

# BOLT BODY ASS. Comp.

Bin Holders      Part      X      Part #      Tote Size      Dem. Of Bin Holder

|                             |                   |   |        |          |                     |
|-----------------------------|-------------------|---|--------|----------|---------------------|
| ----- Firing Pin Ass. ----- |                   |   |        |          |                     |
| 1                           | Bolt Plug         |   | 300368 | <u>7</u> | Holder #1 12h x 18w |
|                             | Tumbler           | x | 300418 | 2        | Lock Plunger        |
|                             | Lock Plunger      | x | 201224 | 1        | Tumbler             |
|                             | Lock Spring       | x | 201217 | 2        | Lock Spring         |
|                             | Spring Retainer   | x | 300427 | 2        | Spring Retainer     |
|                             | Firing Pin        | x | 300334 | 3        | Firing Pin Tip      |
|                             | Firing Pin Tip    | x | 300335 | 2        | Firing Pin Head     |
|                             | Firing Pin Head   | x | 300336 | 2        | Holder #2 16h x 18w |
|                             | Firing Pin Spring | x | 300399 | 4        | Firing Pin          |
|                             |                   |   |        |          | Firing Pin Spring   |

|                            |                |   |        |   |           |
|----------------------------|----------------|---|--------|---|-----------|
| ----- Bolt Head Ass. ----- |                |   |        |   |           |
| 2                          | Extractor      | x | 93712  | 2 | 10h x 12w |
|                            | Ejector        | x | 300342 | 2 |           |
|                            | Ejector Spring | x | 300367 | 2 |           |
|                            | Ejector Pin    | x | 94555  | 1 |           |

|                             |                   |   |        |   |  |
|-----------------------------|-------------------|---|--------|---|--|
| ----- Bolt Ass. Comp. ----- |                   |   |        |   |  |
| 3                           | Bolt Assembly Pin | x | 300330 | 3 |  |

Does a table need to have a hanger if it only has 1 bin assigned to that table?

BOLT Body Assembly Complete

TOTE #  
5

MF0525

# FINAL BUILD ASS.

| Part #  | Description                | Qty. | I | Q | I | E | S | LBS. | Weight   | # of     |
|---------|----------------------------|------|---|---|---|---|---|------|----------|----------|
|         |                            |      | 1 | 2 | 3 | 4 | 5 | 6    | per tote | Stickers |
| F94084  | Front Sights               | 1000 |   |   | 2 |   |   | 19.2 | 9.6      | 4        |
| F94657  | Front Sight Ramp           | 250  |   |   | 8 |   |   | 94.4 | 11.8     | 16       |
| F28505  | Front Sight Ramp Screw (2) | 4000 |   | 2 |   |   |   | 5.6  | 2.8      | 4        |
| F90906  | Elevation Screw            | 2000 |   | 1 |   |   |   | 2.3  | 2.3      | 1        |
| F94333  | Rear Sight Aperature       | 1000 |   |   | 2 |   |   | 19.4 | 9.7      | 4        |
| F103530 | Rear Sight Base            | 250  |   |   | 8 |   |   | 77.6 | 9.7      | 16       |
| F94335  | Rear Sight Slide           | 1000 |   |   | 2 |   |   | 24.8 | 12.4     | 4        |
| F90904  | Windage Screw              | 2000 | 1 |   |   |   |   | 1.1  | 1.1      | 1        |
| F28505  | Rear Sight Base Screw (2)  | 4000 |   | 2 |   |   |   | 5.6  | 2.8      | 4        |
| F94996  | Sling Swivel Stud          | 1000 |   |   | 2 |   |   | 23.4 | 11.7     | 4        |
| F104131 | Front Takedown Screw       | 2000 |   |   | 2 |   |   |      |          | 4        |
| F104133 | Middle Takedown Screw      | 2000 |   |   | 2 |   |   |      |          | 4        |
| F300425 | Rear Takedown Screw        | 2000 |   |   | 2 |   |   |      |          | 4        |

F300345 Bolt Stop

F300454 Recoil Bracket

Receiver Plug Screws 8000 #2

MF0526

# TRIGGER Ass. Comp.

| Bin Holders                | Part                | Steps | X | Part # | Tote Size | Dem. Of Bin Holder |
|----------------------------|---------------------|-------|---|--------|-----------|--------------------|
| <b>Insert Ass.</b>         |                     |       |   |        |           |                    |
| 1                          | Threaded Insert     | 1     |   | 300347 | 3         |                    |
|                            | Receiver Insert     |       |   | 300327 | 6         |                    |
| <b>Trigger Ass.</b>        |                     |       |   |        |           |                    |
| 2                          | Trigger             | 13    | x | 109835 | 4         | 18h x 19w          |
|                            | Trigger Connector   | 14    | x | 19461  | 3         |                    |
|                            | Trigger Pivot Pin   | 15    | x | 300463 | 2         |                    |
|                            | Pin Retaining Clip  | 16    | x | 300465 | 2         |                    |
| <b>Holder #1 12h x 24w</b> |                     |       |   |        |           |                    |
|                            | Side Plate Pin      |       |   |        |           |                    |
|                            | Trigger Eng. Screw  |       |   |        |           |                    |
|                            | Trigger Stop Screw  |       |   |        |           |                    |
|                            | Trigger Screw Front |       |   |        |           | 83                 |
|                            | Trigger Spring      |       |   |        |           |                    |
|                            | Sear Spring         |       |   |        |           |                    |
| <b>Holder #2 12h x 20w</b> |                     |       |   |        |           |                    |
|                            | Side Plate          |       |   |        |           |                    |
|                            | Sear Safety Cam     |       |   |        |           |                    |
|                            | Pivot Pin           |       |   |        |           |                    |
|                            | Sear Retaining Pin  |       |   |        |           |                    |
|                            | Pin Retaining Clip  |       |   |        |           |                    |
| 3                          | Sear Safety Cam     | 9     | x | 15666  | 3         |                    |
|                            | Sear Spring         | 7     | x | 17047  | 2         |                    |
|                            | Trigger Eng. Screw  | 3     | x | 300448 | 3         |                    |
|                            | Trigger Spring      | 6     | x | 15400  | 1         |                    |
|                            | Trigger Screw Front | 5     | x | 17053  | 2         |                    |
|                            | Trigger Stop Screw  | 4     | x | 300426 | 3         |                    |
|                            | Sear Retaining Pin  | 11    | x | 300464 | 2         |                    |
|                            | Pin Retaining Clip  | 12    | x | 300465 | 2         |                    |
|                            | Pivot Pin           | 10    | x | 300351 | 1         |                    |
|                            | Side Plate          | 8     | x | 300333 | 4         |                    |
|                            | Side Plate Pin      | 2     | x | 300328 | 2         |                    |
| <b>Holder #3 15h x 18w</b> |                     |       |   |        |           |                    |
|                            | Safety              | 18    | x | 300408 | 4         |                    |
|                            | Safety Spring       | 17    | x | 300407 | 3         |                    |
|                            | Safety Pivot Pin    | 19    | x | 17043  | 2         |                    |
|                            | Safety Snap Washer  | 20    | x | 17044  | 1         |                    |

MF0527

# BOLT BODY ASS. Comp.

| Bin Holders | Part              | X | Part # | Tote Size      | Dem. Of Bin Holder  |
|-------------|-------------------|---|--------|----------------|---------------------|
| <hr/>       |                   |   |        |                |                     |
|             | Firing Pin Ass.   |   |        |                |                     |
| 1           | Bolt Plug         |   | 300368 | <del>2</del> 7 | Holder #1 12h x 18w |
|             | Tumbler           | x | 300418 | 2              | Lock Plunger        |
|             | Lock Plunger      | x | 201224 | 1              | Tumbler             |
|             | Lock Spring       | x | 201217 | 2              | Lock Spring         |
|             | Spring Retainer   | x | 300427 | 2              | Spring Retainer     |
|             | Firing Pin        | x | 300334 | 3              | Firing Pin Tip      |
|             | Firing Pin Tip    | x | 300335 | 2              | Firing Pin Head     |
|             | Firing Pin Head   | x | 300336 | 2              | Holder #2 16h x 18w |
|             | Firing Pin Spring | x | 300399 | 4              | Firing Pin          |
|             |                   |   |        |                | Firing Pin Spring   |

|       |                |   |        |   |              |
|-------|----------------|---|--------|---|--------------|
| <hr/> |                |   |        |   |              |
|       | Bolt Head Ass. |   |        |   |              |
| 2     | Extractor      | x | 93712  | 2 | 10h x 12w 83 |
|       | Ejector        | x | 300342 | 2 |              |
|       | Ejector Spring | x | 300367 | 2 |              |
|       | Ejector Pin    | x | 94555  |   |              |

|       |                   |   |        |   |  |
|-------|-------------------|---|--------|---|--|
| <hr/> |                   |   |        |   |  |
|       | Bolt Ass. Comp.   |   |        |   |  |
| 3     | Bolt Assembly Pin | x | 300330 | 3 |  |

Does a table need to have a hanger if it only has 1 bin assigned to that table?

