess braze that will be cosmetically unacceptable. The part will then be Eddy current (magnaflux) tested to determine if the part cracked during the braze operation. This operation may be dropped at a later date if history proves zero cracks have ever been developed. 83

The bolt body will then be glass bead blasted to match the finish of the barrel and receiver.

### C. Receiver

Requests for quotes have been sent to 5 screw machine or machining houses. The quotes are due back between August 19th and August 30th. This will determine the blank cost. Each vendor will be quoting three options. The first option is a seamless tube with some end geometry provided. The second option includes some of the internal geometry and the third option is to machine the receiver complete.

The in house complete option is being evaluated currently, this has the least about of detail today both from an engineering estimate and a production tooling a shop floor layout perspective. This will be an area of concerted effort over the next 2 weeks.

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## M/710 Meeting

Date 8/19/99

Next Meeting 8/20/99

8:00 am

Copied process and Summary

Required Information to complete the project proposal:

|                      |                                                                    |  |
|----------------------|--------------------------------------------------------------------|--|
| Jason/Scott          | Tooling Sheets for                                                 |  |
|                      | Receiver                                                           |  |
|                      | Bolt body                                                          |  |
|                      | Updated barrel chamber                                             |  |
| Joe                  | Completed Process Sheets for                                       |  |
|                      | Angularity Straighten                                              |  |
|                      | Assembly of bbl/rec                                                |  |
|                      | Inspect for straightness                                           |  |
|                      | Grind to remove scale?                                             |  |
| Maintenance          | Cart Lane pricing                                                  |  |
|                      | Estimate of normal load and peak load                              |  |
|                      | Buss utilization/total capacity                                    |  |
|                      | Estimate for new buss                                              |  |
|                      | Estimate of total available incoming power                         |  |
|                      | Estimate for machine moves per machine or machine type             |  |
|                      | 4 <sup>th</sup> axis options complied                              |  |
|                      | Inspection fixture for receiver insert                             |  |
| Jerry                | PPI fixture requirements                                           |  |
| Shelly               | Range costs                                                        |  |
|                      | Black oxide racks/runtime/variable costs for the main 3 components |  |
| Production/eng/maint | Test run of 26" barrels                                            |  |
|                      |                                                                    |  |

MF0090



Elizabethtown Research Division PARTS LIST #YYY  
 Date: **Model 710** Supersedes Previous Model XXX  
 08/20/99 **Bolt Action** Parts List #AAA  
**Centerfire Rifle R.H.**

Sheet 1 Dotted line ( - - - )  
 of 1 indicates same part number 30-06 270 7mm 300  
 Rem Mag Win Mag

| DWG. NO. | PART NAME | PART NUMBERS |
|----------|-----------|--------------|
|----------|-----------|--------------|

## RAMAC #

## DOCUMENT ENVELOPE ASSEMBLY

|                               |      |      |      |      |
|-------------------------------|------|------|------|------|
| Document Envelope             | XXXX | ---- | ---- | ---- |
| Instruction Book              | 1649 | ---- | ---- | ---- |
| Product Owners Card           | xxxx | ---- | ---- | ---- |
| Remington Authorized Gunsmith | 1426 | ---- | ---- | ---- |
| Safety Booklet                | 3413 | ---- | ---- | ---- |
| Remington Museum Flyer        | 3499 | ---- | ---- | ---- |
| Oval Label                    | 3475 | ---- | ---- | ---- |
|                               | 3491 | ---- | ---- | ---- |

## CARTON ASSEMBLY

|                             |        |      |      |      |
|-----------------------------|--------|------|------|------|
| Box & Envelope Label        | 993002 | ---- | ---- | ---- |
| (Label To Read "Model 710") |        |      |      |      |

NOTE: THE ABOVE PARTS ARE FOR PACKAGING ONLY

|          |                                         |        |        |        |        |
|----------|-----------------------------------------|--------|--------|--------|--------|
| C-305410 | BARREL ASSEMBLY COMPLETE                | 305410 | 305411 | 305412 | 305413 |
| C-305400 | BARREL ASSEMBLY                         | 305400 | 305401 | 305402 | 305403 |
| E-305315 | BARREL                                  | 305315 | 305316 | 305317 | 305318 |
| E-300340 | RECEIVER                                | 300340 |        |        |        |
| D-300401 | RECEIVER INSERT ASSEMBLY COMPLETE       | 300401 |        |        |        |
| C-300400 | RECEIVER INSERT ASSEMBLY                | 300400 |        |        |        |
| E-300327 | RECEIVER INSERT                         | 300327 |        |        |        |
| A-300347 | THREADED INSERT                         | 300347 |        |        |        |
| C-300333 | SIDE PLATE                              | 300333 |        |        |        |
| A-300328 | SIDE PLATE PIN (2)                      | 300328 |        |        |        |
| C-15666  | SEAR SAFETY CAM (Blk. C-91921)          | 15666  |        |        |        |
| B-300351 | PIVOT PIN (3)                           | 300351 |        |        |        |
| A-17047  | SEAR SPRING                             | 17047  |        |        |        |
| C-15280  | TRIGGER (Blk. C-91912)                  | 15280  |        |        |        |
| C-19461  | TRIGGER CONNECTOR (Blk. C-91921)        | 19461  |        |        |        |
| B-17053  | TRIGGER SCREW FRONT (Blk. B-91920)      | 17053  |        |        |        |
| B-91128  | TRIGGER ENGAGEMENT SCREW (Blk. B-91922) | 91128  |        |        |        |
| A-15400  | TRIGGER SPRING                          | 15400  |        |        |        |
| A-15481  | TRIGGER STOP SCREW (Blk. A-91926)       | 15481  |        |        |        |
| D-300408 | SAFETY                                  | 300408 |        |        |        |
| B-300352 | SAFETY PIVOT PIN                        | 300352 |        |        |        |
| B-300407 | SAFETY SPRING                           | 300407 |        |        |        |
| C-300345 | BOLT STOP                               | 300345 |        |        |        |
| B-17034  | RECEIVER PLUG SCREW (4)                 | 17034  |        |        |        |
| B-300361 | RECOIL BRACKET                          | 300361 |        |        |        |
| B-300403 | BOLT BODY ASSEMBLY                      | 300403 |        |        |        |
| D-300339 | BOLT BODY                               | 300339 |        |        |        |
| C-300370 | BOLT HANDLE                             | 300370 |        |        |        |
| C-300360 | BOLT HANDLE BLANK                       | 300360 |        |        |        |
| A-300329 | BOLT HANDLE PIN                         | 300329 |        |        |        |
| B-300366 | BOLT HANDLE BRAZING SHIM                | 300366 |        |        |        |
| B-305390 | BOLT HEAD ASSEMBLY                      | 305390 |        | 305391 |        |
| E-300338 | BOLT HEAD (30-06, 270)                  | 300338 |        |        |        |
| C-300416 | BOLT HEAD (7mm Rem, 300 Win)            |        |        | 300416 |        |
|          | EXTRACTOR                               |        |        |        |        |
| C-93712  | 30-06, 270 (Blk. 93711)                 | 93712  |        |        |        |
| C-97322  | 7mm Rem, 300 Win (Blk. 97321)           |        |        | 97322  |        |
| C-27340  | EXTRACTOR RIVET                         |        |        | 27341  |        |
| B-300342 | EJECTOR                                 | 300342 |        |        |        |
| A-300367 | EJECTOR SPRING                          | 300367 |        |        |        |
| A-94555  | EJECTOR PIN                             | 94555  |        |        |        |
| B-300330 | BOLT ASSEMBLY PIN                       | 300330 |        |        |        |
| B-300404 | FIRING PIN ASSEMBLY                     | 300404 |        |        |        |
| C-300368 | BOLT PLUG                               | 300368 |        |        |        |
| B-300346 | BOLT PLUG INSERT                        | 300346 |        |        |        |
|          | LOCK TUMBLER                            |        |        |        |        |
|          | LOCK PLUNGER                            |        |        |        |        |

MF0092

Elizabethtown Research Division

PARTS LIST #YYY

Date: **Model 710**

Supersedes Previous Model: XXX

08/20/99 **Bolt Action**

Parts List #AAA

**Centerfire Rifle R.H.**

Sheet 2 Dotted line (---)  
 of 2 indicates same part number

30-06 270

7mm  
Rem Mag300  
Win Mag

| DWG. NO. | PART NAME                               | PART NUMBERS |      |       |      |
|----------|-----------------------------------------|--------------|------|-------|------|
|          | <b>FIRING PIN ASSY CONTINUED</b>        |              |      |       |      |
|          | LOCK SPRING                             |              |      |       |      |
| C-300334 | FIRING PIN                              | 300334       | ---- | ----  | ---- |
| C-300335 | FIRING PIN TIP                          | 300335       | ---- | ----  | ---- |
| C-300336 | FIRING PIN HEAD                         | 300336       | ---- | ----  | ---- |
| A-300399 | FIRING PIN SPRING                       | 300399       | ---- | ----  | ---- |
|          | <b>FRONT SIGHT</b>                      |              |      |       |      |
| C-15373  | 30-06, 270 (Blk. C-90393)               | 94084        | ---- |       |      |
| B-14659  | 7mm REM, 300 WIN                        |              |      | 94095 | ---- |
| B-28510  | FRONT SIGHT RAMP (Blk. B-16724)         | 94657        | ---- |       |      |
| B-28505  | FRONT SIGHT RAMP SCREW (2) (Blk. 90347) | 28505        | ---- |       |      |
| B-103145 | <b>REAR SIGHT ASSEMBLY</b>              | 103145       | ---- |       |      |
| A-90906  | ELEVATION SCREW                         | 90906        | ---- |       |      |
| C-93905  | REAR SIGHT APERTURE (Blk. C-93906)      | 97681        | ---- |       |      |
| C-103530 | REAR SIGHT BASE (Blk. 94023)            | 103530       | ---- |       |      |
| C-93904  | REAR SIGHT SLIDE (Blk. C-93907)         | 94335        | ---- |       |      |
| B-90904  | WINDAGE SCREW (Blk. 91911)              | 90904        | ---- |       |      |
| B-28505  | REAR SIGHT BASE SCREW (2) (Blk. 90347)  | 28505        | ---- |       |      |
|          | <b>STOCK ASSEMBLY COMPLETE</b>          |              |      |       |      |
|          | <b>STOCK ASSEMBLY</b>                   |              |      |       |      |
|          | STOCK                                   |              |      |       |      |
| B-15161  | FRONT SCREW BUSHING (Blk 91915)         | 15161        | ---- |       |      |
|          | MIDDLE SCREW BUSHING                    |              |      |       |      |
|          | REAR SCREW BUSHING                      |              |      |       |      |
| C-97971  | GRIP CAP                                | 97971        | ---- |       |      |
| D-97973  | RECOIL PAD                              | 97973        | ---- |       |      |
| C-97972  | RECOIL PAD BACKER                       | 97972        | ---- |       |      |
| A-98008  | RECOIL PAD SCREW (2)                    | 98008        | ---- |       |      |
| C-300362 | MAGAZINE LATCH                          | 300362       | ---- |       |      |
| B-300398 | LATCH SPRING                            | 300398       | ---- |       |      |
| B-300371 | LATCH PIVOT PIN                         | 300371       | ---- |       |      |
| B-300096 | SLING SWIVEL STUD (2)                   | 300096       | ---- |       |      |
|          | TAKE DOWN SCREW (2)                     |              |      |       |      |
|          | REAR TAKE DOWN SCREW                    |              |      |       |      |
|          | <b>MAGAZINE ASSEMBLY</b>                |              |      |       |      |
| B-305395 | MAGAZINE                                | 305395       | ---- |       |      |
| E-300363 | MAGAZINE BOX                            | 300363       | ---- |       |      |
| D-300364 | MAGAZINE FOLLOWER                       | 300364       | ---- |       |      |
| D-300365 | MAGAZINE BOTTOM                         | 300365       | ---- |       |      |
| B-300405 | MAGAZINE SPRING                         | 300405       | ---- |       |      |

MF0093

## New Parts

| Part # | Part Name             | Material \$ | Ilion<br>Quotes or<br>Estimates |
|--------|-----------------------|-------------|---------------------------------|
| 300327 | Receiver Insert       | 0.62        |                                 |
| 300333 | Side Plate            |             | 0.09                            |
| 300334 | Safety Arm            | 0.31        |                                 |
| 300345 | Bolt Stop             | 0.19        |                                 |
| 300361 | Recoil Bracket        | 0.193       |                                 |
| 300360 | Bolt Handle Blank     | 1.63        |                                 |
| 300366 | Bolt H. Braze Shim    | 0           |                                 |
| 300368 | Bolt Plug             | 0.25        |                                 |
| 300336 | Firing pin head       | 1.45        |                                 |
| 300362 | Mag Latch             | 0.25        |                                 |
| 300363 | Magazine Box          |             | 2.79                            |
| 300364 | Magazine Follower     | 0.259       |                                 |
| 300365 | Magazine Bottom       | 0.256       |                                 |
|        | Stock                 | 5.38        |                                 |
| 300347 | Threaded Insert       | 0.04        |                                 |
| 300328 | Side Plate Pin (2)    | 0.12        |                                 |
| 300351 | Pivot Pins (3)        | 0.06        |                                 |
| 300352 | Safety Pivot Pin      | 0.06        |                                 |
| 300407 | Safety Spring         |             | 0.03                            |
| 300329 | Bolt Handle Pin       | 0.06        |                                 |
| 300342 | Ejector               |             | 0.16                            |
| 300330 | Bolt Assy Pin         | 0.1         |                                 |
| 300346 | Bolt Plug Insert      |             | 0.29                            |
| 300346 | Tumbler               | 0.41        |                                 |
|        | lock plunger          | 0.05        |                                 |
|        | lock spring           | 0.01        |                                 |
|        | key                   |             |                                 |
| 300334 | Firing Pin            | 0.27        |                                 |
| 300335 | Firing Pin Tip        | 1.5         |                                 |
|        | Firing Pin Spring     |             | 0.14                            |
|        | Middle Screw Bushing  |             | 0.05                            |
|        | Rear Screw Bushing    |             | 0.05                            |
| 300405 | Mag Latch Spring      |             | 0.42                            |
| 300371 | Mag Latch Pin         | 0.04        |                                 |
| 300096 | Sling Swivel Stud (2) |             | 0.14                            |
|        | Take Down Screw R     |             | 0.08                            |
|        | Take Down Screw M     |             | 0.08                            |
|        | Take Down Screw F     |             | 0.08                            |
| 300336 | Bolt Head Blank       |             | 1.6                             |
|        | Barrel Blank          | 4.6         |                                 |
|        | Receiver Blank        | 1.76        |                                 |
|        | Bolt Body             | 0.74        |                                 |
|        | Carton Assy (Ilion)   | 2.05        |                                 |

Total Material \$ New  
known to date 22.188  
% of Total anticipated 53.24%

Total Material \$  
Estimated or from  
M/700 costing 6.07  
% of Total anticipated 14.56%

Total Add Use Parts 13.42  
Add Use is 32.20%

% of total material  
cost know by quote 85.44%

## Add Use from M700

| Part # | Part Name               | Material \$ | Quotes<br>from<br>Mayfield |
|--------|-------------------------|-------------|----------------------------|
| 1444   | Carton Assy             | 2.05        |                            |
| 15666  | Sear Safety Cam         | 0.94        |                            |
| 17047  | Sear Spring             | 0.02        |                            |
| 15280  | Trigger                 | 1.53        |                            |
| 19461  | Trigger Connector       | 1.48        |                            |
| 17053  | Trigger Front Screw     | 0.11        | 0.032                      |
| 91128  | Engagement Screw        | 0.03        |                            |
| 15400  | Trigger Spring          | 0.03        |                            |
| 15481  | Trigger Stop Screw      | 0.06        | 0.032                      |
| 17044  | Snap Washer             | 0.09        |                            |
| 17034  | Receiver Plug Screws    | 0.13        |                            |
| 93712  | Extractor               | 0.78        |                            |
| 94555  | Ejector Pin             | 0.01        |                            |
| 94084  | Front sight             | 0.82        |                            |
| 94657  | front Sight Ramp        | 1.13        |                            |
| 28505  | Front Sight Ramp Screws | 0.09        |                            |
| 90906  | Elevation Screw         | 0.02        |                            |
| 94333  | Rear Sight Aperature    | 0.14        | 0.105                      |
| 103531 | Rear Sight Base         | 0.97        |                            |
| 94335  | Rear Sight Slide        | 0.47        |                            |
| 90904  | Windage Screw           | 0.02        |                            |
| 28505  | Rear Sight Base Scre    | 0.09        |                            |
| 15161  | Front Screw Bushing     | 0.13        |                            |
| 97971  | Grip Cap                | 0.16        |                            |
| 97973  | Recoil Pad              | 1.63        |                            |
| 98008  | Recoil Pad Screws       | 0.05        | 0.012                      |
| 17028  | Magazine Spring         | 0.42        |                            |

Total Add Use Parts \$13.42

Add Use is 32.20% % of total

MF0094

CONFIDENTIAL 83

Small Photo Quotes

MF0095



MIDSTATE SPRING, INC.  
PMB234  
280 CONCORD PARKWAY SOUTH  
SUITE 120  
CONCORD, NC 28027  
PHONE: 704-723-6520 FAX: 704-723-6521

COPY  
FYI

## QUOTATION Q-2666

CUSTOMER ID REMARM

DATE OF QUOTATION 9/24/99

PAGE # 1

QUOTED TO

METTY MORGAN  
REMINGTON ARMS COMPANY, INC.  
MAYFIELD PLANT  
22 RIFLE TRAIL  
HICKORY KY 42051

| LINE # | DESCRIPTION                                 | QUANTITY | UNIT PRICE | EXTENDED PRICE |
|--------|---------------------------------------------|----------|------------|----------------|
| 1      | A-15400 - COMPRESSION SPRING (MS # 1103509) |          |            |                |
|        |                                             | 20,000   | 0.0761     | \$1,522.00     |
|        |                                             | 40,000   | 0.0620     | \$2,480.00     |
|        |                                             | 60,000   | 0.0573     | \$3,438.00     |
| 2      | A-17047 - COMPRESSION SPRING (MS # 1103510) |          |            |                |
|        |                                             | 20,000   | 0.0474     | \$948.00       |
|        |                                             | 40,000   | 0.0379     | \$1,516.00     |
|        |                                             | 60,000   | 0.0348     | \$2,088.00     |

Thank you for the opportunity to quote your requirements.

Specifications given without specific tolerances are quoted to commercial tolerances rather than block tolerances.  
Quantities quoted are based on a one-lot shipment (F.O.B. Syracuse) unless noted otherwise.  
Unless otherwise noted, lead time is standard four weeks. Expedited delivery is available.  
Invoice terms are net 30 days pending credit approval.  
Prices firm for 30 days from date of quotation.

John Bernet, Sales Manager  
jbernet@midstatespring.com  
704-723-6520 (Customer Service 800-365-9939x2)

  
John Bernet Sales Manager



MF0096



MIDSTATE SPRING, INC.  
P.O. BOX 850  
SYRACUSE, NY 13206-0850  
PHONE: 315-437-2623 FAX: 315-437-0796

QUOTATION Q-2569

CUSTOMER ID REMARM

DATE OF QUOTATION 8/20/99

PAGE # 1

QUOTED TO

METTY MORGAN  
REMINGTON ARMS COMPANY, INC.  
MAYFIELD PLANT  
22 RIFLE TRAIL  
HICKORY KY 42051

| LINE # | DESCRIPTION                                  | QUANTITY | UNIT PRICE | EXTENDED PRICE |
|--------|----------------------------------------------|----------|------------|----------------|
| 1      | A-300367 - COMPRESSION SPRING (MS # 1103436) |          |            | 83             |
|        |                                              | 20,000   | 0.0152     | \$304.00       |
|        |                                              | 40,000   | 0.0108     | \$432.00       |
|        |                                              | 60,000   | 0.0093     | \$558.00       |
|        | SPRING OVERSTRESSES @ L2                     |          |            |                |
| 2      | A-300399 - COMPRESSION SPRING (MS # 1103437) |          |            |                |
|        |                                              | 20,000   | 0.1008     | \$2,016.00     |
|        |                                              | 40,000   | 0.0870     | \$3,480.00     |
|        |                                              | 60,000   | 0.0824     | \$4,944.00     |
| 3      | A-300398 - TORSION SPRING (MS # 2100584)     |          |            |                |
|        |                                              | 20,000   | 0.0279     | \$558.00       |
|        |                                              | 40,000   | 0.0201     | \$804.00       |
|        |                                              | 60,000   | 0.0179     | \$1,074.00     |

**Thank you for the opportunity to quote your requirements.**

Specifications given without specific tolerances are quoted to commercial tolerances rather than block tolerances.

Quantities quoted are based on a one-lot shipment (F.O.B. Syracuse) unless noted otherwise.

Unless otherwise noted, lead time is standard four weeks. Expedited delivery is available.

Invoice terms are Net 30 Days pending credit approval.

Prices firm for 30 days from date of quotation.

Dawn Custer, Customer Service  
dcuster@midstatespring.com  
800-365-9939x107 or 315-437-2623x107

*Dawn M. Custer*  
Dawn M. Custer Customer Service



MF0097

Confidential - Subject to Protective Order  
BARBER - 5.22.06r0010047  
Williams v. Remington

**Swiss Precision Machining, Inc.**

7550 N. Oak Park Ave., Niles, IL 60714 (847) 647-7111 / FAX (847) 647-7110

COPY  
FYI

August 26, 1999

Remington Arms Co.  
P.O. Box 99  
22 Rifle Trail  
Hickory, KY 42051  
ATTN: Mett Morgan

Dear Mett:

We are pleased to submit the following quotation for your consideration:

## Part #A300328

60,000 @ \$.093 each

120,000 @ \$.086 each

180,000 @ \$.085 each

Non-recurring engineering fee \$275

## Part #A300329

20,000 @ \$.122 each

40,000 @ \$.106 each

60,000 @ \$.101 each

Non-recurring engineering fee \$150

## Part #B300330

20,000 @ \$.226 each

40,000 @ \$.184 each

60,000 @ \$.177 each

Non-recurring engineering fee \$380

## Part #B300342

20,000 @ \$.189 each

40,000 @ \$.153 each

60,000 @ \$.148 each

Non-recurring engineering fee \$325

## Part #B300346\*

20,000 @ \$.808 each

40,000 @ \$.784 each

60,000 @ \$.767 each

Non-recurring engineering fee \$775

## Part #B300351

20,000 @ \$.10 each

40,000 @ \$.075 each

60,000 @ \$.068 each

Non-recurring engineering fee \$150

## Part #B300352

20,000 @ \$.206 each

40,000 @ \$.163 each

60,000 @ \$.157 each

Non-recurring engineering fee \$275

## Part #B300371

20,000 @ \$.102 each

40,000 @ \$.076 each

60,000 @ \$.071 each

Non-recurring engineering fee \$150

Please note that on Part #B300346\* the profile was quoted with a .031 Radii in corners instead of the .020 that is indicated on the print. Please review this information and if you have any questions please don't hesitate to call.

Our current lead time is 6-8 weeks and our terms are Net 30. All parts will be shipped FOB Niles, IL. Thank you very much for the opportunity to quote your business.

Sincerely,

SWISS PRECISION MACHINING, INC.

*Joseph A. Haupers*  
Joseph A. Haupers  
Sales Manager

**SPM**

TOTAL P.02

MF0098

# Swiss Precision Machining, Inc.

7550 N. Oak Park Ave., Niles, IL 60714 (847) 647-7111 / FAX (847) 647-7110

August 30, 1999

*FVI*  
*copy*

Remington Arms Co.  
P.O. Box 99  
22 Rifle Trail  
Hickory, KY 42051  
ATTN: Mett Morgan

Dear Mett:

We are pleased to submit the following quotation for your consideration:

Part #B-90904  
25,000 @ \$.191 each  
50,000 @ \$.17 each  
100,000 @ \$.149 each  
Non-recurring engineering fee \$400

Part #C-300028  
25,000 @ \$.519 each  
50,000 @ \$.498 each  
80,000 @ \$.489 each  
Non-recurring engineering fee \$150

Part #B97437  
60,000 @ \$.197 each  
120,000 @ \$.193 each  
240,000 @ \$.187 each  
Non-recurring engineering fee \$635

Please note on Part #B90904 and #C300028 we have quoted a case depth for carburization @ .010-.015. Also, Part #B90904 we have quoted less color as we could not identify the Nitro Black with our outside sources. Our current lead-time is 6-8 weeks and our terms are Net 30. All parts will be shipped FOB Niles, IL. If you have any questions please don't hesitate to call.

Sincerely,

SWISS PRECISION MACHINING, INC.

*Joseph A. Haupers*  
Joseph A. Haupers  
Sales Manager

JAH/pi

**SPM**

TOTAL P.02

MF0099

COPY  
FYI

# EBN

**FASTENERS & INDUSTRIAL SUPPLIES**  
**1701 EAST COLUMBIA ST.**  
**EVANSVILLE, IN 47711**  
**PHONE:(812)477-0077 FAX:(812)479-0100**

PAGE 1 OF 3

COMPANY NAME: REMINGTON ARMS COMPANY

ATTENTION: METTY MORGAN

FAX NUMBER: 512-856-3233

FROM: KIM WALKER

DATE: 8/19/99

**SUBJECT**

QUOTE FOR DRAWING #'S

A-15481

A-94555

A-99989

B-17053

A-90906

A-200197

B-91128

A-98008

MF0100

08/19/99 10:46 8124790100

EVILLE.BOLT&amp;NUT

002/002

## QUOTATION FROM:

EVANSVILLE BOLT & NUT  
 FAX#812-479-0100  
 1701 EAST COLUMBIA STREET  
 EVANSVILLE IN 47711

Date Quote  
 08/19/99 55328

ENTERED BY: KIM

TO: 99999

PAGE 002

EVANSVILLE BOLT & NUT  
 1701 EAST COLUMBIA ST.  
 EVANSVILLE IN 47711

PHONE : 477-6077  
 FAX : 812-474-7437

F.O.B. Terms Effective Our Representative

| Qty | Part Number/Description                                                                                  | UN | Price | Est Price |
|-----|----------------------------------------------------------------------------------------------------------|----|-------|-----------|
| 11  | 60000 *A-94555<br>MEDIUM DUTY<br>***** FACTORY STOCK *****<br>***** F.O.B. SHIPPING POINT *****<br>***** | C  | 1.12  | 672.00    |
| 12  | 20000 *A-90906                                                                                           | C  | 5.64  | 1128.00   |
| 13  | 40000 *A-90906                                                                                           | C  | 4.95  | 1980.00   |
| 14  | 50000 *A-90906<br>***** LEAD TIME 10-12 WEEKS *****<br>***** F.O.B. SHIPPING POINT *****<br>*****        | C  | 3.96  | 2376.00   |
| 15  | 20000 *A-92008                                                                                           | C  | 0.95  | 170.00    |
| 16  | 20000 *A-95989                                                                                           | C  | 0.60  | 120.00    |
| 17  | 20000 *A-200197                                                                                          | C  | 0.74  | 148.00    |

\*\*\*\*\* FACTORY STOCK \*\*\*\*\*  
 \*\*\*\*\* F.O.B. SHIPPING POINT \*\*\*\*\*  
 NETTY.

THANK YOU FOR GIVING US THE OPPORTUNITY TO  
 QUOTE THE ABOVE ITEMS. IF YOU HAVE ANY QUESTIONS,  
 OR NEED ADDITIONAL PRICING, PLEASE LET US KNOW.

MF0101

QUOTATION FROM:  
 EVANSVILLE BOLT & NUT  
 FAX#812-479-0100  
 1701 EAST COLUMBIA STREET  
 EVANSVILLE IN 47711

Date Quote  
 08/19/99 55328  
 ENTERED BY: KIM

TO: 99999

EVANSVILLE BOLT & NUT  
 1701 EAST COLUMBIA ST.  
 EVANSVILLE IN 47711

PHONE : 477-0077  
 FAX : 812-474-7437

| F.O.B.                            | Terms | Effective | Our Representative | Qty | Part Number/Description      | UM | Price | Ext Price |
|-----------------------------------|-------|-----------|--------------------|-----|------------------------------|----|-------|-----------|
|                                   |       |           |                    | 1   | 20000 *A-15481               | C  | 6.72  | 1344.00   |
|                                   |       |           |                    | 2   | 40000 *A-15481               | C  | 4.45  | 1780.00   |
|                                   |       |           |                    | 3   | 60000 *A-15481               | C  | 3.65  | 2190.00   |
| ***** LEAD TIME 8-10 WEEKS *****  |       |           |                    |     |                              |    |       |           |
| ***** F.O.B. SHIPPING POINT ***** |       |           |                    |     |                              |    |       |           |
|                                   |       |           |                    | 4   | 20000 *B-17053               | C  | 6.80  | 1360.00   |
|                                   |       |           |                    | 5   | 40000 *B-17053               | C  | 3.78  | 1512.00   |
|                                   |       |           |                    | 6   | 60000 *B-17053               | C  | 3.07  | 1842.00   |
| ***** LEAD TIME 8-10 WEEKS *****  |       |           |                    |     |                              |    |       |           |
| ***** F.O.B. SHIPPING POINT ***** |       |           |                    |     |                              |    |       |           |
|                                   |       |           |                    | 7   | 20000 *B-91128               | C  | 6.45  | 1290.00   |
|                                   |       |           |                    | 8   | 40000 *B-91128               | C  | 4.18  | 1672.00   |
|                                   |       |           |                    | 9   | 60000 *B-91128               | C  | 3.32  | 1992.00   |
| ***** LEAD TIME 8-10 WEEKS *****  |       |           |                    |     |                              |    |       |           |
| ***** F.O.B. SHIPPING POINT ***** |       |           |                    |     |                              |    |       |           |
|                                   |       |           |                    | 10  | 20000 *A-94555<br>MEDIUM CUT | C  | 1.55  | 310.00    |

CONTINUED

MF0102

B-17044

THIS DRAWING OR INFORMATION IS  
PROPRIETARY INFORMATION TO THE  
REMINGTON ARMS COMPANY, INC.

25

FOR BLANK ORDER PART #200042

DO NOT SCALE THIS DRAWING: WORK TO FIGURES  
UNLESS OTHERWISE NOTED.  
TOLERANCES ON DECIMAL DIMENSIONS ARE:  
1 PLACE (.1) - TOLERANCE  $\pm .015$   
2 PLACE (.01) - TOLERANCE  $\pm .010$   
3 PLACE (.001) - TOLERANCE  $\pm .005$   
4 ON FRACTIONAL DIMENSIONS  $\pm 1/64$   
4 ON ANGULAR DIMENSIONS  $\pm .001$   
FINISHES ARE DESIGNATED BY ROOT MEAN  
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS  
VALUES AND ARE THE MAXIMUM ROUGHNESS  
ACCEPTABLE: UNLESS OTHERWISE SPECIFIED,  
FINISH ROUGHNESS TO BE  $R\sqrt{A}$  OR BETTER.

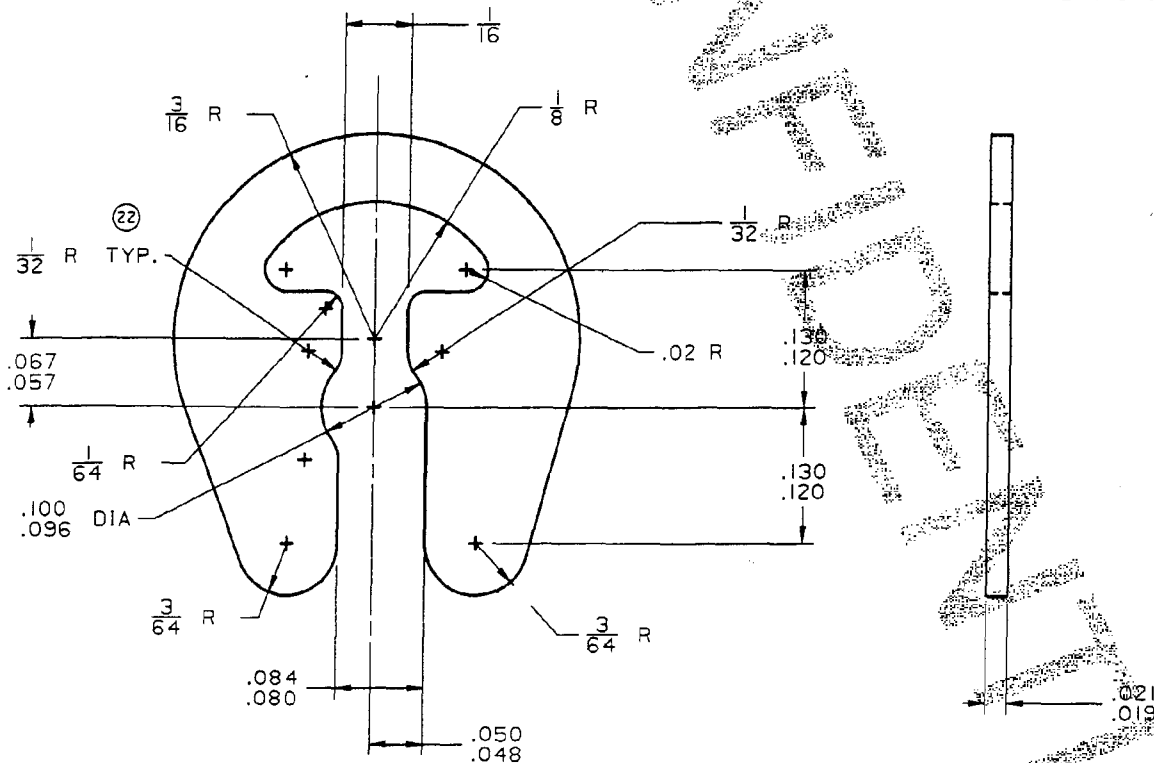
RECOMMENDED MATERIAL AND HEAT TREAT  
MATERIAL C-1095 C.R. SPRING STEEL  
HEAT TREAT NEUTRAL SALT, LOW NITRE QUENCH  
HARDNESS R 30 N 66-69  
COLOR TEMPER COLOR  
HEAT TREAT & COLOR TO  
BE DONE BY REMINGTON

23

24

ALTERATIONS

| ALT. | WAS                                     | REF.  | BY  | DATE     |
|------|-----------------------------------------|-------|-----|----------|
| 21   | REDRAWN                                 | 12046 | TJP | 11-11-85 |
| 22   | ADDED TYP.                              | 13156 | JNR | 3-25-94  |
| 23   | WAS H.T.                                | 13760 | RAW | 7-16-97  |
| 24   | WAS H.T. AND COLOR TO BE DONE BY VENDOR | 13760 | RAW | 7-16-97  |
| 25   | ADD BLANK #200042                       | 13760 | RAW | 7-16-97  |
| 26   | ADD USE XP-100 R                        | 13770 | RAW | 8-11-97  |



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|                                                |              |                    |              |
|------------------------------------------------|--------------|--------------------|--------------|
| XP-100 R                                       | 17044        | SAFETY SNAP WASHER |              |
| 40X.XB.XCF                                     | 17044        | SAFETY SNAP WASHER |              |
| 40XB 1FR                                       | 17044        | SAFETY SNAP WASHER |              |
| XP 100                                         | 17044        | SAFETY SNAP WASHER |              |
| 7 LWT                                          | 17044        | SAFETY SNAP WASHER |              |
| 700 (ALL)                                      | 17044        | SAFETY SNAP WASHER |              |
| MODEL                                          | PART NO.     | PART USE           |              |
| DES. BY DATE                                   | DRN. BY DATE | CHK. BY DATE       | APP. BY DATE |
| TJP 11-11-85                                   | DSF 11-12-85 | DSF 11-12-85       | DSF 11-12-85 |
| TITLE SAFETY SNAP WASHER                       |              |                    |              |
| NUMBER                                         | SCALE        | SUPERSEDES         | REFERENCE    |
| B-17044                                        | 10:1         | A-17044<br>REV. 20 | DCR 12046    |
| REMINGTON ARMS CO. INC.<br>ILION RESEARCH DIV. |              |                    |              |

CV FILENAME - RES.700.B17044.SAFETY-CLIP.TJP

REF. A 736 X

25

27

23

24

26

83

ME0103

Confidential - Springer - 5.22.06P0010053 Order

Williams V. Remington

|                                   |                                      |                                          |              |
|-----------------------------------|--------------------------------------|------------------------------------------|--------------|
| NUMBER<br><b>A-300399</b>         |                                      | REMINGTON ARMS CO. INC.<br>RESEARCH DIV. |              |
| SCALE                             | SUPERSEDES                           | REFERENCE                                |              |
| TITLE<br><b>SPRING.FIRING PIN</b> |                                      |                                          |              |
| DES. BY DATE                      | DRN. BY DATE<br><b>MDK 06/08/99</b>  | CHK. BY DATE                             | APP. BY DATE |
| MODEL<br><b>710</b>               | PART USE<br><b>FIRING PIN SPRING</b> |                                          |              |
|                                   |                                      |                                          |              |
|                                   |                                      |                                          |              |

THIS DRAWING OR INFORMATION IS  
PROPRIETARY INFORMATION TO THE  
REMINGTON ARMS COMPANY, INC.

**MATERIAL AND HEAT TREAT**  
MATERIAL MUSIC WIRE  
HEAT TREAT STRESS RELIEVE  
FINISH OIL

**INSPECTION**

1. TO WORK FREELY IN A .425 DIA. HOLE
2. TO WORK FREELY ON A .275 DIA. PIN
3. LOAD 20.0 TO        LB. AT 3.665 (L1)
- LOAD 23.0 TO        LB. AT 3.430 (L2)
4. SOLID HEIGHT 2.69 MAX.
5. WIND LEFT HAND
6. FREE LENGTH 5.217 MIN.
7. ENDS CEG
8. CHECK HERE FOR NON-COMMERCIAL TOLERANCES ☐

**MANUFACTURE**

9. WIRE DIA. .063
10. FREE LENGTH 5.232 +/- .015
11. OUTSIDE DIA. .416
12. COILS: ACTIVE 40.3267
13. CHECK HERE FOR SET REMOVAL ☐
- TOTAL 42.3267

**DESIGN DATA**

14. SPRING RATE 12.766 LB./IN.
15. STATIC STRESS AT SOLID        LB./SQ.IN.
16. DYNAMIC STRESS        LB./SQ.IN.
17. TOTAL STRESS AT SOLID        LB./SQ.IN.
18. SOLID LOAD        LBS.
19. SPRING INDEX 5.6032
20. TORSIONAL MODULUS        LB./SQ.IN.
21. CURVATURE CORRECTION FACTOR        (WAHL)
22. VELOCITY IMPACTING MASS        IN./SEC.
23. CRITICAL FREQUENCY        HZ.
24. TOTAL STRESS AS % OF TENSILE STRENGTH
25. ENERGY FROM L1 TO L2        IN.-LBS.

THIS SPRING MUST MEET THE REQUIREMENTS IN THE INSPECTION SECTION.  
FIGURES GIVEN IN THE MANUFACTURE SECTION INDICATE THE PREFERRED  
SPRING. THE MANUFACTURER MAY, WITH PRIOR APPROVAL, DEVIATE FROM  
THESE FIGURES. FIGURES IN THE DESIGN DATA SECTION ARE BASED ON  
THOSE IN THE MANUFACTURE SECTION.

|             |     |      |    |      |
|-------------|-----|------|----|------|
|             |     |      |    |      |
|             |     |      |    |      |
|             |     |      |    |      |
| AL T.       | WAS | REF. | BY | DATE |
| ALTERATIONS |     |      |    |      |

CV FILENAME - PARTS.RIF.710.FIRING-PIN-SPRING-300399

**A-300399**

ME0104



## Current DWG Revision

|                                   | Part Number | Drawing Number | Revision Level |
|-----------------------------------|-------------|----------------|----------------|
| Barrel                            | 305315      | E-305315       |                |
| Receiver                          | 300340      | E-300340       |                |
| Receiver Insert Assembly Complete | 300401      | D-300401       | A              |
| Receiver Insert Assembly          | 300400      | C-300400       |                |
| Receiver Insert                   | 300327      | E-300327-1-2   |                |
| Threaded Insert                   | 300347      | A-300347       |                |
| Side Plate                        | 300333      | C-300333       |                |
| Side Plate Pin (2)                | 300328      | A-300328       |                |
| Sear Safety Cam                   | 15666       | C-15666        |                |
| Pivot Pin (3)                     | 300351      | B-300351       |                |
| Sear Spring                       | 17047       | A-17047        |                |
| Trigger                           | 300417      | D-300417       | E              |
| Trigger Connector                 | 19461       | C-19461        |                |
| Trigger Screw Front               | 17053       | B-17053        |                |
| Trigger Engagement Screw          | 91128       | B-91128        |                |
| Trigger Spring                    | 15400       | A-15400        |                |
| Trigger Stop Screw                | 300426      | A-300426       | No Rev.        |
| Safety Arm                        | 300408      | D-300408       | 7              |
| Safety Detent Spring              | 300407      | C-300407       |                |
| Lock tumbler                      | 300420      | D-300420       | A              |
| Lock Detent                       | ????        | ????           |                |
| Safety Pivot Pin                  | 300352      | B-300352       |                |
| Safety Snap Washer                | 17044       | B-17044        |                |
| Bolt Stop                         | 300345      | C-300345       |                |
| Receiver Plug Screws (4)          | 17034       | B-17034        |                |
| Bolt Assembly Complete            | ????        | ????           |                |
| Bolt Body Assembly                | 300403      | D-300403       |                |
| Bolt Body                         | 300339      | D-300339       |                |
|                                   |             |                |                |
|                                   |             |                |                |
|                                   |             |                |                |
| Bolt Handle Pin                   | 300329      | A-300329       | 2              |
| Bolt Head Assembly                | 305390      | B-305390       |                |
|                                   |             |                |                |
| Extractor                         | 93712       | C-93712        |                |
| Ejector                           | 300342      | B-300342       |                |
| Ejector Spring                    | 300367      | A-300367       |                |
| Ejector Pin                       | 94555       | A-94555        |                |

MF0106

|                                                 |        |          |         |
|-------------------------------------------------|--------|----------|---------|
| Bolt Assembly Pin                               | 300330 | B-300330 |         |
| Firing Pin Assembly                             | 300404 | B-300404 | A       |
| Bolt Plug                                       | 300368 | C-300368 | 4       |
| Bolt Plug Insert                                | 300346 | B-300346 |         |
| Firing Pin                                      | 300334 | C-300334 | A       |
| Firing Pin Tip                                  | 300335 | B-300335 | 2       |
| Firing Pin Head                                 | 300336 | C-300336 |         |
| Firing Pin Spring                               | 300399 | A-300399 |         |
| Front Sight                                     | 94084  | C-15373  |         |
| Front Sight Ramp                                | 94657  | B-28510  |         |
| Front Sight Ramp Screws (2)                     | 28505  | B-28505  |         |
| Rear Sight Assembly                             | 103145 | B-103145 |         |
| Elevation Screw                                 | 90906  | A-90906  |         |
| Rear Sight Aperture                             | 97681  | C-93905  |         |
| Rear Sight Aperture Blank                       | 93906  | C-93906  |         |
| Rear Sight Base                                 | 103531 | C-103530 |         |
| Rear Sight Slide                                | 94335  | C-93904  |         |
| Windage Screw                                   | 300026 | B-300026 |         |
| Rear Sight Base Screw (2)                       | 28505  | B-28505  |         |
| Stock Assembly Complete                         | 305455 | B-305455 | No Rev. |
| Stock Assembly                                  | ???    | ???      |         |
| Stock                                           | ???    | ???      |         |
| Front Screw Bushing                             | 104125 | C-104125 | 18      |
| Middle Screw Bushing                            | 104143 | C-104125 |         |
| Rear Screw Bushing                              | 300425 | B-300425 | No Rev. |
| Grip Cap                                        | 97971  | C-97971  |         |
| Recoil Pad                                      | 97973  | D-97973  |         |
| Backer Plate                                    | 97972  | C-97972  |         |
| Recoil Pad Screw (2)                            | 98008  | A-98008  |         |
| Magazine Latch                                  | 300362 | C-300362 |         |
| Magazine Latch Spring                           | 300398 | B-300398 |         |
| Magazine Latch Pin                              | 300371 | B-300371 |         |
| Sling Swivel Stud (2)                           | 300096 | B-300096 |         |
| Rear Takedown Screw                             | ???    | ???      |         |
| Magazine Assembly                               | 305395 | B-305395 |         |
| Magazine Box                                    | 300363 | B-300363 | 9       |
| Magazine Follower                               | 300364 | B-300364 | 4       |
| Magazine Bottom                                 | 300365 | B-300365 |         |
| Magazine Spring                                 | 300405 | C-300405 |         |
| Value Added Cost of: Proof/Gallery/Inspect/Pack |        |          |         |

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MF0107

## Current DWG Revision

|                                   | Part Number | Drawing Number | Revision Level |
|-----------------------------------|-------------|----------------|----------------|
| Barrel                            | 305315      | E-305315       |                |
| Receiver                          | 300340      | E-300340       |                |
| Receiver Insert Assembly Complete | 300401      | E-300401       | A              |
| Receiver Insert Assembly          | 300400      | C-300400       |                |
| Receiver Insert                   | 300327      | E-300327-1-2   |                |
| Threaded Insert                   | 300347      | A-300347       |                |
| Side Plate                        | 300333      | C-300333       |                |
| Side Plate Pin (2)                | 300328      | A-300328       |                |
| Sear Safety Cam                   | 15666       | C-15666        |                |
| Pivot Pin (3)                     | 300351      | B-300351       |                |
| Sear Spring                       | 17047       | A-17047        |                |
| Trigger                           | 300417      | D-300417       | E              |
| Trigger Connector                 | 19461       | C-19461        |                |
| Trigger Screw Front               | 17053       | B-17053        |                |
| Trigger Engagement Screw          | 91128       | B-91128        |                |
| Trigger Spring                    | 15400       | A-15400        |                |
| Trigger Stop Screw                | 300426      | A-300426       | No Rev         |
| Safety Arm                        | 300408      | D-300408       | 7              |
| Safety Detent Spring              | 300407      | C-300407       |                |
| Lock tumbler                      | 300420      | D-300420       | A              |
| Lock Detent                       | ???         | ???            |                |
| Safety Pivot Pin                  | 300352      | B-300352       |                |
| Safety Snap Washer                | 17044       | B-17044        |                |
| Bolt Stop                         | 300345      | C-300345       |                |

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ME0108

|                          |        |          |   |
|--------------------------|--------|----------|---|
| Receiver Plug Screws (4) | 17034  | B-17034  |   |
| Bolt Assembly Complete   | ????   | ???      |   |
| Bolt Body Assembly       | 300403 | D-300403 |   |
| Bolt Body                | 300339 | D-300339 |   |
|                          |        |          |   |
|                          |        |          |   |
| Bolt Handle Pin          | 300329 | A-300329 | 2 |
| Bolt Head Assembly       | 305390 | B-305390 |   |
| Extractor                | 93712  | C-93712  |   |
| Ejector                  | 300342 | B-300342 |   |
| Ejector Spring           | 300367 | A-300367 |   |
| Ejector Pin              | 94555  | A-94555  |   |
| Bolt Assembly Pin        | 300330 | B-300330 |   |
| Firing Pin Assembly      | 300404 | B-300404 | A |
| Bolt Plug                | 300368 | C-300368 | 4 |
| Bolt Plug Insert         | 300346 | B-300346 |   |
| Firing Pin               | 300334 | C-300334 | A |
| Firing Pin Tip           | 300335 | B-300335 | 2 |
| Firing Pin Head          | 300336 | C-300336 |   |
| Firing Pin Spring        | 300399 | A-300399 |   |
| Front Sight              | 94084  | C-15373  |   |
| Front Sight Ramp         | 94657  | B-28510  |   |

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ME0109

|                             |        |          |         |
|-----------------------------|--------|----------|---------|
| Front Sight Ramp Screws (2) | 28505  | B-28505  |         |
| Rear Sight Assembly         | 103145 | B-103145 |         |
| Elevation Screw             | 90906  | A-90906  |         |
| Rear Sight Aperture         | 97681  | C-93905  |         |
| Rear Sight Aperture Blank   | 93906  | C-93906  |         |
| Rear Sight Base             | 103531 | C-103530 |         |
| Rear Sight Slide            | 94335  | C-93904  |         |
| Windage Screw               | 300026 | B-300026 |         |
| Rear Sight Base Screw (2)   | 28505  | B-28505  |         |
| Stock Assembly Complete     | 305455 | B-305455 | No Rev. |
| Stock Assembly              | ????   | ????     |         |
| Stock                       | ????   | ????     |         |
| Front Screw Bushing         | 104125 | C-104125 | 18      |
| Middle Screw Bushing        | 104143 | C-104125 |         |
| Rear Screw Bushing          | 300425 | B-300425 | No Rev. |
| Grip Cap                    | 97971  | C-97971  |         |
| Recoil Pad                  | 97973  | D-97973  |         |
| Backer Plate                | 97972  | C-97972  |         |
| Recoil Pad Screw (2)        | 98008  | A-98008  |         |
| Magazine Latch              | 300362 | C-300362 |         |
| Magazine Latch Spring       | 300398 | B-300398 |         |
| Magazine Latch Pin          | 300371 | B-300371 |         |
| Sling Swivel Stud (2)       | 300096 | B-300096 |         |
| Rear Takedown Screw         | ????   | ????     |         |
| Magazine Assembly           | 305395 | B-305395 |         |

|                                                 |        |          |   |
|-------------------------------------------------|--------|----------|---|
| Magazine Box                                    | 300363 | B-300363 | 9 |
| Magazine Follower                               | 300364 | B-300364 | 4 |
| Magazine Bottom                                 | 300365 | B-300365 |   |
| Magazine Spring                                 | 300405 | C-300405 |   |
| Value Added Cost of: Proof/Gallery/Inspect/Pack |        |          |   |

ME0111

|                           |        |
|---------------------------|--------|
| Total Labor Hours         | 0.8341 |
| Total Labor Cost \$       | 8.825  |
| Total Material Cost \$    | 39.330 |
| Total Variable Tooling \$ | 6.362  |

Total Pre-Op &  
Startup Costs  
Total In-house  
Capital  
Total Vendor  
Capital

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MF0112

| M710 Estimate                     |                       |        |              |                |                |             |                  |                |                  |                    |
|-----------------------------------|-----------------------|--------|--------------|----------------|----------------|-------------|------------------|----------------|------------------|--------------------|
| PART DESCRIPTION                  | Proposed<br>Process   | Part # | Print #      | Rev #          | Material<br>\$ | Labor<br>\$ | Fixed<br>O.H. \$ | Var<br>O.H. \$ | Total<br>O.H. \$ | Estimated<br>Price |
| Document Envelope Assembly        | Purchase              | 7777   | 7777         |                |                |             |                  |                |                  |                    |
| Document Envelope                 | Purchase              | 1649   | 1649         |                |                |             |                  |                |                  |                    |
| Instruction Book                  | Purchase              | 7777   | 7777         |                |                |             |                  |                |                  |                    |
| Product Owner Card                | Purchase              | 1426   | 1426         |                |                |             |                  |                |                  |                    |
| Remington Authorized Gunsmith     | Purchase              | 3413   | 3413         |                |                |             |                  |                |                  |                    |
| Safety Booklet                    | Purchase              | 3439   | 3439         |                |                |             |                  |                |                  |                    |
| Remington Museum Flyer            | Purchase              | 3475   | 3475         |                |                |             |                  |                |                  |                    |
| Oral Label                        | Purchase              | 3491   | 3491         |                |                |             |                  |                |                  |                    |
| Carton Assembly                   | Purchase              | 1444   | 1444         |                |                |             |                  |                |                  |                    |
| Corrugated Box                    | Purchase              |        |              |                | \$ 0.3024      |             |                  |                |                  |                    |
| Box                               | Purchase              |        |              |                | \$ 0.6990      |             |                  |                |                  |                    |
| Box and Envelope Label (710)      | Purchase              | 993002 | 993002       |                |                |             |                  |                |                  |                    |
| Barrel Assembly Complete          | Assemble              | 305410 | C-305410     | No Rev.        |                |             |                  |                |                  |                    |
| Barrel Assembly                   | Assemble & Machine    | 305400 | C-305400     | No Rev.        |                |             |                  |                |                  |                    |
| Barrel                            | Machine               | 245315 | E-253315     |                | \$ 5.6537      |             |                  |                |                  |                    |
| Receiver                          | Machine               | 300340 | E-300340     |                | \$ 2.1780      |             |                  |                |                  |                    |
| Receiver Insert Assembly Complete | Assemble              | 306401 | D-300401     | No Rev.        |                |             |                  |                |                  |                    |
| Receiver Insert Assembly          | Ultrasonic Weld       | 306400 | C-300400     | No Rev.        |                |             |                  |                |                  |                    |
| Receiver Insert                   | Purchase              | 306327 | E-306327-1-2 | (1E)-5 (2E)-23 |                |             |                  |                |                  |                    |
| Threaded Insert                   | Purchase              | 330047 | A-300047     |                | \$ 0.0360      |             |                  |                |                  |                    |
| Slide Plate                       | Purchase & Color      | 330333 | C-300333     | No Rev.        | \$ 0.9900      |             |                  |                |                  |                    |
| Slide Plate Pin (2)               | Purchase & Color      | 330328 | A-300328     | No Rev.        | \$ 0.1600      |             |                  |                |                  |                    |
| Sear Safety Cam                   | A/U M700              | 15666  | C-15666      | 24             | \$ 0.7593      |             |                  |                |                  |                    |
| Pivot Pin (3)                     | Purchase & Heat Treat | 300351 | B-300351     | No Rev.        | \$ 0.0273      |             |                  |                |                  |                    |
| Sear Spring                       | A/U M700              | 17047  | A-17047      | 26             | \$ 0.0228      |             |                  |                |                  |                    |
| Trigger                           | A/U M700              | 15286  | C-15286      | 31             | \$ 0.3771      |             |                  |                |                  |                    |
| Trigger Connector                 | A/U M700              | 15401  | C-15401      | 21             | \$ 1.3063      |             |                  |                |                  |                    |
| Trigger Screw Front               | A/U M700              | 17053  | B-17053      | 32             | \$ 0.0395      |             |                  |                |                  |                    |
| Trigger Engagement Screw          | A/U M700              | 91128  | B-91128      | 7              | \$ 0.0272      |             |                  |                |                  |                    |
| Trigger Spring                    | A/U M700              | 15400  | A-15400      | 11             | \$ 0.0290      |             |                  |                |                  |                    |
| Trigger Stop Screw                | A/U M700              | 15481  | A-15481      | 32             | \$ 0.0415      |             |                  |                |                  |                    |
| Safety Arm                        | Assemble & Heat Treat | 300408 | D-300408     | 1              | \$ 0.2300      |             |                  |                |                  |                    |
| Safety Detent Spring              | Purchase              | 300407 | C-300407     | 1              | \$ 0.0578      |             |                  |                |                  |                    |
| Lock Latch                        | Purchase              | 300420 | D-300420     | No Rev.        |                |             |                  |                |                  |                    |
| Lock Detent                       | A/U M700              | 7777   | 7777         |                |                |             |                  |                |                  |                    |
| Safety Pivot Pin                  | Purchase & Heat Treat | 300352 | B-300352     | 1              | \$ 0.1400      |             |                  |                |                  |                    |
| Soap Washer                       |                       | 17044  | B-17044      | 26             | \$ 0.0247      |             |                  |                |                  |                    |
| Bolt Stop                         | PM/Heat Treat/Color   | 300345 | C-300345     | 2              | \$ 0.2190      |             |                  |                |                  |                    |
| Receiver Plug Screws (4)          | A/U M700              | 17034  | B-17034      | 34             | \$ 0.1193      |             |                  |                |                  |                    |
| Recoil Bracket                    | Purchase & Color      | 300363 | E-300363     | No Rev.        | \$ 0.1550      |             |                  |                |                  |                    |
| Bolt Assembly Complete            |                       | 300330 | D-300330     |                |                |             |                  |                |                  |                    |
| Bolt Body Assembly                | Drill & Finish        | 300403 | D-300403     |                |                |             |                  |                |                  |                    |
| Bolt Body                         | Machine               | 300330 | D-300330     | 2              | \$ 0.7400      |             |                  |                |                  |                    |
| Bolt Handle                       | Heat to Form          | 300330 | C-300330     | No Rev.        | \$ 1.6300      |             |                  |                |                  |                    |
| Bolt Handle Blank                 | Purchase              | 300330 | C-300330     | No Rev.        | \$ 0.1000      |             |                  |                |                  |                    |
| Bolt Handle Pin                   | Purchase              | 300330 | A-300330     | No Rev.        | \$ 0.1000      |             |                  |                |                  |                    |
| Bolt Head Assembly                | Assemble              | 300330 | B-300330     | No Rev.        | \$ 0.1000      |             |                  |                |                  |                    |
| Bolt Head                         | Machine               | 300330 | E-300330     | 14             | \$ 0.7500      |             |                  |                |                  |                    |
| Ejector                           | Purchase & Color      | 300330 | C-300330     | 9              | \$ 0.7117      |             |                  |                |                  |                    |
| Ejector Spring                    | Purchase              | 300330 | A-300330     | No Rev.        | \$ 0.0132      |             |                  |                |                  |                    |
| Ejector Pin                       | A/U M700              | 94554  | C-94554      | 7              | \$ 0.0133      |             |                  |                |                  |                    |
| Bolt Assembly Pin                 | Purchase & Color      | 300330 | D-300330     | No Rev.        | \$ 0.1500      |             |                  |                |                  |                    |
| Priming Pin Assembly              | Purchase              | 300330 | B-300330     | No Rev.        | \$ 0.2156      |             |                  |                |                  |                    |
| Priming Pin                       | Machine               | 300330 | C-300330     | 7              | \$ 0.0250      |             |                  |                |                  |                    |
| Bolt Pin                          | Purchase              | 300330 | B-300330     | No Rev.        | \$ 0.0250      |             |                  |                |                  |                    |
| Priming Pin                       | Purchase & Color      | 300330 | C-300330     | No Rev.        | \$ 1.1930      |             |                  |                |                  |                    |
| Priming Pin                       | Purchase & Heat Treat | 300335 | B-300335     | No Rev.        | \$ 0.2500      |             |                  |                |                  |                    |
| Priming Pin                       | Machine               | 300336 | C-300336     | No Rev.        | \$ 1.5000      |             |                  |                |                  |                    |
| Priming Pin Spring                | Purchase              | 300339 | A-300339     | No Rev.        | \$ 0.1024      |             |                  |                |                  |                    |
| Front Sight Assembly              |                       | 94084  | C-15373      | 26             | \$ 0.8064      |             |                  |                |                  |                    |
| Front Sight                       | A/U M700              | 94057  | B-28510      | 53             | \$ 1.1877      |             |                  |                |                  |                    |
| Front Sight Ramp Screws (2)       | A/U M700              | 28505  | B-28505      | 21             | \$ 0.0795      |             |                  |                |                  |                    |
| Rear Sight Assembly               | A/U M700              | 103145 | B-103145     | 11             | \$ 3.2791      |             |                  |                |                  |                    |
| Diverting Screw                   | A/U M700              | 50306  | A-50306      | 10             | \$ 0.0236      |             |                  |                |                  |                    |
| Rear Sight Aperture               | A/U M700              | 75841  | C-93905      | 9              | \$ 0.2847      |             |                  |                |                  |                    |
| Rear Sight Aperture Blank         |                       | 53906  | C-93906      | 0              |                |             |                  |                |                  |                    |
| Rear Sight Base                   | A/U M700              | 103531 | C-103530     | 3              | \$ 1.0170      |             |                  |                |                  |                    |
| Rear Sight Shoe                   | A/U M700              | 94335  | C-93934      | 7              | \$ 1.2003      |             |                  |                |                  |                    |
| Windage Screw                     | A/U M700              | 300026 | B-300026     | 5              | \$ 0.1513      |             |                  |                |                  |                    |
| Rear Sight Base Screw (2)         | A/U M700              | 28505  | B-28505      | 21             |                |             |                  |                |                  |                    |
| Stock Assembly Complete           | Purchase              | 7777   | 7777         |                |                |             |                  |                |                  |                    |
| Stock                             | Purchase              | 7777   | 7777         |                | \$ 5.3800      |             |                  |                |                  |                    |
| Front Screw Bushing               | A/U M700              | 13161  | B-13161      | 7              | \$ -           |             |                  |                |                  |                    |
| Front Screw Bushing Blank         |                       | 93083  | 7777         | 7777           | \$ -           |             |                  |                |                  |                    |
| Middle Screw Bushing              | Purchase              | 7777   | 7777         |                | \$ -           |             |                  |                |                  |                    |
| Rear Screw Bushing                | Purchase              | 7777   | 7777         |                | \$ -           |             |                  |                |                  |                    |
| Grip Cap                          | A/U M700              | 97073  | C-97071      | No Rev.        | \$ 0.1800      |             |                  |                |                  |                    |
| Recoil Pad                        | A/U M700              | 97073  | D-97073      | 26             | \$ 1.6100      |             |                  |                |                  |                    |
| Recoil Plate                      | Purchase              | 97072  | C-97072      | No Rev.        | \$ 0.1800      |             |                  |                |                  |                    |
| Recoil Pad Screw (2)              | A/U M700              | 99058  | A-99058      | 7              | \$ 0.0220      |             |                  |                |                  |                    |
| Magazine Lock                     | Purchase              | 300362 | C-300362     | 2              | \$ 0.1910      |             |                  |                |                  |                    |
| Magazine Latch Spring             | Purchase              | 300398 | D-300398     | No Rev.        | \$ 0.0277      |             |                  |                |                  |                    |
| Magazine Latch Pin                | Purchase & Color      | 300371 | D-300371     | No Rev.        | \$ 0.0700      |             |                  |                |                  |                    |
| Shing Snowed Stud (2)             | Purchase              | 300056 | B-300056     | 4              | \$ 0.2800      |             |                  |                |                  |                    |
| Takedown Screw (2)                | Purchase              | 7777   | 7777         | 397            | \$ -           |             |                  |                |                  |                    |
| Rear Takedown Screw               | Purchase              | 7777   | 7777         | 397            | \$ -           |             |                  |                |                  |                    |
| Magazine Assembly                 | Assemble              | 300355 | B-300355     | No Rev.        | \$ -           |             |                  |                |                  |                    |
| Magazine Pin                      | Purchase & Color      | 300363 | B-300363     | 2              | \$ 0.8812      |             |                  |                |                  |                    |
| Magazine Followup                 | Purchase              | 300364 | B-300364     | 1              | \$ 0.0930      |             |                  |                |                  |                    |
| Magazine Bottom                   | Purchase              | 300365 | D-300365     | No Rev.        | \$ 0.1050      |             |                  |                |                  |                    |
| Magazine Spring                   | A/U M700              | 300405 | C-300405     | No Rev.        | \$ 0.2590      |             |                  |                |                  |                    |
| Value Added Cost of:              |                       |        |              |                | \$ -           | \$ -        | \$ -             | \$ -           | \$ -             | \$ -               |
| Proof/Gallery/Inspection/Pack     |                       |        |              |                | \$ -           | \$ -        | \$ -             | \$ -           | \$ -             | \$ -               |
| Total Cost                        |                       |        |              |                | \$ 39,3304     | \$ -        | \$ -             | \$ -           | \$ -             | \$ -               |

MF0113

| Quoted Parts                                |        |              |              |            |           |             |                |              |              |                                          |
|---------------------------------------------|--------|--------------|--------------|------------|-----------|-------------|----------------|--------------|--------------|------------------------------------------|
| PART DESCRIPTION                            | Part # | Print #      | Rev#         | Price/part | Order Qty | Eng. Charge | Vendor Capital | Vendor Gages | PPI Gages    | Comments                                 |
| Document Envelope Assembly                  | 7999   | 7999         | 7            |            |           |             |                |              |              |                                          |
| Document Envelope                           | 1649   | 1649         | 7            |            |           |             |                |              |              |                                          |
| Instruction Book                            | 7777   | 7777         | 7            |            |           |             |                |              |              |                                          |
| Product Owners Card                         | 1426   | 1426         | 7            |            |           |             |                |              |              |                                          |
| Remington Authorized Company                | 3413   | 3413         | 7            |            |           |             |                |              |              |                                          |
| Safety Booklet                              | 3499   | 3499         | 7            |            |           |             |                |              |              |                                          |
| Remington Museum Flyer                      | 3475   | 3475         | 7            |            |           |             |                |              |              |                                          |
| Oral Label                                  | 3491   | 3491         | 7            |            |           |             |                |              |              |                                          |
| Carton Assembly                             | 1444   | 1444         | 7            |            |           |             |                |              |              |                                          |
| Corrugate Box                               |        |              |              | \$ 0.5024  | 20        |             |                |              |              | ORPACK-Shore Corporation                 |
| Box                                         |        |              |              | \$ 0.6900  | 20        |             |                | \$ 19,000.00 |              | Tecumseh                                 |
| Box and Envelope Label (710)                | 995002 | 995002       | 7            |            |           |             |                |              |              |                                          |
| Barrel Assembly Complete                    | 305418 | C-305418     | No Rev.      |            |           |             |                |              |              |                                          |
| Barrel Assembly                             | 305400 | C-305400     | No Rev.      |            |           |             |                |              |              |                                          |
| Barrel                                      | 305312 | E-305312     | 5            |            |           |             |                |              |              |                                          |
| Receiver                                    | 306340 | E-306340     | 6            |            |           |             |                |              |              |                                          |
| Receiver Insert Assembly Complete           | 306401 | D-306401     | No Rev.      |            |           |             |                |              |              |                                          |
| Receiver Insert Assembly                    | 306400 | C-306400     | No Rev.      |            |           |             |                |              |              |                                          |
| Receiver Insert                             | 306327 | E-306327-1-2 | (1E)5 (2E)23 |            |           |             |                |              | \$ 5,050.00  |                                          |
| Threaded Insert                             | 306347 | A-306347     | A            | \$ 0.3160  | 20        |             |                |              |              | Precision Fasteners                      |
| Slide Pin                                   | 306333 | C-306333     | No Rev.      | \$ 0.9600  | 20        |             |                |              |              | Historical Data                          |
| Slide Plate Pin (2)                         | 306373 | A-306373     | No Rev.      | \$ 0.1600  | 60        | \$ 225.00   |                |              |              | Isch-Quote                               |
| Star Safety Cam                             | 5666   | C-5666       | 24           | \$ 0.7595  | 20        |             | \$ 11,390.00   |              | \$ 3,030.00  | Sterling Sintered Tech. Inc.-Quote: 8/   |
| Pivot Pin (3)                               | 306151 | B-306151     | No Rev.      | \$ 0.0270  | 60        | \$ 450.00   |                |              |              | Automat & Shovel Corporation-Quote:      |
| Star Spring                                 | 7047   | A-7047       | 26           | \$ 0.0228  | 20        |             |                |              |              | Ilion Quote                              |
| Trigger                                     | 15280  | C-15280      | 31           | \$ 0.3771  | 20        |             | \$ 15,225.00   |              | \$ 3,000.00  | Sterling Sintered Tech. Inc.-Quoted 9/0  |
| Trigger Connector                           | 19461  | C-19461      | 21           | \$ 1.3803  |           |             |                |              |              |                                          |
| Trigger Spring Front                        | 12053  | B-12053      | 32           | \$ 0.0395  | 20.00     |             |                |              |              | Federal-Quote: 8/18/99                   |
| Trigger Engagement Screw                    | 91128  | B-91128      | 7            | \$ 0.0272  | 6.00      |             |                |              |              | Ilion Quote SAP                          |
| Trigger Spring                              | 15400  | A-15400      | 11           | \$ 0.0250  | 20        |             |                |              |              | Ilion Quote SAP                          |
| Trigger Stop Screw                          | 15481  | A-15481      | 32           | \$ 0.0415  | 20        |             |                |              |              | Fastenal-Quote:                          |
| Safety Arm                                  | 90408  | D-90408      | 1            | \$ 0.2860  | 20        |             | \$ 25,552.00   |              | \$ 2,400.00  | Rich Hemisphere Stamping-Quote: 9/28     |
| Safety Detent Spring                        | 306407 | C-306407     | 1            | \$ 0.0518  | 20        |             |                |              |              | Elk State Spring Inc.-Quote: 9/23/99     |
| Lock Hammer                                 | 306320 | D-306320     | No Rev.      |            |           |             |                |              |              |                                          |
| Lock Detent                                 | 7777   | 7777         |              |            |           |             |                |              |              |                                          |
| Safety Pivot Pin                            | 306352 | B-306352     | 1            | \$ 0.1440  | 20        | \$ 225.00   |                |              |              | Isch Company-Quote: 8/25/99              |
| Safety Snap Washer                          | 17044  | B-17044      | 26           | \$ 0.0247  |           |             |                |              |              | Ilion Quote SAP                          |
| Isch Snap                                   | 306343 | C-306343     | 2            | \$ 0.2190  | 20        |             | \$ 6,820.00    |              | \$ 1,500.00  | Sterling Sintered Tech. Inc.-Quote:      |
| Receiver Plug Screws (4)                    | 17034  | B-17034      | 34           | \$ 0.1152  |           |             |                |              |              | Ilion Quote SAP                          |
| Recoil Bracket                              | 306361 | D-306361     | No Rev.      | \$ 0.1229  | 20        | \$ 300.00   |                |              |              | Square Stamping Quoted Aug. 11, 99       |
| Bolt Assembly Complete                      | 306377 | 7777         | 95           |            |           |             |                |              |              |                                          |
| Bolt Body Assembly                          | 306403 | D-306403     | No Rev.      |            |           |             |                |              |              |                                          |
| Bolt Body                                   | 306359 | D-306359     | 1            |            |           |             |                |              |              | #8(F)                                    |
| Bolt                                        | 0      | 0            | 0            |            |           |             |                |              |              |                                          |
| Bolt Handle                                 | 306370 | C-306370     | No Rev.      |            |           |             | \$ 512,775.00  |              |              | Tandem-Quote: 8/12/99                    |
| Bolt Handle Blank                           | 306360 | C-306360     | No Rev.      |            |           |             | \$ 2,580.00    |              |              |                                          |
| Bolt Handle Pin                             | 306329 | A-306329     | 7            | \$ 0.1000  | 20        |             | 450.00         |              |              | Automat & Shovel Corporation-Quote: 8/   |
| Bolt Head Assembly                          | 305390 | B-305390     | No Rev.      |            |           |             |                |              |              |                                          |
| Bolt Head                                   | 306331 | C-306331     | 14           |            |           |             |                |              | \$ 20.00     | Linker & Harper Mfg Company              |
| Extractor                                   | 93112  | C-93112      | 2            | \$ 0.7712  | 20        |             |                |              | \$3,300.00   | Ilion Quote SAP                          |
| Lycator                                     | 306342 | B-306342     | 1            | \$ 0.1100  | 20        | \$ 400.00   |                |              | \$ 1,800.00  | Isch-Quote: 8/25/99                      |
| Lycator Spring                              | 306342 | A-306342     | No Rev.      | \$ 0.0152  | 20        |             |                |              |              | Midstate Spring Inc.-Quote: 8/26/99      |
| Ejector Pin                                 | 94555  | A-94555      | 20           | \$ 0.0137  | 20        |             |                |              |              | Ilion Quote SAP                          |
| Bolt Assembly Pin                           | 306336 | C-306336     | No Rev.      | \$ 0.0137  | 20        | \$ 450.00   |                |              |              | Automat & Shovel Corporation-Quote:      |
| Firing Pin Assembly                         | 306340 | C-306340     | No Rev.      |            |           |             |                |              |              |                                          |
| Bolt Pin                                    | 306340 | C-306340     | No Rev.      | \$ 0.2150  | 20        |             | \$ 30,000.00   |              | \$ 500.00    | Kellens & Coe-Quote: 8/12/99             |
| Bolt Pin                                    | 306340 | C-306340     | No Rev.      | \$ 0.4080  | 20        | \$ 775.00   | \$0.00         |              | \$3,000.00   | Swiss Precision Machining, Inc.-Quot     |
| Bolt Pin                                    | 306340 | C-306340     | No Rev.      | \$ 1.1900  | 20        | \$ 400.00   |                |              | \$ 200.00    | Isch-Quote: 8/16/99                      |
| Firing Pin                                  | 306335 | B-306335     | No Rev.      | \$ 0.2500  | 20        | \$ 225.00   |                |              | \$3,300.00   | Isch-Quote: 8/16/99                      |
| Firing Pin                                  | 306336 | C-306336     | No Rev.      | \$ 1.5000  | 20        |             | \$ 17,500.00   |              | \$ 1,500.00  | Magnet Industries-Quote: 9/13/99         |
| Firing Pin Spring                           | 306330 | A-306330     | No Rev.      | \$ 0.1008  | 20        |             |                |              |              | Midstate Spring-Quote: 8/20/99           |
| Front Sight Assembly                        | 0      | 0            | 0            |            |           |             |                |              |              |                                          |
| Front Sight                                 | 94084  | C-15373      | 26           | \$ 0.8068  |           |             |                |              |              | Ilion Quote: 8/18/99                     |
| Front Sight Spring                          | 94657  | B-28510      | 33           | \$ 1.1877  |           |             |                |              | \$400.00     | Ilion Quote: Last date 8/10/99           |
| Front Sight Spring Screws (2)               | 28505  | B-28505      | 21           | \$ 0.0795  |           |             |                |              |              | Mayfield Quote: SAP latest change 8/1    |
| Rear Sight Assembly                         | 102145 | B-102145     | 11           | \$ 3.2791  |           |             |                |              |              | Ilion Quote: SAP latest change 8/1/99    |
| Rear Sight Screw                            | 50806  | A-50806      | 19           | \$ 0.0236  | 20        |             |                |              |              | Ilion Quote: SAP                         |
| Rear Sight Aperture                         | 93561  | C-93561      | 9            | \$ 0.2847  | 20        |             |                |              |              | May SAP Quote: 8/1/99 Latest change      |
| Rear Sight Aperture Blank                   | 53306  | C-53306      | 6            |            |           |             |                |              |              |                                          |
| Rear Sight Base                             | 133531 | C-133530     | 1            | \$ 1.0170  | 80        |             | \$17,500.00    |              |              | Ilion Quote: 8/1/03                      |
| Rear Sight Slide                            | 94315  | C-93004      | 7            | \$ 1.2090  | 80        |             | \$17,500.00    |              |              | Magnet Industries-Quote: 9/13/99         |
| Windage Screw                               | 306026 | B-306026     | 5            | \$ 0.1510  | 25        | \$ 450.00   |                |              |              | Swiss Precision Machining Inc.-Quote:    |
| Rear Sight Base Screw (2)                   | 28505  | B-28505      | 21           |            |           |             |                |              |              |                                          |
| Stock Assembly Complete                     | 7777   | 7777         | 95           |            |           |             |                |              |              |                                          |
| Stock                                       | 7777   | 7777         | 95           | \$ 5.3900  | 20        |             | \$150,300.00   |              | \$4,500.00   | Pat & Partners, Inc. Aug. 19, 1999       |
| Front Screw Bushing                         | 5164   | D-15161      | 97           |            |           |             |                |              |              |                                          |
| Front Screw Bushing Blank                   | 91915  | 7777         | 7777         |            |           |             |                |              |              |                                          |
| Module Screw Bushing                        | 7777   | 7777         | 7777         |            |           |             |                |              |              |                                          |
| Rear Screw Bushing                          | 7191   | 7191         | 97           |            |           |             |                |              |              |                                          |
| Crop Cap                                    | 97971  | C-97971      | No Rev.      | \$ 0.1800  |           |             |                |              |              | Ilion Quote: SAP: 8/1/99 latest change   |
| Recall Pad                                  | 97973  | D-97973      | 26           | \$ 1.6100  |           |             |                |              | \$400.00     | Ilion Quote: SAP latest price change 8/1 |
| Recoil Plate                                | 97972  | C-97972      | No Rev.      | \$ 0.3900  |           |             |                |              |              | Ilion Quote: SAP                         |
| Recoil Pad Screw (2)                        | 98001  | A-98001      | 7            | \$ 0.0220  | 20        |             |                |              |              | Fastenal-Quote:                          |
| Magazine Latch                              | 306362 | C-306362     | 2            | \$ 0.1910  | 20        |             | \$99,030.00    |              | \$0.00       | Kellens & Coe-Quote: 8/17/99             |
| Magazine Latch Spring                       | 306398 | D-306398     | No Rev.      | \$ 0.0227  | 20        |             |                |              |              | Industrial Spring-Quote: 8/21/99         |
| Magazine Latch Pin                          | 306371 | B-306371     | No Rev.      | \$ 0.0760  | 20        | \$ 225.00   |                |              |              | Isch-Quote: 8/25/99                      |
| Sling Swivel Stud (2)                       | 306936 | B-306936     | 4            | \$ 0.2860  |           |             |                |              |              | Quote A/U from M597                      |
| Takedown Screw (2)                          | 7222   | 7222         | 7222         |            |           |             |                |              | \$200.00     |                                          |
| Rear Takedown Screw                         | 306355 | B-306355     | No Rev.      |            |           |             |                |              | \$290.00     |                                          |
| Magazine Assembly                           | 306363 | B-306363     | 5            | \$ 0.8412  | 20        |             | \$ 89,000.00   |              | \$ 4,500.00  | Ilion Quote: 10/18/99                    |
| Magazine Pin                                | 306364 | B-306364     | 1            | \$ 0.0260  | 20        |             |                |              | \$ 3,000.00  | Par & Partners, Inc.-Quote: 8/27/99      |
| Magazine Pin                                | 306365 | B-306365     | No Rev.      | \$ 0.1350  | 20        |             |                |              |              | Par & Partners, Inc.-Quote: 8/27/99      |
| Magazine Spring                             | 306405 | C-306405     | No Rev.      | \$ 0.2590  |           |             |                |              | \$ 3,400.00  | North American Spring-Quote: 10/27       |
| Value Added Cost: Prod/Gallery/Inspect/Pack |        |              |              |            |           |             |                |              |              |                                          |
| Total Cost                                  |        |              |              | \$ 20,607  | 1045.12   | \$ 4,775.00 | \$ 551,558.00  | \$ -         | \$ 52,690.00 |                                          |



Corrugated Box

| OP #   | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part # | Print # | REV | Material | Quantity | Std. Run Hours | Variable Overhead \$ | Preop | Capital | PPI Gages \$ | Material Handling | Comments                 |
|--------|---------------------|---------------------|--------|---------|-----|----------|----------|----------------|----------------------|-------|---------|--------------|-------------------|--------------------------|
| 10     | Locking Box         |                     |        |         |     | \$       | 20       |                | \$                   |       |         |              |                   | ORPACK-Stone Corporation |
| Totals |                     |                     |        |         |     |          |          |                |                      |       |         |              |                   |                          |

MF0116

Bec

| OP #   | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part # | Print # | REV | Material \$ | Quantity | Std. Run Hours | Variable Overhead \$ | Prep | Capital   | PPI Gages \$ | Material Handling | Comments  |
|--------|---------------------|---------------------|--------|---------|-----|-------------|----------|----------------|----------------------|------|-----------|--------------|-------------------|-----------|
| 10     | Bedding             |                     |        |         |     | 0.00        | 20       |                |                      |      | 19,000.00 |              |                   | Tuscorora |
| Totals |                     |                     |        |         |     |             |          |                |                      |      |           |              |                   |           |
|        |                     |                     |        |         |     | \$ 0.00     | 20       | 0              | \$                   | \$   | 19,000.00 | \$           | \$                |           |

CONFIDENTIAL 83

MF0117

#305410 - Barrel Assy Complete

| OF #   | PROCESS DESCRIPTION        | MACHINE DESCRIPTION           | Part # | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop | Capital | PPI Gages \$ | Material Handling | Comments |
|--------|----------------------------|-------------------------------|--------|---------|-----|-------------|----------------|----------------------|-------|---------|--------------|-------------------|----------|
| 10     | Assemble Sights            | Fixture Modifications Tooling |        |         |     |             |                |                      |       |         |              |                   |          |
|        | Press Receiver Insert Assy |                               |        |         |     |             |                |                      |       |         |              |                   |          |
|        | Complete into barrel Assy  |                               |        |         |     |             |                |                      |       |         |              |                   |          |
| 20     | Complete                   |                               |        |         |     |             |                |                      |       |         |              |                   |          |
| Totals |                            |                               |        |         |     |             |                | \$ -                 | \$ -  | \$ -    |              | \$ -              |          |

710 Complete 1

83

MF0118

#304500 - Barrel Assembly

| OP # | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part # | Print # | REV | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital | EPI Gages \$ | Material Handling | Comments |
|------|---------------------|---------------------|--------|---------|-----|-------------|----------------|----------------------|----------|---------|--------------|-------------------|----------|
|      |                     |                     |        |         |     |             |                |                      |          |         |              |                   |          |
|      |                     | Totals              |        |         |     | \$ -        | 0.000000       | \$0.00               | \$0.00   | \$ -    | \$ -         | \$0.00            |          |

710 Complete 1

ME0119

Confidential - ~~Subcontract~~ - 522.06r0010069 Order  
Williams v. Remington

#305315 - Barrel

| Op. # | PROCESS DESCRIPTION                                                                                                  | MACHINE DESCRIPTION         | Part # | Print # | REV | Material | Std. Run Hours | Variable Overhead \$ | Preop \$     | Capital       | PFI Gages \$ | Comments                                                                            |
|-------|----------------------------------------------------------------------------------------------------------------------|-----------------------------|--------|---------|-----|----------|----------------|----------------------|--------------|---------------|--------------|-------------------------------------------------------------------------------------|
| 10    | Cut to Length                                                                                                        |                             |        |         |     | \$ 5-054 | 0.00000        | \$ 0.008             | \$ 285.80    | \$ -          |              | Operation 010 Detail - Barrel Cut to Length                                         |
| 20    | Gundrill Bore                                                                                                        |                             |        |         |     | N/A      | 0.04181        | \$ 0.111             | \$ 5,733.92  | \$ -          |              | Operation 020 Detail - Barrel Gundrill Bore                                         |
| 30    | Rear Bore                                                                                                            |                             |        |         |     | n/a      | 0.04565        | \$ 0.102             | \$ 3,055.20  | \$ -          |              | Operation 030 Detail - Barrel Rear Bore                                             |
| 40    | Rifle Bore                                                                                                           |                             |        |         |     | n/a      | 0.00000        | \$ 0.075             | \$ 6,752.00  | \$ 6,080.00   |              | Operation 040 Detail - Barrel Rifle Bore                                            |
| 50    | Wash & Stress Relieve                                                                                                |                             |        |         |     | n/a      | 0.00116        | \$ -                 | \$ -         | \$ 9,416.00   |              | Operation 050 Detail - Barrel Wash & Stress Relieve                                 |
| 60    | Turn O.D. & Inspect for Runout                                                                                       | Gaging                      |        |         |     | n/a      | 0.08845        | \$ 0.093             | \$ 4,986.46  | \$ 5,000.00   |              | Operation 060 Detail - Barrel Turn O.D. & Inspect                                   |
| 70    | Face, Chamber, Machine Hub End, Drill & Tap Takedown Screw Holes, Mill Recoil Lug Slot & 100% Inspect Chamber Finish | Gaging<br>Okuma LB-300      |        |         |     | n/a      | 0.09169        | \$ 3.101             | \$ 8,620.00  | \$ 33,404.00  |              | Operation 070 Detail - Barrel Machine Chamber & Hub Complete                        |
| 80    | Cut-off & Crown Muzzle End                                                                                           | Clamping Chuck              |        |         |     | n/a      | 0.00000        | \$ 0.082             | \$ 1,440.56  | \$ 15,000.00  |              | Operation 080 Detail - Barrel Cut-Off & Crown Muzzle                                |
| 90    | Drill & Tap Sight Screw Holes                                                                                        | Gaging                      |        |         |     | n/a      | 0.02020        | \$ 0.062             | \$ 3,515.05  | \$ 14,515.00  |              | Operation 090 Detail - Barrel Drill & Tap Sight Holes                               |
| 100   | Centerless Polish Barrel                                                                                             |                             |        |         |     | n/a      | 0.00500        | \$ 0.094             | \$ 709.43    | \$ -          |              |                                                                                     |
| 110   | Wash & Magnaflux Barrel                                                                                              | Eddy Current Tester         |        |         |     | n/a      | 0.01500        | \$ -                 | \$ -         | \$ 75,766.26  |              | Operation 110 Detail - Barrel Eddy Current Test                                     |
| 120   | Proseco Wash Barrels                                                                                                 |                             |        |         |     | n/a      | 0.00047        | \$ -                 | \$ -         | \$ -          |              | Operation 120 Detail - Barrel Proseco Wash                                          |
| 130   | Induction Heat Treat Hub                                                                                             | Induction Hardening Machine |        |         |     | n/a      | 0.00600        | \$ -                 | \$ -         | \$ 181,566.26 |              | Operation 130 Detail - Barrel Induction Heat Treat Hub                              |
| 140   | Wash & Descale                                                                                                       |                             |        |         |     | n/a      | 0.00257        | \$ -                 | \$ -         | \$ -          |              | Operation 140 Detail - Barrel Wash & Descale                                        |
| 150   | Press Receiver onto Barrel                                                                                           | Gaging                      |        |         |     | n/a      | 0.02337        | \$ 0.150             | \$ 750.00    | \$ 7,500.00   |              | Operation 150 - Press Receiver onto Barrel                                          |
| 160   | Inspect for Runout & Straighten if Necessary                                                                         |                             |        |         |     | n/a      | 0.00000        | \$ 0.005             | \$ 700.00    | \$ 9,530.00   |              | Operation 160 Detail - Barrel Assembly Inspect for Runout & Straighten as Necessary |
| 170   | Roll Mark                                                                                                            |                             |        |         |     | n/a      | 0.00300        | \$ 0.127             | \$ 1,730.00  | \$ 1,240.00   |              | Operation 170 Detail - Barrel Assembly Rollmark                                     |
| 180   | Angularity Straighten Muzzle & Inspect Bore                                                                          |                             |        |         |     | n/a      | 0.00667        | \$ 0.005             | \$ 228.60    | \$ 1,500.00   |              | Operation 180 Detail - Barrel Assembly Angularity Straighten                        |
| 185R  | Centerless Polish                                                                                                    | REPAIR ONLY                 |        |         |     |          |                |                      |              |               |              |                                                                                     |
| 190   | Glass Bead                                                                                                           |                             |        |         |     | n/a      | 0.00556        | \$ -                 | \$ 908.00    | \$ -          |              | Operation 190 Detail - Barrel Assembly Glass Bead                                   |
| 200   | Black Oxide                                                                                                          |                             |        |         |     | n/a      | 0.00417        | \$ 0.004             | \$ 8,952.00  | \$ -          |              | Operation 200 Detail - Barrel Assembly Black Oxide                                  |
|       | TOTALS                                                                                                               |                             |        |         |     | \$ 5.054 | 0.35585        | \$ 4.017             | \$ 49,760.02 | \$ 585,434.74 | \$0.00       |                                                                                     |