TOTE #  
5

BOLT Body Assembly Complete

MF0528

# FINAL BUILD ASS.

| Part #  | Description                | Qty. | I | Q | I | E | S | LBS. | Weight   | # of     |
|---------|----------------------------|------|---|---|---|---|---|------|----------|----------|
|         |                            |      | 1 | 2 | 3 | 4 | 5 |      | per tote | Stickers |
| F94084  | Front Sights               | 1000 |   |   | 2 |   |   | 19.2 | 9.6      | 4        |
| F94657  | Front Sight Ramp           | 250  |   |   | 8 |   |   | 94.4 | 11.8     | 16       |
| F28505  | Front Sight Ramp Screw (2) | 4000 |   | 2 |   |   |   | 5.6  | 2.8      | 4        |
| F90906  | Elevation Screw            | 2000 |   | 1 |   |   |   | 2.3  | 2.3      | 1        |
| F94333  | Rear Sight Aperature       | 1000 |   |   | 2 |   |   | 19.4 | 9.7      | 4        |
| F103530 | Rear Sight Base            | 250  |   |   | 8 |   |   | 77.6 | 9.7      | 16       |
| F94335  | Rear Sight Slide           | 1000 |   |   | 2 |   |   | 24.8 | 12.4     | 4        |
| F90904  | Windage Screw              | 2000 | 1 |   |   |   |   | 1.1  | 1.1      | 1        |
| F28505  | Rear Sight Base Screw (2)  | 4000 |   | 2 |   |   |   | 5.6  | 2.8      | 4        |
| F94996  | Sling Swivel Stud          | 1000 |   |   | 2 |   |   | 23.4 | 11.7     | 4        |
| F104131 | Front Takedown Screw       | 2000 |   |   | 2 |   |   |      |          | 4        |
| F104133 | Middle Takedown Screw      | 2000 |   |   | 2 |   |   |      |          | 4        |
| F300425 | Rear Takedown Screw        | 2000 |   |   | 2 |   |   |      |          | 4        |
| F300345 | Boat Stop                  | 000  |   |   |   |   |   |      |          |          |
| F300454 | Recoil Bracket             | 000  |   |   |   |   |   |      |          |          |
|         | Receiver Plug Screws       | 8000 |   |   |   |   |   |      |          |          |
|         |                            |      |   |   |   |   |   |      |          |          |

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CONFIDENTIAL

MF0529

# TRIGGER Ass. Comp.

Bin Holders      Part      Steps X      Part #      Tote Size      Dem. Of Bin Holder

|       |                 |   |  |        |   |
|-------|-----------------|---|--|--------|---|
| <hr/> |                 |   |  |        |   |
|       | Insert Ass.     |   |  |        |   |
| 1     | Threaded Insert | 1 |  | 300347 | 3 |
|       | Receiver Insert |   |  | 300327 | 6 |

|       |                    |    |   |        |   |
|-------|--------------------|----|---|--------|---|
| <hr/> |                    |    |   |        |   |
|       | Trigger Ass.       |    |   |        |   |
| 2     | Trigger            | 13 | x | 109835 | 4 |
|       | Trigger Connector  | 14 | x | 19461  | 3 |
|       | Trigger Pivot Pin  | 15 | x | 300463 | 2 |
|       | Pin Retaining Clip | 16 | x | 300465 | 2 |

18h x 19w

|   |                     |    |   |        |   |
|---|---------------------|----|---|--------|---|
| 3 | Sear Safety Cam     | 9  | x | 15666  | 3 |
|   | Sear Spring         | 7  | x | 17047  | 2 |
|   | Trigger Eng. Screw  | 3  | x | 300448 | 3 |
|   | Trigger Spring      | 6  | x | 15400  | 1 |
|   | Trigger Screw Front | 5  | x | 17053  | 2 |
|   | Trigger Stop Screw  | 4  | x | 300426 | 3 |
|   | Sear Retaining Pin  | 11 | x | 300464 | 2 |
|   | Pin Retaining Clip  | 12 | x | 300465 | 2 |
|   | Pivot Pin           | 10 | x | 300351 | 1 |
|   | Side Plate          | 8  | x | 300333 | 4 |
|   | Side Plate Pin      | 2  | x | 300328 | 2 |

Holder #1 12h x 24w

Side Plate Pin  
Trigger Eng. Screw  
Trigger Stop Screw  
Trigger Screw Front  
Trigger Spring  
Sear Spring

83

Holder #2 12h x 20w

Side Plate  
Sear Safety Cam  
Pivot Pin  
Sear Retaining Pin  
Pin Retaining Clip

|   |                    |    |   |        |   |
|---|--------------------|----|---|--------|---|
| 4 | Safety             | 18 | x | 300408 | 4 |
|   | Safety Spring      | 17 | x | 300407 | 3 |
|   | Safety Pivot Pin   | 19 | x | 17043  | 2 |
|   | Safety Snap Washer | 20 | x | 17044  | 1 |

15h x 18w

MF0530

Confidential - Subject to Protective Order

BARBER - 5.22.06r0010480

Williams v. Remington

# BOLT BODY ASS. Comp.

Bin Holders      Part      X      Part #      Tote Size      Dem. Of Bin Holder

|                             |                   |   |        |              |                     |
|-----------------------------|-------------------|---|--------|--------------|---------------------|
| ----- Firing Pin Ass. ----- |                   |   |        |              |                     |
| 1                           | Bolt Plug         |   | 300368 | <del>1</del> | Holder #1 12h x 18w |
|                             | Tumbler           | x | 300418 | 2            | Lock Plunger        |
|                             | Lock Plunger      | x | 201224 | 1            | Tumbler             |
|                             | Lock Spring       | x | 201217 | 2            | Lock Spring         |
|                             | Spring Retainer   | x | 300427 | 2            | Spring Retainer     |
|                             | Firing Pin        | x | 300334 | 3            | Firing Pin Tip      |
|                             | Firing Pin Tip    | x | 300335 | 2            | Firing Pin Head     |
|                             | Firing Pin Head   | x | 300336 | 2            | Holder #2 16h x 18w |
|                             | Firing Pin Spring | x | 300399 | 4            | Firing Pin          |
|                             |                   |   |        |              | Firing Pin Spring   |

|                            |                |   |        |   |           |
|----------------------------|----------------|---|--------|---|-----------|
| ----- Bolt Head Ass. ----- |                |   |        |   |           |
| 2                          | Extractor      | x | 93712  | 2 | 10h x 12w |
|                            | Ejector        | x | 300342 | 2 |           |
|                            | Ejector Spring | x | 300367 | 2 |           |
|                            | Ejector Pin    | x | 94555  | 1 |           |

|                             |                   |   |        |   |  |
|-----------------------------|-------------------|---|--------|---|--|
| ----- Bolt Ass. Comp. ----- |                   |   |        |   |  |
| 3                           | Bolt Assembly Pin | x | 300330 | 3 |  |

Does a table need to have a hanger if it only has 1 bin assigned to that table?

TOTE #  
5

Bolt Body Assembly Complete

MF0531

Confidential - Subject to Protective Order

BARBER - 5.22.06r0010481

Williams v. Remington

# FINAL BUILD ASS.

| Part #        | Description                | Qty.        | I | Q | I | E | S | LBS. | Weight   | # of     |
|---------------|----------------------------|-------------|---|---|---|---|---|------|----------|----------|
|               |                            |             | 1 | 2 | 3 | 4 | 5 | 6    | per tote | Stickers |
| F94084        | Front Sights               | 1000        |   |   | 2 |   |   | 19.2 | 9.6      | 4        |
| F94657        | Front Sight Ramp           | 250         |   |   | 8 |   |   | 94.4 | 11.8     | 16       |
| F28505        | Front Sight Ramp Screw (2) | 4000        |   | 2 |   |   |   | 5.6  | 2.8      | 4        |
| <u>F90906</u> | <u>Elevation Screw</u>     | <u>2000</u> |   | 1 |   |   |   | 2.3  | 2.3      | 1        |
| F94333        | Rear Sight Aperature       | 1000        |   |   | 2 |   |   | 19.4 | 9.7      | 4        |
| F103530       | Rear Sight Base            | 250         |   |   | 8 |   |   | 77.6 | 9.7      | 16       |
| F94335        | Rear Sight Slide           | 1000        |   |   | 2 |   |   | 24.8 | 12.4     | 4        |
| <u>F90904</u> | <u>Windage Screw</u>       | <u>2000</u> | 1 |   |   |   |   | 1.1  | 1.1      | 1        |
| F28505        | Rear Sight Base Screw (2)  | 4000        |   | 2 |   |   |   | 5.6  | 2.8      | 4        |
| F94996        | Sling Swivel Stud          | 1000        |   |   | 2 |   |   | 23.4 | 11.7     | 4        |
| F104131       | Front Takedown Screw       | 2000        |   |   | 2 |   |   |      |          | 4        |
| F104133       | Middle Takedown Screw      | 2000        |   |   | 2 |   |   |      |          | 4        |
| F300425       | Rear Takedown Screw        | 2000        |   |   | 2 |   |   |      |          | 4        |

F300345 Bolt Stop 000  
 F300454 Recoil Bracket 000

Receiver Plug Screws 8000 #2

CONFIDENTIAL

MF0532

# TRIGGER Ass. Comp.

Bin Holders      Part      Steps X      Part #      Tote Size      Dem. Of Bin Holder

|                    |                 |   |        |   |  |
|--------------------|-----------------|---|--------|---|--|
| <b>Insert Ass.</b> |                 |   |        |   |  |
| 1                  | Threaded Insert | 1 | 300347 | 3 |  |
|                    | Receiver Insert |   | 300327 | 6 |  |

|                     |                    |      |        |   |           |
|---------------------|--------------------|------|--------|---|-----------|
| <b>Trigger Ass.</b> |                    |      |        |   |           |
| 2                   | Trigger            | 13 x | 109835 | 4 | 18h x 19w |
|                     | Trigger Connector  | 14 x | 19461  | 3 |           |
|                     | Trigger Pivot Pin  | 15 x | 300463 | 2 |           |
|                     | Pin Retaining Clip | 16 x | 300465 | 2 |           |

|   |                     |      |        |   |  |
|---|---------------------|------|--------|---|--|
| 3 | Sear Safety Cam     | 9 x  | 15666  | 3 |  |
|   | Sear Spring         | 7 x  | 17047  | 2 |  |
|   | Trigger Eng. Screw  | 3 x  | 300448 | 3 |  |
|   | Trigger Spring      | 6 x  | 15400  | 1 |  |
|   | Trigger Screw Front | 5 x  | 17053  | 2 |  |
|   | Trigger Stop Screw  | 4 x  | 300426 | 3 |  |
|   | Sear Retaining Pin  | 11 x | 300464 | 2 |  |
|   | Pin Retaining Clip  | 12 x | 300465 | 2 |  |
|   | Pivot Pin           | 10 x | 300351 | 1 |  |
|   | Side Plate          | 8 x  | 300333 | 4 |  |
|   | Side Plate Pin      | 2 x  | 300328 | 2 |  |

**Holder #1 12h x 24w**

Side Plate Pin  
 Trigger Eng. Screw  
 Trigger Stop Screw  
 Trigger Screw Front  
 Trigger Spring  
 Sear Spring

**Holder #2 12h x 20w**

Side Plate  
 Sear Safety Cam  
 Pivot Pin  
 Sear Retaining Pin  
 Pin Retaining Clip

|   |                    |      |        |   |           |
|---|--------------------|------|--------|---|-----------|
| 4 | Safety             | 18 x | 300408 | 4 | 15h x 18w |
|   | Safety Spring      | 17 x | 300407 | 3 |           |
|   | Safety Pivot Pin   | 19 x | 17043  | 2 |           |
|   | Safety Snap Washer | 20 x | 17044  | 1 |           |

MF0533

Part Program: 300320 BOLT HANDLE 2  
Inspector: Administrator

Date/Time: 08/28/2000 07:59:23  
CMM: CMM1

#1

TYPE: I.D.

NAME: RADIUS\_LEFT

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|----|---------|---------|--------|--------|--------|---------|
| Y  | -0.1991 | -0.2000 | 0.0050 | 0.0050 | 0.0009 | +       |
| Z  | 2.5495  | 2.5440  | 0.0050 | 0.0050 | 0.0055 | 0.0005  |
| RD | 0.3469  | 0.3425  | 0.0020 | 0.0020 | 0.0044 | 0.0024  |
| PS |         |         | 0.0060 |        | 0.0111 | 0.0051  |

#2

TYPE: I.D.

NAME: RADIUS\_RIGHT

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Y  | -0.2001 | -0.2000 | 0.0050 | 0.0050 | -0.0001 | -       |
| Z  | 2.5410  | 2.5440  | 0.0050 | 0.0050 | -0.0030 | -       |
| RD | 0.3406  | 0.3425  | 0.0020 | 0.0020 | -0.0019 | -       |
| PS |         |         | 0.0060 |        | 0.0060  | ++++    |

#3

TYPE: BORE

NAME: BOLT\_PIN\_HOLE

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| X  | 0.1972  | 0.2000  | 0.0050 | 0.0050 | -0.0028 | ---     |
| Y  | -0.1993 | -0.2000 | 0.0050 | 0.0050 | 0.0007  | +       |
| DI | 0.2502  | 0.2500  | 0.0015 | 0.0015 | 0.0002  | +       |
| PS |         |         | 0.0060 |        | 1.0000  | 0.9940  |

#4

TYPE: I.D.

NAME: COUNTERBORE\_BURR\_RELIEF

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| X  | 0.1993  | 0.2000  | 0.0050 | 0.0050 | -0.0007 | -       |
| Y  | -0.2000 | -0.2000 | 0.0050 | 0.0050 | 0.0000  | -       |
| DI | 0.2817  | 0.2813  | 0.0020 | 0.0020 | 0.0004  | +       |
| PS |         |         | 0.0060 |        | 0.0013  | +       |

#5

TYPE: POINT

NAME: PIN\_DEPTH

|   | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|---|---------|---------|--------|--------|---------|---------|
| X | 0.1956  | 0.2000  | 0.0050 | 0.0050 | -0.0044 | ----    |
| Y | -0.1993 | -0.2000 | 0.0050 | 0.0050 | 0.0007  | +       |
| Z | 2.2028  | 2.1770  | 0.0050 | 0.0050 | 0.0258  | 0.0208  |

MF0534

Part Program: 300320 BOLT HANDLE 2  
Inspector: Administrator

Date/Time: 08/28/2000 08:01:03  
CMM: CMM1

#1

TYPE: I.D.

NAME: RADIUS LEFT

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV    | OUT-TOL |
|----|---------|---------|--------|--------|--------|---------|
| Y  | -0.1991 | -0.2000 | 0.0050 | 0.0050 | 0.0009 | +       |
| Z  | 2.5504  | 2.5440  | 0.0050 | 0.0050 | 0.0064 | 0.0014  |
| RD | 0.3479  | 0.3425  | 0.0020 | 0.0020 | 0.0054 | 0.0034  |
| PS |         |         | 0.0060 |        | 0.0130 | 0.0070  |

#2

TYPE: I.D.

NAME: RADIUS RIGHT

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| Y  | -0.2001 | -0.2000 | 0.0050 | 0.0050 | -0.0001 | -       |
| Z  | 2.5413  | 2.5440  | 0.0050 | 0.0050 | -0.0027 | -0.0027 |
| RD | 0.3410  | 0.3425  | 0.0020 | 0.0020 | -0.0015 | -0.0015 |
| PS |         |         | 0.0060 |        | 0.0054  | 0.0054  |

#3

TYPE: BORE

NAME: BOLT PIN HOLE

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| X  | 0.1973  | 0.2000  | 0.0050 | 0.0050 | -0.0027 | ---     |
| Y  | -0.1993 | -0.2000 | 0.0050 | 0.0050 | 0.0007  | +       |
| DI | 0.2504  | 0.2500  | 0.0015 | 0.0015 | 0.0004  | +       |
| PS |         |         | 0.0060 |        | 1.0002  | 0.9942  |

#4

TYPE: I.D.