710 Complete 1

83

ME0120

4373421 - Receiver

| OP #   | PROCESS DESCRIPTION             | MACHINE DESCRIPTION | Part # | Rev | Mach'd   | Quality | Engineering | Std. Run   | Variable | Prep        | Capital       | PTH | Material | Comments                                              |
|--------|---------------------------------|---------------------|--------|-----|----------|---------|-------------|------------|----------|-------------|---------------|-----|----------|-------------------------------------------------------|
|        |                                 |                     |        |     |          |         | Change      | Hours      | Overhead |             |               |     | Handling |                                                       |
| 10     | CNC Machine Complete            |                     |        |     | \$ 2,178 |         |             | 0.08371537 | \$ 1.00  | \$12,695.61 | \$ 122,208.72 |     |          | Operation 10 Detail - Receiver CNC Machine Complete   |
| 20     | Receiver O.D. Cylindrical Grind |                     |        |     | \$ -     |         |             | 0 \$ -     | \$ -     | \$ -        | \$ -          |     |          | Operation 10 Detail - Receiver O.D. Cylindrical Grind |
| 30     | Receiver Vitrucut               |                     |        |     | \$ -     |         |             | 0 \$ -     | \$ -     | \$ -        | \$ -          |     |          | Operation 10 Detail - Receiver Vitrucut Debur         |
| Total: |                                 |                     |        |     |          |         |             |            |          |             |               |     |          | Receiver Tooling Inc. Quote 872659                    |

CONFIDENTIAL 83

713 Complete 1

MF0121

#300401- Rece Insert Assy Comp

| OP #   | PROCESS DESCRIPTION          | MACHINE DESCRIPTION | Part # | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$  | PPI Gages \$ | Material Handling | Comments |
|--------|------------------------------|---------------------|--------|---------|-----|-------------|----------------|----------------------|----------|-------------|--------------|-------------------|----------|
| 1      |                              |                     |        |         |     |             |                |                      |          |             |              |                   |          |
| 10     | Demagnetize Metal Components |                     |        |         |     | \$ -        | 0.000404       | \$ -                 | \$ -     |             |              |                   |          |
| 20     | Assemble - Stage 1           | Fixturing           |        |         |     | \$ -        | 0.011383       | \$ -                 | \$ -     | \$ 1,500.00 |              |                   |          |
| 30     | Assemble - Stage 2           | Fixturing           |        |         |     | \$ -        | 0.025275       | \$ -                 | \$ -     | \$ 1,500.00 |              |                   |          |
| 40     | Adjust on Comparator         | Fixturing           |        |         |     | \$ -        | 0.016929       | \$ -                 | \$ -     | \$ 5,000.00 |              |                   |          |
| 60     | Function Check Complete      |                     |        |         |     | \$ -        | 0.006917       | \$ -                 | \$ -     |             |              |                   |          |
| 70     | Stamp Identification         |                     |        |         |     | \$ -        | 0.001908       | \$ -                 | \$ -     |             |              |                   |          |
| Totals |                              |                     |        |         |     | \$ -        | 0.06282        | \$ -                 | \$ -     | \$ 8,000.00 | \$ -         | \$ -              |          |

710 Complete 1

83

ME0122

#300400 - Receiver Insert Assy

| OP # | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$  | PPI Gages \$ | Material Handling | Comments |
|------|---------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|-------------|--------------|-------------------|----------|
| 10   | Ultrasonic Weld     | Fixturing           |       |         |     | \$ -        | 0.001000       | \$ -                 | \$ -     | \$ 2,000.00 |              | \$ -              |          |
|      |                     | Totals              |       |         |     |             | 0.001          | \$ -                 | \$ -     | \$ 2,000.00 | \$ -         | \$ -              |          |

710 Complete 1

ME0123

#300327 - Receiver Insert

| OP # | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part# | Print# | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages \$ | Material Handling | Comments                     |
|------|---------------------|---------------------|-------|--------|-----|-------------|----------------|----------------------|----------|------------|--------------|-------------------|------------------------------|
|      | Gaging              |                     |       |        |     |             |                |                      |          |            | \$ 5,650.00  |                   | Estimated Quote Jerry Helmer |
|      |                     | Totals              |       |        |     |             |                |                      |          |            | \$ 5,650.00  |                   |                              |

710 Complete 1

MF0124

#000347 - Threaded Insert

| OP # | PROCESS DESCRIPTION                                        | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity Piece/M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages \$ | Material Handling | Comments                                             |
|------|------------------------------------------------------------|---------------------|-------|---------|-----|-------------|------------------|--------------------|----------------|----------------------|----------|------------|--------------|-------------------|------------------------------------------------------|
|      | Blank Material - Stamping<br>Gaging (Vendor and Remington) |                     |       |         |     | \$ 0.006    | 20               |                    | 0.001          |                      |          |            | \$ 200.00    |                   | Precision Fasteners<br>Estimated Quote: Jerry Helmer |
|      | Totals                                                     |                     |       |         |     | \$ 0.006    | 20               |                    | 0.001000       |                      |          |            | \$ 200.00    |                   |                                                      |

ME0125

#00333 - Side Panel

| QTY    | PROCESS DESCRIPTION                                           | MACHINE DESCRIPTION | Part | Part # | Rev | Material | Quantity | Engineering Charge | Std. Run Hours | Variable Overhead | Prep | Capital | PTT Charges | Material Handling | Comments                                       |
|--------|---------------------------------------------------------------|---------------------|------|--------|-----|----------|----------|--------------------|----------------|-------------------|------|---------|-------------|-------------------|------------------------------------------------|
| 10     | Blank Material - Stamping<br>Coating (Crescent and Remington) |                     |      |        |     | Steel    | 20       |                    |                |                   |      |         | \$ 1,500.00 |                   | Material Data<br>Estimated Quote: Jerry Helmer |
|        | Black Oxide Coater                                            |                     |      |        |     |          |          |                    | 0.001          |                   |      |         |             |                   |                                                |
| Totals |                                                               |                     |      |        |     |          |          |                    |                |                   |      |         |             |                   | \$ 1,500.00                                    |

TIG Complete 1

MF0126

#300328 - Side Plate Pin

| OP #   | PROCESS DESCRIPTION                                          | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity Price/M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages \$ | Material Handling | Comments     |
|--------|--------------------------------------------------------------|---------------------|-------|---------|-----|-------------|------------------|--------------------|----------------|----------------------|----------|------------|--------------|-------------------|--------------|
|        | Blank Material - Screw Machine Gaging (vendor and Remington) |                     |       |         |     | \$ 0.080    | 60.00            | \$ 225.00          |                |                      |          |            | \$ -         |                   | Isel--Quote: |
| 10     | Black Oxide Color                                            |                     |       |         |     |             |                  |                    | 0.001000       | \$ -                 | \$ -     | \$ -       | \$ -         | \$ -              |              |
| Totals |                                                              |                     |       |         |     | \$ 0.080    | 60.00            | \$ 225.00          | 0.001000       | \$ -                 | \$ -     | \$ -       | \$ -         | \$ -              |              |

Note: Quoted in C12L14 material  
Quoted with .010" max. cornerbreaks unless noted.

ME0127

#15666 - Bear Safety Cam

| OP # | PROCESS DESCRIPTION                                                   | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Prep \$ | Capital \$   | PPI Gages \$ | Material Handling | Comments                                                       |
|------|-----------------------------------------------------------------------|---------------------|-------|---------|-----|-------------|------------|--------------------|----------------|----------------------|---------|--------------|--------------|-------------------|----------------------------------------------------------------|
|      | Blank Material - PM Parts<br>Gaging (vendor and Remington)<br>Tooling |                     |       |         |     | \$ 0.00     | 20         |                    |                |                      |         | \$ 11,300.00 | \$ 3,000.00  |                   | Sterling Sintered Tech. Inc. - Quote: 8/24/99<br>None Supplied |
|      |                                                                       | Totals              |       |         |     | \$ 0.00     | 20         |                    |                | \$ -                 | \$ -    | \$ 11,300.00 | \$ 3,000.00  | \$ -              |                                                                |

Note: Tooling samples will be shipped 12 wks. ARO  
Production to follow tool approval by 6-8 weeks unless customer accepts responsibility for production, given that it meets the print

ME0128

#800351 - Prod Pn

| OP #   | PROCESS DESCRIPTION                                               | MACHINE DESCRIPTION | Part # | Print # | Rev | Material  | Quantity | Engineering Charge | Std. Run Hours | Variable Overhead | Freep | Capital | PPI Cages | Material Handling | Comments                                                                     |
|--------|-------------------------------------------------------------------|---------------------|--------|---------|-----|-----------|----------|--------------------|----------------|-------------------|-------|---------|-----------|-------------------|------------------------------------------------------------------------------|
|        | Blank Material - Screw Machine<br>(casing (Vendor and Remington)) |                     |        |         |     | \$ 450.00 | 60.00    | \$ 450.00          |                |                   |       |         |           |                   | Automatic Swiss Corporation, Quote: 8/20/99<br>Estimated Quote: Jerry Benner |
| Totals |                                                                   |                     |        |         |     |           |          |                    |                |                   |       |         |           |                   |                                                                              |

Note: Quoted in CTELL material

710 Complete 1

MF0129

| OP # | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages \$ | Material Handling | Comments     |
|------|---------------------|---------------------|-------|---------|-----|-------------|------------|--------------------|----------------|----------------------|----------|------------|--------------|-------------------|--------------|
|      | Material--Springs   |                     |       |         |     | \$ 0.023    | 20         |                    |                |                      |          |            |              |                   | Illion Quote |
|      | Totals              |                     |       |         |     | \$ 0.023    | 20         |                    |                |                      |          |            |              |                   |              |

85

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Confidential - Subpoena Order  
~~Subpoena Order~~  
 5.2.2.0600000000  
 Williams v. Remington

ME0130

#1528C - Trigger

| OP # | PROCESS DESCRIPTION             | MACHINE DESCRIPTION | Part# | Print # | Rev | Material | Quantity | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$   | PPI Gages \$ | Material Handling | Comments                                                                                                           |
|------|---------------------------------|---------------------|-------|---------|-----|----------|----------|--------------------|----------------|----------------------|----------|--------------|--------------|-------------------|--------------------------------------------------------------------------------------------------------------------|
|      | Material-PM Parts Tooling Gages |                     |       |         |     | \$ 0.377 | 20       |                    |                |                      |          | \$ 15,225.00 | \$ 3,000.00  |                   | Sterling Sintered Tech. Inc.--Quoted 9/03/99<br>Based on no Serrations on Trigger<br>Estimated Quote: Jerry Helmer |
| 10   | Black Oxide Color               |                     |       |         |     |          |          |                    | 0.001000       |                      |          |              |              |                   |                                                                                                                    |
|      | Totals                          |                     |       |         |     | \$ 0.377 | 20       |                    | 0.001000       |                      |          | \$ 15,225.00 | \$ 3,000.00  |                   |                                                                                                                    |

710 Complete 1

ME0131

#19461 - Trigger Connector

| OP # | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part# | Print # | Rev | Material | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages \$ | Material Handling | Comments                                        |
|------|---------------------|---------------------|-------|---------|-----|----------|----------------|----------------------|----------|------------|--------------|-------------------|-------------------------------------------------|
|      | Gages               |                     |       |         |     | \$ 1.51  |                |                      |          |            | \$ 3,000.00  |                   | Ilion Supplied<br>Estimated Quote: Jerry Helmer |
|      |                     | Totals              |       |         |     | \$ 1.51  |                |                      |          |            | \$ 3,000.00  |                   |                                                 |

710 Complete 1

ME01332

#17053 - Trigger Screw Front

| PROCESS<br>OP # | MACHINE<br>DESCRIPTION      | Part# | Print # | Rev | Material<br>\$ | Quantity<br>M | Engineering<br>Charge | Std. Run<br>Hours | Variable<br>Overhead<br>\$ | Preop<br>\$ | Capital<br>\$ | PPI Gages<br>\$ | Material<br>Handling | Comments                                                  |
|-----------------|-----------------------------|-------|---------|-----|----------------|---------------|-----------------------|-------------------|----------------------------|-------------|---------------|-----------------|----------------------|-----------------------------------------------------------|
|                 | Material-Fasteners<br>Gages |       |         |     | \$ 0.040       | 20.0          |                       |                   |                            |             |               | \$ 300.00       |                      | Fastenal--Quote: 8/19/99<br>Estimated Quote: Jerry Helmer |
| Totals          |                             |       |         |     | \$ 0.040       | 20.0          |                       | 0.000000          |                            |             |               | \$ 300.00       |                      |                                                           |

710 Complete 1

ME0133

#91128 - Trigger Engage. Screw

| OP #   | PROCESS DESCRIPTION         | MACHINE DESCRIPTION | Part# | Print # | Res | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages \$ | Material Handling | Comments                                         |
|--------|-----------------------------|---------------------|-------|---------|-----|-------------|------------|--------------------|----------------|----------------------|----------|------------|--------------|-------------------|--------------------------------------------------|
|        | Material-Fasteners<br>Gages |                     |       |         |     | \$ 0.027    | 0.10       |                    |                |                      |          |            | \$ 300.00    |                   | Ilbon Quote SAP<br>Estimated Quote: Jerry Helmer |
| Totals |                             |                     |       |         |     | \$ 0.027    | 0.10       |                    |                |                      |          |            | \$ 300.00    |                   |                                                  |

710 Complete 1

ME0134

#15400 - Trigger Spring

| OF # | PROCESS<br>DESCRIPTION | MACHINE<br>DESCRIPTION | Part# | Print # | Rev | Material<br>\$ | Quantity<br>M | Engineering<br>Charge | Std. Run<br>Hours | Variable<br>Overhead<br>\$ | Preop<br>\$ | Capital<br>\$ | PPI Gages<br>\$ | Material<br>Handling | Comments        |
|------|------------------------|------------------------|-------|---------|-----|----------------|---------------|-----------------------|-------------------|----------------------------|-------------|---------------|-----------------|----------------------|-----------------|
|      | Cages                  |                        |       |         |     |                | 20            |                       |                   |                            |             |               |                 | 0                    | Ilion Quote SAP |
|      | Totals                 |                        |       |         |     | \$ 0.9295      | 20            |                       |                   |                            |             |               |                 |                      |                 |

ME0135

#15481 - Trigger Stop Screw

| QTY    | PROCESS DESCRIPTION       | MACHINE DESCRIPTION | Part # | Print # | Rev | Material   | Quantity | Engineering Charge | Std. Run Hours | Variable Overhead | Prep | Capital | FPI Gages | Material Handling | Comments                                                         |
|--------|---------------------------|---------------------|--------|---------|-----|------------|----------|--------------------|----------------|-------------------|------|---------|-----------|-------------------|------------------------------------------------------------------|
|        | Material - Screw<br>Chips |                     |        |         |     | \$ 839.042 | 20.00    |                    |                |                   |      |         | \$ 300.00 |                   | Feasibility Quote: Jerry Helmer<br>Estimated Quote: Jerry Helmer |
| Totals |                           |                     |        |         |     |            |          |                    |                |                   |      |         |           |                   |                                                                  |
|        |                           |                     |        |         |     | \$ 0.042   | 20       |                    |                |                   |      |         | \$ 300.00 |                   |                                                                  |

710 Complete 1

MF0136

#509428 - Safety Arm

| OP # | PROCESS DESCRIPTION                                          | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Prep \$ | Capital \$   | PPI Gages \$ | Material Handling | Comments                                                                |
|------|--------------------------------------------------------------|---------------------|-------|---------|-----|-------------|----------|--------------------|----------------|----------------------|---------|--------------|--------------|-------------------|-------------------------------------------------------------------------|
|      | Blank Material                                               |                     |       |         |     | 0.230       | 1        |                    |                |                      |         |              |              |                   |                                                                         |
| 10   | Gaging(vendor and Remington)<br>Tooling<br>Vendor Head Treat |                     |       |         |     |             |          |                    |                |                      |         | \$ 25,552.00 | \$ 2,400.00  |                   | New Hampshire Stamping--Quote: 9/28/99<br>Estimated Quote: Jerry Helmer |
| 20   | Black Oxide Color                                            |                     |       |         |     |             |          |                    | 0.001000       |                      |         |              |              |                   |                                                                         |
|      | Totals                                                       |                     |       |         |     | \$ 0.230    | 1        |                    | 0.001000       |                      |         | \$ 25,552.00 | \$ 2,400.00  |                   |                                                                         |

Note: Production delivery will take two weeks. 1 week for delivery of first quality acceptance sample.  
1 week for delivery of sample approval. 18 weeks total

710 Compliance

ME0137

Confidential - ~~Submittal~~ - \$22,060.00 for Order  
Williams V. Remington

#300407 - Safety Detent Spring

| OP # | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments                             |
|------|---------------------|---------------------|-------|---------|-----|-------------|------------|--------------------|----------------|----------------------|----------|------------|-------------------|--------------------------------------|
|      | Material-Spring     |                     |       |         |     | \$ 0.058    | 20         |                    |                |                      |          |            |                   | Midstate Spring Inc.--Quote: 9/23/99 |
|      | 10 Black Oxide      |                     |       |         |     |             |            |                    | 0.001000       |                      |          |            |                   |                                      |
|      | Totals              |                     |       |         |     | \$ 0.058    | 20         |                    | 0.001000       |                      |          |            |                   |                                      |

710 Complete 1

ME0138

Confidential - ~~Subcontract~~ - \$22,060,000 Order  
Williams v. Remington

#300420 - Lock Tumbler

| OP #   | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments |
|--------|---------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|----------|
| 10     | Wash                |                     |       |         |     |             |                |                      |          |            |                   |          |
| 20     | Black Oxide         |                     |       |         |     |             |                |                      |          |            |                   |          |
| 30     | Paint               |                     |       |         |     |             |                |                      |          |            |                   |          |
| Totals |                     |                     |       |         |     |             |                |                      |          |            |                   |          |

ME0139

#xxx - Lock Detent

| OP #   | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part# | Print # | Res | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments |
|--------|---------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|----------|
|        |                     |                     |       |         |     |             |                |                      |          |            |                   |          |
| Totals |                     |                     |       |         |     |             |                |                      |          |            |                   |          |

710 Complete 1

ME0140

0.140 20 225.00 \$ - \$

83

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#17044 - Safety Snap Washer

| OP # | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages \$ | Material Handling | Comments                                        |
|------|---------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|--------------|-------------------|-------------------------------------------------|
|      | GAGES               |                     |       |         |     | \$ 0.02     |                |                      |          |            | \$ 120.00    |                   | Iron Quote SAP<br>Estimated Quote: Jerry Helmer |
|      |                     | Totals              |       |         |     | \$ 0.02     |                |                      |          |            | \$ 120.00    |                   |                                                 |

ME0142

#300345 - Bolt Stop

| OP #   | PROCESS DESCRIPTION   | MACHINE DESCRIPTION | Part# | Print # | Qty | Material \$ | Quantity | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$  | Wages \$    | Material Handling | Comments                                     |
|--------|-----------------------|---------------------|-------|---------|-----|-------------|----------|--------------------|----------------|----------------------|----------|-------------|-------------|-------------------|----------------------------------------------|
|        | Blank Material - FMPD |                     |       |         |     | \$ 0.219    | 20       |                    |                |                      |          | \$ 6,820.30 | \$ 1,500.00 |                   | Sterling Sintered Tech, Inc...Quote: 8/12/99 |
|        | Tools                 |                     |       |         |     |             |          |                    |                |                      |          |             |             |                   | Estimated Quote: Jerry Helmer                |
|        | Gages                 |                     |       |         |     |             |          |                    |                |                      |          |             |             |                   |                                              |
| 10     | Vendev Heat Treat     |                     |       |         |     |             |          |                    |                |                      |          |             |             |                   |                                              |
| 20     | Black Oxide Color     |                     |       |         |     |             |          |                    | 0.001000       |                      |          |             |             |                   |                                              |
| Totals |                       |                     |       |         |     | \$ 0.219    | 20       |                    | 0.001          | \$                   | \$       | \$ 6,820.00 | \$ 1,500.00 | \$                |                                              |

Note:  
 .060 step instead of .125  
 .015 flat at the .050 radius

710 Complete 1

83

ME0143

Confidential - ~~Submittal~~ - 5.22.06r0010093 Order  
 Williams V. Remington

#17034 - Receiver Plug Screw

| OP # | PROCESS DESCRIPTION                                                   | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages \$ | Material Handling | Comments      |
|------|-----------------------------------------------------------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|--------------|-------------------|---------------|
|      | Blank Material - Stamping<br>Gaging (Vendor and Remington)<br>Tooling |                     |       |         |     | \$ 0.03     |                |                      |          |            |              |                   | Non Quote SAP |
|      |                                                                       | Totals              |       |         |     | \$ 0.03     | 0.000000       | \$ -                 | \$ -     | \$ -       | \$ -         | \$ -              |               |

710 Complete 1

83

ME0144

#300361 - Recoil Bracket

| OP #   | PROCESS DESCRIPTION       | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity Piece/M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments                         |
|--------|---------------------------|---------------------|-------|---------|-----|-------------|------------------|--------------------|----------------|----------------------|----------|------------|-------------------|----------------------------------|
|        | Blank Material - Stamping |                     |       |         |     | 0.123       | 20               | \$ 550.00          |                |                      |          |            |                   | Square Stamping Quote Aug 11, 99 |
| 10     | Black Oxide Color         |                     |       |         |     |             |                  |                    | 0.001600       | \$ -                 | \$ -     | \$ -       | \$ -              |                                  |
| Totals |                           |                     |       |         |     | \$ 0.123    | 20               | \$ 550.00          | 0.001          | \$ -                 | \$ -     | \$ -       | \$ -              |                                  |

Note: Above quote is to be made from C1008 steel, .187" + or - .003 thickness

ME0145

#XXX - Bolt Assy. Complete

| OP #   | PROCESS DESCRIPTION                                        | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments |
|--------|------------------------------------------------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|----------|
| 10     | Blank Material - Stamping<br>Gaging (Vendor and Remington) |                     |       |         |     |             |                |                      |          |            | \$ -              |          |
| Totals |                                                            |                     |       |         |     | \$ - 0      |                | \$ -                 | \$ -     | \$ -       | \$ -              |          |

710 Complete 1

ME0146

#300403 - Bolt Body Assembly

| OP #                                               | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments |
|----------------------------------------------------|---------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|----------|
| <div> <div>83</div> <div>CONFIDENTIAL</div> </div> |                     |                     |       |         |     |             |                |                      |          |            |                   |          |
| Totals                                             |                     |                     |       |         |     |             | 1.0            | \$ -                 | \$ -     | \$ -       | \$ -              |          |

710 Complete 1

ME0147

#000339 - Bolt Body

| OP #   | PROCESS DESCRIPTION                       | MACHINE DESCRIPTION | Part # | Print # | REV | Material \$ | Std. Run Hours | Variable Tool | Preop \$    | Capital      | Material Handling | Comments                                              |
|--------|-------------------------------------------|---------------------|--------|---------|-----|-------------|----------------|---------------|-------------|--------------|-------------------|-------------------------------------------------------|
| 10     | Machine Complete from Bar Stock           |                     |        |         |     | \$ 0.740    | 0.032648       | \$0.29        | \$5,568.76  | \$4,579.95   |                   | Operation 10 Detail - Bolt Body Machine               |
| 20     | Wash                                      |                     |        |         |     | \$ -        | 0.001030       |               | \$0.00      | \$0.00       |                   | Operation 20 Detail - Bolt Body Wash                  |
| 30     | Assemble & Braze Bolt Handle to Bolt Body |                     |        |         |     | \$ -        | 0.017500       | \$0.01        | \$0.00      | \$94,693.36  |                   | Operation 30 Detail - Bolt Body Assy. & Braze Bolt... |
| 40     | Deplete & Wash                            |                     |        |         |     | \$ -        | 0.002000       | \$0.07        | \$660.00    | \$10,500.00  |                   | Operation 40 Detail - Bolt Body Deplete & Wash        |
| 50     | Glass Bead Bolt Body                      |                     |        |         |     | \$ -        | 0.005556       | \$0.00        | \$252.00    | \$0.00       |                   | Operation 60 Detail - Bolt Body Glass Bead            |
| 60     | Black Oxide                               |                     |        |         |     | \$ -        | 0.002084       | \$0.00        | \$6,568.00  | \$0.00       |                   | Operation 70 Detail - Bolt Body Black Oxide           |
| TOTALS |                                           |                     |        |         |     | \$ 0.740    | 0.055787       | \$0.37        | \$15,048.76 | \$109,773.31 | 0.00              |                                                       |

Note:  
Prices are material and labor only

710 Complete 1

ME0148

Confidential - Subject - 5.22.06r0010098 Order  
Williams V. Remington

710 Complete !

Confidential - Subject to Protective Order  
BARBER - 5.22.06/0010099  
Williams v. Remington

#300360 - Bot Handle Blank

| OP # | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages   | Material Handling | Comments                      |
|------|---------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------|-------------------|-------------------------------|
|      | Gages               |                     |       |         |     |             |                |                      |          |            | \$ 2,500.00 |                   | Estimated Quote: Jerry Helmer |
|      | Total               |                     |       |         |     |             |                |                      |          |            | \$ 2,500.00 |                   |                               |

7:0 Complete 1

ME0150

#300329 - Bot Handle Pin

| OP #   | PROCESS DESCRIPTION                                     | MACHINE DESCRIPTION          | Part# | Print # | Rev | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments                                    |
|--------|---------------------------------------------------------|------------------------------|-------|---------|-----|-------------|------------|--------------------|----------------|----------------------|----------|------------|-------------------|---------------------------------------------|
|        | Blank Material - Stamping Gaging (Vendor and Remington) |                              |       |         |     | 0.100       | 20         | \$ 450.00          |                |                      |          |            |                   | Automatic Swiss Corporation--Quote: 8/20/99 |
| 10     | Inspection.                                             | Fixture Comparator w/ Screen |       |         |     |             |            |                    |                |                      |          |            |                   |                                             |
| Totals |                                                         |                              |       |         |     | \$ 0.100    | 20         | \$ 450.00          |                | \$0.00               | \$0.00   | \$0.00     | \$0.00            |                                             |

710 Complete 1

ME0151

| PROCESS |             | MACHINE     | Part# | Print # | Rev | Material | Std. Run | Variable | Preop | Capital | Material | Comments |
|---------|-------------|-------------|-------|---------|-----|----------|----------|----------|-------|---------|----------|----------|
| OP #    | DESCRIPTION | DESCRIPTION |       |         |     | \$       | Hours    | Overhead | \$    | \$      | Handling |          |
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#30593 - Bolt Head Assy

| OP #   | PROCESS DESCRIPTION          | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments |
|--------|------------------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|----------|
| 10     | Assemble Rivetless Extractor |                     |       |         |     | \$ -        | 0.00692        | \$ -                 | \$ -     | \$ -       | \$ -              |          |
| 20     | Assemble Ejector             |                     |       |         |     | \$ -        | 0.0083         | \$ -                 | \$ -     | \$ -       | \$ -              |          |
| Totals |                              |                     |       |         |     | \$0.00      | 0.01522        | \$0.00               | \$0.00   | \$0.00     | \$0.00            |          |

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4/22/06 - 10:40:43

| OP # | PROCESS DESCRIPTION                                      | MACHINE DESCRIPTION | Part# | Print # | Material \$ | Internal Processing \$ | Std. Run Hours | Variable Overhead \$ | Prep \$  | Capital \$ | PFI Gages \$ | Material Handling | Comments                                                      |
|------|----------------------------------------------------------|---------------------|-------|---------|-------------|------------------------|----------------|----------------------|----------|------------|--------------|-------------------|---------------------------------------------------------------|
|      | Blank Material Gages                                     |                     |       |         | see op. 10  |                        |                |                      |          |            |              |                   | Parker & Harper Mfg. Company<br>Estimated Quote: Jerry Helmer |
| 10   | CNC Machine Bolt Face Complete                           |                     |       |         | \$1.75      | 0.019814               | 0.257593       | \$                   | 2,491.94 | \$173,922  |              |                   | Operation 10 Detail - Bolt Head CNC Machine ...               |
| 20   | Superabrasive Grind Laps                                 |                     |       |         | \$0.00      | 0.018865692            | 0.393750       | \$                   | \$315    |            |              | \$39,500          | Operation 20 Detail - Bolt Head Superabrasive ...             |
| 30   | CNC Machine Bolt Head Retaining Pin Hole                 |                     |       |         | \$0.00      | 0.017562428            | 0.036875       | \$                   | 1,085.95 |            |              | \$19,500          | Operation 30 Detail Bolt Head Retaining Pin Hole              |
| 40   | CNC Machine Cam Lins, Ejector Retaining Pin Hole, Deburr |                     |       |         | \$0.00      | 0.017240               | 0.251875       | \$                   | 1,706.78 |            |              |                   | Operation 40 Detail - Bolt Head Ejector.....                  |
|      |                                                          |                     |       |         | \$0.00      | 0.0006380              |                | \$                   | 0.01     | \$         | 100.00       | \$28,000          |                                                               |
| 50   | Punch Form Extractor Rotation Notch                      |                     |       |         | \$0.00      |                        |                |                      |          |            |              | \$10,766          | Operation 50 Detail - Bolt Head Punch...                      |
| 60   | Vendor Heat Treat & Inspect for Hardness                 |                     |       |         | \$0.00      | \$1.60                 | 0.000370333    | \$                   | -        | \$         |              | \$0               | Operation 60 Detail - Bolt Head Vendor...                     |
| 70   | Black Oxide                                              |                     |       |         | \$0.00      |                        |                | \$                   | 0.00     |            |              | \$0               |                                                               |
|      | Totals                                                   |                     |       |         | \$ 1.75     | 0.072278420            | 0.701278420    | \$                   | 5,697.69 | \$         | 271,698.48   | \$ 120.00         |                                                               |

710 Complete 1

83

ME0154

#93712 - Extractor

| OP #  | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part# | Print # | Rev | Material | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | FPI Gages \$ | Material Handling | Comments                                         |
|-------|---------------------|---------------------|-------|---------|-----|----------|----------------|----------------------|----------|------------|--------------|-------------------|--------------------------------------------------|
|       | Gages               |                     |       |         |     | \$ 0.77  |                |                      |          |            | \$ 3,300.00  |                   | Ilion Quote SAP<br>Estimated Quote: Jerry Helmer |
| Total |                     |                     |       |         |     | \$ 0.77  |                |                      |          |            |              |                   |                                                  |

710 Complete 1

ME0155

#00142 - Fjeller

| OP #  | PROCESS DESCRIPTION                                               | MACHINE DESCRIPTION | Part # | Rev | Material | Quantity | Engineering Charge | Std. Run Hours | Variable Overhead | Freep | Capital | PFI Gages   | Material Handling | Comments                                             |
|-------|-------------------------------------------------------------------|---------------------|--------|-----|----------|----------|--------------------|----------------|-------------------|-------|---------|-------------|-------------------|------------------------------------------------------|
|       | Blank Material - Screw Machine<br>(Gaging (Vendor and Remington)) |                     |        |     | \$ 0.110 | 20       | \$ 400.00          | 0.001000       | \$ -              | \$ -  | \$ -    | \$ 3,000.00 |                   | Incls-Quote 8/25/99<br>Estimated Quote, Terry Helmer |
| Total |                                                                   |                     |        |     |          |          |                    |                |                   |       |         |             |                   |                                                      |

Note:  
Quoted in C1214 material  
Quoted with C10 max corners/threads unless noted

710 Complete 1

MF0156

#xxx- Ejector Spring

| OP #   | PROCESS DESCRIPTION            | MACHINE DESCRIPTION | Part# | Print # | Rev | Variable |          |             |          |          |       |         | Comments                              |
|--------|--------------------------------|---------------------|-------|---------|-----|----------|----------|-------------|----------|----------|-------|---------|---------------------------------------|
|        |                                |                     |       |         |     | Material | Quantity | Engineering | Std. Run | Overhead | Preop | Capital |                                       |
|        |                                |                     |       |         |     | \$       | M        | Charge      | Hours    | \$       | \$    | \$      |                                       |
|        | Blank Material - Screw Machine |                     |       |         |     | \$ 0.015 | 20       |             |          |          |       |         | Midstate Spring, Inc.--Quote, 8/20/99 |
|        | Gaging (vendor and Remington)  |                     |       |         |     |          |          |             |          |          |       |         |                                       |
| Totals |                                |                     |       |         |     | \$ 0.015 | 20       |             |          | \$ -     | \$ -  | \$ -    |                                       |

ME0157

#94555 - Ejector Pin

| OP #   | PROCESS<br>DESCRIPTION                                            | MACHINE<br>DESCRIPTION | Part# | Print # | Rev | Material | Quantity<br>M | Engineering<br>Charge | Std. Run<br>Hours | Variable<br>Overhead<br>\$ | Preop<br>\$ | Capital<br>\$ | Material<br>Handling | Comments       |
|--------|-------------------------------------------------------------------|------------------------|-------|---------|-----|----------|---------------|-----------------------|-------------------|----------------------------|-------------|---------------|----------------------|----------------|
|        | Blank Material - Screw Machine<br>(Gaging (vendor and Remington)) |                        |       |         |     | \$15.00  | 0.01          | 20                    |                   |                            |             |               |                      | Thon Quote SAP |
| Totals |                                                                   |                        |       |         |     | \$15.00  | 20            |                       | 0                 | \$                         | -           | \$            | -                    | \$             |

ME0158

#300330 - Bolt Assy Pin

| OP #   | PROCESS DESCRIPTION                                          | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments                                    |
|--------|--------------------------------------------------------------|---------------------|-------|---------|-----|-------------|------------|--------------------|----------------|----------------------|----------|------------|-------------------|---------------------------------------------|
|        | Blank Material - Screw Machine Gaging (vendor and Remington) |                     |       |         |     | \$ 0.150    | 20         | \$ 450.00          |                |                      |          |            |                   | Automatic Swiss Corporation--Quote: 8/20/99 |
| 10     | Black Oxide Color                                            |                     |       |         |     |             |            |                    | 0.000001       | \$ -                 | \$ -     | \$ -       | \$ -              |                                             |
| Totals |                                                              |                     |       |         |     | \$ 0.150    | 20         | \$ 450.00          | 0.000001       | \$0.00               | \$0.00   | \$0.00     | \$0.00            |                                             |

Note: Quoted in C12L14 material  
Quoted with .10" max. cornerbreaks unless noted.

710 Complete 1

83

MF0159

Confidential - ~~Submittal~~ - 5.22.06r0010109 Order  
Williams v. Remington

#300404 - Firing Pin Assembly

| OP #   | PROCESS DESCRIPTION                                                        | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments |
|--------|----------------------------------------------------------------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|----------|
| 10     | Assemble Firing Pin Tip to Firing Pin                                      |                     |       |         |     | \$ -        | 0.001109       | \$ -                 | \$ -     |            | \$ -              |          |
| 20     | Assemble Firing Pin Sub Assembly, Main Spring, Bolt Plug & Firing Pin Head |                     |       |         |     | \$ -        | 0.014515       | \$ -                 | \$ -     |            | \$ -              |          |
| Totals |                                                                            |                     |       |         |     | \$0.00      | 0.0156238      | \$0.00               | \$0.00   | \$0.00     | \$0.00            |          |

ME0160

#90048 - Bot Plug

| QTY #  | PROCESS DESCRIPTION | MACHINE DESCRIPTION | Part# | Prod # | Rev | Material \$ | Quantity M | Engineering Charge | Sid Run Hours | Variable Overhead \$ | Presp \$ | Capital \$   | FPI Gen \$ | Material Handling | Comments                                                      |
|--------|---------------------|---------------------|-------|--------|-----|-------------|------------|--------------------|---------------|----------------------|----------|--------------|------------|-------------------|---------------------------------------------------------------|
|        | Metal (Plastic)     |                     |       |        |     | \$ 0.315    | 20         |                    |               | \$ 0.00              | \$ 0.00  | \$ 34,000.00 | \$ 800.00  | \$ 0.00           | Sellers & Coe-Quote: 8/17/99<br>Estimated Quote: Jerry Hammer |
| Totals |                     |                     |       |        |     | \$ 0.315    | 20         |                    | 0             | \$ 0.00              | \$ 0.00  | \$ 34,000.00 | \$ 800.00  | \$ 0.00           |                                                               |

Note: Remington is to supply metal inserts.

710 Complete 1

83

MF0161

APPROX. B. & P. Cost Report

| OP #  | PROCESS<br>DESCRIPTION                                       | MACHINE<br>DESCRIPTION | Part# | Rev | Material | Quantity | Engineers | Std Run<br>Hours | Variable Overhead | Prep   | Capital | PFT Gages   | Material<br>Handling | Comments                                                                      |
|-------|--------------------------------------------------------------|------------------------|-------|-----|----------|----------|-----------|------------------|-------------------|--------|---------|-------------|----------------------|-------------------------------------------------------------------------------|
|       | Blank Mating Bore Machine<br>Opening (outside and Remington) |                        |       |     | \$ 0.00  | 20       | \$ 0.00   | 0.00             | \$0.00            | \$0.00 | \$0.00  | \$ 3,000.00 |                      | Seta Precision Machine, Inc. - Quote. 8/2/99<br>Estimated Quote. Jerry Helmer |
| Total |                                                              |                        |       |     |          |          |           |                  |                   |        |         |             |                      | \$0.00                                                                        |

710 Complete 1

MF0162

#300334 - Firing Pin

| OP # | PROCESS DESCRIPTION                                          | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity M | Engineering Charges | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages \$ | Material Handling | Comments                                              |
|------|--------------------------------------------------------------|---------------------|-------|---------|-----|-------------|------------|---------------------|----------------|----------------------|----------|------------|--------------|-------------------|-------------------------------------------------------|
|      | Blank Material - Screw Machine Gaging (Vendor and Remington) |                     |       |         |     | \$ 1.190    | 20         | \$ 400.00           |                |                      |          |            | \$ 200.00    |                   | Jestl-Quote: 8/16/99<br>Estimated Quote: Terry Helmer |
| 10   | Black Oxide Color                                            |                     |       |         |     |             |            |                     | 0.001000       | \$ -                 | \$ -     | \$ -       |              | \$ -              |                                                       |
|      | Totals                                                       |                     |       |         |     | \$ 1.190    |            | \$ 400.00           | 0.001          | \$0.00               | \$0.00   | \$0.00     | \$ 200.00    | \$0.00            |                                                       |

Note:

Note:  
Quote to altered drawing ( faxed on 8-10-99 by Matt Golemboski )  
Quote in C12L14 material  
Quoted with 10-24 reading 8-32.  
Quoted with heat treat and black oxide to be done by Remington  
Quoted with .015" max. cornerbreaks unless noted

ME0163

#300335 - Filing Pin Tip

| QTY    | PROCESS DESCRIPTION                                          | MACHINE DESCRIPTION | Part# | Print# | Rev | Material  | Quantity | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages \$ | Material Handling | Comments                                              |
|--------|--------------------------------------------------------------|---------------------|-------|--------|-----|-----------|----------|--------------------|----------------|----------------------|----------|------------|--------------|-------------------|-------------------------------------------------------|
|        | Blank Material - Screw Machine Gaging (vendor and Remington) |                     |       |        |     | \$ .00230 | 20       | \$ 225.00          |                |                      |          |            | \$ 3,300.00  |                   | Iseli-Quote: 8/16/99<br>Estimated Quote: Jerry Helmer |
| 10     | Heat Treat                                                   |                     |       |        |     | \$ .0020  |          |                    |                |                      |          |            |              |                   |                                                       |
| 20     | Black Oxide Color                                            |                     |       |        |     |           |          |                    | 0.001000       | \$ -                 | \$ -     | \$ -       |              | \$ -              |                                                       |
| Totals |                                                              |                     |       |        |     | \$ .00230 | 20       | \$ 225.00          | 0.001          | \$0.00               | \$0.00   | \$0.00     | \$3,300.00   | \$0.00            |                                                       |

Note: Quoted in altered drawing (faxed 8-10-95 by Matt Golemboski)  
 Quoted with 10-24 reading 8-32  
 Quoted with .143 +/- .002 diameter reading .141 +/- diameter  
 Quoted with heat treat and black oxide to be done by Remington  
 Quoted with .015" max. cut-off nub on threaded end.