NAME: COUNTERBORE BURR RELIEF

|    | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|----|---------|---------|--------|--------|---------|---------|
| X  | 0.1994  | 0.2000  | 0.0050 | 0.0050 | -0.0006 | -       |
| Y  | -0.2000 | -0.2000 | 0.0050 | 0.0050 | 0.0000  | +       |
| DI | 0.2817  | 0.2813  | 0.0020 | 0.0020 | 0.0005  | +       |
| PS |         |         | 0.0060 |        | 0.0013  | +       |

#5

TYPE: POINT

NAME: PIN DEPTH

|   | ACTUAL  | NOMINAL | + TOL  | - TOL  | DEV     | OUT-TOL |
|---|---------|---------|--------|--------|---------|---------|
| X | 0.1955  | 0.2000  | 0.0050 | 0.0050 | -0.0045 | ----    |
| Y | -0.1994 | -0.2000 | 0.0050 | 0.0050 | 0.0006  | +       |
| Z | 2.2030  | 2.1770  | 0.0050 | 0.0050 | 0.0260  | 0.0210  |

MF0535

Elizabethtown Research Division

PARTS LIST #YYY

Date: Model 710

Supersedes Previous Model XXX

03/07/00 Bolt Action

Parts List #AAA

Centerfire Rifle R.H.

|       |   |                            |       |     |                |                |
|-------|---|----------------------------|-------|-----|----------------|----------------|
| Sheet | 1 | Dotted line (- - -)        |       |     |                |                |
| of    | 2 | indicates same part number | 30-06 | 270 | 7mm<br>Rem Mag | 300<br>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-305315-21  | BARREL (Blank 300447)              | 305315 | 305316 | 305317 | 305318 |
| D-305465-    | BARREL MARKING                     |        |        |        |        |
| E-300340-19  | RECEIVER                           | 300340 | ----   | ----   | ----   |
| D-300401-A   | RECEIVER INSERT ASSEMBLY COMPLETE  | 300401 | ----   | ----   | ----   |
| C-300400-    | RECEIVER INSERT ASSEMBLY           | 300400 | ----   | ----   | ----   |
| 1E-300327-17 | RECEIVER INSERT                    | 300327 | ----   | ----   | ----   |
| 2E-300327-30 |                                    |        | ----   | ----   | ----   |
| A-300347-A   | THREADED INSERT                    | 300347 | ----   | ----   | ----   |
| C-300333-5   | SIDE PLATE                         | 300333 | ----   | ----   | ----   |
| A-300328-2   | SIDE PLATE PIN (2)                 | 300328 | ----   | ----   | ----   |
| C-15666      | SEAR SAFETY (Blk. C-91919)         | 15666  | ----   | ----   | ----   |
| B-300351-    | PIVOT PIN (3)                      | 300351 | ----   | ----   | ----   |
| A-17047      | SEAR SPRING                        | 17047  | ----   | ----   | ----   |
| C-300435-C   | TRIGGER (Blk. 300436)              | 300435 | ----   | ----   | ----   |
| C-19461      | TRIGGER CONNECTOR (Blk. C-91921)   | 19461  | ----   | ----   | ----   |
| B-17053      | TRIGGER SCREW FRONT (Blk. B-91920) | 17053  | ----   | ----   | ----   |
| B-300448-    | TRIGGER ENGAGEMENT SCREW           | 300448 | ----   | ----   | ----   |
| A-15400      | TRIGGER SPRING                     | 15400  | ----   | ----   | ----   |
| A-300426     | TRIGGER STOP SCREW                 | 300426 | ----   | ----   | ----   |
| D-300408-16  | SAFETY                             | 300408 | ----   | ----   | ----   |
| A-17048      | SAFETY PIVOT PIN (Blk. B-91918)    | 17043  | ----   | ----   | ----   |
| B-17044      | SAFETY SNAP WASHER (Blk. 200042)   | 17044  | ----   | ----   | ----   |
| B-300407-3   | SAFETY SPRING                      | 300407 | ----   | ----   | ----   |
| C-300345-10  | BOLT STOP                          | 300345 | ----   | ----   | ----   |
| B-17034      | RECEIVER PLUG SCREW (4)            | 17034  | ----   | ----   | ----   |
| B-300361-B   | RECOIL BRACKET                     | 300361 | ----   | ----   | ----   |
| B-300403-    | BOLT BODY ASSEMBLY                 | 300403 | ----   | ----   | ----   |
| C-300339-16  | BOLT BODY                          | 300339 | ----   | ----   | ----   |
| C-300370-C   | BOLT HANDLE                        | 300370 | ----   | ----   | ----   |
| D-300360-C   | BOLT HANDLE BLANK                  | 300360 | ----   | ----   | ----   |
| A-300329-2   | BOLT HANDLE PIN                    | 300329 | ----   | ----   | ----   |
| B-305390-2   | BOLT HEAD ASSEMBLY                 | 305390 | ----   | 305391 | ----   |
| E-300338-18  | BOLT HEAD (30-06, 270)             | 300338 | ----   | ----   | ----   |
| C-300416-F   | BOLT HEAD (7mm Rem, 300 Win)       |        | ----   | 300416 | ----   |
| D-300434-    | BOLT HEAD BLANK                    | 300434 | ----   | ----   | ----   |
|              | EXTRACTOR                          |        | ----   | ----   | ----   |
| C-93712      | 30-06, 270 (Blk. 93711)            | 93712  | ----   | ----   | ----   |
| C-97322      | 7mm Rem, 300 Win (Blk. 97321)      |        | ----   | 97322  | ----   |
| C-27340      | EXTRACTOR RIVET                    |        | ----   | 27341  | ----   |
| B-300342-2   | EJECTOR                            | 300342 | ----   | ----   | ----   |
| A-300367-    | EJECTOR SPRING                     | 300367 | ----   | ----   | ----   |
| A-94555      | EJECTOR PIN                        | 94555  | ----   | ----   | ----   |
| B-300330-    | BOLT ASSEMBLY PIN                  | 300330 | ----   | ----   | ----   |
| B-300404-A   | FIRING PIN ASSEMBLY                | 300404 | ----   | ----   | ----   |
| D-300368-5   | BOLT PLUG                          | 300368 | ----   | ----   | ----   |
| B-300346-D   | BOLT PLUG INSERT                   | 300346 | ----   | ----   | ----   |
| B-300418-B   | TUMBLER                            | 300418 | ----   | ----   | ----   |
| D-300420-D   | TUMBLER BLANK                      | 300420 | ----   | ----   | ----   |

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MF0536

Elizabethtown Research Division PARTS LIST #YYY  
 Date: **Model 710** Supersedes Previous Model XXX  
 03/07/00 **Bolt Action** Parts List #AAA  
**Centerfire Rifle R.H.**

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Sheet 2 Dotted line ( - - - )  
 of 2 indicates same part number 30-06 270 7mm 300  
Rem Mag Win Mag

| DWG. NO.                         | PART NAME                               | PART NUMBERS |      |       |      |
|----------------------------------|-----------------------------------------|--------------|------|-------|------|
| <b>FIRING PIN ASSY CONTINUED</b> |                                         |              |      |       |      |
| C-201224                         | LOCK PLUNGER (Blk. 201223)              | 201224       | ---- | ----  | ---- |
| A-201217                         | LOCK SPRING                             | 201217       | ---- | ----  | ---- |
| A-300427                         | SPRING RETAINER                         | 300427       | ---- | ----  | ---- |
| C-300334-A                       | FIRING PIN                              | 300334       | ---- | ----  | ---- |
| C-300335-2                       | FIRING PIN TIP                          | 300335       | ---- | ----  | ---- |
| C-300336-G                       | FIRING PIN HEAD                         | 300336       | ---- | ----  | ---- |
| A-300399-E                       | FIRING PIN SPRING                       | 300399       | ---- | ----  | ---- |
| <b>FRONT SIGHT</b>               |                                         |              |      |       |      |
| C-15373                          | 30-06, 270 (Blk. 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)      | 94333        | ---- | ----  | ---- |
| 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-305455                         | <b>STOCK ASSEMBLY COMPLETE</b>          | 305455       | ---- | ----  | ---- |
| C-300437                         | STOCK                                   | 300437       | ---- | ----  | ---- |
| J-15161                          | FRONT SCREW BUSHING (Blk 91915)         | 15161        | ---- | ----  | ---- |
| C-97971                          | GRIP CAP                                | 97971        | ---- | ----  | ---- |
| D-97973                          | RECOIL PAD                              | 97973        | ---- | ----  | ---- |
| C-97972                          | RECOIL PAD BACKER                       | 97972        | ---- | ----  | ---- |
| A-98008                          | RECOIL PAD SCREW (2)                    | 98008        | ---- | ----  | ---- |
| C-300362-8                       | MAGAZINE LATCH                          | 300362       | ---- | ----  | ---- |
| B-300398-B                       | LATCH SPRING                            | 300398       | ---- | ----  | ---- |
| B-300371-A                       | LATCH PIVOT PIN                         | 300371       | ---- | ----  | ---- |
| B-15358                          | SLING SWIVEL STUD (2)                   | 15358        | ---- | ----  | ---- |
| C-104125                         | FRONT TAKE DOWN SCREW (Blk. 104111)     | 104131       | ---- | ----  | ---- |
| C-104125                         | MIDDLE TAKE DOWN SCREW (Blk. 104111)    | 104133       | ---- | ----  | ---- |
| B-300425-                        | REAR TAKE DOWN SCREW                    | 300425       | ---- | ----  | ---- |
| B-305395-                        | <b>MAGAZINE ASSEMBLY</b>                | 305395       | ---- | ----  | ---- |
| E-300363-14                      | MAGAZINE BOX                            | 300363       | ---- | ----  | ---- |
| D-300364-16                      | MAGAZINE FOLLOWER                       | 300364       | ---- | ----  | ---- |
| D-300364-20                      | MAGAZINE BOTTOM                         | 300365       | ---- | ----  | ---- |
| B-300405-                        | BOTTOM ARTWORK                          |              |      |       |      |
| C-300405-                        | MAGAZINE SPRING                         | 300405       | ---- | ----  | ---- |

**FOR ACCESSORY SALES**

D-300441-A SCOPE RAIL 300441  
 B-28505 SCREW (4 REQ'D) 28505

MF0537

Golemboski, Matt R.

---

From: Bristol, II Ronald H.  
Sent: Friday, March 31, 2000 1:15 PM  
To: Keeney, Mike; Golemboski, Matt R.

I let the folks in consumer service see the 710 today for the first time

***Their key questions are as follows:***

- Chemical effect on synthetic liner
- Bolt dragging on comb of stock
- Rough lock up
- Bolt stop - spring loaded or really this loose in final version
- Magazine box side need some nurling to ease in pull out of box
- Effect on liner of ice, snow etc..
- How can magazine be disassembled for cleaning
- any specil cleaning reuirements for gun given the sytnhetic liner
- Safety need cosmetic improvement
- willfire and safe be marked on stock and if so how???
- Locking lugs on firing pin are very small - any concern about it holding up in a blow back
- Bolt head attachment to bolt body - will pin stand up over time

Ronald H. Bristol II  
VP & GM, Firearms  
Tel: 336.548.8875  
Fax: 336.548.7875  
email: bristolrh@remington.com

PRIVILEGED AND CONFIDENTIAL

This e-mail message is intended only for the use of the individual or entity to which it is addressed and may contain information that is privileged, confidential and exempt from disclosure. If you are not the intended recipient, please do not disseminate, distribute or copy this communication, by e-mail or otherwise. Instead, please notify us immediately by return e-mail (including the original message in your reply) and by telephone at 1-800-243-9700 and then delete and discard all copies of the e-mail. Thank you.

4/18/00

To: M. Golemboski  
From: J. Helmer

Material Handling Update

- \* One barrel basket here, other due now.
- \* Black Oxide Racks:
  - \* Three barrel racks complete, one to be made outside.
  - \* One Bolt Body/Bolt head rack complete, one to be made outside.
- \* Barrel Cell truck:
  - \* One truck made, needs handles.
  - \* Three more to be made here.
- \* Barrel Trucks:
  - \* Three frames have been made.
  - \* One frame is being completed with bottom, middle and top installed to check fit of barrels (vertical). Truck is being designed to convert from M/710 barrels to M/597 barrels. The top tray will change only.
- \* Trays and Totes:
  - \* Janice has communicated with Drake and ordered four totes to check color (BLUE). Drake can possibly give us all the trays and totes that we need in BLUE.
- \* Parts Rack:
  - \* Janice and Brian have one sample Parts Rack. This rack is proposed to hold the monthly supply of parts needed for monthly assembly build. For example – one parts rack would be issued to assembly for the month and Janice would have another for the next month's issue.
- \* Assembly Gun racks:
  - \* It is proposed to use the same style racks as currently being used for the M/597.

MF0539

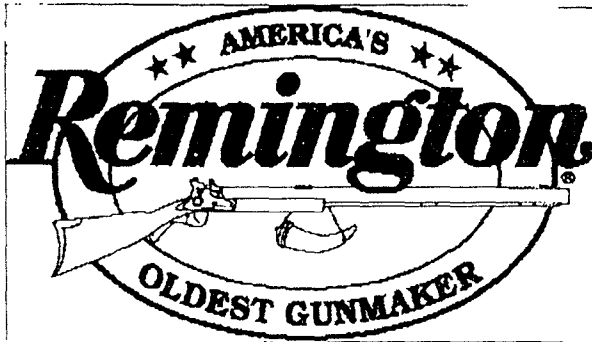
\* Ammo Handling:

- \* Proposed to purchase synthetic type push trucks (like current stores & quality push trucks) for dispensing of daily needed ammo from stores to the gallery.

CONFIDENTIAL 83

MF0540

Remington Arms Company 870 Remington Drive, P.O. Box 700, Madison, NC 27284-0700



Date: 04/25/00 9:43 AM

Number of pages including cover sheet: 2

# FAX

To:

Matt Golemboski

Phone:

Fax phone: 270-8563233

CC: Mett Morgan

From:

Drew Kohler

Phone: 336-548-8599

Fax phone: 336-548-7799

Internet: KOHLERAA@REMINGTON.COM

REMARKS:

☐ Urgent

☒ For your review

☐ Reply ASAP

☐ Please comment

Taste scope and rings info.

DK

MF0541

**tasco**

**Mark J. Shore**  
DIRECTOR OF SALES NORTH AMERICA

2839 COMMERCE PARKWAY, MIRAMAR, FL 33025  
P.O. BOX 26900, PINEHURST PINES, FL 33026  
PHONE: (954) 272-3403 / FAX: (954) 272-3703  
mshore@tasconet.com

April 20, 2000

Mr. Drew Kohler  
Remington Arms Co., Inc.  
870 Remington Drive  
Madison, NC. 27025

Dear Drew:

Thank you for the opportunity to further grow our business partnership. Tasco can supply Remington with a Pronghorn 3X-9X32 with or without rings based on the below listed 2000 quote. I sent a scope and ring mounts to your attention via overnight. They will arrive Friday, please give me a call when the merchandise arrives and let me know that you received it or if you have any questions.

| <u>Item No.</u> | <u>Description</u>            | <u>2000 Cost</u> |
|-----------------|-------------------------------|------------------|
| PH39X32         | Pronghorn 3X-9X32 rifle scope | \$22.00          |
| 791C            | 1" standard ring mounts       | \$ 3.00          |

Based on Remington's minimum purchase of 5000 units for the year 2000, we will accommodate the above pricing and prepay the freight.

Thanks again.

Best regards,  
  
Mark J. Shore  
Director of Sales  
Tasco WorldWide, Inc.

APR 20 19:11

FAX: 954-272-3703

TELEPHONE

MF0542

# Remington®

REMINGTON ARMS COMPANY, INC.

22 RIFLE TRAIL  
P.O. Box 99  
HICKORY, KY 42051

TEL: 270-856-4200  
FAX: 270-856-3233

4/28/00

Mr. Larry Crouch  
Crouch Building Associates  
P.O. Box J  
Mayfield, KY 42066

Larry,

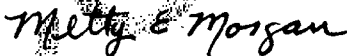
For your records, please use contract Purchase Order # M017602 to begin construction of the 100 yard range.

A formal hard copy of this contract will be faxed and mailed to you on Monday, May 1st. Per our phone conversation, this contract will be written with the option of Remington subcontracting the electrical work. The final decision of who is doing this work will be given to you as soon as possible.

This letter is to allow you to begin your project, without further delay.

If you have any questions after reviewing your hard copy of the contract, please feel free to contact me at the plant. Phone: 856-4204

Sincerely,



Metty E. Morgan  
Materials Manager  
Remington Arms Company, Inc.

cc: Matt Golemboski

MF0543

Golemboski, Matt R.

---

**From:** Cook, Todd D.  
**Sent:** Monday, February 28, 2000 12:39 PM  
**To:** Keeney, Mike; Golemboski, Matt R.  
**Subject:** Mold Try-out on Bolt Plug

Mike & Matt,

Mike Bennett called from Kellems & Coe, and they want to do a trial on the new Bolt Plug mold on Friday. They wanted some help getting the material--which as you know has been specified the same as the stock, but in black.

I do NOT have the currently specified material, RTP 199X83039E, in black. However, I did have 199X83039D in black; and I shipped it to Kenny at Kellems & Coe, so they will have it in time for the Friday trial.

The "D" version differs from the currently specified "E" grade only in the UV stabilizer--which will not effect the color, shrink, or properties (other than UV stability). "D" should be fine for tool check out for dimensions and for testing. The correct thing to do is to order the "E" material and re-sample for T&P; but I am not convinced that would be necessary, as we do no long-term weathering tests in T&P. For EET & even DAT, I think these parts will be fine. We just need to make sure that the final product has the "E" version for added UV stability.