#300339- Firing Pin Spring

| OP #   | PROCESS DESCRIPTION                                          | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Prep \$ | Capital \$ | Material Handling | Comments                         |
|--------|--------------------------------------------------------------|---------------------|-------|---------|-----|-------------|----------|--------------------|----------------|----------------------|---------|------------|-------------------|----------------------------------|
|        | Blank Material - Screw Machine Gaging (vendor and Remington) |                     |       |         |     | \$ 0.1008   | 20       |                    |                |                      |         |            |                   | Midstate Spring - Quote: 8/20/99 |
| 10     | Black Oxide Color                                            |                     |       |         |     | \$ 0.003000 |          |                    | 0.003000       | \$ -                 | \$ -    | \$ -       | \$ -              |                                  |
| Totals |                                                              |                     |       |         |     | \$0.1008    | 20       |                    | 0.003          | \$0.00               | \$0.00  | \$0.00     | \$0.00            |                                  |

ME0166

#XXX - Front Sight Assy.

| OP #   | PROCESS DESCRIPTION                                             | MACHINE DESCRIPTION | Part # | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments |
|--------|-----------------------------------------------------------------|---------------------|--------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|----------|
|        | Blank Material - Screw Machine<br>Gaging (vendor and Remington) |                     |        |         |     |             |                |                      |          |            |                   |          |
| 10     | Assem. Front sight to front sight ramp                          |                     |        |         |     |             |                |                      |          |            |                   |          |
| Totals |                                                                 |                     |        |         |     | \$0.00      | 0              | \$0.00               | \$0.00   | \$0.00     | \$0.00            |          |

ME0167

#94084 - Front Sight

| OP #   | PROCESS DESCRIPTION                                          | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments                                              |
|--------|--------------------------------------------------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|-------------------------------------------------------|
|        | Blank Material - Screw Machine Gaging (vendor and Remington) |                     |       |         |     | \$ .8068    |                |                      |          |            |                   | Ilion-Quote: Std. Avg: .8068, Latest revision 8/01/99 |
| 10     | Black Oxide Color                                            |                     |       |         |     | 0.0000      | 0.000000       | \$ -                 | \$ -     | \$ -       | \$ -              |                                                       |
| Totals |                                                              |                     |       |         |     | \$ 0.8068   | 0.0000         | \$0.00               | \$0.00   | \$0.00     | \$0.00            |                                                       |

710 Complete 1

ME0168

#84657 - Front Sight Ramp

| PROCESS<br>DESCRIPTION                                          | MACHINE<br>DESCRIPTION | Part# | Print # | Rev | Material  | Std. Run<br>Hours | Variable Overhead<br>\$ | Preop<br>\$ | Capital<br>\$ | PPI Gages<br>\$ | Material<br>Handling | Comments                                                           |
|-----------------------------------------------------------------|------------------------|-------|---------|-----|-----------|-------------------|-------------------------|-------------|---------------|-----------------|----------------------|--------------------------------------------------------------------|
| Blank Material - Screw Machine<br>Gaging (vendor and Remington) |                        |       |         |     | \$ 1.1877 |                   |                         |             |               | \$ 400.00       |                      | Ilion SAP-Quote: Last date 8/1/99<br>Estimated Quote: Jerry Helmer |
| 10 Black Oxide Color                                            |                        |       |         |     |           | 0.002000          | \$ -                    | \$ -        | \$ -          |                 | \$ -                 |                                                                    |
| Totals                                                          |                        |       |         |     | \$1.188   | 0.002             | \$0.00                  | \$0.00      | \$0.00        | \$400.00        | \$0.00               |                                                                    |

710 Complete 1

ME0169

#28505 - F. Sight Ramp Screws

| OP #   | PROCESS DESCRIPTION                                          | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments                                |
|--------|--------------------------------------------------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|-----------------------------------------|
|        | Blank Material - Screw Machine Gaging (Vendor and Remington) |                     |       |         |     | \$ 0.0398   |                |                      |          |            |                   | Mayfield Quote SAP latest change 8/1/99 |
| Totals |                                                              |                     |       |         |     | \$0.0398    | 0%             | \$0.00               | \$0.00   | \$0.00     | \$0.00            |                                         |

ME0170

#103146 - Rear Sight Assembly

| PROCESS<br>OP # DESCRIPTION                                     | MACHINE<br>DESCRIPTION | Part# | Print # | Rev | Material<br>\$ | Std. Run<br>Hours | Variable<br>Overhead<br>\$ | Preop<br>\$ | Capital<br>\$ | Material<br>Handling | Comments                             |
|-----------------------------------------------------------------|------------------------|-------|---------|-----|----------------|-------------------|----------------------------|-------------|---------------|----------------------|--------------------------------------|
| Blank Material - Screw Machine<br>Gaging (Vendor and Remington) |                        |       |         |     | \$3.28         | 0                 | \$0.00                     | \$0.00      | \$0.00        | \$0.00               | Ilion Quote SAP latest change 8/1/99 |
| Totals                                                          |                        |       |         |     | \$3.28         | 0                 | \$0.00                     | \$0.00      | \$0.00        | \$0.00               |                                      |

ME0171

#90906 - Elevation Screw

| OP #   | PROCESS DESCRIPTION                                             | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments         |
|--------|-----------------------------------------------------------------|---------------------|-------|---------|-----|-------------|------------|--------------------|----------------|----------------------|----------|------------|-------------------|------------------|
|        | Blank Material - Screw Machine<br>Gaging (vendor and Remington) |                     |       |         |     | \$ 0.024    | 20         |                    |                |                      |          |            |                   | Il: on Quote SAP |
| Totals |                                                                 |                     |       |         |     | \$ 0.024    | 20         |                    | 0              | \$0.00               | \$0.00   | \$0.00     | \$0.00            |                  |

ME0172

#94333 - Rear Sight Aperture

| OP #   | PROCESS DESCRIPTION                                          | MACHINE DESCRIPTION | Part# | Print# | Rev | Material    | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments                            |
|--------|--------------------------------------------------------------|---------------------|-------|--------|-----|-------------|----------------|----------------------|----------|------------|-------------------|-------------------------------------|
|        | Blank Material - Screw Machine Gaging (vendor and Remington) |                     |       |        |     | \$ 0.285    |                |                      |          |            |                   | May SAP Quote. 8/1/99 Latest change |
| 10     | Black Oxide Color                                            |                     |       |        |     | \$ 0.003000 |                | \$ -                 | \$ -     | \$ -       | \$ -              |                                     |
| Totals |                                                              |                     |       |        |     | \$ 0.285    | 0.003          | \$0.00               | \$0.00   | \$0.00     | \$0.00            |                                     |

ME0173

#103531 - Rear Sight Base

| OP #   | PROCESS DESCRIPTION            | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$   | Material Handling | Comments                |
|--------|--------------------------------|---------------------|-------|---------|-----|-------------|------------|--------------------|----------------|----------------------|----------|--------------|-------------------|-------------------------|
|        | Blank Material - Screw Machine |                     |       |         |     | \$ 1.017    | 80         |                    |                |                      |          |              |                   | Ilion SAP Quote: 8/1/99 |
|        | Gaging (vender and Remington)  |                     |       |         |     |             |            |                    |                |                      |          | \$ 15,000.00 |                   |                         |
|        | Tools                          |                     |       |         |     |             |            |                    |                |                      |          | \$ 2,500.00  |                   |                         |
|        | Fixtures                       |                     |       |         |     |             |            |                    |                |                      |          |              |                   |                         |
| 10     | Black Oxide Color              |                     |       |         |     |             |            |                    | 0.003900       |                      |          |              |                   |                         |
| Totals |                                |                     |       |         |     | \$ 1.017    | 80         |                    | 0.003          | \$0.00               | \$0.00   | \$17,500.00  | \$0.00            |                         |

ME0174

#94355 - Rear Sight Slide

| OP #   | PROCESS DESCRIPTION                                                        | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$                  | Material Handling | Comments                          |
|--------|----------------------------------------------------------------------------|---------------------|-------|---------|-----|-------------|----------|--------------------|----------------|----------------------|----------|-----------------------------|-------------------|-----------------------------------|
|        | Blank Material - Screw Machine Gaging (Vendor and Remington) Tools Fixture |                     |       |         |     | 1.200       | 80       |                    |                |                      |          | \$ 15,000.00<br>\$ 2,500.00 |                   | Megamet Industries-Quote: 9/13/99 |
| 10     | Drill and Tap                                                              |                     |       |         |     |             |          |                    |                |                      |          |                             |                   |                                   |
| 20     | Black Oxide Color                                                          |                     |       |         |     |             |          |                    | 0.001000       |                      |          |                             |                   |                                   |
| Totals |                                                                            |                     |       |         |     | \$ 1.200    | 80       |                    | 0.001          | \$0.00               | \$0.00   | \$17,500.00                 | \$0.00            |                                   |

ME0175

#00004 - Windage Screw

| QTY #  | PROCESS DESCRIPTION                                            | MACHINE DESCRIPTION | Part # | Print # | Rev # | Material \$ | Quantity | Engineering Charge \$ | Std. Run Hours | Variable Overhead \$ | Prep \$ | Capital \$ | Material Handling | Comments                                      |
|--------|----------------------------------------------------------------|---------------------|--------|---------|-------|-------------|----------|-----------------------|----------------|----------------------|---------|------------|-------------------|-----------------------------------------------|
|        | Blank Material - Screw Machine (gaging (Vendor and Remington)) |                     |        |         |       | \$ 0.191    | 25       | \$ 410.00             |                |                      |         |            |                   | Swiss Precision Machine Inc. - Quote: 8/29/99 |
| Totals |                                                                |                     |        |         |       |             |          |                       |                |                      |         |            |                   |                                               |
|        |                                                                |                     |        |         |       | \$ 0.191    | 25       | \$ 410.00             |                | \$ 0.00              | \$ 0.00 | \$ 0.00    | \$ 0.00           |                                               |

710 Complete 1

MF0176

#28505 - Rear Sight Base Screws

| OP #   | PROCESS<br>DESCRIPTION                                          | MACHINE<br>DESCRIPTION | Part# | Print # | Rev | Material<br>\$ | Std. Run<br>Hours | Variable<br>Overhead<br>\$ | Preop<br>\$ | Capital<br>\$ | Material<br>Handling | Comments                            |
|--------|-----------------------------------------------------------------|------------------------|-------|---------|-----|----------------|-------------------|----------------------------|-------------|---------------|----------------------|-------------------------------------|
|        | Blank Material - Screw Machine<br>Gaging (vender and Remington) |                        |       |         |     | \$ 0.04        |                   |                            |             |               |                      | May SAP Quote: 8/1/99 latest charge |
| Totals |                                                                 |                        |       |         |     | \$0.04         | 0                 | \$0.00                     | \$0.00      | \$0.00        | \$0.00               |                                     |

ME0177

#xxx - Stock Assy. Complete

| OP #   | PROCESS DESCRIPTION                                                                          | MACHINE DESCRIPTION | Part # | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments |
|--------|----------------------------------------------------------------------------------------------|---------------------|--------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|----------|
| 10     | Blank Material - Screw Machine Gaging (vender and Remington)<br>Assemble butt plate to stock |                     |        |         |     |             | 0.016000       |                      |          |            |                   |          |
| Totals |                                                                                              |                     |        |         |     | \$0.00      | 0.016          | \$0.00               | \$0.00   | \$0.00     | \$0.00            |          |

710 Complete 1

ME0178

#xxx - Stock Assy.

| OP #   | PROCESS<br>DESCRIPTION                                          | MACHINE<br>DESCRIPTION | Part# | Print# | Rev | Material<br>\$ | Std. Run<br>Hours | Variable<br>Overhead<br>\$ | Preop<br>\$ | Capital<br>\$ | Material<br>Handling | Comments |
|--------|-----------------------------------------------------------------|------------------------|-------|--------|-----|----------------|-------------------|----------------------------|-------------|---------------|----------------------|----------|
|        | Blank Material - Screw Machine<br>Gaging (vendor and Remington) |                        |       |        |     | \$ 0.30        |                   |                            |             |               |                      |          |
| Totals |                                                                 |                        |       |        |     | \$0.30         | 0                 | \$0.00                     | \$0.00      | \$0.00        | \$0.00               |          |

MOCK - Stock

| OP #   | PROCESS DESCRIPTION                            | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preup \$ | Capital \$    | PFI Gages \$ | Material Handling | Comments                           |
|--------|------------------------------------------------|---------------------|-------|---------|-----|-------------|------------|--------------------|----------------|----------------------|----------|---------------|--------------|-------------------|------------------------------------|
|        | Material Plastic Gaging (Vendor and Remington) |                     |       |         |     | \$ 5.38     | 20         |                    |                |                      |          |               | \$ 4,500.00  |                   | Par 4 Plastics, Inc. Aug. 19, 1999 |
| 10     | Cavity Mold                                    | New Tooling         |       |         |     |             |            |                    |                |                      |          | \$ 150,300.00 |              |                   |                                    |
| Totals |                                                |                     |       |         |     | \$5.38      | 20         |                    | 0              | \$0.00               | \$0.00   | \$150,300.00  | \$4,500.00   | \$0.00            |                                    |

Note: Divider sleeves for the stock have been amortized over the first years production at a cost of \$.006 per sleeve

ME0180

#1561 - Front Screw Bushing

| OP #   | PROCESS DESCRIPTION                         | MACHINE DESCRIPTION | Part # | Print # | Rev | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Prep \$ | Capital \$ | Material Handling | Comments                            |
|--------|---------------------------------------------|---------------------|--------|---------|-----|-------------|------------|--------------------|----------------|----------------------|---------|------------|-------------------|-------------------------------------|
| 10     | Curry Mold<br>Gaging (Vendor and Remington) | New Tooling         |        |         |     | 0.1485      | 1.00       |                    | 0              | \$0.00               | \$0.00  | \$0.00     | \$0.00            | Ilion SAG Quote 8/19/99 heat charge |
| Totals |                                             |                     |        |         |     |             |            |                    |                |                      |         |            |                   |                                     |

710 Complete

MF0181

WCC - Middle Screw Bushing

| OP #   | PROCESS DESCRIPTION                                | MACHINE DESCRIPTION | Part# | Print # | Qty | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments |
|--------|----------------------------------------------------|---------------------|-------|---------|-----|-------------|------------|--------------------|----------------|----------------------|----------|------------|-------------------|----------|
|        | Material: Plastic<br>Caging (Vendor and Remington) |                     |       |         |     |             |            |                    |                |                      |          |            |                   |          |
| 10     | Cavity Mold                                        | New Tooling         |       |         |     |             |            |                    |                |                      |          |            |                   |          |
| Totals |                                                    |                     |       |         |     | \$0.00      | 0          |                    | 0              | \$0.00               | \$0.00   | \$0.00     | \$0.00            |          |

MF0182

[illegible]

MF0183

#93971 - Grip Cap

| OP #  | PROCESS DESCRIPTION                            | MACHINE DESCRIPTION | Part # | Print # | Rev | Material | Quantity | Engineering Charge | Std. Run Hours | Variable Overhead | Prep   | Capital | Material Handling | Comments                            |
|-------|------------------------------------------------|---------------------|--------|---------|-----|----------|----------|--------------------|----------------|-------------------|--------|---------|-------------------|-------------------------------------|
|       | Material Plastic Gaging (Vendor and Kenington) |                     |        |         |     | \$ 0.18  | 20       |                    |                | \$1.00            | \$0.00 | \$0.00  | \$0.00            | Item Quote SAE: 87199 latest change |
| 10    | Cavity Mold                                    | New Tooling         |        |         |     |          |          |                    |                |                   |        |         |                   |                                     |
| Total |                                                |                     |        |         |     |          |          |                    |                |                   |        |         |                   |                                     |

710 Complete 1

MF0184

4/10/03 Printed

| OP #   | PROCESS DESCRIPTION                                   | MACHINE DESCRIPTION | Part # | Part # | Material | Quantity | Engineering Change | Std. Run Hours | Variable Overhead | Prep | Capital | PFI Gage | Material Handling | Comments                                            |
|--------|-------------------------------------------------------|---------------------|--------|--------|----------|----------|--------------------|----------------|-------------------|------|---------|----------|-------------------|-----------------------------------------------------|
| 01     | Material Parts<br>(Output Transfer and Remanufacture) |                     |        |        |          | 1.01     |                    |                |                   |      |         | 1        | 400.00            | Run Qty: 500<br>Inventory: 0<br>Estimated Qty: 1000 |
| Total: |                                                       |                     |        |        |          |          |                    |                |                   |      |         |          |                   |                                                     |

1/0 Complete

83

MF0185

#97972 - Backer Plate

| OP # | PROCESS DESCRIPTION                            | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages \$ | Material Handling | Comments                                        |
|------|------------------------------------------------|---------------------|-------|---------|-----|-------------|------------|--------------------|----------------|----------------------|----------|------------|--------------|-------------------|-------------------------------------------------|
|      | Material-Plastic Gaging (vendor and Remington) |                     |       |         |     | \$ 0.39     | 0          |                    |                | \$0.00               | \$0.00   | \$0.00     | \$0.00       | \$0.00            | Then Quote SAP<br>Estimated Quote: Jerry Helmer |
|      |                                                | Totals              |       |         |     | \$0.39      | 0          |                    |                | \$0.00               | \$0.00   | \$0.00     | \$0.00       | \$0.00            |                                                 |

MF0186

| OP # | PROCESS DESCRIPTION                                | MACHINE DESCRIPTION | Part # | Print # | Rev | Material<br># | Quantity<br>Meters | Engineering<br>Charge | N/L Run<br>Hours | Variable Overhead<br>\$ | Fixed<br>\$ | Capital<br>\$ | Material<br>Handling | Comment      |
|------|----------------------------------------------------|---------------------|--------|---------|-----|---------------|--------------------|-----------------------|------------------|-------------------------|-------------|---------------|----------------------|--------------|
|      | Material Plastic<br>Chasing (welder and Remington) |                     |        |         |     | \$ .021       | 20                 |                       |                  |                         |             |               |                      | Baird-Quest: |
|      |                                                    |                     |        |         |     |               |                    |                       |                  |                         |             |               |                      |              |
|      |                                                    |                     |        |         |     |               | 20                 |                       |                  | 60.00                   | 180.00      | 53.00         | 10.00                |              |
|      |                                                    |                     |        |         |     |               |                    |                       |                  |                         |             |               |                      |              |
|      |                                                    |                     |        |         |     |               | 20                 |                       |                  | 60.00                   | 180.00      | 53.00         | 10.00                |              |

Fig. 2. Comparison of the results of the two methods.

Confidential - Subject to Protective Order  
BARBER - 5.22.06/0010157  
Williams v. Remington

# 300362 - Magazine Latch

| OP #   | PROCESS DESCRIPTION                            | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Quantity | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$   | Material Handling | Comments                     |
|--------|------------------------------------------------|---------------------|-------|---------|-----|-------------|----------|--------------------|----------------|----------------------|----------|--------------|-------------------|------------------------------|
|        | Material Plastic Gaging (vendor and Remington) |                     |       |         |     | 0.191       | 20       |                    |                |                      |          |              |                   | Kellems & Coe-Quote: 8/17/99 |
| 10     | Cavity Mold                                    | New Tooling         |       |         |     |             |          |                    |                |                      |          | \$ 39,000.00 |                   |                              |
| Totals |                                                |                     |       |         |     | \$ 0.191    | 20       |                    | 0              | \$0.00               | \$0.00   | \$39,000.00  | \$0.00            |                              |

TIC Complete 1

83

MF0188

172

100-443887-100

ALL INFORMATION CONTAINED  
HEREIN IS UNCLASSIFIED  
DATE 08-11-2010 BY 60322  
UCBAW/STP/STP

83

146 Complete 4

#300371 - Mag Latch Pivot Pin

| OP #          | PROCESS DESCRIPTION                                          | MACHINE DESCRIPTION | Part# | Print # | Res | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments              |
|---------------|--------------------------------------------------------------|---------------------|-------|---------|-----|-------------|------------|--------------------|----------------|----------------------|----------|------------|-------------------|-----------------------|
|               | Blank Material - Screw Machine Gaging (vendor and Remington) |                     |       |         |     | \$ 0.070    | 20         | \$ 225.00          |                |                      |          |            |                   | Iseli--Quote: 8/25/99 |
| 10            | Black Oxide Color                                            |                     |       |         |     | \$ -        |            |                    | 0.001000       | \$ -                 | \$ -     | \$ -       | \$ -              |                       |
| <b>Totals</b> |                                                              |                     |       |         |     | \$ 0.070    | 20         | \$ 225.00          | 0.001          | \$0.00               | \$0.00   | \$0.00     | \$0.00            |                       |

Note:  
Quoted in C12L14 material  
Quoted with .015" max. cornerbreaks unless noted

MF0190

#300096 - Sing Swivel Stud

| OP # | PROCESS DESCRIPTION                                          | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments            |
|------|--------------------------------------------------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|---------------------|
|      | Blank Material - Screw Machine Gaging (vendor and Remington) |                     |       |         |     | 0.14        |                |                      |          |            |                   | Quote A/U from M597 |
|      | Totals                                                       |                     |       |         |     | \$0.14      | 0              | \$0.00               | \$0.00   | \$0.00     | \$0.00            |                     |

MF0191

#000- Takedown Screws (2)

| OP #   | PROCESS DESCRIPTION                                             | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Set Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PFI Gages \$ | Material Handling | Comments                      |
|--------|-----------------------------------------------------------------|---------------------|-------|---------|-----|-------------|---------------|----------------------|----------|------------|--------------|-------------------|-------------------------------|
|        | Blank Material - Screw Machine<br>Gaging (vendor and Remington) |                     |       |         |     |             |               |                      |          |            | \$ 200.00    |                   | Estimated Quote: Jerry Halmer |
| Totals |                                                                 |                     |       |         |     | \$0.00      |               | \$0.00               | \$0.00   | \$0.00     | \$200.00     | \$0.00            |                               |

MF0192

#XXX - Rear Takedown Screw

| OP # | PROCESS DESCRIPTION                                          | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | PPI Gages \$ | Material Handling | Comments                      |
|------|--------------------------------------------------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|--------------|-------------------|-------------------------------|
|      | Blank Material - Screw Machine Gaging (vendor and Remington) |                     |       |         |     |             |                |                      |          |            | \$ 200.00    |                   | Estimated Quote: Jerry Holner |
|      |                                                              |                     |       |         |     | \$0.00      | 0.00           | \$0.00               | \$0.00   | \$0.00     | \$200.00     | \$0.00            |                               |
|      |                                                              | Total               |       |         |     | \$0.00      | 0.00           | \$0.00               | \$0.00   | \$0.00     | \$200.00     | \$0.00            |                               |

710 Complete 1

MF0193

#XXXX -Magazine Assy

| OP # | PROCESS DESCRIPTION   | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments |
|------|-----------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|----------|
| 10   | Assemble Magazine box |                     |       |         |     | \$ -        | 0.0083         | \$ -                 | \$ -     | \$ -       | \$ -              |          |
|      |                       | Totals              |       |         |     | \$ -        | 0.0083         | \$ -                 | \$ -     | \$ -       | \$ -              |          |

ME0194

#000333 - Magazine Box

| OP #   | PROCESS DESCRIPTION                                         | MACHINE DESCRIPTION | Part | Part # | Rev | Material Price | Quantity | Engineering Charge | Std Run Hours | Variable Overhead | Prop | Capital      | PPI Charges | Material Handling | Comments                                                 |
|--------|-------------------------------------------------------------|---------------------|------|--------|-----|----------------|----------|--------------------|---------------|-------------------|------|--------------|-------------|-------------------|----------------------------------------------------------|
|        | Blank Material - Stamping<br>Coating (Vendor and Remington) |                     |      |        |     | \$ 1.00        | 20       |                    |               |                   |      | \$ 80,000.00 | \$ 4,500.00 |                   | Brinits Quote 10/18/99<br>Estimated Quote - Jerry Helmer |
| 10     | Blank Oxide Color                                           |                     |      |        |     |                |          |                    | 0.001000      | \$ -              | \$ - | \$ -         | \$ -        | \$ -              |                                                          |
| Totals |                                                             |                     |      |        |     |                |          |                    |               |                   |      |              |             |                   |                                                          |
|        |                                                             |                     |      |        |     | \$ 2,000.00    | 20       |                    | 0.001000      | \$ -              | \$ - | \$ 80,000.00 | \$ 4,500.00 | \$ -              |                                                          |

718 Complete 1

MF0195

4331951 - Magnetic Cylinder

| OP #  | PROCESS DESCRIPTION                                                     | MACHINE DESCRIPTION | Part # | Rev | Material | Quantity | Engineering Charge | Std. Run Time | Variable Overhead | Prep | Capital      | PFI Gages   | Material Handling | Comments                                                              |
|-------|-------------------------------------------------------------------------|---------------------|--------|-----|----------|----------|--------------------|---------------|-------------------|------|--------------|-------------|-------------------|-----------------------------------------------------------------------|
|       | Blank Material - Stamping<br>Coating (Vendor and Remington)<br>Twilling |                     |        |     | \$ 1.00  | 0.003    |                    |               |                   |      | \$ 76,766.00 | \$ 3,000.00 |                   | Part 4 Plastics, Inc. - Quote 4/27/95<br>Estimate Quote: Jerry Reimer |
| Total |                                                                         |                     |        |     |          |          |                    |               |                   |      |              |             |                   |                                                                       |

716 Complete 1

83

MF0196

#300365 - Magazine Bottom

| OF #   | PROCESS DESCRIPTION                                               | MACHINE DESCRIPTION | Part # | Print # | Rev | Material \$ | Quantity M | Engineering Charge | Std. Run Hours | Variable Overhead \$ | Prep \$ | Capital \$ | Material Handling | Comments                             |
|--------|-------------------------------------------------------------------|---------------------|--------|---------|-----|-------------|------------|--------------------|----------------|----------------------|---------|------------|-------------------|--------------------------------------|
|        | Blank Mfg. - Sampling<br>Gaging (vender and Remington)<br>Tooling |                     |        |         |     | \$ 0.105    | 20         |                    | 0.000000       |                      |         |            |                   | Per 4 Plastics, Inc. - Quote \$27799 |
| Totals |                                                                   |                     |        |         |     |             |            |                    |                |                      |         |            |                   |                                      |

710 Complete 1

MF0197

#300405 - Magazine Spring

| OP # | PROCESS DESCRIPTION                                                   | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Sub. Rate Hour | Variable Overhead \$ | Preop \$ | Capital \$   | PPI Gages \$ | Material Handling | Comments                                                               |
|------|-----------------------------------------------------------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|--------------|--------------|-------------------|------------------------------------------------------------------------|
|      | Blank Material - Stamping<br>Gaging (verdor and Remington)<br>Tooling |                     |       |         |     | \$ 0.259    |                |                      |          | \$ 13,000.00 | \$ 3,000.00  |                   | North American Spring-Quote: 10/22/99<br>Estimated Quote: Jerry Holmer |
|      | Totals                                                                |                     |       |         |     | \$ 0.259    |                | \$ -                 | \$ -     | \$ 13,000.00 | \$ 3,000.00  | \$ -              |                                                                        |

Note:

The dimension tolerances will be difficult to maintain after heat treat. Therefore the part will require an expensive heat treating operation included in the above pricing.  
The other concern is that the solid height listed as .210 + or - .010 may not be achievable.

M710 - Assembly, Gallery, Pack

| OP #   | PROCESS DESCRIPTION         | MACHINE DESCRIPTION | Part# | Print # | Rev | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$ | Capital \$ | Material Handling | Comments |
|--------|-----------------------------|---------------------|-------|---------|-----|-------------|----------------|----------------------|----------|------------|-------------------|----------|
| 10     | Proof Test                  |                     |       |         |     | \$ 1.25     | 0.016046       | \$ -                 | \$ -     | \$ -       | \$ -              |          |
| 20     | Test & Target (10%)         | (5x\$.15)*10%       |       |         |     | \$ 0.10     | 0.031759       | \$ -                 | \$ -     | \$ -       | \$ -              |          |
| 30     | Inspect Heading & Sear Lift |                     |       |         |     | \$ -        | 0.019630       | \$ -                 | \$ -     | \$ -       | \$ -              |          |
| 40     | Inspect for Live AMMO       |                     |       |         |     | \$ -        | 0.004270       | \$ -                 | \$ -     | \$ -       | \$ -              |          |
| 50     | Final Inspection            |                     |       |         |     | \$ -        | 0.022370       | \$ -                 | \$ -     | \$ -       | \$ -              |          |
| 60     | Assemble Rear Swivel Screw  |                     |       |         |     | \$ -        | 0.004315       | \$ -                 | \$ -     | \$ -       | \$ -              |          |
| 65     | Laser Engrave               |                     |       |         |     |             | 0.000100       |                      |          |            |                   |          |
| 70     | Pack                        |                     |       |         |     | \$ -        | 0.019043       | \$ -                 | \$ -     | \$ -       | \$ -              |          |
| Totals |                             |                     |       |         |     | \$ 1.35     | 0.117533       | \$0.00               | \$0.00   | \$ -       | \$0.00            |          |

710 Complete 1

MF0199

Barber

CONFIDENTIAL 83

MF0200

#305315 - Barrel

| OP # | Op. # | PROCESS DESCRIPTION                                                                                                        | MACHINE DESCRIPTION | Part # | Print #  | REV | Material \$ | Std. Run Hours | Variable Overhead \$ | Preop \$    | Capital      | PPI Gages \$ | Material Handling | Comments                           |
|------|-------|----------------------------------------------------------------------------------------------------------------------------|---------------------|--------|----------|-----|-------------|----------------|----------------------|-------------|--------------|--------------|-------------------|------------------------------------|
|      |       | Material (Blank 94523)                                                                                                     |                     | 305315 | E-305315 | 1   |             |                |                      |             |              |              |                   |                                    |
| 10   | 10    | Cut to Length                                                                                                              |                     |        |          |     | \$ 4.800    | 0.000000       | \$0.12               | \$4,140.72  | \$0.00       |              |                   |                                    |
| 20   | 20    | Gundrill Bore Dies & Rams                                                                                                  |                     |        |          |     |             | 0.034670       |                      |             |              |              |                   |                                    |
| 30   | 30    | Ream Bore                                                                                                                  |                     |        |          |     | n/a         | 0.029946       | \$0.39               | \$15,118.98 | \$6,080.00   |              |                   |                                    |
| 40   | 40    | Rifle Bore                                                                                                                 |                     |        |          |     |             | 0.000000       |                      |             |              |              |                   |                                    |
| 50   | 50    | Wash & Stress Relieve                                                                                                      |                     |        |          |     |             | 0.000413       | \$0.00               | 0           | \$7,000.00   |              |                   | M710 Barrel Wash and Stress Relief |
| 60   | 60    | Turn O.D. & Inspect for Runout Gaging                                                                                      |                     |        |          |     | \$          | 0.027713       | 0.072                | \$4,993.90  | \$5,000.00   |              |                   | Turn O. D. & Inspect               |
| 70   | 70    | Cut-off & Crown Muzzle End                                                                                                 |                     |        |          |     |             | 0.000700       |                      |             |              |              |                   |                                    |
|      |       | Clamping Chuck                                                                                                             |                     |        |          |     | \$          | 0.011670       | \$0.08               | \$1,440.56  | \$15,000.00  |              |                   | M710 Cutoff and Crown Operation    |
| 80   | 80    | Face, Chamber, Machine Hub End, Drill & Tap Takedown Screw Holes, Mil Recoil Lug Slot & 100% Inspect Chamber Finish Gaging | Okuma LB-300        |        |          |     |             | 0.080145       |                      |             |              |              |                   |                                    |
|      |       | Chamber operation                                                                                                          |                     |        |          |     |             |                | \$0.00               | \$0.00      | \$222,880.00 | \$0.00       |                   | M710 Chamber Operation             |
| 90   | 90    | Wash & Magnaflex Barrel                                                                                                    |                     |        |          |     |             | 0.015500       |                      |             |              |              |                   |                                    |
| 100  | 100   | Drill & Tap Sight Screw Holes Gaging                                                                                       |                     |        |          |     |             | 0.000000       |                      |             |              |              |                   |                                    |
| 110  | 110   | Induction Heat Treat Hub                                                                                                   |                     |        |          |     |             | 0.000000       |                      |             |              |              |                   |                                    |
| 120  | 120   | Press Receiver onto Barrel Gaging                                                                                          |                     |        |          |     |             | 0.025970       |                      |             |              |              |                   |                                    |
| 130  | 130   | Inspect for Runout & Straighten if Necessary                                                                               |                     |        |          |     |             | 0.000300       |                      |             |              |              |                   |                                    |
| 140  | 140   | Roll Mark                                                                                                                  |                     |        |          |     |             | 0.003000       |                      |             |              |              |                   |                                    |
| 150  | 150   | Angularly Straighten Muzzle & Inspect Bore                                                                                 |                     |        |          |     |             | 0.000000       |                      |             |              |              |                   |                                    |
| 160  | 160   | Centerless Polish                                                                                                          |                     |        |          |     |             | 0.004167       |                      |             |              |              |                   |                                    |
| 170  | 170   | Glass Bead                                                                                                                 |                     |        |          |     |             | 0.005556       |                      |             |              |              |                   |                                    |
| 180  | 180   | Black Oxide                                                                                                                |                     |        |          |     |             | 0.004167       |                      |             |              |              |                   |                                    |
|      |       | TOTALS                                                                                                                     |                     |        |          |     | \$ 4.800    | 0.246983       | \$0.50               | \$15,999.14 | \$255,980.00 | \$0.00       | 0.00              |                                    |

710 Complete 1

83

ME0201

## Summary

Part Name      Barrel  
Part Number    305400

Operation Name   Grind Barrel O.D.  
Operation Number   

| Material | Run Time | External Processing | Variable Overhead | Capital Required | Pre-Op and Start -up |
|----------|----------|---------------------|-------------------|------------------|----------------------|
| n/a      | 0.006362 | n/a                 | 0.23625           | \$85,000         | \$ 1,700.00          |

## Assumptions:

|                                                                                |
|--------------------------------------------------------------------------------|
| Scale is left from Induction H.T. that can't be removed by aggressive cleaning |
| Machine cycle time A/U from Ilion Estimate dated 6/18                          |
| Grinding wheel price based on comparably sized Ilion wheel                     |
|                                                                                |
|                                                                                |
|                                                                                |
|                                                                                |
|                                                                                |
|                                                                                |
|                                                                                |
|                                                                                |
|                                                                                |
|                                                                                |
|                                                                                |
|                                                                                |
|                                                                                |

## Risks/unknowns:

|                                                                                                  |
|--------------------------------------------------------------------------------------------------|
| 1. Exact equipment price                                                                         |
| 2. Exact wheel price                                                                             |
| 3. Will Steady Rest be necessary to keep barrel from deflecting during grinding?                 |
| 4. Exact wheel life - soft material will tend to gum up wheel and require more frequent dressing |
|                                                                                                  |
|                                                                                                  |
|                                                                                                  |
|                                                                                                  |
|                                                                                                  |
|                                                                                                  |



|        |
|--------|
| Barrel |
| 305400 |

Grind Barrel O.D.

|    | ADD/USE | ILION RUN RATE |
|----|---------|----------------|
| 0  | 0       | 0              |
| 1  | 1       | 1              |
| 2  | 2       | 2              |
| 3  | 3       | 3              |
| 4  | 4       | 4              |
| 5  | 5       | 5              |
| 6  | 6       | 6              |
| 7  | 7       | 7              |
| 8  | 8       | 8              |
| 9  | 9       | 9              |
| 10 | 10      | 10             |
| 11 | 11      | 11             |
| 12 | 12      | 12             |
| 13 | 13      | 13             |
| 14 | 14      | 14             |
| 15 | 15      | 15             |
| 16 | 16      | 16             |
| 17 | 17      | 17             |
| 18 | 18      | 18             |
| 19 | 19      | 19             |
| 20 | 20      | 20             |
| 21 | 21      | 21             |
| 22 | 22      | 22             |
| 23 | 23      | 23             |
| 24 | 24      | 24             |
| 25 | 25      | 25             |
| 26 | 26      | 26             |
| 27 | 27      | 27             |
| 28 | 28      | 28             |
| 29 | 29      | 29             |
| 30 | 30      | 30             |
| 31 | 31      | 31             |
| 32 | 32      | 32             |
| 33 | 33      | 33             |
| 34 | 34      | 34             |
| 35 | 35      | 35             |
| 36 | 36      | 36             |
| 37 | 37      | 37             |
| 38 | 38      | 38             |
| 39 | 39      | 39             |
| 40 | 40      | 40             |
| 41 | 41      | 41             |
| 42 | 42      | 42             |
| 43 | 43      | 43             |
| 44 | 44      | 44             |
| 45 | 45      | 45             |
| 46 | 46      | 46             |
| 47 | 47      | 47             |
| 48 | 48      | 48             |
| 49 | 49      | 49             |
| 50 | 50      | 50             |
| 51 | 51      | 51             |
| 52 | 52      | 52             |
| 53 | 53      | 53             |
| 54 | 54      | 54             |
| 55 | 55      | 55             |
| 56 | 56      | 56             |
| 57 | 57      | 57             |
| 58 | 58      | 58             |
| 59 | 59      | 59             |
| 60 | 60      | 60             |
| 61 | 61      | 61             |
| 62 | 62      | 62             |
| 63 | 63      | 63             |
| 64 | 64      | 64             |
| 65 | 65      | 65             |
| 66 | 66      | 66             |
| 67 | 67      | 67             |
| 68 | 68      | 68             |
| 69 | 69      | 69             |
| 70 | 70      | 70             |
| 71 | 71      | 71             |
| 72 | 72      | 72             |
| 73 | 73      | 73             |
| 74 | 74      | 74             |
| 75 | 75      | 75             |
| 76 | 76      | 76             |
| 77 | 77      | 77             |
| 78 | 78      | 78             |
| 79 | 79      | 79             |
| 80 | 80      | 80             |
| 81 | 81      | 81             |
| 82 | 82      | 82             |
| 83 | 83      | 83             |
| 84 | 84      | 84             |
| 85 | 85      | 85             |
| 86 | 86      | 86             |
| 87 | 87      | 87             |
| 88 | 88      | 88             |
| 89 | 89      | 89             |
| 90 | 90      | 90             |
| 91 | 91      | 91             |
| 92 | 92      | 92             |
| 93 | 93      | 93             |
| 94 | 94      | 94             |
| 95 | 95      | 95             |
| 96 | 96      | 96             |
| 97 | 97      | 97             |
| 98 | 98      | 98             |
| 99 | 99      | 99             |

## Inspection Procedure

|                    |        |
|--------------------|--------|
| <b>Part Name</b>   | Barrel |
| <b>Part Number</b> | 305400 |

|                  |                   |  |
|------------------|-------------------|--|
| Operation Name   | Grind Barrel O.D. |  |
| Operation Number |                   |  |

## Inspection Procedure

Check Barrel 1.229/1.231 diameter w/ ring gages

[illegible]

Barrel O.D.

[illegible]

0.2363

|                  |                   |  |
|------------------|-------------------|--|
| Operation Name   | Grind Barrel O.D. |  |
| Operation Number |                   |  |

## Capital Required

| Machine or Fixture                                                              | Dollars      |  | Expected Delivery |
|---------------------------------------------------------------------------------|--------------|--|-------------------|
| Cylindrical O.D. Grinder - Grinds 1.230 dia. Of barrel, located between centers | \$ 70,000.00 |  | 8-12 wks          |
| Coolant Filtration System                                                       | \$ 15,000.00 |  | 8-12 wks          |
|                                                                                 | \$ -         |  |                   |
|                                                                                 | \$ -         |  |                   |
|                                                                                 | \$ -         |  |                   |
|                                                                                 | \$ -         |  |                   |
|                                                                                 | \$ -         |  |                   |
|                                                                                 | \$ -         |  |                   |
|                                                                                 | \$ -         |  |                   |
|                                                                                 | \$ -         |  |                   |
|                                                                                 | \$ -         |  |                   |
|                                                                                 | \$ -         |  |                   |
| TOTAL CAPITAL                                                                   | 85,000       |  |                   |

8/23/99

Operation Detail - Grind Barrel O.D.

Page 5 of 5

REVIEWED BY BOLT BROW

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MF0207

Part Program: BOLT BODY  
Inspector: Administrator

Date/Time: 05/25/2000 10:24:18  
CMM: CMM1

REAR DATUM-A DIAMETER

#1

TYPE: O.D.

NAME: DATUM A REAR

|    | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|--------|---------|--------|--------|---------|---------|
| DI | 0.6935 | 0.6950  | 0.0020 | 0.0020 | -0.0015 | ----    |

DATUM-A DIAMETER AT FRONT OF BOLT BODY

#2

TYPE: O.D.

NAME: DATUM A FRONT

|    | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|--------|---------|--------|--------|---------|---------|
| DI | 0.6941 | 0.6950  | 0.0020 | 0.0020 | -0.0009 | --      |

DATUM-C HOLE ON BOTTOM OF BOLT BODY

#3

TYPE: I.D.

NAME: DATUM C BOTTOM

|    | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|----|--------|---------|--------|--------|--------|---------|
| X  | 0.0005 | 0.0000  | 0.0040 | 0.0040 | 0.0005 | +       |
| Y  | 0.2162 | 0.2100  | 0.0040 | 0.0040 | 0.0062 | 0.0022  |
| DI | 0.2531 | 0.2500  | 0.0020 | 0.0020 | 0.0031 | 0.0011  |
| PS |        |         | 0.0040 |        | 0.0123 | 0.0043  |



DATUM-C HOLE ON TOP OF PART

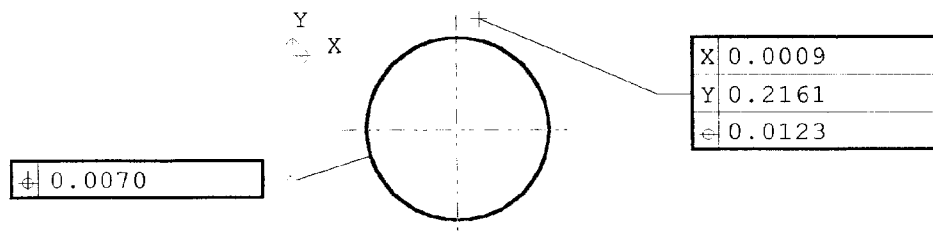
#4

TYPE: I.D.

NAME: DATUM C TOP

|    | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|----|--------|---------|--------|--------|--------|---------|
| X  | 0.0009 | 0.0000  | 0.0040 | 0.0040 | 0.0009 | +       |
| Y  | 0.2161 | 0.2100  | 0.0040 | 0.0040 | 0.0061 | 0.0021  |
| DI | 0.2510 | 0.2500  | 0.0020 | 0.0020 | 0.0010 | ++      |
| PS |        |         | 0.0040 |        | 0.0123 | 0.0052  |

MF0208



OVERALL LENGTH OF BOLT BODY - ALSO DATUM-D SURFACE

#5

TYPE: PLANE

NAME: PART LENGTH

|   | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|---|--------|---------|--------|--------|--------|---------|
| Y | 5.0682 | 5.0650  | 0.0050 | 0.0050 | 0.0032 | +++     |

STRAIGHT NOTCH SURFACE .094 FROM CENTERLINE

#6

TYPE: PLANE

NAME: RH NOTCH SURFACE

|   | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|---|--------|---------|--------|--------|--------|---------|
| X | 0.0962 | 0.0940  | 0.0050 | 0.0050 | 0.0022 | ++      |

.094 RADIUS AT BOTTOM OF FIRING PIN HEAD CAM NOTCH

#7

TYPE: I.D.

NAME: FIRING PIN HEAD NOTCH RADIUS

|    | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|----|--------|---------|--------|--------|--------|---------|
| X  | 0.0036 | 0.0000  | 0.0050 | 0.0050 | 0.0036 | +++     |
| RD | 0.0960 | 0.0940  | 0.0050 | 0.0050 | 0.0020 | ++      |

MAX DEPTH OF FIRING PIN CAM RADIUS FROM DATUM-D

#8

TYPE: POINT

NAME: RADIUS\_MAX\_DEPTH

|   | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|---|---------|---------|--------|--------|--------|---------|
| Y | -0.2331 | -0.2340 | 0.0050 | 0.0050 | 0.0009 | +       |

CAM SURFACE LOCATION @Y-.0933 &amp; Z.2649 (MATHEMATICALLY DERIVED POINT)

#9

TYPE: POINT

NAME: CAM\_SURFACE\_POINT\_1

|   | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|---|---------|---------|--------|--------|---------|---------|
| X | -0.1530 | -0.1493 | 0.0050 | 0.0050 | -0.0037 | ---     |

CAM SURFACE @Y-.0466 Z.2349 (MATHEMATICALLY DERIVED POINT ON HELIX OF CAM)

#10

TYPE: POINT

NAME: CAM\_SURFACE\_POINT\_2

|   | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|---|---------|---------|--------|--------|--------|---------|
| X | -0.1888 | -0.1902 | 0.0050 | 0.0050 | 0.0014 | ++      |

BOTTOM .125R GROOVE: X-POSITION &amp; RADIUS

MF0209

#11

TYPE: I.D.