ASIDE

This bolt plug material is a common material with M/597 Magnum Stocks, so there may be some volume discounts available. If you need more info on the specifics, let me know.

Todd

CONFIDENTIAL 83

3/17/2000

To: S. Truax  
From: E. M. Douglass

Here are some suggestions and considerations regarding the new range design. I expect to have some additional input on exhaust and electrical items for you Monday.

1. Consider modifying the entry to the 100 yd range to allow access from the shooters area without shutting down the proof/test area.
2. Doors to the shooting area should have Best locks so that the area can be secured when not in use and should be connected to the ADT security system.
3. Provide some type of partition (fixed or movable) between shooting positions faced with sound absorbing material.
4. Line at least a portion of the South wall of the 40 yd target area with wood. The wood should be easily removable for replacement when necessary and should be installed in lengths that can be contained in a 55 gallon drum for disposal.
5. Increase the thickness of the South wall of the 40 yd target area to 18".
6. Installation of a sliding door or other type of barrier should be considered for future installation to contain shotgun pellets.
7. Provide smoke detectors in the shooters area and ammo storage area and connect to the ADT system.
8. Provide panic alarm buttons at each shooting position that are connected to the ADT system.
9. Keyed (Best) locks should be provided for all exterior range doors in addition to the magnetic interlocks. The exterior doors should also be monitored by the ADT system.
10. Permanent markers should be installed at the 40 and 100 yd points.
11. Your Factory Mutual representative should review the range plans.
12. The roof installation should have at least a 10 year total system warrantee and a 20 year membrane warrantee.
13. Concrete surfaces should be rubbed, any voids filled and then coated with paint or other suitable material.
14. Add steps at snail to allow safe access to 100 yd target area without having to go outside range.
15. Compressed air or nitrogen will be needed to blow down the dust collector filters.
16. The leading edge of the snail should be recessed into the concrete floor.
17. Any electrical panels, switchgear, breakers, etc. required for the range should be consistent with the brands currently used in your plant.
18. If you need any help determining what equipment and personal protective gear is needed for range cleanup I'm sure that Ron Gurtowsky can be of assistance.

83

MF0545

Golemboski, Matt R.

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From: Helmer, Gerald A.  
Sent: Tuesday, January 18, 2000 11:16 AM  
To: Truax, Sheldon F.  
Cc: Golemboski, Matt R.; Zajk, Joseph J; Chavis, William T.; Gooch, Jim C.; Morgan, Metty E.  
Subject: 3 Sided cart

Shelly, Jimmy Gooch has quoted to build one three sided cart for the M/710 barrels after cutoff. Jimmy's price is approx. \$600.00 (versus a vendor price of \$1,066.05). He has ordered material this morning which is all due this week. Estimated completion of the cart is 2/1/00.

CONFIDENTIAL 83

**Golemboski, Matt R.**

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**From:** Keeney, Mike  
**Sent:** Tuesday, January 18, 2000 8:19 AM  
**To:** Morgan, Metty E.  
**Cc:** Golemboski, Matt R.  
**Subject:** RE: F300346

Matt and Mett,  
I misspoke yesturday, I did not think the drawing called out a fillet at the corner of the "ears" and main body. I was thinking it was a sharp intersection but when I pulled the drawing in preparation for a conversation with Swiss Precision Machining I noticed that we have spec'd a .02" fillet which will work fine. I had trouble with the protos at .062" radius, but .02 will not cause problems. If Swiss did not take exception to the .02 radius on their quote, i do not need to discuss it with them. Mett can go ahead and place the proto order to the drawing B-300346 (no rev. levels).

sorry for the confusion,  
Mike

-----  
**From:** Morgan, Metty E.  
**Sent:** Monday, January 17, 2000 3:35 PM  
**To:** Keeney, Mike  
**Subject:** F300346

01/17/2000

Mike, **Bolt Plug Insert**

Matt said you need to talk with the supplier before I ask for 300 prototype parts. These would be coming from Swiss Precision Machining, phone 847-647-7111 contact is Mr. Joe Haupers. Let me know when you have all the technicals squared away and he can call me and we will take care of the Purchase Order.

Thanks,  
Mett  
Mayfield

Golemboski, Matt R.

---

From: Cook, Todd D.  
Sent: Thursday, February 10, 2000 6:59 AM  
To: Golemboski, Matt R.; Zajk, Joseph J; Keeney, Mike  
Subject: New Gray Plaques

Update on M/710 Gray Material Development:

I have a promise date of 2/23/00 for the plaques of the new gray. It's supposed to be half way between the ear muff gray and the M/597 gray. Once plaques arrive, I will check to make sure that is true and forward some to Hickory. Hopefully, upon examination, it is half way between the two colors in question and all of us can approve moving forward. The next step would be ordering a quantity to sample stocks (M/597 prototype has been discussed and is available at Par 4 for this purpose).

There is a cost reduction angle to this that I want to discuss briefly. The RTP 199X 83039D is shrink-matched to the current M/597 molds. It is chemically-coupled but has no UV stabilizer. We asked RTP to add that and get new pricing together for a one-to-one comparison. The new compound, RTP 199X83039E, is available for sampling. I think we should get some of each. UV Stabilizer is \$0.05/lb adder, but will dramatically improve resistance to fading and property retention for our gun-in-the-pickup-rack customers. The new pricing should still reflect a cost savings, although not as dramatic. I am guessing it will come in around \$.83 initially, with some negotiations, perhaps down to \$.80.

That's my update. Comments and Feedback welcome.

Todd

CONFIDENTIAL 83

## Forging Inspection using Quasar Resonant Inspection

photo

A forging operation in the United States recently installed two fully automated Quasar systems to 100% inspect hub bearing component forgings. The management was driven by customer requirements for improved quality at minimum cost. They evaluated several NDT methods and chose the Quasar system for three reasons: more reliable defect detection, reduced scrap rate and reduced labor cost. This article describes the results of the installation after several months successful operation. 83

### Reliable defect detection

The Quasar system has eliminated the false acceptance of defective parts due to human error and magnetic particle equipment misapplication or malfunction. Customers have reported to plant management that for the first time they are receiving forgings with no significant defects. This forging operation, which supplies safety critical automotive components, was caught between customer demands for "zero defects" or "six sigma" and the generally accepted estimate that the typical magnetic particle operator detects only about 80% of the defective parts. Quasar offers the best way to realistically meet customer demands.

### Reduced scrap rate

Scrap rate is down compared to the previous magnetic particle inspection because superficial marks, scratches, thin flaps or overlaps of metal that do not extend structurally into the forging, and other surface blemishes are saved because they do not alter the structural integrity of the part. Resonant Inspection is based on structural discrimination and not visual indications. Typically, well over 50% of the forgings rejected by magnetic particle inspection operators are acceptable when reviewed by plant management. The percentage of false rejects exceeded 80% of the total rejects in several forging operations.

### Reduced labor costs

The most obvious effect from a management perspective is the reduction in the cost of inspection. The operation had been using an outside magnetic particle inspection service at a cost of \$0.32 to \$0.42 per part. More recently, they moved the service in-house and reduced the cost to \$0.18 per part. With the Quasar system, their cost is \$0.04 per part, including labor and depreciation. This is a typical situation where the Quasar system pays for itself in terms of labor cost, in less than a year.

### Automated material handling

In each of the two systems, the parts are manually loaded onto a turntable. A fully automated pick-and-place system moves the hub forgings from the turntable to the Quasar Production Nest. The nest is designed to provide an compatible interface with virtually any kind of material handling system. As long as the part is brought to within about 1/4 inch (6 mm) of the target drop location, the Production Nest is designed to "catch" the part and position it for testing. The Production Nest also provides shock and vibration isolation from the production machinery and senses the part temperature to compensate for variations.

MF0549

**The Quasar systems detect all structurally significant defects:**

- Structural weakness caused by seams or inclusions in the steel feed stock.
- Cracks from any cause
- Structural weakness caused by forging machine problems such as bar end sticking.
- Forging machine part positioning problems such as mis-strikes or double strikes.
- Eccentric piercing or forming.
- Material related problems, such as the wrong bar stock or out-of-spec steel.
- Material problems related to accidental quenching from tool-cooling sprays.
- Heat treatment problems, which cause unacceptable or uneven hardness.
- Missed operations.
- Underfill, underweight or overweight if it is significant.
- Significantly distorted or bent parts.

**Computer controlled sorting decisions**

After the Production Nest receives the part, the automated computer controlled Quasar RI-2000 system takes about three seconds to measure a few key resonant frequencies. The computer then performs what amounts to a structural analysis of that part, based on the resonances measured. If the part falls within the acceptable limits for material, dimensions and freedom from structural defects, the part is accepted, and proceeds to packing and shipping. If the part is defective in any of the ways listed above the part is rejected, and the material handling system places the part in a reject bin. The entire test cycle takes about 7 seconds. The throughput is up to 500 parts per hour for each of the two systems. The throughput for a given application is a function of the part's size and complexity and the relative defect size. Throughputs up to 1200 parts per hour are possible with a dual nest system. Quasar has delivered multiple unit systems with throughputs up to 7500 parts per hour.

Quasar designed and supplied these two systems on a turnkey basis and would be pleased to do the same for your operation, or we will work with your preferred material handling supplier. Please call Quasar to learn more about how this technology can benefit your operation. We want to demonstrate the Quasar capability in your facility, on your parts.

Quasar's software makes it possible to inspect for defects that would be masked by the effect of normal product variations. The patented **pattern recognition** method detects localized structural differences that signal a crack or other defect. Material properties differences that are out of specification limits are also rejected. The responsible quality or production manager sets the acceptance limits, and the Quasar system enforces those standards. The same decision is made every time by the computer, with no chance for human judgment errors. Because Quasar **quantitatively** measures the **degree of defectiveness**, the greater the structural effect of the defect the greater the rejection measurement. The forging plant management decides where to "draw the line" for acceptance and rejection for each product and for each customer. The engineer responsible for the Quasar systems uses the Quasar software tools to set up the sorting to those standards.

The RI 1000, RI 2000 and RU Spec systems employ non-destructive inspection methods covered by U.S. Patents including numbers 5,408,880; 5,495,763; 5,425,272; 5,631,423; 5,641,905; 5,837,896; 5,886,263; 5,952,576; 5,965,817; and 5,992,234 assigned to Quasar International Inc., and also by other U.S. and European patents pending and allowed.

MF0550

## Questions and Answers About Quasar

Q. I have never heard of Quasar International Inc. What kind of company is it?

A. Quasar is a privately held corporation, based in Albuquerque New Mexico. Quasar personnel design, produce and apply software and hardware tools of a unique nondestructive inspection technology used by factories around the world.

Q. What is this Quasar technology?

A. The Quasar system measures the frequencies of the natural mechanical vibration resonances and uses these measurements to compare the structural characteristics of similar parts. The relationship or "pattern" of these resonances determines which of these parts are within production tolerances and specifications and which are outside of these limits, and therefore are considered "defective" and should be rejected.

Q. How are these frequencies measured?

A. The part to be tested is generally supported on three transducers. One of the transducers is driven by an alternating current, with discrete frequency steps, over a range of specific frequencies, in narrow frequency bands chosen to excite specific expected resonances. Two other transducers sense the vibration motion of the part and generate an alternating current, at the frequencies determined by the vibration of the part. This signal is then filtered to pass only the frequency that is driving the transducer and that is exciting the part. This effectively measures the response of the part only to the exciting frequency, and ignores all the other frequencies that may be included in the signals from the sensing transducers.

Q. Why is this method used?

A. Because it quickly measures the frequencies of the resonances of the part more repeatably than any other practical method. It operates well in an industrial environment, and provides the data that enable the Quasar system to detect small differences that identify significant structural characteristics or defects.

Q. How does the Quasar system use the resonance data?

A. The Quasar system analyzes the frequency characteristics of many good and defective parts ("defective" as defined by the production and quality management) and recognizes patterns that correlate with the structural characteristics of these parts.

Q. Why use this pattern recognition method instead of just finding one or two frequencies that correlate with the presence of defects?

A. Acceptable variations in material, dimensions, heat treat and other attributes of a parts make more difference in frequencies than some of the small cracks, inclusions and other defects that disqualify the part for reliable use. It's easy to demonstrate how one or two frequencies will sort a small group of parts, or parts from one production run, but that does not work in a real production environment.

MF0551

Q. How does this pattern recognition approach work?

A. The structural characteristic of many good parts, including those with a representative range of acceptable production variations, defines many acceptable patterns for good parts. Then, using the data from a variety of defective parts, the patented Quasar pattern recognition software detects the frequency patterns that only reject the defective parts.

Q. What is a clear way of explaining this sorting method?

A. One way of looking at this is to say that the resonant frequencies of a part are higher if the material is stiffer, and this overall stiffness creates a pattern of higher frequencies. A crack in one area of the part tends to lower the natural resonant frequency only of that area. That breaks the pattern, which is recognized by the Quasar system. This is really a structural comparison or structural analysis.

Q. What about a part with bad heat treat or the wrong material?

A. Material properties differences that are out of specification limits are also rejected, because they are so far from the examples of the good parts that even though they effect the entire part, they break the pattern allowed for good parts.

Q. Who sets the standard of acceptance?

A. The responsible quality or production manager sets the acceptance limits, and the Quasar system enforces those standards. The same decision is made every time by the computer, with no chance for human judgment errors. Because Quasar quantitatively measures the degree of defectiveness, the greater the structural effect of the defect the greater the rejection measurement.

Q. How are these standards brought to the factory floor?

A. The plant management decides where to "draw the line" for acceptance and rejection for each product and for each customer. The engineer or operator responsible for the Quasar systems uses the Quasar software tools to set up the sorting to those standards.

10Jan2000

MF0552

Rev6-est

Sheffield Measurement  
P.O. Box 1127  
Dayton OH 45401-1127 USA

Phone: 937 259 5257  
Fax: 937 254 5054  
www.giddings.com

**Sheffield****Fax**

**To:** Matt Golemboski  
**At:** Remington Arms Co., Inc.  
**Fax Number:** 270-856-3233  
**From:** Jim Miller  
**Date:** October 25, 1999  
**Subject:** Revised part prog. quote

**Total pages** 4  
(including cover page)

If you do not receive all pages,  
Please call back as soon as possible to:  
937 259 5257

Matt,

Here's the revised copy of your part program quotation for MeasureMax. I look forward to hearing from you soon. In the meantime, I'll have our retrofit department work on your CMM retrofit quotes. I just found out there is a discount for multiple CMMs. So let me know via email how many you want retrofitted. Per the contract, they will all be done at the same time, so keep that in mind.

Any questions, give me a call or email ([jpmiller@sheffield-cmm.com](mailto:jpmiller@sheffield-cmm.com)).

A Thyssen Production Systems Business

MF0554

Sheffield Measurement  
721 Springfield Street  
Dayton OH 45403 USA  
P.O. Box 1127 Dayton OH 45401-1127 USA

Phone: 937 254 5377  
Fax: 937 254 5054  
www.giddings.com

## Sheffield

REMINGTON ARMS COMPANY  
22 Rifle Trail  
Hickory, KY 42051  
Matt Golemboski  
Engineering Manager

File Number 13306901  
Date October 26, 1999  
Inquiry Date  
Inquiry No.  
FOB Dayton, OH  
Approx. Delivery Noted Within  
Terms Noted Within

| Item                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Description                                                                                                                       | Qty | Price/Unit |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----|------------|
| V1a                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Inspection Part Program : Inspection program for Remington Arms Receiver Insert Part #300327 including Probe Calibration Program. |     |            |
| PRICE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                   | 1   | \$5,565.00 |
| <p>NOTE: Any requested additional hours spent at Remington Arms facility will be at the current published rate of \$120.00 per hour. In addition, all extra business expenses (transportation and living) incurred for the services performed at your facility will be billed at actual cost.</p> <p>PROJECT SCOPE / REQUIREMENT ITEMS:</p> <ol style="list-style-type: none"> <li>1. The complete part program shall have all features measured which were marked on Remington part print 300327 sheets 1 &amp; 2.</li> <li>2. Part/s and the latest part print/s are required for part program development.</li> <li>3. A Gage R &amp; R study was not requested for the Receiver Insert #300327. If one is needed it will be quoted at that time.</li> <li>4. Schedule for delivery of the Part Program will be determined based on receipt of order and the above stated conditions.</li> </ol> <p>NOTE: Any dimensional inspection referenced above are to be supplied as follows:</p> <p><u>Note 1:</u> The Part Inspection Program will perform geometric tolerance evaluation for measured part features using standard Sheffield Measurement routines as described in the MLB programming documentation for the CMM System.</p> <p><u>Note 2:</u> The complete Part Inspection Program to be written in MeasureMax (Microsoft Visual Basic 6.0) for use on your Sheffield Measurement CMM System.</p> <p><u>Note 3:</u> One (1) copy of the Part Inspection Program will be supplied on 3.5" Floppy storage media compatible with the DirectInspect computer system.</p> <p><u>Note 4:</u> Technical discussions will be required with Remington Arms personnel to establish parameters for the dimensional inspection. These parameters will include</p> |                                                                                                                                   |     |            |