NAME: BOTTOM GROOVE

|    |        |        |        |        |         |    |
|----|--------|--------|--------|--------|---------|----|
| X  | 0.0018 | 0.0000 | 0.0050 | 0.0050 | 0.0018  | ++ |
| RD | 0.1241 | 0.1250 | 0.0050 | 0.0050 | -0.0009 | -  |

DISTANCE OF BOTTOM GROOVE FROM A-DATUM TO EDGE OF GROOVE RADIUS

#12

TYPE: POINT

NAME: BOTTOM GROOVE Z

|   | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|---|--------|---------|--------|--------|--------|---------|
| Z | 0.3002 | 0.3000  | 0.0050 | 0.0050 | 0.0002 | +       |

TOP .125R GROOVE X-POSITION &amp; RADIUS

#13

TYPE: I.D.

NAME: TOP GROOVE

|    | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|--------|---------|--------|--------|---------|---------|
| X  | 0.0012 | 0.0000  | 0.0050 | 0.0050 | -0.0012 | 83      |
| RD | 0.1263 | 0.1250  | 0.0050 | 0.0050 | 0.0013  | ++      |

MAX. DISTANCE BETWEEN TOP &amp; BOTTOM .125R GROOVES

#14

|    | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|----|--------|---------|--------|--------|--------|---------|
| DS | 0.6006 | 0.6000  | 0.0050 | 0.0050 | 0.0006 | +       |

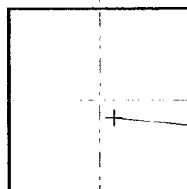
REAR INSIDE DIAMETER RELATIVE TO DATUM-A

#15

TYPE: I.D.

NAME: ID REAR

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Z  | 0.0005  | 0.0000  | 0.0035 | 0.0035 | 0.0005  | +       |
| X  | -0.0007 | 0.0000  | 0.0035 | 0.0035 | -0.0007 | -       |
| DI | 0.4990  | 0.4980  | 0.0030 | 0.0030 | 0.0010  | ++      |

X  
Z

|   |         |
|---|---------|
| Z | 0.0005  |
| X | -0.0007 |

ID AT FRONT OF BOLT BODY RELATIVE TO A-DATUM

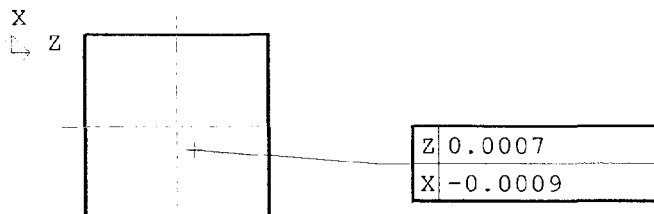
#16

TYPE: I.D.

NAME: ID\_FRONT

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Z  | 0.0007  | 0.0000  | 0.0035 | 0.0035 | 0.0007  | +       |
| X  | -0.0009 | 0.0000  | 0.0035 | 0.0035 | -0.0009 | --      |
| DI | 0.4993  | 0.4980  | 0.0030 | 0.0030 | 0.0013  | ++      |

MF0210



ANSI COAXIALITY: To DATUM\_A\_LINE

#17

FEATURE #26

TYPE: LINE

NAME: ID\_AXIS

|   | ACTUAL  | NOMINAL |
|---|---------|---------|
| X | -0.0008 | 0.0000  |
| Y | -2.6778 | -2.5771 |
| Z | 0.0006  | 0.0000  |
| I | 0.0001  | 0.0000  |
| J | 1.0000  | 1.0000  |
| K | 0.0000  | 0.0000  |

#18

|    | ACTUAL | NOMINAL | + TOL  | - TOL | DEV    | OUT-TOL |
|----|--------|---------|--------|-------|--------|---------|
| PS |        |         | 0.0100 |       | 0.0023 | +       |

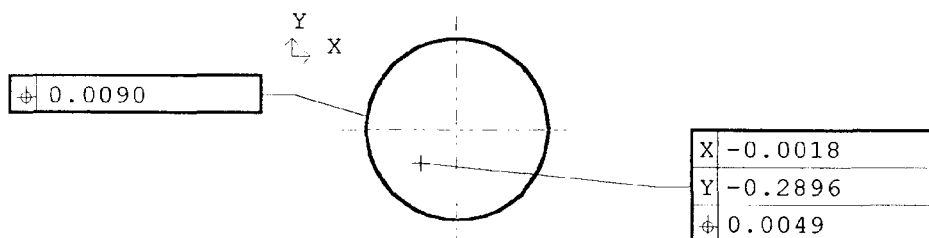
BOLT HANDLE HOLE AT 60 DEGREES FROM DATUMS A, C &amp; FROM DATUM-D

#19

TYPE: I.D.

NAME: BOLT HANDLE HOLE

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| X  | -0.0018 | 0.0000  | 0.0050 | 0.0050 | -0.0018 | --      |
| Y  | -0.2896 | -0.2880 | 0.0050 | 0.0050 | -0.0016 | --      |
| DI | 0.2580  | 0.2570  | 0.0020 | 0.0020 | 0.0010  | +++     |
| PS |         |         | 0.0060 |        | 0.0049  | +++     |



MAX GROOVE DEPTH FROM DATUM-D (.450+.130)  
 DIAMETER & POSITION OF .600 DIAMETER GROOVE

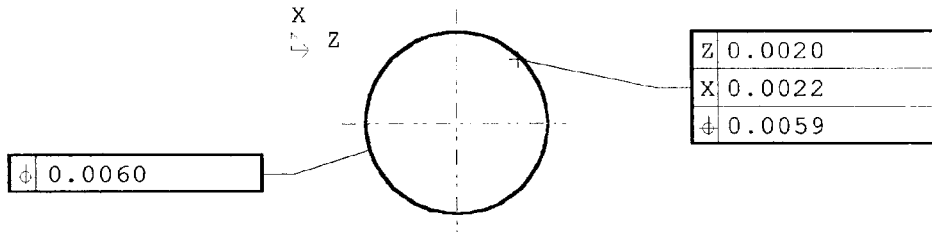
#20

TYPE: CIRCLE

NAME: GROOVE\_DIAMETER

MF0211

|    | ACTUAL | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|--------|---------|--------|--------|---------|---------|
| X  | 0.0022 | 0.0000  | 0.0080 | 0.0080 | 0.0022  | ++      |
| Z  | 0.0020 | 0.0000  | 0.0080 | 0.0080 | 0.0020  | ++      |
| DI | 0.5913 | 0.6000  | 0.0050 | 0.0050 | -0.0087 | -0.0037 |
| PS |        |         | 0.0060 |        | 0.0059  | ++++    |



.450 DISTANCE OF GROOVE FROM DATUM-D

#21

TYPE: POINT

NAME: 450\_DISTANCE

|   | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|---|---------|---------|--------|--------|---------|---------|
| Y | -0.4540 | -0.4500 | 0.0050 | 0.0050 | -0.0040 | ----    |

.130 GROOVE WIDTH

#22

TYPE: DISTANCE

NAME: 130\_GROOVE\_WIDTH

|   | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|---|---------|---------|--------|--------|---------|---------|
| Y | -0.1327 | -0.1300 | 0.0050 | 0.0050 | -0.0027 | ---     |

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MF0212

4/23/06 - 06:00:00

| QTY # | PROCESS DESCRIPTION                                                             | MACHINE DESCRIPTION                               | Part # | Part # | Rev | Material | Quality Factor | Engineering Charge | Sold Run Hours | Variable Overhead | Prep      | Capital   | FFI | Material Handling | Comments                                                                          |
|-------|---------------------------------------------------------------------------------|---------------------------------------------------|--------|--------|-----|----------|----------------|--------------------|----------------|-------------------|-----------|-----------|-----|-------------------|-----------------------------------------------------------------------------------|
| 10    | Part 11 Part 12 Part 13 Part 14 Part 15 Part 16 Part 17 Part 18 Part 19 Part 20 | 1111 1111 1111 1111 1111 1111 1111 1111 1111 1111 |        |        |     |          |                |                    | 0.00166667     |                   |           |           |     |                   | Part 11 Part 12 Part 13 Part 14 Part 15 Part 16 Part 17 Part 18 Part 19 Part 20   |
| 20    | CNC Machine Turning Cyls                                                        |                                                   |        |        |     |          |                |                    | 0.00166667     | 0.00              | 11,697.87 | 11,697.87 |     |                   | CNC Machine Based on 197 CH04 Part for the hole @400 and a #48 thread size @22.20 |
| 30    | Machine Machine Mill & Drill on Part                                            |                                                   |        |        |     |          |                |                    | 0.00166667     |                   |           |           |     |                   |                                                                                   |
| 40    | Vertical Driller                                                                |                                                   |        |        |     |          |                |                    | 0.00166667     |                   |           |           |     |                   |                                                                                   |
| Total |                                                                                 |                                                   |        |        |     |          |                |                    |                |                   |           |           |     |                   |                                                                                   |

83

7/10 Complete 1

MF0213

710 Complete I

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BARBER - 5.22.06/0010164  
Williams v. Remington

|                                               | Receiver<br>597 | Current<br>Receiver<br>710 | Revised<br>Receiver<br>710 | "Pink"<br>Receiver<br>710 | Current<br>Bolt Body<br>710 | Revised<br>Bolt Body<br>710 | "Pink"<br>Bolt Body<br>710 |
|-----------------------------------------------|-----------------|----------------------------|----------------------------|---------------------------|-----------------------------|-----------------------------|----------------------------|
| Run Time                                      | 0.0530          | 0.0055                     | 0.0068                     | 0.0620                    | 0.0032                      | 0.0033                      |                            |
| Material (includes Powder Coat)               | 3.40            | 1.76                       | 2.18                       | 3.70                      | 0.74                        | 0.74                        |                            |
| Labor                                         | 0.56            | 0.06                       | 0.06                       | 0.66                      | 0.03                        | 0.03                        |                            |
| Incremental Overhead                          |                 |                            |                            |                           |                             |                             |                            |
| Employee Benefits 58%                         | 0.32            | 0.03                       | 0.04                       | 0.38                      | 0.02                        | 0.02                        |                            |
| Tooling Costs                                 | 0.30            | 1.02                       | 1.43                       | 1.41                      | 0.24                        | 0.29                        |                            |
| Depreciation                                  | 0.32            | 1.38                       | 1.38                       | 1.31                      | 0.80                        | 0.80                        |                            |
| Property Taxes (.008 of Fixed<br>Asset Costs) | 0.04            | 0.11                       | 0.11                       | 0.11                      | 0.05                        | 0.05                        |                            |
| Electricity (estimated)                       | 0.02            | 0.08                       | 0.08                       | 0.08                      | 0.04                        | 0.04                        |                            |
|                                               | 4.96            | 4.44                       | 5.28                       | 7.64                      | 1.93                        | 1.98                        |                            |

Note: 1) Depreciation for receiver & bolt body based on 58,000 597s and 20,000 710s

2) Depreciation on Revised Receiver & Bolt Body on \$437,000 machine  
allocated on Run Time (63% receiver 37% Bolt Body)

3) Depreciation on "Pink" receiver based on \$261,654 machine allocated 100% to receiver

|                                               | Receiver<br>597 | Bolt Body<br>710 | 710    |
|-----------------------------------------------|-----------------|------------------|--------|
| Run Time                                      | 0.0530          | 0.0055           | 0.0032 |
| Material (includes Powder Coat)               | 3.40            | 1.76             | 0.74   |
| Labor                                         | 0.56            | 0.06             | 0.03   |
| Incremental Overhead                          |                 |                  |        |
| Employee Benefits 58%                         | 0.32            | 0.03             | 0.02   |
| Tooling Costs                                 | 0.30            | 1.02             | 0.24   |
| Depreciation                                  | 0.32            | 1.58             | 1.47   |
| Property Taxes (.008 of Fixed<br>Asset Costs) | 0.04            | 0.13             | 0.12   |
| Electricity                                   |                 |                  |        |
|                                               | 4.94            | 4.58             | 2.62   |

Note: 1) Depreciation based on 58,000 597s and 20,000 710s

2) Depreciation on Receiver & Bolt Body on \$500,000 machine  
allocated on Run Time (63% receiver 37% Bolt Body)

MF0216

**Chamblee, Danny**

**From:** Chamblee, Danny  
**Sent:** Thursday, September 16, 1999 3:08 PM  
**To:** Golemboski, Matt R.  
**Subject:** RE: 710 receiver

Matt,

Receiver cost comparison

|                                                | 710    | 597   |
|------------------------------------------------|--------|-------|
| Run Time                                       | 0.0055 | 0.053 |
| Material                                       | 1.76   | 2.53  |
| Labor                                          | 0.06   | 0.56  |
| Overhead (443% based on 58,000<br>30,000 710s) | 0.27   | 2.48  |
| Powder Coat                                    | -      | 0.32  |
| Port City Tool                                 | -      | 0.25  |
| Total                                          | 2.09   | 6.14  |

Thanks,  
Danny

**From:** Golemboski, Matt R.  
**Sent:** Thursday, September 16, 1999 9:29 AM  
**To:** Chamblee, Danny  
**Subject:** 710 receiver

Also, list the m710 costs for the receiver by operation.

|                                               | Receiver<br>597 | Current<br>Receiver<br>710 | Revised<br>Receiver<br>710 | Current<br>Bolt Body<br>710 | Revised<br>Bolt Body<br>710 |
|-----------------------------------------------|-----------------|----------------------------|----------------------------|-----------------------------|-----------------------------|
| Run Time                                      | 0.0530          | 0.0055                     | 0.0058                     | 0.0032                      | 0.0033                      |
| Material (includes Powder Coat)               | 3.40            | 1.76                       | 2.18                       | 0.74                        | 0.74                        |
| Labor                                         | 0.56            | 0.06                       | 0.06                       | 0.03                        | 0.03                        |
| Incremental Overhead                          |                 |                            |                            |                             |                             |
| Employee Benefits 58%                         | 0.32            | 0.03                       | 0.04                       | 0.02                        | 0.02                        |
| Tooling Costs                                 | 0.30            | 1.02                       | 1.43                       | 0.24                        | 0.29                        |
| Depreciation                                  | 0.32            | 1.38                       | 1.38                       | 0.80                        | 0.80                        |
| Property Taxes (.008 of Fixed<br>Asset Costs) | 0.04            | 0.11                       | 0.11                       | 0.05                        | 0.05                        |
| Electricity (estimated)                       | 0.02            | 0.08                       | 0.08                       | 0.04                        | 0.04                        |
|                                               | 4.96            | 4.44                       | 5.28                       | 1.93                        | 1.98                        |

Note: 1) Depreciation based on 58,000 597s and 20,000 710s  
 2) Depreciation on Receiver & Bolt Body on \$500,000 machine  
 allocated on Run Time (63% receiver 37% Bolt Body)

MF0218

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## Model 710 Engineering Trials Report

### Summary

Engineering trials were conducted on three components of the Model 710 from October 11, 1999 to October 22, 1999 in order to gain more accurate information of tool lives, cycle time, and various other machining parameters. The machining tests were conducted in Charlotte, NC at the Okuma America Technology Institute, and utilized an Okuma LT-15M Turning Center. Technical assistance was provided by Okuma America and Matthew Machinery out of Louisville, KY.

The components machined on the LT-15 were:

- Model 710 Receiver, Part No. 300340
- Model 710 Bolt Body, Part No. 300339
- Model 710 Barrel, Part No. 305315

As a result of these machining tests important information was gathered on the best methods to manufacture these components and the cost associated with each. This information will be used to update and refine the Model 710 Project Estimate prior to final submission. Additionally, several opportunities to improve the manufacturability of the 710 design have been identified as a result of these machining trials. The results of the trials to date are given below.

### Model 710 Receiver

There were numerous difficulties in machining the receiver. The problems encountered were:

- Boring the I.D. of the receiver due to vibration in the boring bar. This was due to the fact that the ratio of the depth of the receiver that needed to be bored vs. the boring bar diameter was excessively large. When that ratio exceeds 6:1 stock tooling begins to become ineffective at damping out vibration caused by cutting forces (the ratio for this operation is about 4:1). Exacerbating this situation was the fact that the tubing being machined was not to the O.D. & I.D. dimensions planned to be used in production. The closest stock size was used for these trials, but the closest stock material required removing app. 0.100 in. of material from the I.D. to get it to size. Several different methods were tried to overcome the chatter but without much success. Additional work needs to be done to determine the best options for creating the I.D. to model drawing dimensions and tolerances.
- Some difficulty in machining the various slots in the receiver body due to tool chatter. The tool chatter problem can be overcome by tooling changes.
- Chip evacuation was a problem. The low carbon steel w/ low hardness tends to produce long, stringy chips that are hard to break up and tend to tangle inside the receiver body. This can be overcome by more aggressive speeds & feed rates, but low carbon steel also tends to weld to cutting tool surfaces. Therefore, TiN, TiCN, or TiAlN coated tools are necessary to ensure long tool life. Indexable insert endmills may be an option for roughing cuts. The inserts tend to have good chip breaking abilities and are coated.

Due to these difficulties it was not possible to run a substantial number of components. It was possible, though, to extrapolate the following information:

- **Machine cycle time:** 6 minutes actual vs. an estimated cycle time (100% efficiency) of 5.023 min.
- **Variable Tooling Cost:** \$1.433 per part vs. an estimated cost of \$0.927, due to having to purchase coated tools and reduced life for slotting endmills

Remington Arms Company, Inc.

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**Model 710 Engineering Trials Report****Model 710 Receiver (cont'd)**

- **Labor Run Rate:** .00417 (2 minutes of operator time required per one 8-piece (5 ft.) bar) vs. an estimated run-rate of .00397 (5 minutes of operator time per one 21-piece (12 ft.) bar)
- **Material Cost:** Remnant length app. 6" (same as original estimate). With a 5' long bar, this will result in 8 pcs per bar, and a per piece material cost of \$2.178 vs. an estimated cost of \$1.76. **NOTE:** The initial estimate did not calculate material cost based on DOM material, which will be necessary to use to help eliminate I.D. boring problem. Re-calculating the initial estimate material cost for a 12' bar with 6" remnant at the DOM price of \$3.52 per foot yields a material cost of \$2.028 per part, not \$1.76

More detailed information is given in Appendix A.

There is considerable opportunity to decrease tooling cost by testing indexable insert end mills for roughing the magazine well cut and ejection port cut. This tooling must be tested to see how it performs, though. If it works this style of end mill would replace one end mill completely, with an approximate savings of between \$.30 and \$.40 per part. Its effects on cycle time are not known as of yet.

The machine used for the receiver, the Okuma LT-15M, seems well suited for machining this component complete. The options required to maximize the machines efficiency still require more research and more information from machining results. Some the problems encountered, like the formation of long stringy chips and whether the I.D. has to be bored out, will dictate what kind of bar feeder is purchased and how long the bar stock will be. As thing stand right now, if the I.D. has to be machined, then the bar stock length will be limited to about 5' max, and a magazine bar feeder will need to be utilized. Otherwise the chips formed by boring will become too compacted in a longer tube length and will interfere with machining. According to the bar feeder manufacturer normally used by Okuma, LNS, the smaller magazine bar feed system can be modified to provide through the spindle coolant or an air blast to clear chips out, but those options can't be put on a longer bar feeder.

Chips also present a potential problem for unloading the parts as well. LNS has a vacuum parts unloading system to literally suck the parts out through the back of the spindle, but an excessive amount of chips in the parts may interfere with the operation of the unloader. Okuma's parts catcher option for the LT-15 may end up being the better option for automatically unloading finished parts.

**Model 710 Bolt Body**

There were few problems encountered in machining the bolt body. The only trouble encountered was with chips packing in the I.D. of the bolt body (same material as the receiver). This caused the insert on the boring bar to fail after approximately 80 pcs. Changing the grooving cycle can reduce chip size. Different types of inserts also need to be explored in order to optimize this tool. Overall, though, the machining went well. Cycle times, run-rates, etc. are given below:

- **Machine cycle time:** 1.933 minutes actual vs. an estimated cycle time (100% efficiency) of 1.959 min.
- **Variable Tooling Cost:** \$0.285 per part vs. an estimated cost of \$0.24, due primarily to decreased life in grooving insert
- **Labor Run Rate:**

TOOLING COST COMPARISON - ESTIMATE VS. RUNOFF

Model 710

| Model 710 Component           | Operation        | Initial Tooling Cost Estimate (per part) | Revised Tooling Cost based on Runoff Data (per part) | Change in \$ [Note: ( ) favorable] | % Change |
|-------------------------------|------------------|------------------------------------------|------------------------------------------------------|------------------------------------|----------|
| Receiver                      | Machine Complete | \$ 0.927                                 | \$ 1.433                                             | \$ 0.506                           | 55%      |
| Barrel                        | Gundrill         | \$ 0.119                                 | \$ 0.176                                             | \$ 0.056                           | 47%      |
|                               | Ream, Rifle      | \$ 0.386                                 | \$ 0.202                                             | \$ (0.184)                         | -48%     |
|                               | Turn O.D.        | \$ 0.072                                 | \$ 0.091                                             | \$ 0.020                           | 27%      |
|                               | Chamber Complete | \$ 2.762                                 | \$ 3.039                                             | \$ 0.277                           | 10%      |
| Bolt Body                     | Machine Complete | \$ 0.240                                 | \$ 0.285                                             | \$ 0.046                           | 19%      |
| Total Change-Variable Tooling |                  |                                          |                                                      | \$ 0.720                           |          |

DRAFT

BARBER - 5.22.06r0010171

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Summary

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MF0221

Confidential - Subject - 5.22.06r0010171 Order

Williams v. Remington

| Initial Estimate of Tooling Cost and Life                                |                                              |               |                        |           | New Tooling and Costs based on Engineering Runoff Observations                                                                                  |               |                        |           |                                                                                                                                                                                               |
|--------------------------------------------------------------------------|----------------------------------------------|---------------|------------------------|-----------|-------------------------------------------------------------------------------------------------------------------------------------------------|---------------|------------------------|-----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Operation                                                                | Tool Name                                    | Cost per tool | Tool Life (parts/tool) | Cost/Part | Tool Name                                                                                                                                       | Cost per tool | Tool Life (parts/tool) | Cost/Part | Comments                                                                                                                                                                                      |
| MILL FIRE CONTROL SLOT, FINISH MILL MAGAZINE BOX SLOT                    | 15/64 Carbide Endmill, 3-flute               | \$10.05       | 225                    | \$0.045   | .320 3-flute TiCN coated Carbide Endmill, Garr Tool EDP#12204 (21/64 or .328), Modified std                                                     | \$33.01       | 225                    | \$0.147   | Modified std to get fire control slot to size; assumes design changes will allow magazine well radii to be changed to .160; new price assumed to Garr list price plus 20%                     |
| ROUGH MILL MAGAZINE BOX SLOT, MILL RECEIVER TOP TANG RADIUS CUT          | 3/4 Carbide Endmill                          | \$72.34       | 250                    | \$0.289   | 3/4 3-flute TiCN Carbide Endmill, Garr Tool EDP#12354, Modified std w/ .125 corner radius and short (1") flute length                           | \$112.80      | 250                    | \$0.451   | Tool life lowered based on uncertainty caused by runoff performance of original endmill; new price assumed to Garr list price plus 20%                                                        |
| CENTER DRILL FOR .265 CLEARANCE HOLE, SCOPE SCREW HOLES                  | 3/8 NC Spot Drill                            | \$13.95       | 450                    | \$0.031   | #3 TiN Coated Carbide Center Drill, Stores #306184                                                                                              | \$18.20       | 600                    | \$0.030   | was 3/8 carbide spot drill; however, performance at run-off resulted in change; tool life based on 597 bbl assy (300 pcs. Per end; double-ended)                                              |
| DRILL .265 CLEARANCE HOLE                                                | 17/64 Carbide Drill                          | \$17.77       | 500                    | \$0.036   | 17/64 HSS Screw Machine Length Drill, MSC #63804462 (Cleveland Twist)                                                                           | \$1.66        | 250                    | \$0.007   | Was 17/64 Carbide 3-flute; change made based on run-off experience                                                                                                                            |
| ROUGH MILL EJECTION PORT, FINISH MILL EJECTION PORT, MILL BOLT STOP FLAT | 1/2 Carbide Endmill                          | \$25.59       | 400                    | \$0.064   | 15mm (.599) 3-flute TiCN coated Carbide Endmill, Garr Tool EDP#12334 (5/8 endmill), Modified std w/ .06 corner radius                           | \$79.64       | 250                    | \$0.319   | Tool life lowered based on uncertainty caused by runoff performance of original endmill; new price assumed to Garr list price plus 20%                                                        |
| MILL EJECTION PORT MOUTH                                                 | Special 3/4 Endmill w/ .625 Spherical Radius | \$133.85      | 500                    | \$0.268   | Special 3/4" Endmill w/ .625 radius nose (2 flutes). Modified standard of Garr EDP#51354. Cost equivalent to 597 hammer endmill, Stores #306633 | \$133.85      | 500                    | \$0.268   | Four flute tended to chatter on entry; need either a 2, 3, or 6+ flutes to eliminate chatter; price based on M597 hammer endmill as worst case; tool life based on 1/2 of hammer endmill life |
| MILL BOLT HANDLE CAM/CLEARANCE CUT                                       | 3/8 Carbide Endmill                          | \$15.97       | 225                    | \$0.071   | 3/8 Carbide Endmill, 6-flute, TiCN coated, Garr EDP#51284                                                                                       | \$26.12       | 225                    | \$0.116   | Based on 597 carbon bolt 1/4" emill at 225 p/t tool                                                                                                                                           |
| TAP DRILL FOR SCOPE SCREW HOLES                                          | #30 Drill                                    | \$0.66        | 250                    | \$0.003   | #30 Drill                                                                                                                                       | \$0.66        | 250                    | \$0.003   | based on 597 barrels job                                                                                                                                                                      |
| TAP #6-48 SCOPE SCREW HOLES                                              | #6-48 NS-2 Tap                               | \$14.25       | 750                    | \$0.019   | #6-48 NS-2 Tap                                                                                                                                  | \$14.25       | 750                    | \$0.019   | based on 597 barrel job                                                                                                                                                                       |
| DRILL .279 HOLE                                                          | 7.1mm Drill                                  | \$18.80       | 500                    | \$0.038   | "K" (.281) HSS Screw Machine Length Drill, MSC #61792105 (Cleveland Twist)                                                                      | \$2.32        | 250                    | \$0.009   | Was 7.1mm carbide; change made based on runoff experience                                                                                                                                     |
| COUNTERBORE 1.227                                                        | Insert                                       | \$12.00       | 500                    | \$0.024   | Insert                                                                                                                                          | \$12.00       | 500                    | \$0.024   |                                                                                                                                                                                               |
| CUT-OFF                                                                  | Insert                                       | \$10.16       | 250                    | \$0.041   | Insert                                                                                                                                          | \$10.16       | 250                    | \$0.041   | TL BASED ON 597 CUTOFF AND CROWN OPERATION                                                                                                                                                    |
| TOTAL COST PER PART (ESTIMATE)                                           |                                              |               |                        | \$0.927   | TOTAL COST PER PART (REVISED PER RUNOFF RESULTS)                                                                                                |               |                        |           | \$1.433                                                                                                                                                                                       |

**Other recommendations:**

- 1). May want to try inserted endmill for roughing 3/4 slot for magazine well. If it works the cost per part would most likely drop to between \$.06 and \$.15 per part (assumes \$15.00/insert and tool life between 100 & 250 pcs per insert)
- 2). May want to add a small face mill to cut top tang and bolt stop flat. This would create better finish, and allow us to buy an LT-15 w/o the Y-axis option. Looking at a Sandvik Corp. Mill 200 or similar. This uses three round carbide inserts and is commonly used in the mold and die industry for milling contours.

| Initial Estimate of Tooling Cost and Life                          |                               |               |                        |           | New Tooling and Costs based on Engineering Runoff Observations |               |                        |           |                                                                                                                                                                                               |
|--------------------------------------------------------------------|-------------------------------|---------------|------------------------|-----------|----------------------------------------------------------------|---------------|------------------------|-----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Operation                                                          | Tool Name                     | Cost per tool | Tool Life (parts/tool) | Cost/Part | Tool Name                                                      | Cost per tool | Tool Life (parts/tool) | Cost/Part | Comments                                                                                                                                                                                      |
| SPOT FACE FOR .250 C-DATUM HOLE, FINISH MILL CAM CUT               | 5/32 ENDMILL                  | \$7.99        | 250                    | \$0.032   | 3/16 6-Flute Endmill, TiCN coated, Garr EDP# 51114             | \$11.47       | 400                    | \$0.029   | Used a 2-flute HSS TiN Coated Endmill for runoff with little wear after app. 130 pcs; carbide will give longer life and better finish                                                         |
| SPOT DRILL .250 C-DATUM HOLE, SPOT DRILL .250 BOLT HANDLE PIN HOLE | 3/8 NC Spot Drill             | \$13.95       | 450                    | \$0.031   | 3/8 TiN Coated Carbide Center Drill, Stores #306184            | \$18.20       | 600                    | \$0.030   | Replaced 3/8 NC Spot Drill with center drill                                                                                                                                                  |
| DRILL .250 C-DATUM HOLE, DRILL .250 BOLT HANDLE PIN HOLE           | .250 CARBIDE DRILL            | \$16.33       | 250                    | \$0.065   | 1/4 Carbide 2-flute Drill, TiCN coated, Screw Machine Length   | \$20.05       | 400                    | \$0.050   | was 3/8 carbide spot drill; however, performance at run-off resulted in change; tool life based on 597 bbl assy (300 pcs. Per end; double-ended)                                              |
| MILL .125R SLOTS                                                   | 3/16 CARBIDE ENDMILL, 4 FLUTE | \$6.82        | 225                    | \$0.030   | 1/4 4-Flute Carbide Endmill, Garr Tool EDP# 13450              | \$10.20       | 300                    | \$0.034   |                                                                                                                                                                                               |
| TURN FIRING PIN HEAD RETAINING GROOVE                              | KC 720 INSERT                 | \$10.16       | 250                    | \$0.041   | KC 720 INSERT                                                  | \$10.16       | 100                    | \$0.102   | Insert Broke at app. 90 pcs due to insufficient chip evacuation inside hole; can be overcome by tooling/coolant options                                                                       |
| CUT-OFF                                                            | Insert                        | \$10.16       | 250                    | \$0.041   | Insert                                                         | \$10.16       | 250                    | \$0.041   | Four flute tended to chatter on entry; need either a 2, 3, or 6+ flutes to eliminate chatter; price based on M597 hammer endmill as worst case; tool life based on 1/2 of hammer endmill life |
| TOTAL COST PER PART (ESTIMATE)                                     |                               |               |                        | \$0.240   | TOTAL COST PER PART (REVISED PER RUNOFF RESULTS)               |               |                        |           | \$0.285                                                                                                                                                                                       |

**NOTES:**

Tooling Cost for Cut-off & Spot Drill were omitted from original estimate - they are added here

**Other recommendations:**

| Initial Estimate of Tooling Cost and Life |           |               |                        |           | New Tooling and Costs based on Engineering Runoff Observations |               |                        |           |                                                                                                                                                             |
|-------------------------------------------|-----------|---------------|------------------------|-----------|----------------------------------------------------------------|---------------|------------------------|-----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Operation                                 | Tool Name | Cost per tool | Tool Life (parts/tool) | Cost/Part | Tool Name                                                      | Cost per tool | Tool Life (parts/tool) | Cost/Part | Comments                                                                                                                                                    |
| Gun Drill                                 | Drills    | \$10.02       | 100                    | \$0.100   | Drills                                                         | \$23.50       | 150                    | \$0.157   | Cost is a composite of new drill cost and regrinds; assumes 1 new drill @ \$90, 5 regrinds @ \$12 ea, 1 re-tip @ \$72, and 5 additional regrinds @ \$12 ea. |
| Gun Drill                                 | Bushings  | \$61.95       | 10,000                 | \$0.006   | Bushings                                                       | \$61.95       | 10,000                 | \$0.006   |                                                                                                                                                             |
| Gun Drill                                 | Gizmos    | \$4.50        | 1,000                  | \$0.005   | Gizmos                                                         | \$4.50        | 1,000                  | \$0.005   |                                                                                                                                                             |
| cut off                                   | saw blade | \$16.80       | 2,000                  | \$0.008   | saw blade                                                      | \$16.80       | 2,000                  | \$0.008   |                                                                                                                                                             |
| TOTAL COST PER PART (ESTIMATE)            |           |               |                        | \$0.119   | TOTAL COST PER PART (REVISED PER RUNOFF RESULTS)               |               |                        |           | \$0.176                                                                                                                                                     |

**NOTES:**

Average Regrind Cost Mistakenly placed in tool cost for gundrill

**NOTES:**

| Initial Estimate of Tooling Cost and Life |           |               |                        |                                | New Tooling and Costs based on Engineering Runoff Observations |               |                        |                                                  | Comments |
|-------------------------------------------|-----------|---------------|------------------------|--------------------------------|----------------------------------------------------------------|---------------|------------------------|--------------------------------------------------|----------|
| Operation                                 | Tool Name | Cost per tool | Tool Life (parts/tool) | Cost/Part                      | Tool Name                                                      | Cost per tool | Tool Life (parts/tool) | Cost/Part                                        |          |
| Ream                                      | Reamer    | \$97.90       | 1000                   | \$0.10                         | Reamer                                                         | \$126.55      | 1000                   | \$0.13                                           |          |
| Rifle                                     | Button    | \$576.00      | 2000                   | \$0.29                         | Button                                                         | \$300.00      | 4000                   | \$0.08                                           |          |
|                                           |           |               |                        | TOTAL COST PER PART (ESTIMATE) | \$0.386                                                        |               |                        | TOTAL COST PER PART (REVISED PER RUNOFF RESULTS) | \$0.202  |

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BBL Ream, Rifle Cost Comparison

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| Initial Estimate of Tooling Cost and Life |                      |               |                        |           | New Tooling and Costs based on Engineering Runoff Observations |               |                        |           |                               |
|-------------------------------------------|----------------------|---------------|------------------------|-----------|----------------------------------------------------------------|---------------|------------------------|-----------|-------------------------------|
| Operation                                 | Tool Name            | Cost per tool | Tool Life (parts/tool) | Cost/Part | Tool Name                                                      | Cost per tool | Tool Life (parts/tool) | Cost/Part | Comments                      |
| Rough Turn Barrel                         | Kennametal CNMS432   | \$12          | 300                    | \$ 0.039  | Kennametal CNMS432                                             | \$9           | 150                    | \$ 0.059  | Assumes two sides per insert  |
| Finish Turn Barrel                        | Kennametal DNMG432LF | \$14.63       | 450                    | \$ 0.033  | Kennametal DNMG432LF                                           | \$14.63       | 450                    | \$ 0.033  | Assumes four sides per insert |
| TOTAL COST PER PART (ESTIMATE)            |                      |               |                        | \$0.072   | TOTAL COST PER PART (REVISED PER RUNOFF RESULTS)               |               |                        |           | \$0.091                       |

NOTES:

NOTES:

| Initial Estimate of Tooling Cost and Life                           |                                                     |               |                        |           | New Tooling and Costs based on Engineering Runoff Observations                                       |               |                        |           |                                                                                                                                                                                                                                                                                   |
|---------------------------------------------------------------------|-----------------------------------------------------|---------------|------------------------|-----------|------------------------------------------------------------------------------------------------------|---------------|------------------------|-----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Operation                                                           | Tool Name                                           | Cost per tool | Tool Life (parts/tool) | Cost/Part | Tool Name                                                                                            | Cost per tool | Tool Life (parts/tool) | Cost/Part | Comments                                                                                                                                                                                                                                                                          |
| Face Breech End of Barrel                                           | Insert                                              | \$10.80       | 1000                   | \$0.011   | Insert                                                                                               | \$10.80       | 1000                   | \$0.011   | No Change                                                                                                                                                                                                                                                                         |
| Rough C'Bore to .833 Depth                                          | PILOTED CARBIDE STEP CORE DRILL                     | \$184.78      | 400                    | \$0.462   | 5/8 4-flute Endmill w/ .03 corner radius, Garr EDP#80390                                             | \$61.60       | 200                    | \$0.308   | Tool life approximate and may be low; endmill slipped in collet on last (93rd) part and pulled out. Endmill itself had some BUE but no damage. Most likely a workholding issue (need weldon flat or something similar). May need to switch to coated endmill or an inserted drill |
| Core Drill Chamber Body                                             | 27/64 Carbide 3-flute Drill                         | N/A           | N/A                    | N/A       | 27/64 Carbide 3-flute Drill                                                                          | \$49.77       | 300                    | \$0.166   | Tool had some BUE on it on 93rd (last) part. Tool life approximate but based on actual machining results. Speed might be slow, or might need to coat tool                                                                                                                         |
| Rough Ream Chamber & Cut .025 Chamber Mouth Radius                  | PILOTED ROUGH CHAMBER REAMER                        | \$185.20      | 300                    | \$0.617   | PILOTED ROUGH CHAMBER REAMER                                                                         | \$168.00      | 200                    | \$0.840   | Material gummier than expected; life reduced based on expectation of BUE ruining finish sooner than expected. Might need to coat tool (TiCN or TiAlN)                                                                                                                             |
| Finish Ream Chamber Complete                                        | PILOTED FINISH CHAMBER REAMER                       | \$185.20      | 300                    | \$0.617   | PILOTED FINISH CHAMBER REAMER                                                                        | \$168.00      | 200                    | \$0.840   | Material gummier than expected; life reduced based on expectation of BUE ruining finish sooner than expected. Might need to coat tool (TiCN or TiAlN)                                                                                                                             |
| Finish Counterbore .7045 dia., .708 Diameter, and 45 degree chamfer | FINISH C'BORE TOOL                                  | \$172.33      | 400                    | \$0.431   | Piloted Finish Counterbore Tool, Carbide-Tipped, 3 flute                                             | \$214.00      | 400                    | \$0.535   | Counterbore tool worked well; speed might be low, as some BUE evident, but no major wear evident                                                                                                                                                                                  |
| T-slot cut .925 undercut and .02 x 45 degree chamfer                | .625 DIA. FORM T-SLOT CUTTER                        | \$106.25      | 200                    | \$0.531   | 5/16 T-S. Cobalt T-Slot Cutter, 8 flute (cutting diameter .2132 [.656], shank diameter .2364 [.394]) | \$39.85       | 200                    | \$0.199   | Standard T-slot cutter worked well but was slow. T-slot showed relatively little wear after 75 pcs.; slight BUE                                                                                                                                                                   |
| Rough & Finish Mill Locking Lug Profile                             | 7/32 DIAMETER 4-FLUTE CARBIDE ENDMILL               | \$17.00       | 400                    | \$0.043   | 1/4 6-flute TiCN coated Endmill, Garr EDP#51154                                                      | \$15.51       | 400                    | \$0.039   | Used non-coated, 4-flute carbide endmill with good results after 93 pcs.; little wear visible. Switching to a 6-flute 1/4 endmill will likely result in decreased cycle time and extended life.                                                                                   |
| DEBUR LUG PROFILE                                                   | CARBIDE BURR                                        | \$12.50       | 2000                   | \$0.006   | CARBIDE BURR                                                                                         | N/A           | N/A                    | N/A       | Removed; added two passes to 1/4 endmill                                                                                                                                                                                                                                          |
| Spot Drill for Two Takedown Screw Holes                             | N/A                                                 | N/A           | N/A                    | N/A       | #3 TiN Coated Carbide Center Drill Stores #305184                                                    | \$18.20       | 600                    | \$0.030   | Added spot drill to reduce wear on .213 endmill                                                                                                                                                                                                                                   |
| Endmill two Takedown Scre Holes, Endmill Recoil Lug Slot            | .213 DIAMETER SPECIAL END MILL W/ .015 X 45 CHAMFER | \$13.57       | 500                    | \$0.027   | .213 DIAMETER SPECIAL END MILL W/ .015 X 45 CHAMFER                                                  | \$13.57       | 250                    | \$0.054   | Very little wear visible after 93 pcs.; tool life lowered in anticipation of more wear from slotting operation                                                                                                                                                                    |
| Tap 2 Takedown Screw Holes                                          | 1/4-28 TAP                                          | \$12.68       | 750                    | \$0.017   | 1/4-28 TAP                                                                                           | \$12.68       | 750                    | \$0.017   | Little visible sign of wear; tool life should be OK                                                                                                                                                                                                                               |
| TOTAL COST PER PART (ESTIMATE)                                      |                                                     |               |                        | \$2.762   | TOTAL COST PER PART (REVISED PER RUNOFF RESULTS)                                                     |               |                        |           | \$3.039                                                                                                                                                                                                                                                                           |

Other recommendations:

BARBER - 5.22.06/0010177

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Bbl Chamber Cost Comparison

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Williams v. Remington

**FEDERAL STEEL SUPPLY, INC.**

747 Goddard Ave  
P.O. Box 840  
Chesterfield, MO 63006  
636-537-2393-800-325-1584  
FAX 636-537-8795

|                      |         |                   |
|----------------------|---------|-------------------|
| FEDERAL STEEL SUPPLY | 69107   | PAGE: 1           |
| SALES REP #          | 3       | 3 Vernon C. Smith |
| INVOICE #            | 2       |                   |
| PRICE / QUOTE #      | 51924   | 51924             |
| QUOTE DATE           | 9/08/99 |                   |

ATTENTION:

MET MORGAN

YOUR INQUIRY #

COMPANY:

REMINGTON ARMS  
14 HOEFLER AVE  
ILION, NY 13357

FREIGHT INFO:

CUSTOMER P.O.#

ACCEPTED BY:

**QUOTATION**

| LINE#                                                                                                                                                                                                                                 | DESCRIPTION & PIECE LENGTH                                                         | QTY      | PRICE     | U/M | POUNDS | ITEM TOTAL                   |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------|----------|-----------|-----|--------|------------------------------|
| THIS IS A REQUOTE ON DOM OVER HF SNLS<br>PLEASE NOTE TOLERANCES<br>ITEMS 1 AND 3 AND MIN ROLLINGS DEL 6/7 WEEKS<br>ITEMS 2 AND 4 6/7 WEEK DEL<br>ALL PRICE DELIVERED                                                                  |                                                                                    |          |           |     |        |                              |
| 1                                                                                                                                                                                                                                     | 1.3950 OD X 1.049 ID<br>OD TOL: +.005 -.000 IN ORDER TO MEET .010<br>CONCENTRICITY | 1108 FT  | 3.5200 FT |     |        | 3,900.16                     |
| 2                                                                                                                                                                                                                                     | 1.3950 OD X 1.049 ID                                                               | 10000 FT | 2.8000 FT |     |        | 28,000.00                    |
| 3                                                                                                                                                                                                                                     | .6930 OD X .5010 ID<br>ID TOL: +.000/ -.004 TO MEET .006 CONC.                     | 2500 FT  | 1.4800 FT |     |        | 3,700.00                     |
| 4                                                                                                                                                                                                                                     | .6930 OD X .5010 ID                                                                | 10000 FT | 1.1500 FT |     |        | 11,500.00                    |
| This quotation and all sales resulting from it, are subject<br>to FSSI Standard Terms & Conditions of Sale which are available upon your request.                                                                                     |                                                                                    |          |           |     |        | TAXABLE TOTAL<br>SALES TAX   |
| ALL ITEMS ARE OFFERED SUBJECT TO PRIOR SALE. PRICES IN U.S.\$<br>ALL PRICES SUBJECT TO FINAL CONFIRMATION<br>TERMS: NET 30 DAYS UPON APPROVAL.<br>Visit our Web site at <a href="http://www.fedsteel.com">http://www.fedsteel.com</a> |                                                                                    |          |           |     |        | TOTAL AMOUNT<br>\$ 47,100.16 |

NET TOTAL

MF0228

Remington Arms Company, Inc.

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**Model 710 Engineering Trials Report****Summary**

Engineering trials were conducted on three components of the Model 710 from October 11, 1999 to October 22, 1999 in order to gain more accurate information of tool lives, cycle time, and various other machining parameters. The machining tests were conducted in Charlotte, NC at the Okuma America Technology Institute, and utilized an Okuma LT-15M Turning Center. Technical assistance was provided by Okuma America and Matthew Machinery out of Louisville, KY.

The components machined on the LT-15 were:

- Model 710 Receiver, Part No. 300340
- Model 710 Bolt Body, Part No. 300339
- Model 710 Barrel, Part No. 305315

As a result of these machining tests important information was gathered on the best methods to manufacture these components and the cost associated with each. This information will be used to update and refine the Model 710 Project Estimate prior to final submission. Additionally, several opportunities to improve the manufacturability of the 710 design have been identified as a result of these machining trials. The results of the trials to date are given below.

**Model 710 Receiver**

There were numerous difficulties in machining the receiver. All features could be machined, although some were approximations of cuts and not to the model drawing specs, because the LT-15M available did not have a Y-axis option.

The problems encountered were:

- Boring the I.D. of the receiver due to vibration in the boring bar. This was due to the fact that the ratio of the depth of the receiver that needed to be bored vs. the boring bar diameter was excessively large. When that ratio exceeds 6:1 stock tooling begins to become ineffective at damping out vibration caused by cutting forces (the ratio for this operation is about 8:1). Exacerbating this situation was the fact that the tubing being machined was not to the O.D. & I.D. dimensions planned to be used in production. The closest stock size was used for these trials, but the closest stock material required removing app. 0.100 in. of material from the I.D. to get it to size. Several different methods were tried to overcome the chatter but without much success. Additional work needs to be done to determine the best options for creating the I.D. to model drawing dimensions and tolerances.
- Some difficulty in machining the various slots in the receiver body due to tool chatter. The tool chatter problem can be overcome by tooling changes.
- Chip evacuation was a problem. The low carbon steel w/ low hardness tends to produce long, stringy chips that are hard to break up and tend to tangle inside the receiver body. This can be overcome by more aggressive speeds & feed rates, but low carbon steel also tends to weld to cutting tool surfaces. Therefore, TiN, TiCN, or TiAlN coated tools are necessary to ensure long tool life. Indexable insert endmills may be an option for roughing cuts. The inserts tend to have good chip breaking abilities and are coated.

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**Model 710 Engineering Trials Report****Model 710 Receiver (cont'd)**

Due to these difficulties it was not possible to run a substantial number of components. It was possible, though, to extrapolate the following information:

- **Machine cycle time:** 6 minutes actual vs. an estimated cycle time (100% efficiency) of 5.023 min.
- **Variable Tooling Cost:** \$1.433 per part vs. an estimated cost of \$0.927, due to having to purchase coated tools and reduced life for slotting endmills
- **Labor Run Rate:** .00417 (2 minutes of operator time required per one 8-piece (5 ft.) bar) vs. an estimated run-rate of .00397 (5 minutes of operator time per one 21-piece (12 ft.) bar)
- **Material Cost:** Remnant length app. 6" (same as original estimate). With a 5' long bar, this will result in 8 pcs per bar, and a per piece material cost of \$2.178 vs. an estimated cost of \$1.76. **NOTE:** The initial estimate did not calculate material cost based on DOM material, which will be necessary to use to help eliminate I.D. boring problem. Re-calculating the initial estimate material cost for a 12' bar with 6" remnant at the DOM price of \$3.52 per foot yields a material cost of \$2.028 per part, not \$1.76

More detailed information is given in Appendix A.

The material used was plain low carbon tubing, 1.437" O.D. with 0.25" thick wall. Since a bar feeder was not available, the tubing was cut into 32" lengths which yielded 4 pcs per bar.

There is considerable opportunity to decrease tooling cost by testing indexable insert end mills for roughing the magazine well cut and ejection port cut. This tooling must be tested to see how it performs, though. If it works this style of end mill would replace one end mill completely, with an approximate savings of between \$.30 and \$.40 per part. Its effects on cycle time are not known as of yet.

The machine used for the receiver, the Okuma LT-15M, seems well suited for machining this component complete. The options required to maximize the machine's efficiency still require more research and more information from machining results. Some of the problems encountered, like the formation of long stringy chips, and whether the I.D. has to be bored out, will dictate what kind of bar feeder is purchased and how long the bar stock will be. As things stand right now, if the I.D. has to be machined, then the bar stock length will be limited to about 5' max, and a magazine bar feeder will need to be utilized. Otherwise the chips formed by boring will become too compacted in a longer tube length and will interfere with machining. According to the bar feeder manufacturer normally used by Okuma, LNS, the smaller magazine bar feed system can be modified to provide through the spindle coolant or an air blast to clear chips out, but those options can't be put on a longer bar feeder.

Chips also present a potential problem for unloading the parts as well. LNS has a vacuum parts unloading system to literally suck the parts out through the back of the spindle, but an excessive amount of chips in the parts may interfere with the operation of the unloader. Okuma's parts catcher option for the LT-15 may end up being the better option for automatically unloading finished parts. The Okuma parts catcher will add approximately 7 seconds to any cycle time.

The material price changes above reflect the use of DOM (drawn over mandrel) seamless tubing with additional processing done to it to lower the O.D./I.D. concentricity to at or below 0.01. This concentricity would eliminate the I.D. boring operation and lower tooling cost. It may allow the use of the 12 foot bars again instead of shorter bars, resulting in a material cost of \$2.028, or a reduction of app. \$0.15 per part. The machine cycle time may not be substantially reduced, because the boring is done simultaneously with other operations on back end of the part. As a result the boring time is internal to the process. The concentricity is being reviewed with the tubing vendor to make sure the promised concentricity can be delivered.

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**Model 710 Engineering Trials Report****Model 710 Bolt Body**

There were few problems encountered in machining the bolt body. All features could be machined. The only trouble encountered was with chips packing in the I.D. of the bolt body (same material as the receiver). This caused the insert on the boring bar to fail after approximately 80 pcs. Changing the grooving cycle can reduce chip size. Different types of inserts also need to be explored in order to optimize this tool. Overall, though, the machining went well. The same comments noted about the LT-15M machine and the automation needed for the receiver are equally applicable to the bolt body (i.e., bar stock length, unloading method, etc.). Cycle times, run-rates, etc. are given below:

- **Machine cycle time:** 1.933 minutes actual vs. an estimated cycle time (100% efficiency) of 1.959 min.
- **Variable Tooling Cost:** \$0.285 per part vs. an estimated cost of \$0.24, due primarily to decreased life in grooving insert
- **Labor Run Rate:** .00333 (2 minutes of operator time required per one 10-piece (5 ft.) bar) vs. an estimated run-rate of .00321 (5 minutes of operator time per one 26-piece (12 ft.) bar)
- **Material Cost:** Remnant length app. 4" (same as original estimate). With a 5' long bar, this will result in 10 pcs per bar, and a per piece material cost of \$0.74 vs. an estimated cost of \$0.74.

More detailed information see Appendix A.

The material used was plain low carbon tubing, 0.75" O.D. with a .134" thick wall. Since a bar feeder was not available, the tubing was cut into 32" lengths, which yielded 5 pcs per bar.

**Model 710 Barrel**

There were few problems in machining the barrel chamber area. The features machined were the chamber, counterbore, bolt head clearance cuts and takedown screw holes. The machine available for use at Okuma did not have a Y-axis option; therefore the recoil lug slot could not be machined. It should be noted here that the machine desired to run the barrel chamber operation is an LB-300 MY lathe. The LT-15M was used to simulate this machine, as Okuma did not have an LB-300 available for use.

The primary difficulty encountered was machining the  $\varnothing .925 \times .325$  wide undercut. The tooling initially chosen, a grooving boring bar, ended up being too marginal to be used. The bar tended to rub in the counterbore when cutting to full depth. Several modifications to the boring bar head were tried; enough clearance was added for the bar to clear the counterbore, but it made the head too weak and it would break after 5 or so pcs. As a result a 5/16 HS cobalt T-slot cutter was used to cut the undercut groove. This change resulted in an additional minute being added to the cycle time. More research into different boring bars is needed in order to find a standard bar that will suit this operation. None have been found to date.

There was some chatter encountered initially in the cutting of the bolt head relief cuts (the "ears"). Feeds & speeds were modified to eliminate this problem; this resulted in the addition of app. 30 seconds to the cycle time. Different tooling choices will help in speeding up this operation.

The 4140 barrel material used in this runoff is not heat treated at this point in the barrel process, unlike a M700 barrel. Therefore the steel adhered more readily to cutting tools. As a result of this the tool lives for the rough and finish reamers were reduced to ensure the chamber finish remained good enough. This will make sure there aren't any secondary chamber burnishing operations required.

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**Model 710 Engineering Trials Report****Model 710 Barrel (cont'd)**

As previously stated above, the slot could not be cut in the barrel. Based on the experience gained from these trials, it is estimated that the recoil lug slot will add approximately 20 seconds (.33 min) to the cycle time. Load/unload time was approximately 10 seconds (.1667 min.). The cycle times, etc. are given below:

- **Machine cycle time (including estimate of Recoil Lug Slot & load/unload):** 5.57 minutes actual vs. an estimated cycle time (100% efficiency) of 3.69 min., due primarily to the use of the T-cutter and slowing down the bolt head relief cut
- **Variable Tooling Cost:** \$3.039 per part vs. an estimated cost of \$2.762, due primarily to decreased life in the rough and finish reamers
- **Labor Run Rate:** .0928 vs. an estimated run-rate of .06146
- **Material Cost:** Not applicable for this operation

More detailed information see Appendix A.

**Conclusions**

As a result of these trials, the following conclusions could be formulated:

- The total labor run-rate for the Model 710 project increased by .06 from the original estimate. This does not match the total increase list here (the total increase reported up to this point amounts to an increase of .1317). In the process of running barrels up to the point where they were ready for the trials other information on cycle times were gathered. This resulted in no change in run rates for the barrel gundrill, ream, and rifle operations, and an increase of app. .03 to the turn operation. An additional turning pass was added to the turning operation.
- The total variable tooling cost increased by a total of \$0.72 from the original estimate. This does not match the total increase list here (the total increase reported up to this point amounts to an increase of \$0.829. In the process of running barrels up to the point where they were ready for the trials other information on tool lives and cycle times were gathered. This resulted in a tooling cost reduction of \$0.109 for the barrel gundrill, ream, rifle, and turn operations.
- The total material cost for the Model 710 project should increase by app. \$0.44, due primarily to the increase in the receiver cost.
- Pending complete dimensional inspections it seems that the LT-15M turning center (and by inference the LB-300) is capable of running repeatable, consistent parts. This initial conclusion is based on spot checks of critical dimensions of parts. The final conclusions will be based on inspections of the parts and statistical analysis of the data over the next two weeks.
- Due to the trouble encountered with the receiver, it is desired that a return trip to Okuma be planned to follow up with optimizing the receiver process so better definitions on tooling cost and cycle times can be created.

Please note that the above changes are taken in isolation and may be offset by other recent information (quotes, etc.).

MF0232

*Remington Arms Company, Inc.***Confidential****Model 710 Engineering Trials Report*****Conclusions (cont'd)***

In conclusion, Remington now possesses solid, if somewhat un-optimized, machining processes for the chamber and bolt body complete, and it is felt by both Matthew Machinery and Okuma that a solid process is achievable for the receiver with an additional weeks worth of work at Okuma. Beyond that, there are several opportunities and paths forward to decrease the run times and tooling costs from the values stated above, but they may take up to several months to implement and optimize.

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Model 710 Engineering Trials Report

Appendix A:

**Tooling Cost Comparison – Estimate vs. Runoff**

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| Model 710 Component           | Operation        | Initial Tooling Cost Estimate (per part) | Revised Tooling Cost based on Runoff Data (per part) | Change in \$ [Note: ( ) favorable] | % Change |
|-------------------------------|------------------|------------------------------------------|------------------------------------------------------|------------------------------------|----------|
| Receiver                      | Machine Complete | \$ 0.927                                 | \$ 1.433                                             | \$ 0.506                           | 55%      |
| Barrel                        | Gundrill         | \$ 0.119                                 | \$ 0.176                                             | \$ 0.056                           | 47%      |
|                               | Ream, Rifle      | \$ 0.386                                 | \$ 0.202                                             | \$ (0.184)                         | -48%     |
|                               | Turn O.D.        | \$ 0.072                                 | \$ 0.091                                             | \$ 0.020                           | 27%      |
|                               | Chamber Complete | \$ 2.762                                 | \$ 3.039                                             | \$ 0.277                           | 10%      |
| Bolt Body                     | Machine Complete | \$ 0.240                                 | \$ 0.285                                             | \$ 0.046                           | 19%      |
| Total Change-Variable Tooling |                  |                                          |                                                      | \$ 0.720                           |          |

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Summary

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| Initial Estimate of Tooling Cost and Life                                |                                              |               |                        |           | New Tooling and Costs based on Engineering Runoff Observations                                                                                 |               |                        |           |                                                                                                                                                                                               |
|--------------------------------------------------------------------------|----------------------------------------------|---------------|------------------------|-----------|------------------------------------------------------------------------------------------------------------------------------------------------|---------------|------------------------|-----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Operation                                                                | Tool Name                                    | Cost per tool | Tool Life (parts/tool) | Cost/Part | Tool Name                                                                                                                                      | Cost per tool | Tool Life (parts/tool) | Cost/Part | Comments                                                                                                                                                                                      |
| MILL FIRE CONTROL SLOT, FINISH MILL MAGAZINE BOX SLOT                    | 15/64 Carbide Endmill, 3-flute               | \$10.05       | 225                    | \$0.045   | 320 3-flute TiCN coated Carbide Endmill, Garr Tool EDP#12204 (21/64 or .328), Modified std                                                     | \$33.01       | 225                    | \$0.147   | Modified std to get fire control slot to size; assumes design changes will allow magazine well radii to be changed to .160; new price assumed to Garr list price plus 20%                     |
| ROUGH MILL MAGAZINE BOX SLOT, MILL RECEIVER TOP TANG RADIUS CUT          | 3/4 Carbide Endmill                          | \$72.34       | 250                    | \$0.289   | 3/4 3-flute TiCN Carbide Endmill, Garr Tool EDP#12354, Modified std w/ .125 corner radius and short (1") flute length                          | \$112.80      | 250                    | \$0.451   | Tool life lowered based on uncertainty caused by runoff performance of original endmill; new price assumed to Garr list price plus 20%                                                        |
| CENTER DRILL FOR .265 CLEARANCE HOLE, SCOPE SCREW HOLES                  | 3/8 NC Spot Drill                            | \$13.95       | 450                    | \$0.031   | #3 TiN Coated Carbide Center Drill, Stores #306184                                                                                             | \$18.20       | 600                    | \$0.030   | was 3/8 carbide spot drill; however, performance at run-off resulted in change; tool life based on 597 bbl assy (300 pcs. Per end; double-ended)                                              |
| DRILL .265 CLEARANCE HOLE                                                | 17/64 Carbide Drill                          | \$17.77       | 500                    | \$0.036   | 17/64 HSS Screw Machine Length Drill, MSC #63804462 (Cleveland Twist)                                                                          | \$1.66        | 250                    | \$0.007   | Was 17/64 Carbide 3-flute; change made based on run-off experience                                                                                                                            |
| ROUGH MILL EJECTION PORT, FINISH MILL EJECTION PORT, MILL BOLT STOP FLAT | 1/2 Carbide Endmill                          | \$25.59       | 400                    | \$0.064   | 15mm (.593") 3-flute TiCN coated Carbide Endmill, Garr Tool EDP#12334 (5/8 endmill), Modified std w/ .06 corner radius                         | \$79.64       | 250                    | \$0.319   | Tool life lowered based on uncertainty caused by runoff performance of original endmill; new price assumed to Garr list price plus 20%                                                        |
| MILL EJECTION PORT MOUTH                                                 | Special 3/4 Endmill w/ .625 Spherical Radius | \$133.85      | 500                    | \$0.268   | Special 3/4" Endmill w/ .625 radius nose, 2 flutes, Modified standard of Garr EDP#51354, Cost equivalent to 597 hammer endmill, Stores #306633 | \$133.85      | 500                    | \$0.268   | Four flute tended to chatter on entry; need either a 2, 3, or 6+ flutes to eliminate chatter; price based on M597 hammer endmill as worst case; tool life based on 1/2 of hammer endmill life |
| MILL BOLT HANDLE CAM/CLEARANCE CUT                                       | 3/8 Carbide Endmill                          | \$15.97       | 225                    | \$0.071   | 3/8 Carbide Endmill, 6-flute, TiCN coated, Garr EDP#51234                                                                                      | \$26.12       | 225                    | \$0.116   | Based on 597 carbon bolt 1/4" emill at 225 pt/tool                                                                                                                                            |
| TAP DRILL FOR SCOPE SCREW HOLES                                          | #30 Drill                                    | \$0.66        | 250                    | \$0.003   | #30 Drill                                                                                                                                      | \$0.66        | 250                    | \$0.003   | based on 597 barrels job                                                                                                                                                                      |
| TAP #6-48 SCOPE SCREW HOLES                                              | #6-48 NS-2 Tap                               | \$14.25       | 750                    | \$0.019   | #6-48 NS-2 Tap                                                                                                                                 | \$14.25       | 750                    | \$0.019   | based on 597 barrel job                                                                                                                                                                       |
| DRILL .279 HOLE                                                          | 7.1mm Drill                                  | \$18.80       | 500                    | \$0.038   | "K" (.281) HSS Screw Machine Length Drill, MSC #63792105, (Cleveland Twist)                                                                    | \$2.32        | 250                    | \$0.009   | Was 7.1mm carbide; change made based on runoff experience                                                                                                                                     |
| COUNTERBORE 1.227                                                        | Insert                                       | \$12.00       | 500                    | \$0.024   | Insert                                                                                                                                         | \$12.00       | 500                    | \$0.024   |                                                                                                                                                                                               |
| CUT-OFF                                                                  | Insert                                       | \$10.16       | 250                    | \$0.041   | Insert                                                                                                                                         | \$10.16       | 250                    | \$0.041   | TL BASED ON 597 CUTOFF AND CROWN OPERATION                                                                                                                                                    |
| TOTAL COST PER PART (ESTIMATE)                                           |                                              |               |                        | \$0.927   | TOTAL COST PER PART (REVISED PER RUNOFF RESULTS)                                                                                               |               |                        |           | \$1.433                                                                                                                                                                                       |

**Other recommendations:**

- 1). May want to try inserted endmill for roughing 3/4 slot for magazine well. If it works the cost per part would most likely drop to between \$.06 and \$.15 per part (assumes \$15.00/insert and tool life between 100 & 250 pcs per insert)
- 2). May want to add a small face mill to cut top tang and bolt stop flat. This would create better finish, and allow us to buy an LT-15 w/o the Y-axis option. Looking at a Sandvik Coro-Mill 200 or similar. This uses three round carbide inserts and is commonly used in the mold and die industry for milling contours.

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10/26/99

Receiver Tool Cost Comparison

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| Initial Estimate of Tooling Cost and Life                         |                              |               |                        |           | New Tooling and Costs based on Engineering Runoff Observations |               |                        |           |                                                                                                                                                                                                |
|-------------------------------------------------------------------|------------------------------|---------------|------------------------|-----------|----------------------------------------------------------------|---------------|------------------------|-----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Operation                                                         | Tool Name                    | Cost per tool | Tool Life (parts/tool) | Cost/Part | Tool Name                                                      | Cost per tool | Tool Life (parts/tool) | Cost/Part | Comments                                                                                                                                                                                       |
| SPOT FACE FOR .250 C-DATUM HOLE,FINISH MILL CAM CUT               | 5/32 ENDMILL                 | \$7.99        | 250                    | \$0.032   | 3/16 6-flute Endmill, TiCN coated, Garr EDP# 51114             | \$11.47       | 400                    | \$0.029   | Used a 2-flute HSS TiN Coated Endmill for runoff with little wear after app. 130 pcs; carbide will give longer life and better finish                                                          |
| SPOT DRILL .250 C-DATUM HOLE,SPOT DRILL .250 BOLT HANDLE PIN HOLE | 3/8 NC Spot Drill            | \$13.95       | 450                    | \$0.031   | 3/8 NC Coated Carbide Center Drill, Stores #306184             | \$18.20       | 600                    | \$0.030   | Replaced 3/8 NC Spot Drill with center drill                                                                                                                                                   |
| DRILL .250 C-DATUM HOLE,DRILL .250 BOLT HANDLE PIN HOLE           | .250 CARBIDE DRILL           | \$16.33       | 250                    | \$0.065   | 1/4 Carbide 2-flute Drill, TiCN coated, Screw Machine Length   | \$20.05       | 400                    | \$0.050   | was 3/8 carbide spot drill; however, performance at run-off resulted in change; tool life based on 597 bbl assy (300 pcs. Per end; double-ended)                                               |
| MILL .125R SLOTS                                                  | 3/16 CARBIDE ENDMILL,4 FLUTE | \$6.82        | 225                    | \$0.030   | 1/4 4-flute Carbide Endmill, Garr Tool EDP# 43150              | \$10.20       | 300                    | \$0.034   |                                                                                                                                                                                                |
| TURN FIRING PIN HEAD RETAINING GROOVE                             | KC 720 INSERT                | \$10.16       | 250                    | \$0.041   | KC 720 INSERT                                                  | \$10.16       | 100                    | \$0.102   | Insert Broke at app. 90 pcs due to insufficient chip evacuation inside hole; can be overcome by tooling/coolant options                                                                        |
| CUT-OFF                                                           | Insert                       | \$10.16       | 250                    | \$0.041   | Insert                                                         | \$10.16       | 250                    | \$0.041   | Four flute tended to chatter on entry; need either a 2, 3, or 6+ flutes to eliminate chatter; price based on M/597 hammer endmill as worst case; tool life based on 1/2 of hammer endmill life |
| TOTAL COST PER PART (ESTIMATE)                                    |                              |               |                        | \$0.240   | TOTAL COST PER PART (REVISED PER RUNOFF RESULTS)               |               |                        |           | \$0.285                                                                                                                                                                                        |

**NOTES:**

Tooling Cost for Cut-off & Spot Drill were omitted from original estimate - they are added here

**Other recommendations:**

| Initial Estimate of Tooling Cost and Life |           |               |                                |           | New Tooling and Costs based on Engineering Runoff Observations |               |                                                  |           |                                                                                                                                                             |
|-------------------------------------------|-----------|---------------|--------------------------------|-----------|----------------------------------------------------------------|---------------|--------------------------------------------------|-----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Operation                                 | Tool Name | Cost per tool | Tool Life (parts/tool)         | Cost/Part | Tool Name                                                      | Cost per tool | Tool Life (parts/tool)                           | Cost/Part | Comments                                                                                                                                                    |
| Gun Drill                                 | Drills    | \$10.02       | 100                            | \$0.100   | Drills                                                         | \$23.50       | 150                                              | \$0.157   | Cost is a composite of new drill cost and regrinds; assumes 1 new drill @ \$90, 5 regrinds @ \$12 ea, 1 re-tip @ \$72, and 5 additional regrinds @ \$12 ea. |
| Gun Drill                                 | Bushings  | \$61.95       | 10,000                         | \$0.006   | Bushings                                                       | \$61.95       | 10,000                                           | \$0.006   |                                                                                                                                                             |
| Gun Drill                                 | Gizmos    | \$4.50        | 1,000                          | \$0.005   | Gizmos                                                         | \$4.50        | 1,000                                            | \$0.005   |                                                                                                                                                             |
| cut off                                   | saw blade | \$16.80       | 2,000                          | \$0.008   | saw blade                                                      | \$16.80       | 2,000                                            | \$0.008   |                                                                                                                                                             |
|                                           |           |               |                                |           |                                                                |               |                                                  |           |                                                                                                                                                             |
|                                           |           |               | TOTAL COST PER PART (ESTIMATE) | \$0.119   |                                                                |               | TOTAL COST PER PART (REVISED PER RUNOFF RESULTS) | \$0.176   |                                                                                                                                                             |

**NOTES:**

Average Regrind Cost Mistakenly placed in tool cost for gundrill

**NOTES:**

| Initial Estimate of Tooling Cost and Life |           |               |                        |           | New Tooling and Costs based on Engineering Runoff Observations |               |                        |           |          |
|-------------------------------------------|-----------|---------------|------------------------|-----------|----------------------------------------------------------------|---------------|------------------------|-----------|----------|
| Operation                                 | Tool Name | Cost per tool | Tool Life (parts/tool) | Cost/Part | Tool Name                                                      | Cost per tool | Tool Life (parts/tool) | Cost/Part | Comments |
| Ream                                      | Reamer    | \$97.90       | 1000                   | \$0.10    | Reamer                                                         | \$126.55      | 1000                   | \$0.13    |          |
| Rifle                                     | Button    | \$576.00      | 2000                   | \$0.29    | Button                                                         | \$300.00      | 4000                   | \$0.08    |          |
| TOTAL COST PER PART (ESTIMATE)            |           |               |                        | \$0.386   | TOTAL COST PER PART (REVISED PER RUNOFF RESULTS)               |               |                        |           | \$0.202  |

NOTES:

NOTES:

|                                            | Receiver | Current Receiver | Revised Receiver | Current Bolt Body | Revised Bolt Body |
|--------------------------------------------|----------|------------------|------------------|-------------------|-------------------|
|                                            | 597      | 710              | 710              | 710               | 710               |
| Run Time                                   | 0.0530   | 0.0055           | 0.0058           | 0.0032            | 0.0033            |
| Material (includes Powder Coat)            | 3.40     | 1.76             | 2.18             | 0.74              | 0.74              |
| Labor                                      | 0.56     | 0.06             | 0.06             | 0.03              | 0.03              |
| Incremental Overhead                       |          |                  |                  |                   |                   |
| Employee Benefits 58%                      | 0.32     | 0.03             | 0.04             | 0.02              | 0.02              |
| Tooling Costs                              | 0.30     | 1.02             | 1.43             | 0.24              | 0.29              |
| Deprciation                                | 0.32     | 1.38             | 1.38             | 0.80              | 0.80              |
| Property Taxes (.008 of Fixed Asset Costs) | 0.04     | 0.11             | 0.11             | 0.05              | 0.05              |
| Electricity (estimated)                    | 0.02     | 0.08             | 0.08             | 0.04              | 0.04              |
|                                            | 4.96     | 4.44             | 5.28             | 1.93              | 1.98              |

Note: 1) Depreciation based on 58,000 597s and 20,000 710s

2) Depreciation on Receiver & Bolt Body on \$500,000 machine allocated on Run Time (63% receiver 37% Bolt Body)

MF0240

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lost HEAD

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MF0241

Golemboski, Matt R.

---

From: Morgan, Metty E.  
Sent: Friday, March 31, 2000 1:57 PM  
To: Golemboski, Matt R.  
Cc: Zajk, Joseph J  
Subject: Megamet

03/31/2000

Matt,

Jim from Megamet informed me this morning that they ran some parts and inspected them only to find that one of the dimensions was off. They are re-cutting one of the plates and should have samples to us by Wed. of next week.

Mett

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Golemboski, Matt R.

---

From: Morgan, Metty E.  
Sent: Tuesday, April 25, 2000 9:53 AM  
To: Golemboski, Matt R.  
Cc: Helmer, Gerald A.  
Subject: Megamet

04/25/2000

Matt / Jerry,

Jim at Megamet said the Firing Pin Heads are in the furnace and the Lock Tumblers are in the press, we should have both by week end. He is sorry for the early on performance and assures me they will perform much better. I told him we were not happy with his initial start up performance and that they must do better to expect anymore future business.

FYI  
Mett

CONFIDENTIAL 83

#00338 - Bolt Head

| OP #   | PROCESS DESCRIPTION                                     | MACHINE DESCRIPTION | Part# | Prp | Rev | Material | Std. Run Hours | Variable Overhead \$ | Prep \$     | Capital \$    | PPI Gages \$ | Material Handling | Comments                                        |
|--------|---------------------------------------------------------|---------------------|-------|-----|-----|----------|----------------|----------------------|-------------|---------------|--------------|-------------------|-------------------------------------------------|
|        | Blank Material Gages                                    |                     |       |     |     | \$ 1.75  |                |                      |             |               | \$ 120.00    |                   | Parker & Harper Mfg. Company<br>Estimated Quote |
| 1      | Superabrasive Grind Lugs                                |                     |       |     |     | \$0.00   | 0.01887        | 85625                | \$2,040     | \$31,500      |              |                   | Superabrasive grind lugs                        |
| 2      | CNC Machine Bolt Face Complete                          |                     |       |     |     | \$0.00   | 0.019810       | \$ 0.28              | \$ 2,141.95 | \$154,500     |              |                   | M710 Bolt Head CNC Machine Face                 |
| 3      | CNC Machine Bolt Head Retaining Pin Hole                |                     |       |     |     | \$0.00   | 0.00756        | \$ 0.14              | \$ 1,262.43 | \$15,000      |              |                   | M710 Bolt Head Ejector Retaining Hole           |
| 4      | CNC Machine Cam Cut: Ejector Retaining Pin Hole, Deburr |                     |       |     |     | \$0.00   | 0.017820       | \$ 0.08              | \$ 1,557.00 | \$15,000      |              |                   | M710 Bolt Head Retaining Hole and Cam Cut       |
| 5      | Punch Form Extractor Rotation Notch                     |                     |       |     |     | \$0.00   | 0.006380       |                      |             |               |              |                   |                                                 |
| 6      | Vendor Heat Treat & Inspect for Hardness                |                     |       |     |     | \$0.00   |                |                      |             |               |              |                   |                                                 |
| 7      | Black Oxide                                             |                     |       |     |     | \$0.00   | 0.001330       | \$ -                 | \$ 800.00   | \$0           |              |                   | M710 Bolt Head Black Oxide                      |
| Totals |                                                         |                     |       |     |     | \$ 1.75  | 0.05232        | \$ 0.50              | \$ 7,861.38 | \$ 216,000.00 | \$ 120.00    | \$ -              |                                                 |

710 Complete 1

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|    | PROCESS DESCRIPTION    | MACHINE DESCRIPTION | Capital \$ | Ops \$ | Depart. Number | Depart. Labor \$ | Total % Overhead | Std. Run Hours | Material \$ | Labor \$ | Fixed Overhead \$ | Variable Overhead \$ | Total Overhead \$ | Oper. Cost |
|----|------------------------|---------------------|------------|--------|----------------|------------------|------------------|----------------|-------------|----------|-------------------|----------------------|-------------------|------------|
| 10 | Wash & Projection Weld |                     | \$ -       | \$ -   | 8551           | \$ 18.39         | 240.20%          | 0.003696       | \$ -        | \$ 0.07  | \$ 0.02           | \$ 0.15              | \$ 0.16           | \$ 0.23    |
| 20 | Micro-Carb             |                     | \$ -       | \$ -   | 8551           | \$ 18.39         | 240.20%          | 0.000529       | \$ -        | \$ 0.01  | \$ 0.00           | \$ 0.02              | \$ 0.02           | \$ 0.03    |
| 30 | Lindberg Draw          |                     | \$ -       | \$ -   | 8551           | \$ 18.39         | 240.20%          | 0.000680       | \$ -        | \$ 0.01  | \$ 0.00           | \$ 0.03              | \$ 0.03           | \$ 0.04    |
| 40 | Inspect                |                     | \$ -       | \$ -   | 8551           | \$ 18.39         | 240.20%          | 0.000001       | \$ -        | \$ 0.00  | \$ 0.00           | \$ 0.00              | \$ 0.00           | \$ 0.00    |
| 50 | Sweco                  |                     | \$ -       | \$ -   | 8551           | \$ 18.39         | 240.20%          | 0.000160       | \$ -        | \$ 0.00  | \$ 0.00           | \$ 0.01              | \$ 0.01           | \$ 0.01    |
| 60 | Black Oxide Color      |                     | \$ -       | \$ -   | 8551           | \$ 18.39         | 240.20%          | 0.000109       | \$ -        | \$ 0.00  | \$ 0.00           | \$ 0.00              | \$ 0.00           | \$ 0.01    |
|    |                        |                     |            |        |                |                  |                  |                |             |          |                   |                      |                   |            |
|    |                        |                     |            |        |                |                  |                  |                |             |          |                   |                      |                   |            |
|    |                        |                     |            |        |                |                  |                  |                |             |          |                   |                      |                   |            |
|    |                        |                     |            |        |                |                  |                  |                |             |          |                   |                      |                   |            |
|    |                        |                     |            |        |                |                  |                  |                |             |          |                   |                      |                   |            |
|    | Totals                 |                     | \$ -       | \$ -   |                |                  |                  | 0.001479       | \$ -        | \$ 0.10  | \$ 0.03           | \$ 0.20              | \$ 0.23           | \$ 0.32    |

Simple - TAB and no

[illegible]

COPY

**STERLING SINTERED TECHNOLOGIES, INC.**

P.O. BOX 1057 • WINSTED, CONNECTICUT 06098  
(860) 379-2753 • FAX: (860) 738-0564

## Q U O T A T I O N

NUMBER 2935      DATE 8/12/99

TO REMINGTON ARMS CO., INC.  
MAYFIELD PLANT  
22 RIFLE TRAIL  
HICKORY KY 42051

SHIP  
TO

PH 502/856-4204 Fax 502/856-3233

| NET 30 DAYS                                   |                | TERMS      | SHIP VIA  | SALES PERSON | PAGE |
|-----------------------------------------------|----------------|------------|-----------|--------------|------|
|                                               |                |            |           | 6            | 1    |
| QUANTITY                                      | DESCRIPTION    | UNIT PRICE | AMOUNT    |              |      |
| 20,000                                        | Part # C-91852 |            |           |              |      |
| 10,000                                        | Rev 5          |            |           |              |      |
| 120,000                                       | BUTTON         | 108.30/M   | 2,166.00  |              |      |
|                                               |                | 95.80/M    | 3,832.00  |              |      |
|                                               |                | 85.90/M    | 10,308.00 |              |      |
|                                               | Misc Charges:  |            |           |              |      |
|                                               | TOOLING        |            | 4,700.00  |              |      |
| *PLEASE NOTE: QUOTED +/- .003 ON .280 LENGTH  |                |            |           |              |      |
| 50% OF TOOLING CHARGE DUE WITH PURCHASE ORDER |                |            |           |              |      |
| BALANCE UPON APPROVAL OF TOOLING SAMPLES.     |                |            |           |              |      |
| TOOLING SAMPLES WILL BE SHIPPED 12 WEEKS ARO  |                |            |           |              |      |
| PRODUCTION TO FOLLOW TOOL APPROVAL BY 6-8     |                |            |           |              |      |
| WEEKS UNLESS CUSTOMER ACCEPTS RESPONSIBILITY  |                |            |           |              |      |
| FOR PRODUCTION, GIVEN THAT IT MEETS THE PRINT |                |            |           |              |      |
| THIS QUOTE IS GOOD FOR 30 DAYS FROM THE QUOTE |                |            |           |              |      |
| DATE.                                         |                |            |           |              |      |
| OUR REVISION CONTROL PROCEDURE REQUIRES THAT  |                |            |           |              |      |
| PRINT REVISION LEVELS ACCOMPANY ALL PURCHASE  |                |            |           |              |      |
| ORDERS. PLEASE ASSIST US IN OUR CONTINUOUS    |                |            |           |              |      |
| IMPROVEMENT PROCESS.                          |                |            |           |              |      |
| THANK-YOU FOR THE OPPORTUNITY TO QUOTE.       |                |            |           |              |      |
| ANN DELUTRIE                                  |                |            |           |              |      |

P.03

4990827380664

AUG-12-99 01:47 PM

MF0246

CONFIDENTIAL

83

*But stop*

MF0247

CONFIDENTIAL 83

*Rec'd Barber*

MF0248

CONFIDENTIAL

83

FILED IN TIP/PRO/PRO

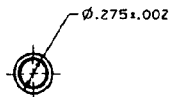
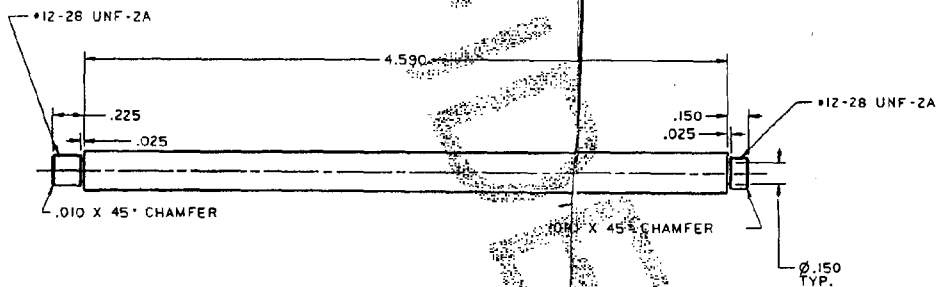
MF0249

[illegible]

C-300334

DO NOT SCALE THIS CHARTING; WORK TO FIGURES  
IN 1/8 OTHERWISE NOTED.  
UN RANGES ON DECIMAL DIMENSIONS ARE:  
RACE 1.01 - TOLERANCE .2 .3/8  
PLACE 1.01 - TOLERANCE .5 .5/8  
PLACE 1.001 - TOLERANCE .4 .5/8  
FRAC FORMAL DIMENSIONS .1/8  
4 AMERICAN DIMENSIONS .2 .3/8  
5 DIMS ARE DESIGNATED BY ROOT MEAN  
SQ UN U.S.J. MICRO-INCH ROUGHNESS  
7 ARE AND ARE THE MAXIMUM SPECIFIED  
AG PTAINLE, UNLESS OTHERWISE INDICED.  
F IN ROUGHNESS TO BE  $\sqrt{\quad}$  OR BETTER.

MATERIAL 4151 1215  
HEAT TREAT NONE  
HARDNESS RB 89 MIN.  
COLOR BLACK OXIDE  
HEAT TREAT AND COLOR TO BE DONE BY  
REXINGTON

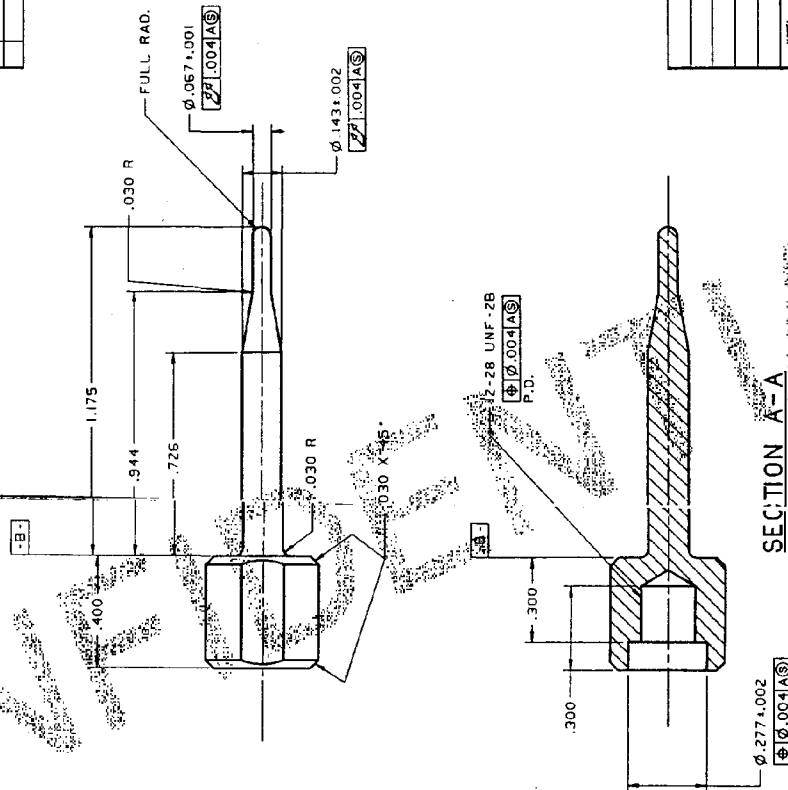
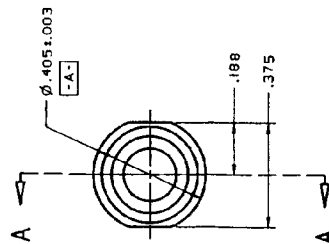
[illegible][illegible]

CV FILENAME - PARTS.RIF.710.FIRING-PIN.300334

THIS DRAWING OR INFORMATION IS  
 PROPRIETARY INFORMATION TO THE  
 REMINGTON ARMS COMPANY, INC.



ISO VIEW  
SCALE 2:1



SECTION A-A

[illegible]

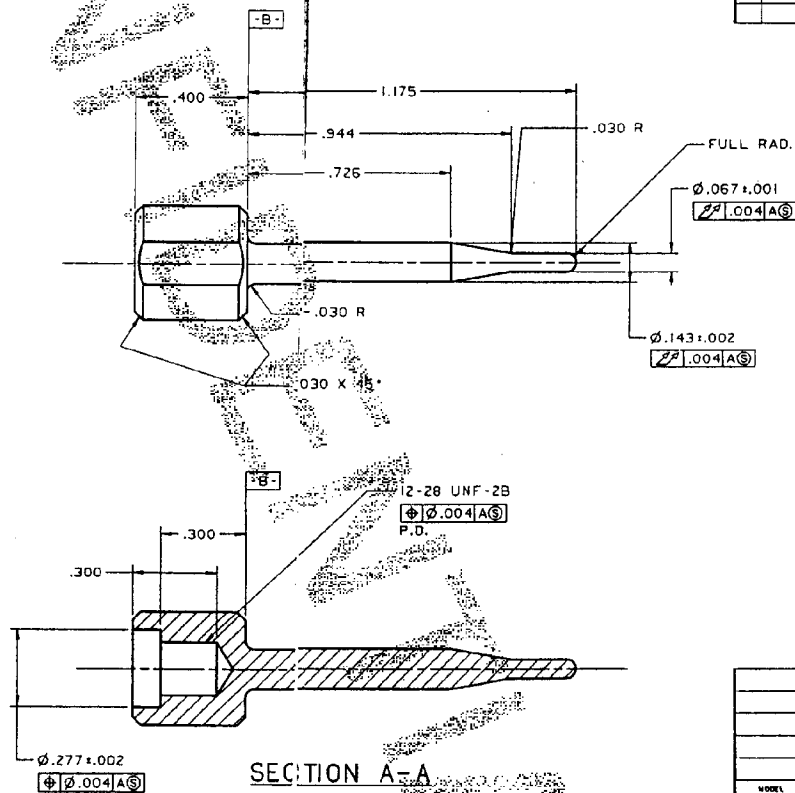
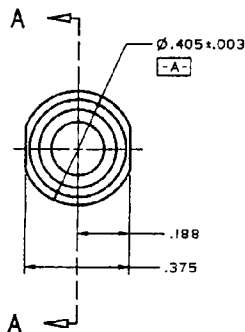
|                |     |             |     |            |     |            |     |
|----------------|-----|-------------|-----|------------|-----|------------|-----|
| FIRING PIN TIP |     | WEAR<br>4-1 |     | UNEMPLOYED |     | REEMPLOYED |     |
| TYPE           |     | DATE        |     | NAME       |     | ADDRESS    |     |
| 1              | 2   | 3           | 4   | 5          | 6   | 7          | 8   |
| 9              | 10  | 11          | 12  | 13         | 14  | 15         | 16  |
| 17             | 18  | 19          | 20  | 21         | 22  | 23         | 24  |
| 25             | 26  | 27          | 28  | 29         | 30  | 31         | 32  |
| 33             | 34  | 35          | 36  | 37         | 38  | 39         | 40  |
| 41             | 42  | 43          | 44  | 45         | 46  | 47         | 48  |
| 49             | 50  | 51          | 52  | 53         | 54  | 55         | 56  |
| 57             | 58  | 59          | 60  | 61         | 62  | 63         | 64  |
| 65             | 66  | 67          | 68  | 69         | 70  | 71         | 72  |
| 73             | 74  | 75          | 76  | 77         | 78  | 79         | 80  |
| 81             | 82  | 83          | 84  | 85         | 86  | 87         | 88  |
| 89             | 90  | 91          | 92  | 93         | 94  | 95         | 96  |
| 97             | 98  | 99          | 100 | 101        | 102 | 103        | 104 |
| 105            | 106 | 107         | 108 | 109        | 110 | 111        | 112 |
| 113            | 114 | 115         | 116 | 117        | 118 | 119        | 120 |
| 121            | 122 | 123         | 124 | 125        | 126 | 127        | 128 |
| 129            | 130 | 131         | 132 | 133        | 134 | 135        | 136 |
| 137            | 138 | 139         | 140 | 141        | 142 | 143        | 144 |
| 145            | 146 | 147         | 148 | 149        | 150 | 151        | 152 |
| 153            | 154 | 155         | 156 | 157        | 158 | 159        | 160 |
| 161            | 162 | 163         | 164 | 165        | 166 | 167        | 168 |
| 169            | 170 | 171         | 172 | 173        | 174 | 175        | 176 |
| 177            | 178 | 179         | 180 | 181        | 182 | 183        | 184 |
| 185            | 186 | 187         | 188 | 189        | 190 | 191        | 192 |
| 193            | 194 | 195         | 196 | 197        | 198 | 199        | 200 |
| 201            | 202 | 203         | 204 | 205        | 206 | 207        | 208 |
| 209            | 210 | 211         | 212 | 213        | 214 |            |     |

CV FILENAME : PARTS, RIF. 710, FIRING-PIN- TP 300335

THIS DRAWING OR INFORMATION IS  
 PROPRIETARY INFORMATION TO THE  
 RAYNOLSON ARMS COMPANY, INC.

### MATERIAL AND HEAT TREAT

MATERIAL AISI 8620  
HEAT TREAT CARBURIZE 1.70% C POTENTIAL  
HARDNESS R15N 87 MAX CORE, R15N 98-92 CASE  
COLOR BLACK OXIDE  
HEAT TREAT AND COLOR TO BE DONE BY  
REMINGTON



SECTION A-A

CY FILENAME : PARTS.BIF.710.FIRING-PIN-TIP.300335

THIS DRAWING OR INFORMATION IS  
 PROPRIETARY INFORMATION TO THE  
 REMINGTON ARMS COMPANY, INC.

DO NOT SCALE THIS DRAWING: WORK TO FIGURES  
UNLESS OTHERWISE NOTED.

TOLERANCES ON DECIMAL DIMENSIONS ARE:

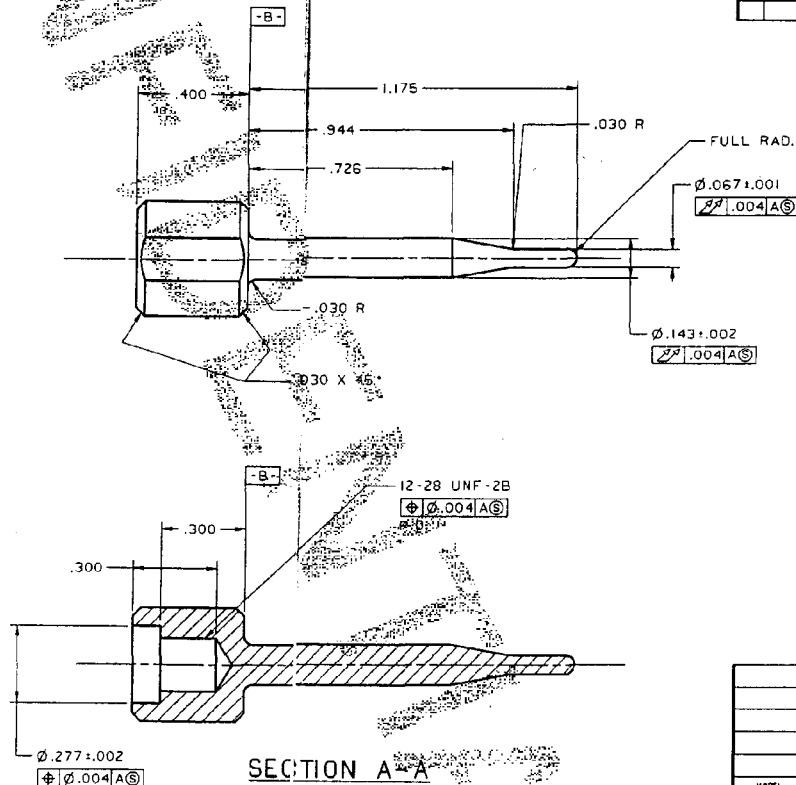
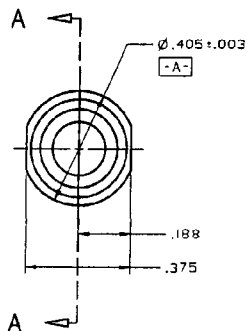
PLACE .10 - TOLERANCE  $\pm .015$   
PLACE .010 - TOLERANCE  $\pm .005$   
PLACE .001 - TOLERANCE  $\pm .006$

FRACTIONAL DIMENSIONS  $\pm .1/32$   
4 IN. AND OVER DIMENSIONS  $\pm .0030$

FINISHES ARE DESIGNATED BY ROOT MEAN  
SQUARE (R.M.S.) MICRO-ROUGHNESS  
VALUES AND ARE THE MAXIMUM ROUGHNESS  
ACCEPTABLE, UNLESS OTHERWISE SPECIFIED.

FINISH ROUGHNESS TO BE  $\sqrt{16}$  OR BETTER.

MATERIAL: AISI 8620  
HEAT TREAT: CARBURIZE 1.70% C POTENTIAL  
HARDNESS: R15N 97 MAX CORE, R15N 88-92 CASE  
COLOR: BLACK OXIDE  
HEAT TREAT AND COLOR TO BE DONE BY  
REINSTEIN



CV FILENAME - PARTS,RIF,710,FIRING-PIN-TIP,300335

|  |  |  |  |
|--|--|--|--|
|  |  |  |  |
|  |  |  |  |
|  |  |  |  |
|  |  |  |  |
|  |  |  |  |

| MODEL        | PART NO.     |             | PART USE     |
|--------------|--------------|-------------|--------------|
| DEL. BY DATE | EXP. EX DATE | CW. BY DATE | APP. BY DATE |
|              | NOK 10/05/98 |             |              |

TITLE      FIRING PIN TIP

|                         |        |            |           |
|-------------------------|--------|------------|-----------|
| DRAWER                  | SAMPLE | SUPERSEDED | REFERENCE |
| C-300335                | 4:     |            |           |
| REMINGTON ARMS CO. INC. |        |            |           |

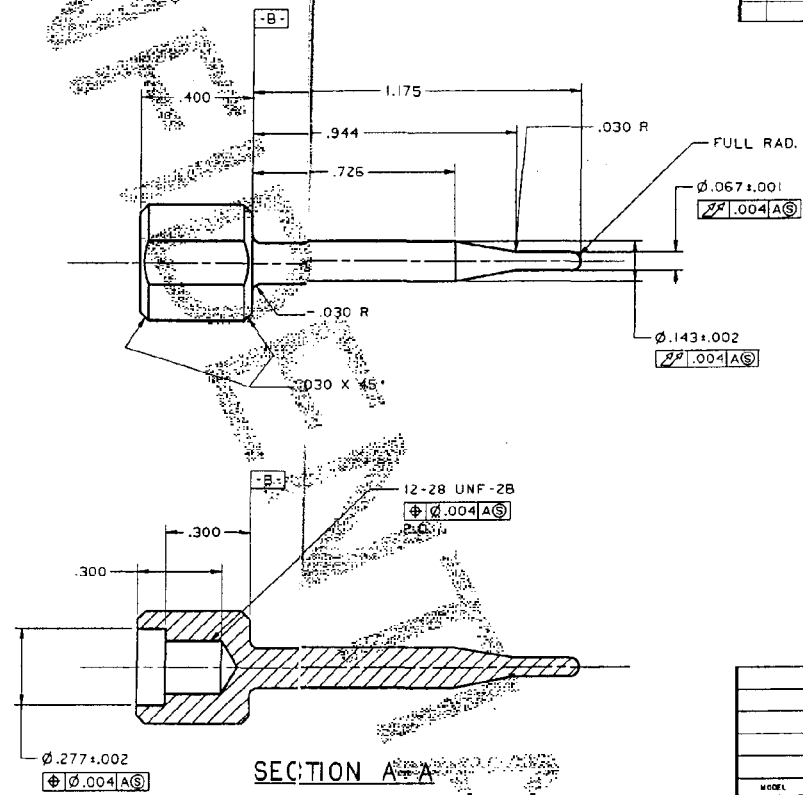
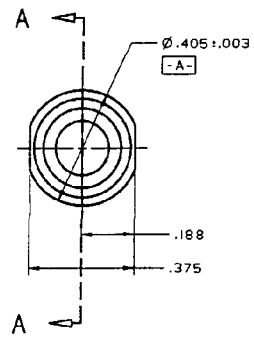
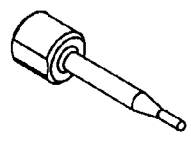
C-300335

THIS DRAWING OR INFORMATION IS  
 PROPRIETARY INFORMATION TO THE  
 REMINGTON ARMS COMPANY, INC.

DOLPOT SCALE THIS DRAWING: MORE TO FIGURES  
 UNLESS OTHERWISE NOTED.  
 TWO NAMES ON DECIMAL DIMENSIONS ARE:  
 1. PLACE 1.01 - TOLERANCE  $\pm .005$   
 2. PLACE 1.011 - TOLERANCE  $\pm .005$   
 3. PLACE 1.0111 - TOLERANCE  $\pm .005$   
 4. IN FRACTIONAL DIMENSIONS  $\pm 1/16$   
 5. IN ANGULAR DIMENSIONS  $\pm .0030$   
 FINISHES ARE DESIGNATED BY ROOT MEAN  
 SQUARE (R.M.S.) WAVELENGTH ROUGHNESS  
 NOTES AND ARE AS FOLLOWS: SURF 5  
 ACCEPTABLE, UNLESS OTHERWISE SPECIFIED.  
 FINISH ROUGHNESS TO BE  $10^5$  OR BETTER.

MATERIAL AND HEAT TREAT  
MATERIAL: AISI 8620  
HEAT TREAT: CARBURIZE 1.70% C POTENTIAL  
HARDNESS: R15N 87 WAX CORE, R15N 88-92 CASE  
COLOR: BLACK OXIDE  
HEAT TREAT AND COLOR TO BE DONE BY  
REMINGTON

ISO VIEW  
SCALE 2:1



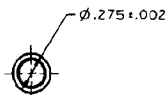
SECTION A-A

CV FILENAME - PARTS, RIF, 710, FIRING-PIN- TIP, 300335

C-300334

30 10T SCALE THIS DRAWING: WORK TO FIGURES  
 UNLESS OTHERWISE NOTED.  
 10 RANGES ON DECIMAL DIMENSIONS ARE:  
 1 PLACE 1.0 - TOLERANCE  $\pm .015$   
 2 PLACE 1.01 - TOLERANCE  $\pm .005$   
 3 PLACE 1.001 - TOLERANCE  $\pm .005$   
 4 FRACTIONAL DIMENSIONS 1/64  
 5 ANGULAR DIMENSIONS  $\pm .01^\circ$   
 7 SIZES ARE DESIGNATED BY ROOT MEAN  
 SQUARE (R.M.S.) MICRO-INCH ROUGHNESS  
 VALUES AND ARE THE MAXIMUM ROUGHNESS  
 ACCEPTABLE, UNLESS OTHERWISE SPECIFIED.  
 F. 125A ROUGHNESS TO BE  $\sqrt{10}$  OR BETTER.

MATERIAL AISI 4125  
HEAT TREAT NONE  
HARDNESS RB 80 MIN,  
COLOR BLACK OXIDE  
HEAT TREAT AND COLOR TO BE DONE BY  
REMINGTON



CV FILENAME : PARTS.RIF.710.FIRING-PIN.300334

**SUPREME****QUOTATION**

August 19, 1999

REMINGTON ARMS COMPANY, INC.

22 Rifle Trail

P.O. Box 99

Hickory, KY 42051

ATTN: Metty Morgan

Reference:

QUOTE # 6273

Gentlemen:

We are pleased to submit the following quotation:

| Part No.       | Quantity | Price     | Tooling |
|----------------|----------|-----------|---------|
| C-300334       |          |           |         |
| Firing Pin     | 20M/yr.  | 2.593 ea. | \$1500  |
|                | 40M/yr.  | 2.493 ea. |         |
|                | 60M/yr.  | 2.443 ea. |         |
| C-300335       |          |           |         |
| Firing Pin Tip | 20M/yr.  | 1.270 ea. | \$1000  |
|                | 40M/yr.  | 1.165 ea. |         |
|                | 60M/yr.  | 1.113 ea. |         |

DELIVERY: 8 - 10 weeks

NOTE: This preliminary quote is per Supreme's proposed design; see attached drawing showing this proposal.

This form is being used to expedite our reply. Should you have any questions or comments concerning our quotation we will be happy to discuss them with you.

Prices are  
F.O.B. Spring Lake, MI

Terms are  
1/2% 10 days — Net 30 days

**SUPREME MACHINED PRODUCTS CO., INC.**  
18686 172nd Avenue  
Spring Lake, Michigan 49456  
Phone: (616) 842-6550  
Fax: (616) 842-4481

Very truly yours,

**SUPREME MACHINED PRODUCTS CO., INC.***Edd Curry*

EDD CURRY

**PRECISION SCREW MACHINE PRODUCTS**

1000

SUPREME

08/19/99 14:01 FAX 616 842 4481

MF0257

Confidential - Subject to Protective Order  
BARBER - 5.22.06r0010207  
Williams v. Remington

002

SUPREME

08/19/99 14:01 FAX 616 842 4481

| REV. | DESCRIPTION | BY  | DATE     |
|------|-------------|-----|----------|
| SP-X | -----       | XXX | XX/XX/XX |

**CURRENT DESIGN**



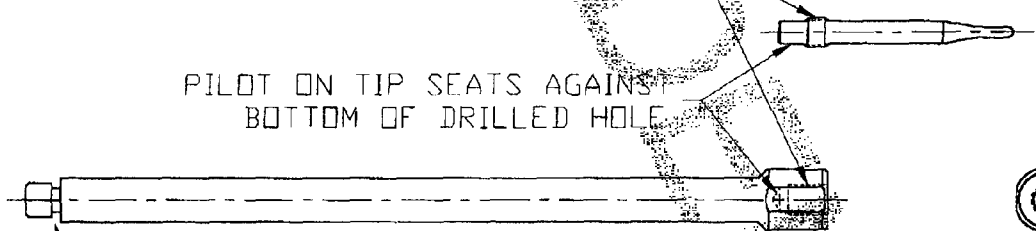
#10-32 THREADS

PIN MADE FROM 3/8 SQUARE STOCK, THEN TURNED TO .405Ø.

PIN ON TIP SEATS AGAINST BOTTOM OF DRILLED HOLE

GROOVE WIDTH .06"

**PROPOSED DESIGN**



UNLESS OTHERWISE SPECIFIED THE FOLLOWING TOLERANCES APPLY

+/- .020 ALLOWED ON ONE PLACE DECIMALS

+/- .010 ALLOWED ON TWO PLACE DECIMALS

+/- .005 ALLOWED ON THREE PLACE DECIMALS

+/- 1° ON ANGLES

ALL SURFACE FINISHES TO BE 125 MICRO INCHES UNLESS OTHERWISE SPECIFIED

GEOMETRIC CHARACTERISTICS AND SYMBOLS

ANSI Y14.5M-1982

- FLATNESS
- STRAIGHTNESS
- CIRCULARITY
- ⊙ CYLINDRICITY
- ⌒ PROFILE OF A SURFACE
- ⌒ PROFILE OF A LINE
- ⊥ PERPENDICULARITY
- ∥ PARALLELISM
- ⊙ PROFILE OF A SURFACE
- ⊙ PROFILE OF A LINE
- ⊙ MAXIMUM MATERIAL CONDITION
- ⊙ REGARDLESS OF FEATURE SIZE
- ⊙ LEAST MATERIAL CONDITION
- ⊙ ANGLE
- ⊙ CIRCULARITY
- ⊙ PARALLELISM
- ⊙ PERPENDICULARITY
- ⊙ POSITION
- ⊙ CONCENTRICITY
- ⊙ TOTAL RUNOUT
- ⊙ CIRCULAR RUNOUT
- ⊙ PROJECTED TOLERANCE ZONE
- ⊙ RADIUS
- ⊙ REFERENCE

|                             |                  |          |
|-----------------------------|------------------|----------|
| <b>SUPREME</b>              |                  |          |
| MACHINED PRODUCTS CO., INC. |                  |          |
| CADFILE NO: BSQ#531         |                  |          |
| DRAWER:                     | EJC              | 8/16/99  |
| CHECKER:                    |                  |          |
| PROJECT ENG:                |                  |          |
| CUSTOMER:                   | REMINGTON        |          |
| CUST. REF. NO:              | C-300334/5       |          |
| CUST. REV:                  |                  | DATED: - |
|                             | SCALE: FULL      | SIZE: A  |
| MATERIAL SPEC:              | AS NOTED         |          |
| NAME:                       | FIRING PIN & TIP |          |
| ITEM NO:                    |                  |          |

ME0258

Confidential - ~~Supreme~~ - 5.22.06r0010208 Order

Williams V. Remington

Please quote the following options:

Quote #1 - C-300335 as per print

Quote #2 - C-300334 as per print

Quote #3 - C-300334 and C-300335 as a one piece assembly. This eliminates the 12-28 drilled and tapped hole on C-300335 and eliminates the (12-28 by .150 long) threaded end on C-300334. The OAL of this combined part is 6.39 inches.

CONFIDENTIAL 83

MF0259

COPY FYI

QUOTATION

Quotation Number: 99081303  
 Date: August 13, 1999  
 Prepared By: Jim Mullineaux



**Megamet  
Industries**

Powder Injection Molding

4073 Wedgeway Court • Earth City, MO 63045  
 314 739-4499 fax: 314 739-5281

To: Remington Arms Co., Inc.  
 22 Rifle Trail  
 P.O. Box 99  
 Hickory, KY 42051  
 Attn: Metty Morgan

Phone: 502-856-4200  
 Fax: 502-856-3233

RE: RFQ

| Quantity  | Part Description               | Description of Work                                 | Price                      |
|-----------|--------------------------------|-----------------------------------------------------|----------------------------|
| 3 ea      | Molds                          | Metal injection mold @ \$15,000 each                | \$ 45,000.00               |
| 3 ea      | Furnace Fixtures               | Furnace fixtures for all parts quoted @ \$2500      | \$ 7,500.00                |
| 20K pcs.  | C300336 <i>FRONT P.O.</i>      | Metal injection molded Alloy FN02 parts per drawing | \$ 1.50 each               |
| 40K pcs.  | C300336 <i>HEAD</i>            | Metal injection molded Alloy FN02 parts per drawing | \$ 1.45 each <sup>83</sup> |
| 60K pcs.  | C300336                        | Metal injection molded Alloy FN02 parts per drawing | \$ 1.35 each               |
| 80K pcs.  | C103530 <i>REAR SIGHT</i>      | Metal injection molded Alloy FN02 parts per drawing | \$ 1.65 each               |
| 100K pcs. | C103530 <i>BASE</i>            | Metal injection molded Alloy FN02 parts per drawing | \$ 1.60 each               |
| 200K pcs. | C103530                        | Metal injection molded Alloy FN02 parts per drawing | \$ 1.50 each               |
| 80K pcs.  | C93907 <i>REAR SIGHT SLIDE</i> | Metal injection molded Alloy FN02 parts per drawing | \$ 1.20 each               |
| 100K pcs. | C93907                         | Metal injection molded Alloy FN02 parts per drawing | \$ 1.15 each               |
| 200K pcs. | C93907                         | Metal injection molded Alloy FN02 parts per drawing | \$ 1.10 each               |

**Notes: A DRAWING REVIEW MUST TAKE PLACE BETWEEN ALL PARTIES BEFORE ACCEPTANCE OF A P.O.**

**DESIGN INFO:** Complete, original, signed and dated print complete and ready for tooling design is required. A 3D solid model database in acceptable format if available is requested. Additional charges will apply if engineering time is required.

**TOOLING:** Tooling charges listed above include design and fabrication of said tools. Upon receipt of final tooling payment, customer will obtain ownership of those tools. Tooling charge is based upon maximum capacity stated. Tooling is guaranteed to last at least the lesser of 3 times the order quantity or 36 months unless there is a customer-originated design change.

**PARTS:** Parts will be supplied in the heat treated, surface finish, and surface coating conditions specified. Engineering reviews with the customer as well as sample pieces submitted will be used to evaluate acceptable mold design and molding and sintering practices with regard to gate location, shrinkage, appearance, and tooling design.

**SAMPLES:** Samples 8 weeks ARO and acceptance of purchase order by Megamet. See below for multiple orders.

MF0260

Quotation

Quotation Number: 99081303  
Date: August 13, 1999  
Prepared By: Jim Mullineaux

PAGE 2 of 2



Megamet  
Industries

4073 Wedgeway Court • Earth City, MO 63045  
314 739-4499 fax 314 739-5281

MULTIPLE ORDERS: New part orders placed within a 30 day period of each other will ship samples on the following schedule:

Order #1 - 8 weeks ARO

Order #2 - 14 weeks after receipt of Order #1, 6 weeks from previous order samples.

Order #3 - 18 weeks after receipt of Order #1, 4 weeks from previous order samples.

Order #4 and up - additional 2 weeks after shipment of previous Order's samples

DELIVERY: 2.5% of quantity ordered shipped 4 weeks after sample approval, an additional 5% of quantity ordered shipped 8 weeks after sample approval, 10% of quantity ordered per month thereafter until order is complete. Bulk<sup>3</sup> packaging assumed. FOB Megamet, Earth City, MO., plus reasonable delivery charges. Delivery times stated are ARO and after receipt of product design information or sample approval, which ever applies. Delivery terms are contingent on the total number of orders placed by the customer within a 30 day period. If multiple orders are placed within 30 days the customer must establish a priority/sequence for ramp-up/delivery of the parts ordered. An effort will be made to work with the customer's delivery requirements.

TERMS: Tooling: 50% of any tooling and furnace setter charges with purchase order, balance due after sample approval. Molded parts: Net 15 with credit approval, invoiced with each shipment. Please supply credit references, and if applicable a tax exemption form.

CONDITIONS: Offer is subject to acceptance of conditions of sale on reverse (or accompanying). Prices and delivery dates are valid for a period of 30 days from the date of this offer.

  
Jim Mullineaux, Production Manager  
Megamet Industries, Inc.

MF0261

CONFIDENTIAL 83

PWT pw 300357

MF0262

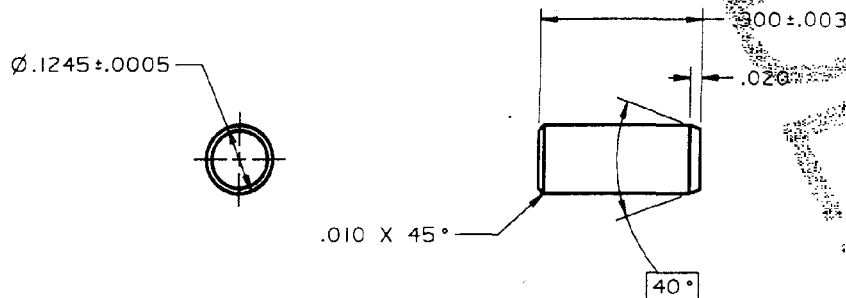
CV FILENAME - PARTS.RIF.710.PIVOT-PIN.300351

**B-300351**

NOTE: SCALE THIS DRAWING: WORK TO FIGURES  
UNLESS OTHERWISE NOTED.  
TOLERANCES ON DECIMAL DIMENSIONS ARE:  
1 PLACE .(1) TOLERANCE  $\pm .015$   
2 PLACE .(01) TOLERANCE  $\pm .010$   
3 PLACE .(001) TOLERANCE  $\pm .005$   
4 OR FRACTIONAL DIMENSIONS  $\pm 1/64$   
6 ON ANGULAR DIMENSIONS  $\pm .0030^\circ$   
FINISHES ARE DESIGNATED BY ROOT MEAN  
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS  
VALUES AND ARE THE MAXIMUM ROUGHNESS  
ACCEPTABLE UNLESS OTHERWISE SPECIFIED.

FINISH ROUGHNESS TO BE  $125 \sqrt{\text{R}}$  OR BETTER.

MATERIAL AISI 1018  
HEAT TREAT CARBURIZE (70% C POTENTIAL)  
HARDNESS R15N 88-92 (1.008 MIN CASE)  
COLOR BLACK OXIDE  
HEAT TREAT AND COLOR TO BE DONE BY  
REMINGTON

[illegible]

CV FILENAME - PARTS.RIF.710.PIVOT-PIN.300351

1/6/09 PM 3:00:27

CONFIDENTIAL 83

MF0265

THREAT 10/28/06  
800547

CONFIDENTIAL 83

MF0266

CONFIDENTIAL

83

late 5/20/06  
3/23/05

MF0267

CONFIDENTIAL

83  
251001  
02 0001 618445

MF0268

B-300352

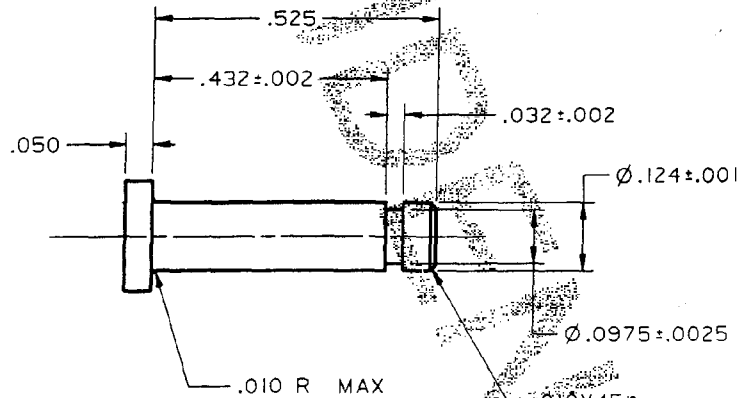
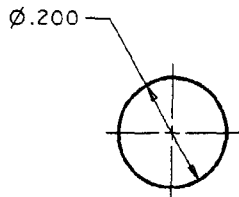
THIS DRAWING OR INFORMATION IS  
PROPRIETARY INFORMATION TO THE  
REMINGTON ARMS COMPANY, INC.

DO NOT SCALE THIS DRAWING: WORK TO FIGURES  
UNLESS OTHERWISE NOTED.  
TOLERANCES ON DECIMAL DIMENSIONS ARE:  
1 PLACE (.1) - TOLERANCE  $\pm .015$   
2 PLACE (.01) - TOLERANCE  $\pm .010$   
3 PLACE (.001) - TOLERANCE  $\pm .005$   
4 ON FRACTIONAL DIMENSIONS  $\pm 1/64$   
5 ON ANGULAR DIMENSIONS  $\pm 30'$   
FINISHES ARE DESIGNATED BY ROOT MEAN  
SQUARE (R.M.S.) MICRO-INCH ROUGHNESS  
VALUES AND ARE THE MAXIMUM ROUGHNESS  
ACCEPTABLE, UNLESS OTHERWISE SPECIFIED.  
FINISH ROUGHNESS TO BE  $\sqrt{160}$  OR BETTER.

**MATERIAL AND HEAT TREAT**  
MATERIAL AISI 1018  
HEAT TREAT CARBURIZE (170% C POTENTIAL)  
HARDNESS R15N 88-92 (1.008 MIN CASE)  
COLOR BLACK OXIDE  
HEAT TREAT AND COLOR TO BE DONE BY  
REMINGTON

ALTERATIONS

| ALT. | WAS                 | REF. | BY  | DATE     |
|------|---------------------|------|-----|----------|
| 1    | REVISED AND REDRAWN |      | MDK | 05-26-99 |
|      |                     |      |     |          |
|      |                     |      |     |          |
|      |                     |      |     |          |
|      |                     |      |     |          |
|      |                     |      |     |          |
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|      |                     |      |     |          |
|      |                     |      |     |          |
|      |                     |      |     |          |



|                        |              |              |              |                                          |  |
|------------------------|--------------|--------------|--------------|------------------------------------------|--|
| MODEL                  |              | PART NO.     |              | PART USE                                 |  |
| DES. BY DATE           | CHK. BY DATE | CHK. BY DATE | APP. BY DATE |                                          |  |
| MDK 03/01/99           |              |              |              |                                          |  |
| TITLE SAFETY PIVOT PIN |              |              |              |                                          |  |
| NUMBER                 |              | SCALE        | SUPERSEDES   | REFERENCE                                |  |
| B-300352               |              | 5:1          |              | REMINGTON ARMS CO. INC.<br>RESEARCH DIV. |  |

CV FILENAME - PARTS.RIF.710.SAFETY-PIVOT-PIN.300352

CONFIDENTIAL

83

*Barber  
+ Family*

MF0270

CONFIDENTIAL 83

MA-Box

MF0271

**Brainin**

Deer Park Die &amp; Stamping Division

Fairfield

|                                          |                   |                                                                                     |
|------------------------------------------|-------------------|-------------------------------------------------------------------------------------|
| TO: MATT<br>GOLEMBOSKI<br>Remington Arms | FROM:<br>Rich Lee | Date: 5/23/00<br>Number of Pages: 2<br>Phone: (513) 874-9760<br>Fax: (513) 874-9764 |
|------------------------------------------|-------------------|-------------------------------------------------------------------------------------|

270-856-3233

## Remarks:

83

☐ URGENT ☒ FOR YOUR REVIEW ☐ REPLY ASAP ☐ PLEASE COMMENT

Dear Matt,

Please find the latest tool program chart for the mag box. You will notice that we are currently showing a bit behind our earlier one. Based on the % completions, we have initiated some overtime, including Saturdays, in an attempt to better this outlook of 7-14. I realize we will be tight for the 8-1 production target, but I have spoken with Metty about materials to prepare us for the launch accordingly. I will keep you advised of any further changes to this.

Best regards,

Rich Lee

Rich

CONVERSATION on 5/26 w/ RICH LEE

REV 16 HAND COPY

- DID RECEIVE CAD DATA
- SHOT FOR PPAP on 7/1/00
- 

MF0272



Deer Park Die & Stamping Division

Fairfield

5-23-2000

Deer Park Die & Stamping  
Tooling Status Report

Customer: Remington Arms

Part Number: E-300363

Part Name: Magazine Box

Enter Task Completion % Below

| Task Name                 | Duration       | Start Date     | Finish Date    | wk 1           | wk 2          | wk 3           | wk 4           | wk 5           | wk 6          | wk 7          | wk 8           | wk 9           | wk 10          | wk 11         | wk 12          | wk 13 | wk 14 | wk 15 | wk 16 |
|---------------------------|----------------|----------------|----------------|----------------|---------------|----------------|----------------|----------------|---------------|---------------|----------------|----------------|----------------|---------------|----------------|-------|-------|-------|-------|
| SO# <u>40263</u>          |                |                |                | <u>4-28-00</u> | <u>5-5-00</u> | <u>5-12-00</u> | <u>5-19-00</u> | <u>5-26-00</u> | <u>6-2-00</u> | <u>6-9-00</u> | <u>6-16-00</u> | <u>6-23-00</u> | <u>6-30-00</u> | <u>7-7-00</u> | <u>7-14-00</u> |       |       |       |       |
| strip layout              | <u>1 week</u>  | <u>4-21-00</u> | <u>4-28-00</u> | <u>100%</u>    |               |                |                |                |               |               |                |                |                |               |                |       |       |       |       |
| cross sections            | <u>2 weeks</u> | <u>4-28-00</u> | <u>5-12-00</u> |                | <u>30%</u>    | <u>100%</u>    |                |                |               |               |                |                |                |               |                |       |       |       |       |
| design complete           | <u>3 weeks</u> | <u>4-28-00</u> | <u>5-19-00</u> |                | <u>20%</u>    | <u>60%</u>     | <u>100%</u>    |                |               |               |                |                |                |               |                |       |       |       |       |
| steels received           | <u>3 weeks</u> | <u>5-11-00</u> | <u>6-2-00</u>  |                |               |                | <u>40%</u>     |                |               |               |                |                |                |               |                |       |       |       |       |
| components soft machined  | <u>5 weeks</u> | <u>5-12-00</u> | <u>6-16-00</u> |                |               |                |                | <u>15%</u>     |               |               |                |                |                |               |                |       |       |       |       |
| die set machined received | <u>2 weeks</u> | <u>5-12-00</u> | <u>5-26-00</u> |                |               |                | <u>100%</u>    |                |               |               |                |                |                |               |                |       |       |       |       |
| complete HT & ground      | <u>4 weeks</u> | <u>5-19-00</u> | <u>6-16-00</u> |                |               |                | <u>15%</u>     |                |               |               |                |                |                |               |                |       |       |       |       |
| tryout mtl received       | <u>6 weeks</u> | <u>5-12-00</u> | <u>6-30-00</u> |                |               |                |                |                |               |               |                |                |                |               |                |       |       |       |       |
| wire edm & jig complete   | <u>5 weeks</u> | <u>5-19-00</u> | <u>6-27-00</u> |                |               |                | <u>5%</u>      |                |               |               |                |                |                |               |                |       |       |       |       |
| fitting / assembly        | <u>3 weeks</u> | <u>6-16-00</u> | <u>7-7-00</u>  |                |               |                |                |                |               |               |                |                |                |               |                |       |       |       |       |
| tryout complete           | <u>1 week</u>  | <u>7-10-00</u> | <u>7-14-00</u> |                |               |                |                |                |               |               |                |                |                |               |                |       |       |       |       |
| samples made              | <u>1 week</u>  | <u>7-10-00</u> | <u>7-14-00</u> |                |               |                |                |                |               |               |                |                |                |               |                |       |       |       |       |
| SR shipped                | <u>1 week</u>  | <u>7-10-00</u> | <u>7-14-00</u> |                |               |                |                |                |               |               |                |                |                |               |                |       |       |       |       |

Special instructions / Notes:

Form # 23-1 Rev. 2 8/27/99

ME0273

Confidential - BARBER - 5.22.06/0010223 Order

Williams v. Remington

**Brainin**

Deer Park Die &amp; Stamping Division

ISO 9001

Fairfield

*Matt  
copy  
FYI*May 16<sup>th</sup>, 2000

Remington Arms Co.  
22 Rifle Trail P.O. Box 99  
Hickory, KY 42051  
Attn: Metty Morgan

Subject: E300363 Mag Box Program

Dear Metty,

Thank you for your input on the phone today to discuss the mag box program. We are preparing to order raw materials for the upcoming production die try out scheduled for a PPAP approximately July 1, 2000. In order to accommodate your plans to have production parts available for early August, we will need to commit to raw materials before hand.

As mentioned, our normal coil release is about 5,000# of this strip size, which will make approximately 15,000 parts. You have indicated an 8-10,000 need in the fourth quarter plus another 7,000 for service part inventory. The 5000# coil should work out nicely and you have agreed we should proceed with it. The formal PO release for parts will not take place until the 1<sup>st</sup> pc samples have been approved. After some experience with the part we can work together on future material planning to keep your needs covered.

Thank your assistance, and we wish to also thank you again for the opportunity to demonstrate our desire to be a quality, capable supplier to Remington Arms.

Brainin-Deer Park Stamping Division

*Richard R. Lee*

Richard R. Lee  
Technical Sales

CONFIDENTIAL 83

*Ms. by F. J. [unclear]*

MF0275



# KELLEMS & COE

TOOL CORPORATION

P.O. Box 784, Jeffersonville, IN 47131-0784  
Phone (812) 283-1435 • Fax (812) 282-3863

## QUOTATION

5507

*COPY  
FYI*

To:  
Ms. Metty Morgan  
Remington Arms Co., Inc.  
22 Rifle Trail  
PO Box 99  
Hickory, KY 42051

Date: 8-17-99

(INQUIRY NO.)

We are pleased to quote the following:

- 1) 4-cavity production mold for the Bolt Plug, P/N 300346  
Tooling cost: \$36,000.00  
Piece price for 20,000: \$0.215  
40,000: \$0.213  
60,000: \$0.211
- 2) 4-cavity production mold for the Box Bottom, P/N 300365  
Tooling cost: \$41,000.00  
Piece price for 20,000: \$0.287  
40,000: \$0.282  
60,000: \$0.278
- 3) 4-cavity production mold for the Latch, P/N 300362  
Tooling cost: \$39,000.00  
Piece price for 20,000: \$0.191  
40,000: \$0.186  
60,000: \$0.182
- 4) 4-cavity production mold for the Follower, P/N 300364  
Tooling cost: \$27,500.00  
Piece price for 20,000: \$0.247  
40,000: \$0.242  
60,000: \$0.238

Terms on tooling: 1/3 with PO, 1/3 at tryout, 1/3 N30  
Terms on parts: N45

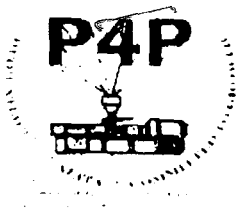
*Kenny Ulrich* EXT. 314  
Kenny Ulrich  
Account Manager

MF0276

CONFIDENTIAL 83

*Mr. Byr Bottom*

MF0277



# PAR 4 PLASTICS, INC.

(502) 965-9141  
Fax (502) 965-9560

Princeton Road  
P.O. Box 385  
Marion, KY 42064

August 19, 1999

Ms. Metty Morgan  
Remington Arms Company, Inc.  
22 Rifle Trail  
P. O. Box 99  
Hickory, KY. 42051

Dear Metty:

Per your request, we are pleased to quote the following:

## Model 710 Box Bottom, # 300365:

Two Cavity Production Mold

Cost = \$ 47,880.00  
Lead Time = 15 wks.

Molded Parts Delivered, Annual Volumes

|              |                    |
|--------------|--------------------|
| 100,000 pcs. | Cost = \$ .205 ea. |
| 60,000 pcs.  | .226 ea.           |
| 40,000 pcs.  | .241 ea.           |
| 20,000 pcs.  | .256 ea.           |

## Model 710 Follower, # D-300364:

Two Cavity Production Mold

Cost = \$ 33,300.00  
Lead Time = 14 wks.

Molded Parts Delivered, Annual Volumes

|              |                    |
|--------------|--------------------|
| 100,000 pcs. | Cost = \$ .193 ea. |
| 60,000 pcs.  | .207 ea.           |
| 40,000 pcs.  | .217 ea.           |
| 20,000 pcs.  | .259 ea.           |

**KELLEMS & COE**  
TOOL CORPORATIONP.O. Box 784, Jeffersonville, IN 47131-0784  
Phone (812) 283-4435 • Fax (812) 282-3863**QUOTATION**  
5507*COPY  
FYI*

To:

Ms. Metty Morgan  
Remington Arms Co., Inc.  
22 Rifle Trail  
PO Box 99  
Hickory, KY 42051

Date:

8-17-99

(INQUIRY NO.)

We are pleased to quote the following:

- 1) 4-cavity production mold for the Bolt Plug, P/N 300346

Tooling cost: \$36,000.00

Piece price for 20,000: \$0.215

40,000: \$0.213

60,000: \$0.211

- X 2) 4-cavity production mold for the Box Bottom, P/N 300365

Tooling cost: \$41,000.00

Piece price for 20,000: \$0.287

40,000: \$0.282

60,000: \$0.278

- 3) 4-cavity production mold for the Latch, P/N 300362

Tooling cost: \$39,000.00

Piece price for 20,000: \$0.191

40,000: \$0.186

60,000: \$0.182

- X 4) 4-cavity production mold for the Follower, P/N 300364

Tooling cost: \$27,500.00

Piece price for 20,000: \$0.247

40,000: \$0.242

60,000: \$0.238

Terms on tooling: 1/3 with PO, 1/3 at tryout, 1/3 N30

Terms on parts: N45

*Kenny Ulrich* EXT.  
Kenny Ulrich 31A  
Account Manager

MF0279

*Monroe Latta*

CONFIDENTIAL 83

MF0280



# KELLEMS & COE

## TOOL CORPORATION

P.O. Box 784, Jeffersonville, IN 47131-0784  
Phone (812) 283-4435 • Fax (812) 282-3863

# QUOTATION

## 5507

*COPY  
FYI*

To:  
Ms. Metty Morgan  
Remington Arms Co., Inc.  
22 Rifle Trail  
PO Box 99  
Hickory, KY 42051

Date: 8-17-99

(INQUIRY NO.)

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40,000: \$0.282  
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40,000: \$0.186  
60,000: \$0.182
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Tooling cost: \$27,500.00  
Piece price for 20,000: \$0.247  
40,000: \$0.242  
60,000: \$0.238

Terms on tooling: 1/3 with PO, 1/3 at tryout, 1/3 N30  
Terms on parts: N45

*Kenny Ulrich EXT. 314*  
Kenny Ulrich  
Account Manager

MF0281

Sansy Allen

CONFIDENTIAL 83

MF0282

Golemboski, Matt R.

---

From: Morgan, Metty E.  
Sent: Monday, January 24, 2000 2:28 PM  
To: Keeney, Mike  
Cc: Golemboski, Matt R.  
Subject: 710 Safety Arm

01/24/2000

Mike,

Dan Hart at Square Stamping can be reached at 315-896-2641.

The scenario goes: Square has quoted the best tooling cost by some \$4500.00. vs. the other quoters., however, his piece price is highest. .23 cents vs .88 cents which I have just today gotten him down to .68 cents.

He says he has three issues with the design. 1.) no hole to check the cam surface.

2.) hole size

3.) tighter die clearance. shouldn't be much die break there.  
needs to be straight as possible.

He said our 710 safety has a form that is not on the 700 design. He is charging .285 ea. for that to Ilion. I could use some help here. Dan is very familiar with the 700 safety. He is confident that we will have trouble with a new vendor at .23 cents each. He is willing to drop the cost on other 710 parts if necessary, but says as this design is now there is no way he can move further. Please call him and see what you can do.

Thanks Mike,  
Mett @ Mayfield

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83

STOCK ASSEMBLY  
COMPLETE

MF0284

CONFIDENTIAL

STOCK

MF0285

Confidential

Remington Arms Co.

## Memo

**To:** Mett Morgan  
**From:** Matt Golemboski  
**CC:** Joe Zajk  
**Date:** 05/16/00  
**Re:** Par4 Information

After the sample run of stocks on 5/3/00, it was noticed that the trigger bow area has some flex to it and a portion of the stock near the grip area is thin enough to disrupt the flow of material. On a short shot this area did not fill. Par 4 was asked to quote the cost of the revisions. Remington received a quote via fax on 5/15/00 to correct the two issues mentioned above. **Total cost of \$3300.** Please forward Par4 a purchase order to cover this cost. Add it as a line item to the original PO if possible to keep record keeping later easier for me. I want to know the total cost of the stock mold after the project is complete.

The solid model design changes are in process at R&D and will be forwarded directly from the designer in Elizabethtown. Please have Par4 contact us when this design work is received by their tool shop.

● Page 1

MF0286



*MATT  
PO For this To pay 4  
?*  
*METT*

# PAR 4 PLASTICS, INC.

(502) 965-9141  
Fax (502) 965-9560

Princeton Road  
P.O. Box 385  
Marion, KY 42064

May 15, 2000

Ms. Metty Morgan  
Remington Arms Co. Inc.  
22 Rifle Trail  
P.O. Box 99  
Hickory, KY. 42051

Dear Metty;

Per the request of Matt Golemboski and Joe Zajk, we are pleased to quote the following:

- #1. Modify the 710 Stock Butt Core as per math data to be supplied by Remington.
- #2. Enlarge Trigger Guard Area on the 710 Stock Mold Core and Cavity Blocks as per new math data to be supplied by Remington.

TOTAL COST = \$ 3300.00

Sincerely

Sam Todd  
Dir. Sales and Marketing

MF0287

**Model 710 Latch, # C -300362:**

Two Cavity Production Mold

Cost = \$ 33,480.00  
Lead Time = 14 wks.

Molded Parts Delivered, Annual Volumes 60,000 pcs.  
40,000 pcs.  
20,000 pcs.

Cost = \$ .212 ea.  
.231 ea.  
.245 ea.

**Model 710 Bolt Plug, # C - 300368:**

Two Cavity Production Mold

Cost = \$ 38,088.00  
Lead Time = 12 wks.

Molded Parts Delivered, Annual Volumes 60,000 pcs.  
40,000 pcs.  
20,000 pcs.

Cost = \$ .215 ea.  
.239 ea.  
.249 ea.

Note, Remington to supply metal inserts.

**Model 710 Stock:**

One Cavity Production Mold

Cost = \$ 150,300.00  
Lead Time = 21 wks.

Molded Parts Delivered, Annual Volumes 60,000 pcs.  
40,000 pcs.  
20,000 pcs.

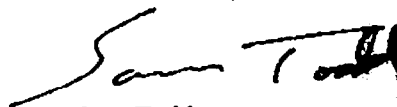
Cost = \$ 5.17 ea  
5.27 ea  
5.38 ea

Divider sleeves for the stock have been amortized over the first years production at a cost of \$ .006 per sleeve.

Note: Prices are base on current information supplied by Remington Arms. Changes in material, volumes, cycle times, packaging, or part design may result in price changes.

Metty, thanks for the opportunity to quote on your work. If we can be of further assistance please let us know.

Sincerely,  
Par 4 Plastics, Inc.



Sam Todd  
Dir. of Sales and Marketing

CONFIDENTIAL

83

Finne A. 104  
Barber Document

MF0289

**Golemboski, Matt R.**

**From:** Zajk, Joseph J  
**Sent:** Wednesday, June 30, 1999 10:14 AM  
**To:** Golemboski, Matt R.  
**Subject:** FW: 100 Yard Range for Mayfield

Interesting.

-----Original Message-----

**From:** Douglass, Edwin M.  
**Sent:** Wednesday, June 30, 1999 9:45 AM  
**To:** Zajk, Joseph J  
**Subject:** RE: 100 Yard Range for Mayfield

Joe,

Here are a collection of my thoughts regarding your proposed range:

- Get Osborne to give you an updated cost estimate for the 100 yd/meter range. They gave us an estimate for the first expansion at Mayfield in late 1996, which included an option for a 100 meter range. I will fax you a copy. If you need any help getting an update let me know.
- The actual construction cost for the 100 meter range at E-Town was \$492,212 but did not include the snail (approx. \$30,000), target rolls, shooter's benches, shooting jacks or any of their electronic instrumentation.
- If you haven't already, take a ride over to E-Town and take a look at that range.
- Provide more space and \$ for noise reduction at the shooter's end of the range than what was provided at E-Town.
- Include \$ for vacuum equipment and personal protective equipment for range cleanup. My preference is to vacuum the range rather than wash down and filter as is done at E-Town.
- Include an earthen berm behind and to the sides of the target house as an additional safety measure if it is above ground.
- Use Kirk safety interlocks (or other similar devices) for range access.
- Tube (concrete pipe) or catlapse construction would work but is not nearly as flexible for use as a rectangular cross-section and may not be any cheaper if you are planning for multiple firing positions.
- I would recommend a full length rectangular cross-section range which would give you the ability to shoot at intermediate ranges as well as at 100 yds/meters. It also gives you access from inside and is better suited for possible extension to 200 or 300 yds if desired.
- I am not familiar with the Savage IR96 Bullet Trap, but I am assuming that it is their snail design and similar to the one at E-Town. If so, I am not aware of any better design for use in a production range. I believe that they have had good results with the snail at E-Town. We have tried a couple of other designs here at Ilion, but they really aren't suitable for centerfire production use. We have gone back to sand for our two 100 yd ranges and the 200 yd range. As far as the conveyor system goes, I guess that is your call. E-Town chose not to include a conveyor for their range. I believe the additional cost was about \$12,000 three years ago.
- Tad Yager can give you some information on HVAC requirements and Ron Gurtowski can provide information on vacuum and ppe requirements.
- Check with the local codes person. I don't recall that there are any particular restrictions or requirements in Kentucky.
- Include \$ for any cable, wiring and outlets you may need at several points downrange for instrumentation or equipment. You will also need a water line at the target end for makeup in the snail.
- The snail should have a low level/low flow alarm to prevent running dry.
- Include \$ for a hardsurfaced access drive to the target house for service.

If you have questions on any of these items or other issues don't hesitate to call.

Ed

-----  
**From:** Zajk, Joseph J

Sent: Tuesday, June 29, 1999 11:25 AM  
To: Douglass, Edwin M.  
Subject: 100 Yard Range for Mayfield  
Importance: High

Ed,

I need to estimate the cost of building a 100 yard range for Mayfield. This is part of the cost Mayfield would need to incorporate into the Model 710 project proposal. Are there minimum requirements for range construction, either by law or by Remington std.. that I would need to incorporate? I guess the same thing would go for air handling requirements. According to Jim Snedecker at E'town, their range cost between \$500,00 & \$600,000. That's for poured concrete roof, walls, floor, air handling, etc. Will the tube system we have for Mayfield's 25 yard range work if we scaled it up and beefed it up?

The initial caliber that would be made in the 710 would be 30-06, but marketing is supposed to want magnum calibers up through 338 Win Mag included as well. I was planning on using a Savage IR96 Bullet Trap. It will cover an 8' x8' opening. It has an option of a conveyor system to remove bullet material. If you know of something else that might work better, let me know.

Any assistance, general guidance on range construction, etc. that you guys up there can give me would be a great help. Our preliminary estimate for producing the 710 down here needs to be sent to Bristol by 8/30, so there is some urgency.

Thanks,

Joe Z.

P.S.: That other information for the A/C stuff was interesting. Some of the equipment did change, for what its worth.

CONFIDENTIAL

10/6/97

BARBER - 5.22.06r0010242

| BOM item/Operat/Resource |     |                       |             | Quantity  | UM | Gross value | ObCrc | Name                                 |
|--------------------------|-----|-----------------------|-------------|-----------|----|-------------|-------|--------------------------------------|
| M                        | MAY | 26550                 |             | 1,000.000 | EA | 65,998.36   | USD   | 597 .22 LR                           |
| #                        | E   | 4670 28100            | WC2207 MLG2 | ✓ 191     | HR | 1,560.47    | USD   | Inspect & Pack; WC2207 All Reporting |
| #                        | M   | 0280 4670 MAY F300045 |             | 1,000.000 | EA | 860.26      | USD   | BOLT HANDLE                          |
| #                        | F   | 0010 103386           |             | 1,000.000 | EA | 20.00       | USD   | Vendor Heat Treat - For F300045      |
| #                        | M   | 0010 0010 MAY F300078 |             | 1,000.000 | EA | 800.00      | USD   | BOLT HANDLE BLANK                    |
| #                        | E   | 0030 28150            | WC0005 MLG3 | 1         | HR | 9.43        | USD   | Black Oxide                          |
| #                        | G   | 28100                 | 8990889     |           |    | 21.97       | USD   | Overhead - Prod'n.                   |
| #                        | G   | 28100                 | 8990890     |           |    | 8.86        | USD   | Overhead - Prod Var                  |
| #                        | M   | 0290 4670 MAY F300001 |             | 2,000.000 | EA | 79.48       | USD   | BOLT GUIDE RAIL                      |
| #                        | E   | 0005 28150            | WC0005 MLG3 | 2         | HR | 18.86       | USD   | Black Oxide; Report Production       |
| #                        | M   | 0010 0005 MAY F300079 |             | 2,000.000 | EA | 160.00      | USD   | BOLT GUIDE RAIL BLANK                |
| #                        | G   | 28100                 | 8990889     |           |    | 43.94       | USD   | Overhead - Prod'n.                   |
| #                        | G   | 28100                 | 8990890     |           |    | 17.72       | USD   | Overhead - Prod Var                  |
| #                        | M   | 0300 4670 MAY F300018 |             | 2,000.000 | EA | 47.50       | USD   | GUIDE RAIL RETAINING SCREW           |
| #                        | M   | 0310 4670 MAY F300007 |             | 2,000.000 | EA | 58.90       | USD   | ACTION SPRING                        |
| #                        | M   | 0320 4670 MAY F305055 |             | 1,000.000 | EA | 10,775.01   | USD   | HOUSING ASSEMBLY                     |
| #                        | E   | 0140 28100            | WC2215 MLG2 | 118       | HR | 964.06      | USD   | Ass. Hold Open, H O Sprg, & H O Pin  |
| #                        | M   | 0010 0140 MAY F300051 |             | 1,000.000 | EA | 1,000.00    | USD   | HOUSING                              |
| #                        | M   | 0020 0140 MAY F300041 |             | 1,000.000 | EA | 1,039.92    | USD   | TRIGGER                              |
| #                        | M   | 0030 0140 MAY F300020 |             | 1,000.000 | EA | 138.85      | USD   | EJECTOR                              |
| #                        | F   | 0010 103386           |             | 1,000.000 | EA | 10.00       | USD   | Vendor Heat Treat - For F300020      |
| #                        | M   | 0010 0010 MAY F300081 |             | 1,000.000 | EA | 88.59       | USD   | EJECTOR BLANK                        |
| #                        | E   | 0040 28150            | WC0005 MLG3 |           | HR | 9.43        | USD   | Black Oxide                          |
| #                        | G   | 28100                 | 8990889     |           |    | 21.97       | USD   | Overhead - Prod'n.                   |
| #                        | G   | 28100                 | 8990890     |           |    | 8.86        | USD   | Overhead - Prod Var                  |
| #                        | M   | 0040 0140 MAY F300047 |             | 1,000.000 | EA | 1,299.76    | USD   | SEAR                                 |
| #                        | M   | 0050 0140 MAY F305005 |             | 1,000.000 | EA | 120.26      | USD   | PIN, LINK SEAR                       |
| #                        | F   | 0010 103386           |             | 1,000.000 | EA | 10.00       | USD   | Vendor Heat Treat - For F305005      |
| #                        | M   | 0010 0010 MAY F300083 |             | 1,000.000 | EA | 70.00       | USD   | SEAR, LINK PIN BLANK                 |
| #                        | E   | 0030 28150            | WC0005 MLG3 | 1         | HR | 9.43        | USD   | Black oxide                          |
| #                        | G   | 28100                 | 8990889     |           |    | 21.97       | USD   | Overhead - Prod'n.                   |
| #                        | G   | 28100                 | 8990890     |           |    | 8.86        | USD   | Overhead - Prod Var                  |
| #                        | M   | 0060 0140 MAY F305006 |             | 2,000.000 | EA | 240.52      | USD   | LINK PIN                             |
| #                        | F   | 0010 103386           |             | 2,000.000 | EA | 20.00       | USD   | Vendor Heat Treat - For F305006      |
| #                        | M   | 0010 0010 MAY F300084 |             | 2,000.000 | EA | 140.00      | USD   | LINK PIN BLANK                       |
| #                        | E   | 0030 28150            | WC0005 MLG3 | 2         | HR | 18.86       | USD   | Black oxide                          |
| #                        | G   | 28100                 | 8990889     |           |    | 43.94       | USD   | Overhead - Prod'n.                   |
| #                        | G   | 28100                 | 8990890     |           |    | 17.72       | USD   | Overhead - Prod Var                  |
| #                        | M   | 0070 0140 MAY F300008 |             | 1,000.000 | EA | 15.55       | USD   | SEAR RETURN SPRING                   |
| #                        | M   | 0080 0140 MAY F300031 |             | 1,000.000 | EA | 105.13      | USD   | HAMMER                               |
| #                        | E   | 0003 28100            | WC2211 MLG3 | 8         | HR | 75.44       | USD   | Machine Sear Notch & Deburr          |
| #                        | M   | 0010 0003 MAY F300048 |             | 1,000.000 | EA | 283.00      | USD   | HAMMER BLANK                         |
| #                        | F   | 0005 103386           |             | 1,000.000 | EA | 60.00       | USD   | Vendor Heat Treat - For F300031      |
| #                        | F   | 0060 2532596          |             | 1,000.000 | EA | 240.00      | USD   | Vendor Plate - For F300031           |
| #                        | G   | 28100                 | 8990889     |           |    | 175.78      | USD   | Overhead - Prod'n.                   |
| #                        | G   | 28100                 | 8990890     |           |    | 70.91       | USD   | Overhead - Prod Var                  |
| #                        | M   | 0090 0140 MAY F300033 |             | 1,000.000 | EA | 69.85       | USD   | HAMMER SPRING                        |
| #                        | M   | 0100 0140 MAY F300005 |             | 2,000.000 | EA | 200.00      | USD   | SPRING BUSHING                       |

*Handwritten notes:*  
 2x1 = 2  
 B-NICKET  
 +18.86  
 +43.94  
 +17.72

*Handwritten note:*  
 Elim Deburr

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Confidential - SHARPER - 5.22.06r0010242 Order Williams V. Remington

MF0292

| BOM item/Operat/Resource  | Quantity  | UM | Gross value      | ObCrc | Name                                    |
|---------------------------|-----------|----|------------------|-------|-----------------------------------------|
| # M 0110 0140 MAY F300000 | 5,000.000 | EA | +16.50 96.50     | USD   | PIN, PIVOT FOR TRIGGER ASSEMBLY         |
| M 0120 0140 MAY F300004   | 1,000.000 | EA | -2.00 78.26      | USD   | LINK LEFT                               |
| F 0010 0010 103386        | 1,000.000 | EA | -10.00 10.00     | USD   | Vendor Heat Treat - For F300004         |
| M 0010 0010 MAY F300086   | 1,000.000 | EA | +8.00 28.00      | USD   | LINK LEFT BLANK                         |
| E 0030 28150 WC0005 MLG3  | 1         | HR | 9.43             | USD   | Black Oxide                             |
| G 28100 8990889           |           |    | 21.97            | USD   | Overhead - Prod'n.                      |
| G 28100 8990890           |           |    | 8.86             | USD   | Overhead - Prod Var                     |
| # M 0130 0140 MAY F300023 | 1,000.000 | EA | -5.00 75.26      | USD   | LINK RIGHT                              |
| F 0010 0010 103386        | 1,000.000 | EA | -10.00 10.00     | USD   | Vendor Heat Treat - For F300023         |
| M 0010 0010 MAY F300087   | 1,000.000 | EA | +5.00 25.00      | USD   | LINK RIGHT BLANK                        |
| E 0030 28150 WC0005 MLG3  | 1         | HR | 9.43             | USD   | Black Oxide                             |
| G 28100 8990889           |           |    | 21.97            | USD   | Overhead - Prod'n.                      |
| G 28100 8990890           |           |    | 8.86             | USD   | Overhead - Prod Var                     |
| # M 0140 0140 MAY F300019 | 1,000.000 | EA | +9.05 55.00      | USD   | LINK RETURN SPRING                      |
| M 0150 0140 MAY F300022   | 1,000.000 | EA | -25.40 73.00     | USD   | CAP, LINK PIVOT PIN                     |
| # M 0160 0140 MAY F300036 | 1,000.000 | EA | +43.93 300.80    | USD   | SAFETY BUTTON                           |
| F 0010 0010 103386        | 1,000.000 | EA | 10.00            | USD   | Vendor Heat Treat - For F300036         |
| M 0010 0010 MAY F300074   | 1,000.000 | EA | +43.93 170.00    | USD   | SAFETY BUTTON BLANK                     |
| E 0030 28150 WC0005 MLG3  | 1         | HR | 9.43             | USD   | Black Oxide                             |
| E 0050 28100 WC2213 MLG3  | 2         | HR | 18.86            | USD   | Oven Cure Stripe Paint                  |
| G 28100 8990889           |           |    | 65.92            | USD   | Overhead - Prod'n.                      |
| G 28100 8990890           |           |    | 26.59            | USD   | Overhead - Prod Var                     |
| # M 0170 0140 MAY F300003 | 1,000.000 | EA | -52.27 97.26     | USD   | SAFETY PLUNGER                          |
| F 0010 0010 103386        | 1,000.000 | EA | -10.00 10.00     | USD   | Vendor Heat Treat - For F300003         |
| M 0010 0010 MAY F300088   | 1,000.000 | EA | -2.00 47.00      | USD   | SAFETY PLUNGER BLANK                    |
| E 0030 28150 WC0005 MLG3  | 1         | HR | 9.43             | USD   | Black Oxide                             |
| G 28100 8990889           |           |    | 21.97            | USD   | Overhead - Prod'n.                      |
| G 28100 8990890           |           |    | 8.86             | USD   | Overhead - Prod Var                     |
| M 0180 0140 MAY F300009   | 1,000.000 | EA | 3.95             | USD   | SAFETY PLUNGER SPRING, ELEVATION SPRING |
| M 0190 0140 MAY F300015   | 1,000.000 | EA | 8.75             | USD   | HOLD OPEN PIN                           |
| M 0200 0140 MAY F300038   | 1,000.000 | EA | 243.36           | USD   | MAGAZINE LATCH                          |
| M 0210 0140 MAY F300024   | 1,000.000 | EA | 41.35            | USD   | LATCH SPRING                            |
| M 0220 0140 MAY F300002   | 1,000.000 | EA | 9.83             | USD   | LATCH PIVOT PIN                         |
| M 0230 0140 MAY F300032   | 1,000.000 | EA | 358.91           | USD   | MAGAZINE RELEASE                        |
| M 0240 0140 MAY F300025   | 1,000.000 | EA | 22.80            | USD   | HOLD OPEN RETURN SPRING                 |
| # M 0250 0140 MAY F300039 | 1,000.000 | EA | -77.87 163.26    | USD   | HOLD OPEN                               |
| F 0010 0010 103386        | 1,000.000 | EA | -10.00 10.00     | USD   | Vendor Heat Treat - For F300039         |
| M 0010 0010 MAY F300091   | 1,000.000 | EA | +3.00 13.00      | USD   | HOLD OPEN BLANK                         |
| E 0040 28150 WC0005 MLG3  | 1         | HR | 9.43             | USD   | Black Oxide                             |
| G 28100 8990889           |           |    | 21.97            | USD   | Overhead - Prod'n.                      |
| G 28100 8990890           |           |    | 8.86             | USD   | Overhead - Prod Var                     |
| M 0260 0140 MAY F300017   | 1,000.000 | EA | -1.10 5.71       | USD   | SAFETY SPRING RETAINING PIN             |
| M 0270 0140 MAY F300016   | 1,000.000 | EA | -0.00 4.63       | USD   | MAGAZINE RELEASE RETAINING PIN          |
| G 28100 8990889           |           |    | 246.26           | USD   | Overhead - Prod'n.                      |
| G 28100 8990890           |           |    | 906.22           | USD   | Overhead - Prod Var                     |
| # M 0330 4670 MAY F305060 | 1,000.000 | EA | +153.25 1,013.18 | USD   | MAGAZINE BOX ASSEMBLY                   |
| M MAY F300021             | 1,000.000 | EA | 153.25           | USD   | MAGAZINE SPRING                         |
| V                         | 1,000.000 | EA | +153.25 859.93   | USD   | Vendor work                             |
| M 0340 4670 MAY F300010   | 1,000.000 | EA | 17.50            | USD   | ASSEMBLY PIN                            |
| M 0350 4670 MAY F305045   | 1,000.000 | EA | -39.69 5,400.00  | USD   | STOCK ASSEMBLY (SYNTHETIC)              |

Error in  
old of 153.25  
+ Price increase

Elim Debus

-1.10  
-0.00

+153.25

-39.69

E. Maibach  
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BOM item/Operat/Resource

Quantity UM

Gross value ObCrc Name

|   |      |       |        |         |           |           |         |          |           |                                         |                                          |
|---|------|-------|--------|---------|-----------|-----------|---------|----------|-----------|-----------------------------------------|------------------------------------------|
| M | 0370 | 4670  | MAY    | F300012 | 2,000.000 | EA        | +64.30  | 110.30   | USD       | TAKEDOWN SCREW, Front                   |                                          |
| M | 0390 | 4670  | MAY    | F1645   | 200.000   | EA        |         | 343.00   | USD       | CARTON, FIVE PACK                       |                                          |
| M | 0410 | 4670  | MAY    | F993002 | 1,000.000 | EA        |         | 37.50    | USD       | BOX AND ENVELOPE LABEL                  |                                          |
| M | 0470 | 4670  | MAY    | F300116 | 200.000   | EA        |         | 3.89     | USD       | LABEL, 5-PAK SMALL FORMAT               |                                          |
| M | 0480 | 4670  | MAY    | 21238   | 7,000.000 | RND       |         | 91.91    | USD       | TB-22A R 22 LR HV TC SB                 |                                          |
| M | 0490 | 4670  | MAY    | 21074   | 7,000.000 | RND       |         | 100.87   | USD       | 1722 R 22LR YJ TCHP                     |                                          |
| M | 0500 | 4670  | MAY    | F330031 | 1,000.000 | EA        |         | 2,871.70 | USD       | Carton Assembly Complete                |                                          |
| M | 0520 | 4670  | MAY    | F300105 | 1,000.000 | EA        |         | 130.00   | USD       | WINCHESTER PROOF LOAD DPSX22LR          |                                          |
| # | M    | 0540  | 4670   | MAY     | F305065   | 1,000.000 | EA      | +2600.94 | 25,914.58 | USD                                     | Barrel Assembly Complete; .22LR (CS)     |
| E |      | 0050  | 28100  | WC2216  | MLG2      | 79        | HR      |          | 645.43    | USD                                     | Ass. Receiver to Bbl Ass'y; All Reportin |
| # | M    | 0010  | 0050   | MAY     | F305040   | 1,000.000 | EA      | -729.59  | 4,994.10  | USD                                     | RECEIVER; CS, BLACK                      |
| E |      | 0018  | 28100  | WC2210  | MLG3      | 53        | HR      | +198.03  | 499.79    | USD                                     | Vibratory Finish; WC2210 Reporting       |
| F |      | 0020  | 103402 | F300046 |           |           | EA      | +14.00   | 2,540.00  | USD                                     | RECEIVER BLANK; CS, SS, WM               |
| G |      | 28100 |        | 8990889 |           |           | EA      | -150.00  | 320.00    | USD                                     | Vendor Powder Coat - FOR F305040         |
| G |      | 28100 |        | 8990890 |           |           |         | +647.56  | 1,164.51  | USD                                     | Overhead - Prod'n.                       |
|   |      |       |        |         |           |           |         |          | 469.80    | USD                                     | Overhead - Prod Var                      |
| M | 0020 | 0050  | MAY    | F17034  | 1,000.000 | EA        |         | 114.24   | USD       | RECEIVER PLUG SCREWS (CS)               |                                          |
| M | 0030 | 0050  | MAY    | F300040 | 1,000.000 | EA        |         | 425.39   | USD       | BARREL CLAMP                            |                                          |
| M | 0040 | 0050  | MAY    | F300013 | 1,000.000 | EA        | +2.40   | 24.40    | USD       | BARREL CLAMP SCREW                      |                                          |
| M | 0050 | 0050  | MAY    | F305000 | 1,000.000 | EA        | -1.08   | 90.00    | USD       | BOLT BUFFER                             |                                          |
| M | 0060 | 0050  | MAY    | F300035 | 1,000.000 | EA        |         | 1,258.52 | USD       | FRONT SIGHT                             |                                          |
| M | 0070 | 0050  | MAY    | F28505  | 1,000.000 | EA        |         | 39.77    | USD       | FRONT SIGHT SCREW                       |                                          |
| M | 0080 | 0050  | MAY    | F300042 | 1,000.000 | EA        |         | 2,252.10 | USD       | REAR SIGHT BASE                         |                                          |
| M | 0090 | 0050  | MAY    | F300027 | 1,000.000 | EA        |         | 125.20   | USD       | REAR SIGHT BASE SCREW                   |                                          |
| # | M    | 0100  | 0050   | MAY     | F300034   | 1,000.000 | EA      | +300.00  | 810.26    | USD                                     | SCREW, ELEVATION FOR REAR SIGHT          |
| F |      | 0010  | 103386 |         |           |           | EA      |          | 20.00     | USD                                     | Vendor Heat Treat - For F300034          |
| M | 0010 | 0010  | MAY    | F300073 | 1,000.000 | EA        | +300.00 | 750.00   | USD       | ELEVATION SCREW BLANK                   |                                          |
| F |      | 0030  | 28150  | WC0005  | MLG3      |           | HR      |          | 9.43      | USD                                     | Black Oxide                              |
| G |      | 28100 |        | 8990889 |           |           |         | 21.97    | USD       | Overhead - Prod'n.                      |                                          |
| G |      | 28100 |        | 8990890 |           |           |         | 8.86     | USD       | Overhead - Prod Var                     |                                          |
| M | 0110 | 0050  | MAY    | F300009 | 1,000.000 | EA        |         | 3.95     | USD       | SAFETY PLUNGER SPRING, ELEVATION SPRING |                                          |
| M | 0120 | 0050  | MAY    | F300043 | 1,000.000 | EA        | -3.40   | 90.00    | USD       | REAR SIGHT CANTILEVER                   |                                          |
| M | 0130 | 0050  | MAY    | F300037 | 1,000.000 | EA        |         | 1,019.43 | USD       | APERTURE                                |                                          |
| M | 0140 | 0050  | MAY    | F300026 | 1,000.000 | EA        |         | 120.00   | USD       | SCREW, WINDAGE                          |                                          |
| # | M    | 0150  | 0050   | MAY     | F305030   | 1,000.000 | EA      | +1599.73 | 7,791.24  | USD                                     | BARREL ASSEMBLY (CS)                     |
| E |      | 0015  | 28100  | WC2201  | MLG3      | 77        | HR      |          | 726.11    | USD                                     | Rifle Bore; WC2201 All Reporting         |
| M | 0020 | 0015  | MAY    | F300099 | 1,875.000 | EA        |         | 1,931.63 | USD       | M 597 BARREL MATERIAL (C.S.)            |                                          |
| E |      | 0079  | 28100  | WC2203  | MLG3      | 98        | HR      | +198.03  | 1,924.14  | USD                                     | Roll Mark Caliber; WC2203 Reporting      |
| # | M    | 0010  | 0079   | MAY     | F305020   | 1,000.000 | EA      | +10.98   | 2,007.72  | USD                                     | BARREL EXTENSION (CS)                    |
| E |      | 0010  | 28100  | WC2212  | MLG3      | 29        | HR      |          | 273.47    | USD                                     | Machine, Deburr; WC2212 All Reporting    |
| M | 0010 | 0010  | MAY    | F305015 | 1,000.000 | EA        | -12.95  | 840.00   | USD       | BARREL EXTENSION BLANK (CS)             |                                          |
| G |      | 28100 |        | 8990889 |           |           |         | 637.19   | USD       | Overhead - Prod'n.                      |                                          |
| G |      | 28100 |        | 8990890 |           |           |         | 257.06   | USD       | Overhead - Prod Var                     |                                          |
| E |      | 0110  | 28150  | WC0005  | MLG3      | 20        | HR      | +179.17  | 188.60    | USD                                     | Black Oxide                              |
| G |      | 28100 |        | 8990889 |           |           |         | 1,284.52 | USD       | Overhead - Prod'n.                      |                                          |
| G |      | 28100 |        | 8990890 |           |           |         | 1,728.52 | USD       | Overhead - Prod Var                     |                                          |
| G |      | 28100 |        | 8990889 |           |           |         | 503.85   | USD       | Overhead - Prod'n.                      |                                          |
| G |      | 28100 |        | 8990890 |           |           |         | 606.70   | USD       | Overhead - Prod Var                     |                                          |
| # | M    | 0550  | 4670   | MAY     | F305050   | 1,000.000 | EA      | -917.06  | 2,218.53  | USD                                     | Bolt Assembly; .22 LR                    |
| E |      | 0030  | 28100  | WC2217  | MLG2      | 39        | HR      |          | 318.63    | USD                                     | Ass. Firing Pin, Spring; All Reporting   |
| # | M    | 0010  | 0030   | MAY     | F300049   | 1,000.000 | EA      | +458.95  | 1,229.01  | USD                                     | BOLT (L.R.)                              |

Email to [unclear] 10/6  
57.32 avg  
Need 2 [unclear]  
SB 114.65  
avg of 82

anticipated price increase

incl Glass Bolt

was 79

Changed back 10/6/97  
SB 79  
Time?

BARBER - 5.22.06r0010244

BOM it.../Operat/Resource

Quantity UM

Gross value ObCrc Name

|   |      |      |         |         |         |           |           |          |          |                   |                                  |                                     |
|---|------|------|---------|---------|---------|-----------|-----------|----------|----------|-------------------|----------------------------------|-------------------------------------|
| M | 0010 | 0008 | MAY     | F300050 |         | 1,000.000 | EA        | 1,850.00 | USD      | BOLT BLANK (L.R.) |                                  |                                     |
| E |      | 0010 | 28100   | WC2209  | MLG3    | 53        | HR        | +141.45  | 499.79   | USD               | Machine Bolt Complete            |                                     |
| F |      | 0020 | 103386  |         |         | 1,000.000 | EA        | +620.00  | 720.00   | USD               | Vendor Heat Treat - For F300049  |                                     |
| E |      | 0032 | 28100   | WC2214  | MLG3    | 36        | HR        |          | 339.48   | USD               | Grind Two Rail Slots             |                                     |
| F |      | 0047 | 28100   | WC2209  | MLG3    | 20        | HR        | -179.17  | 188.60   | USD               | Dip in rust Inhibitor; Reporting |                                     |
| F |      | 0050 | 2532596 |         |         | 1,000.000 | EA        |          | 330.00   | USD               | Vendor Plating - For F300049     |                                     |
| G |      |      | 28100   | 8990889 |         |           |           | -123.33  | 2,394.94 | USD               | Overhead - Prod'n.               |                                     |
| G |      |      | 28100   | 8990890 |         |           |           |          | 966.20   | USD               | Overhead - Prod Var              |                                     |
| # | M    | 0020 | 0030    | MAY     | F300029 | 1,000.000 | EA        | -10.00   | 32.17    | USD               | SPRING, BOLT HANDLE              |                                     |
| F |      |      | 0010    | 103386  |         | 1,000.000 | EA        | -10.00   | 10.00    | USD               | Vendor Heat Treat - For F300029  |                                     |
| F |      |      | 0010    | 0010    | MAY     | F330029   | 1,000.000 | EA       |          | 22.17             | USD                              | Bolt Handle spring Blank            |
| # | M    | 0030 | 0030    | MAY     | F300011 | 1,000.000 | EA        | -27.80   | 61.00    | USD               | RIVET, BOLT SPRING               |                                     |
| # | M    | 0040 | 0030    | MAY     | F305011 | 1,000.000 | EA        | -79.54   | 213.29   | USD               | EXTRACTOR (L.R.; REGULAR)        |                                     |
| F |      |      | 0005    | 103371  |         | 1,000.000 | EA        | -99      | 0.01     | USD               | Vendor Heat Treat - for F305011  |                                     |
| M | 0010 | 0005 | MAY     | F300030 |         | 1,000.000 | EA        |          | 11.95    | USD               | EXTRACTOR BLANK                  |                                     |
| E |      | 0010 | 28100   | WC2214  | MLG3    | 4         | HR        | +18.86   | 37.72    | USD               | Grind Form and Manual Deburr     |                                     |
| E |      | 0030 | 28150   | WC0005  | MLG3    | 1         | HR        |          | 9.43     | USD               | Black Oxide                      |                                     |
| G |      |      | 28100   | 8990889 |         |           |           | +109.87  | 109.86   | USD               | Overhead - Prod'n.               |                                     |
| G |      |      | 28100   | 8990890 |         |           |           |          | 44.32    | USD               | Overhead - Prod Var              |                                     |
| # | M    | 0050 | 0030    | MAY     | F97418  | 1,000.000 | EA        |          | 7.82     | USD               | SPRING, HELICAL COMPRESSION      |                                     |
| # | M    | 0060 | 0030    | MAY     | F97039  | 1,000.000 | EA        |          | 42.71    | USD               | EXTRACTOR PLUNGER                |                                     |
| # | M    | 0070 | 0030    | MAY     | F300028 | 1,000.000 | EA        | -20.07   | 1,156.18 | USD               | FIRING PIN                       |                                     |
| E |      |      | 0010    | 28100   | WC2208  | MLG3      | 26        | HR       |          | 245.18            | USD                              | Machine Complete, Deburr; Reporting |
| M | 0010 | 0010 | MAY     | F300101 |         | 260.000   | FT        |          | 39.00    | USD               | M 597 FIRING PIN MATERIAL        |                                     |
| F |      |      | 0020    | 103386  |         | 1,000.000 | EA        | +20.00   | 30.00    | USD               | Vendor Heat Treat - For F300028  |                                     |
| E |      |      | 0050    | 28150   | WC0005  | MLG3      | 1         | HR       | +9.43    | 9.43              | USD                              | Black Oxide                         |
| G |      |      | 28100   | 8990889 |         |           |           | -30.84   | 593.24   | USD               | Overhead - Prod'n.               |                                     |
| G |      |      | 28100   | 8990890 |         |           |           |          | 239.33   | USD               | Overhead - Prod Var              |                                     |
| # | M    | 0080 | 0030    | MAY     | F300006 | 1,000.000 | EA        | -2.05    | 10.70    | USD               | FIRING PIN SPRING                |                                     |
| # | M    | 0090 | 0030    | MAY     | F300014 | 1,000.000 | EA        |          | 45.10    | USD               | FIRING PIN RETAINING PIN         |                                     |
| G |      |      | 28100   | 8990889 |         |           |           | -1068.63 | 742.41   | USD               | Overhead - Prod'n.               |                                     |
| G |      |      | 28100   | 8990890 |         |           |           |          | 299.51   | USD               | Overhead - Prod Var              |                                     |
| G |      |      | 28100   | 8990889 |         |           |           |          | 3,635.90 | USD               | Overhead - Prod'n.               |                                     |
| G |      |      | 28100   | 8990890 |         |           |           |          | 1,466.84 | USD               | Overhead - Prod Var              |                                     |

BARBER - 5.22.06r0010245

changed 10/6/93  
5B 10.00

Elim Tumble

83

MF0295

Confidential - SHARPER - 5.22.06r0010245 Order

Williams V. Remington

## **BUSS BAR LOADS**

**OBJECTIVE** - TO SEE IF THERE IS ENOUGH CAPACITY LEFT FOR  
THE NEW MACHINES NEEDED FOR THE MODEL 710.

**BUSS RATING** - 800 A

**# OF BUSS** - 2 (NORTH, SOUTH)

MF0296

NORTH BUSS BAR CAPACITY

| <u>MACHINE</u>   | <u>FUSED @</u> |
|------------------|----------------|
| CHILLER (REAMER) | 10A            |
| CHILLER (DRILL)  | 20A            |
| RIFLER           | 45A            |
| REAMER           | 60A            |
| REAMER           | 60A            |
| GUNDRILL         | 125A           |
| GREENARD PRESS   | 20A            |
| LIGHTING PANEL   | 200A           |
| DUAL HEAD DRILL  | 10A            |
| OKUMA (RAIL)     | 40A            |
| O-12             | 10A            |
| ROLLMARK 575     | 20A            |
| RECEIVER         | 40A            |
| RECEIVER         | 40A            |
| CARBON BOLT      | 40A            |
| TUNGSTEN         | 40A            |
| TUNGSTEN         | 40A            |
| DADSON           | 40A            |
| OKUMA (B.A.)     | 40A            |
| OKUMA (B.A.)     | 40A            |
| MONARCH          | 80A            |
| MONARCH          | 80A            |
| CROWN            | 40A            |
| CHAMBER          | 40A            |
| TORIT (POLISHER) | 10A            |
| ROLLMARK (B.A.)  | 10A            |
| SURFACE GRINDER  | 25A            |
| O-18             | <u>10A</u>     |

TOTAL 1235 A

CURRENT LOAD ON BUSS BAR

(1235 A) (30%) = 370.5 A

LOAD 370.5 A

MF0297

**SOUTH BUSS BAR CAPACITY**

| <b><u>MACHINE</u></b>  | <b><u>FUSED @</u></b> |
|------------------------|-----------------------|
| ASSEMBLY PANEL         | 200A                  |
| EDGETEK                | 100A                  |
| CENTRIFUGE             | 40A                   |
| SOUTHBEND LATHE        | 4A                    |
| AMRICAN PACEMAKER      | 5A                    |
| BRIDGEPORT             | 4A                    |
| BRIDGEPORT             | 4A                    |
| SURFACE GRINDER        | 15A                   |
| ROTO FINISH            | 10A                   |
| CITIZEN                | 30A                   |
| SHIPPING PANEL         | 100A                  |
| GUNDRILL               | 125A                  |
| GRAYMILLS PARTS WASHER | 30A                   |
| A/C UNIT               | 70A                   |
| A/C UNIT               | 90A                   |
| A/C UNIT               | 60A                   |
| WAGNER CUT-OFF         | <u>20A</u>            |

TOTAL 907 A

**CURRENT LOAD ON BUSS BAR**

(907A) (30%) = 272.1 A

LOAD 272.1 A

MF0298

TRICKS

NEW BUSS Equipment and Installed

# 23770 <sup>00</sup>

CONFIDENTIAL 83

MF0299

## **BUSS BAR LOADS**

**OBJECTIVE -**

TO SEE IF THE BUSS BARS HAVE ENOUGH CAPACITY LEFT FOR THE NEW MACHINES NEEDED FOR THE MODEL 710.

**BUSS RATING -**

800 A

**# OF BUSS -**

2 (NORTH SOUTH)

**NORTH BUSS****MACHINE****FUSED @**

|                  |       |
|------------------|-------|
| CHILLER (REAMER) | 10 A  |
| CHILLER (DRILL)  | 20 A  |
| RIFLER           | 45 A  |
| REAMER           | 60 A  |
| REAMER           | 60A   |
| GUNDRILL         | 125 A |
| GREENARD PRESS   | 20 A  |
| LIGHTING PANEL   | 200 A |
| DUAL HEAD DRILL  | 10 A  |
| OKUMA (RAIL)     | 40 A  |
| O-12             | 10 A  |
| ROLLMARK 575     | 20 A  |
| RECEIVER         | 40 A  |
| RECEIVER         | 40 A  |
| CARBON BOLT      | 40 A  |
| TUNGSTEN         | 40 A  |
| TUNGSTEN         | 40 A  |
| DADSON           | 40 A  |
| OKUMA (B.A.)     | 40 A  |
| OKUMA (B.A.)     | 40 A  |
| MONARCH          | 80 A  |
| MONARCH          | 80 A  |
| CROWN            | 40 A  |
| CHAMBER          | 40 A  |
| TORT (POLISHER)  | 10 A  |
| ROLLMARK (B.A.)  | 10 A  |
| SURFACE GRINDER  | 25 A  |
| O-18             | 10 A  |

|              |               |
|--------------|---------------|
| <b>TOTAL</b> | <b>1235 A</b> |
|--------------|---------------|

|                                          |                |
|------------------------------------------|----------------|
| <b>BUSS LOAD - (1235 A) (30%) = LOAD</b> | <b>370.5 A</b> |
|------------------------------------------|----------------|

**46 % OF BUSS IS CURRENTLY BEING USED**

**SOUTH BUSS****MACHINE****FUSED @**

|                          |       |
|--------------------------|-------|
| ASSEMBLY PANEL           | 200 A |
| EDGETEK                  | 100 A |
| CENTRIFUGE               | 40 A  |
| SOUTHBEND LATHE          | 4 A   |
| AMERICAN PACEMAKER LATHE | 5 A   |
| BRIDGEPORT               | 4 A   |
| BRIDGEPORT               | 4 A   |
| SURFACE GRINDER          | 15 A  |
| ROTO FINISH              | 10 A  |
| CITIZEN                  | 30 A  |
| SHIPPING PANEL           | 100 A |
| GUNDRILL                 | 125 A |
| GRAYMILLS PARTS WASHER   | 80 A  |
| A/C UNIT                 | 70 A  |
| A/C UNIT                 | 90 A  |
| A/C UNIT                 | 60 A  |
| WAGNER CUT-OFF           | 20 A  |

**TOTAL 907 A****BUSS LOAD - (907 A) (30%) = LOAD 272.1 A****34 % OF BUSS CURRENTLY BEING USED**