PLEASE REFER TO OUR FILE NUMBER ON ANY CORRESPONDENCE & PURCHASE ORDER RELATING TO THIS QUOTATION

A Division of Giddings & Lewis, Inc.  
A Thyssen Production Systems Business

MF0555

Confidential - Subject to Protective Order  
BARBER - 5.22.06r0010505  
Williams v. Remington

## Sheffield

File # 13306900

Page #2

| Item | Description                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Qty | Price/Unit |
|------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----|------------|
|      | <p>datum establishment, number of points required to properly inspect a feature, and customer interpretation of print / part features.</p> <p><u>Note 5:</u> Customer requested inspection modifications after the initial discussions may result in a quotation for additional charges which would be incurred to meet any requested changes.</p> <p><u>Note 6:</u> Part Program written for inspection shall assume for the part to be placed in a fixed orientation and location on the CMM as agreed to by Sheffield Measurement Representative and your personnel.</p> <p><u>Note 7:</u> Probe configurations used with the Part Inspection Program will be compatible with Renishaw a PH6, TP200 and Stylus Changer furnished on Remington Arms CMM.</p> <p><u>Note 8:</u> Technical visits to Remington Arms Co., Inc. facility by a Sheffield Measurement Representative engineer will be at the current published rate of \$120.00 per hour for services performed on location. In addition, all transportation charges, living and other normal incidental expenses incurred for the services performed at your facility will be billed at actual cost.</p> <p>T1</p> <p style="text-align: center;"><b>STANDARDS</b></p> <p>The machine and accessories proposed in the enclosed quotation are largely standard commercially offered devices built to Giddings &amp; Lewis Sheffield Measurement standards and specifications. Although it is the intent of Sheffield Measurement to provide products which meet applicable Government and Commercial standards, we cannot guarantee total compliance with all Commercial and Government standards and specifications other than those formally acknowledged by written agreement from Sheffield Measurement.</p> <p>Any attempt to completely conform to Buyer's specifications and requirements may require design and manufacturing changes which would result in a significant increase in the price charged for this equipment or additional charge to provide non-standard items being requested in your specifications and requirements.</p> <p>T4</p> <p style="text-align: center;"><b>PAYMENT TERMS</b></p> <p>All payment terms are subject to credit review.</p> <p>(a) Credit cards accepted - VISA Mastercard and American Express.</p> <p>(b) Repair parts, service work and software license - Net cash due 15 days from invoice date.</p> <p>(c) Standard products selling for less than \$50,000 - Net cash due 30 days from invoice date.</p> |     |            |

PLEASE REFER TO OUR FILE NUMBER ON ANY CORRESPONDENCE &amp; PURCHASE ORDER RELATING TO THIS QUOTATION

MF0556



**STERLING SINTERED TECHNOLOGIES, INC.**

P.O. BOX 1057 • WINSTED, CONNECTICUT 06098  
(860) 379-2753 • FAX: (860) 738-0664

## Q U O T A T I O N

NUMBER 2965A

DATE 10/06/99

TO REMINGTON ARMS CO., INC.  
ATTN: MATT GOLEMBOSKI  
MAYFIELD PLANT  
22 RIFLE TRAIL  
HICKORY KY 42051

SHIP  
TO

PH 270/856-4204 Fax 270/856-3233

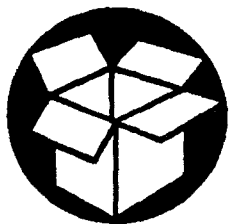
| TERMS       |                                                                                                                                                                                                                                                                                          | SHIP VIA   |           | SALESPERSON | PAGE |
|-------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------|-----------|-------------|------|
| NET 30 DAYS |                                                                                                                                                                                                                                                                                          |            |           | 6           | 1    |
| QUANTITY    | DESCRIPTION                                                                                                                                                                                                                                                                              | UNIT PRICE | AMOUNT    |             |      |
|             | Part # C-15280<br>TRIGGER                                                                                                                                                                                                                                                                |            |           |             |      |
|             | Rev 31<br>Ref: NO SERRATIONS                                                                                                                                                                                                                                                             |            |           |             |      |
| 20,000      |                                                                                                                                                                                                                                                                                          | 377.10/M   | 7,542.00  |             |      |
| 40,000      |                                                                                                                                                                                                                                                                                          | 367.55/M   | 14,702.00 |             |      |
| 120,000     |                                                                                                                                                                                                                                                                                          | 347.70/M   | 41,724.00 |             |      |
|             | Misc Charges:<br>TOOLING                                                                                                                                                                                                                                                                 |            | 15,225.00 |             |      |
|             | * PLEASE NOTE: QUOTED WITH NO SERRATIONS                                                                                                                                                                                                                                                 |            |           |             |      |
|             | 50% OF TOOLING CHARGE DUE WITH PURCHASE ORDER<br>BALANCE UPON APPROVAL OF TOOLING SAMPLES.<br>TOOLING SAMPLES WILL BE SHIPPED 12 WEEKS ARO<br>PRODUCTION TO FOLLOW TOOL APPROVAL BY 6-8<br>WEEKS UNLESS CUSTOMER ACCEPTS RESPONSIBILITY<br>FOR PRODUCTION, GIVEN THAT IT MEETS THE PRINT |            |           |             |      |
|             | THIS QUOTE IS GOOD FOR 30 DAYS FROM THE QUOTE<br>DATE.                                                                                                                                                                                                                                   |            |           |             |      |
|             | OUR REVISION CONTROL PROCEDURE REQUIRES THAT<br>PRINT REVISION LEVELS ACCOMPANY ALL PURCHASE<br>ORDERS. PLEASE ASSIST US IN OUR CONTINUOUS<br>IMPROVEMENT PROCESS.                                                                                                                       |            |           |             |      |
|             | THANK-YOU FOR THE OPPORTUNITY TO QUOTE.<br>ANN DELUTRIE                                                                                                                                                                                                                                  |            |           |             |      |

MF0558

10/14/99 16:35 FAX 8189423026

ORPACK-STONE

002



ORPACK-STONE Corporation

ORPACK-Stone Corporation

1

1800 WEST OAK STREET  
HERRIN IL 62948

618/942-2112

618/942-3026 FAX



date 10/14/99

prices F.O.B. MAYFIELD KY

quotation to REMINGTON ARMS COMPANY  
BOX 99  
22 RIFLE ROAD  
HICKORY KY 42051

delivery within 10 days of receipt of order

terms Net 30 days

your file no. 0780

83

this quotation expires 11/13/99

Attention of METTY MORGAN

We are pleased to quote as follows on your recent inquiry:

| Description     | Quantity | Price Per M |
|-----------------|----------|-------------|
| 1010 LOCKING    | 20,000   | 502.35      |
| 26 1/2 x 62 5/8 | 40,000   | 471.60      |
| D/R 200 B 1P1C  | 60,000   | 448.20      |
|                 | 200,000  | 430.60      |

We wish to thank you for this opportunity to quote  
on your requirements.

ROBERT MORGAN  
SALES REPRESENTATIVE

Yours very truly  
ORPACK - STONE CORP.

*[Signature]*  
LARRY HADFIELD  
BY SALES MANAGER

This quotation is subject to the terms  
and conditions on the reverse side hereof.

CAVC 0050 Rev. 08/97

MF0559

## MODEL 710 BARREL PRESS PARTS LIST

83

## SUMMARY

|                   |               |
|-------------------|---------------|
| Estimated Capital | \$578,621.00  |
| Actual Capital    | \$550,824.63  |
| Delta             | (\$27,796.37) |
|                   |               |
| Estimated Expense | \$50,124.02   |
| Actual Expense    | \$51,051.13   |
| Delta             | \$927.11      |

-5%

2%

## LINE ITEM DETAIL

| Op # | Operation Description | Tooling, Gages, Fixture, Machines, etc | Drawing Number    | Capital or Expense (est) | Estimated Cost per Unit | Estimated Number Req'd | Estimated Total Cost | Capital or Expense (act) | Actual Cost per Unit | Actual Number Req'd | P O Number        | Actual Total Cost | Delta (Actual - Estimated) | Comments |  |
|------|-----------------------|----------------------------------------|-------------------|--------------------------|-------------------------|------------------------|----------------------|--------------------------|----------------------|---------------------|-------------------|-------------------|----------------------------|----------|--|
| 10   | Cut to Length         | Barrel Length Gage                     |                   | E                        | \$270 00                | 1                      | \$270 00             | E                        | \$350 00             | 1                   |                   | \$350 00          | \$80 00                    |          |  |
|      |                       | Saw Blade                              |                   | E                        | \$16 80                 | 1                      | \$16 80              | E                        | \$16 80              | 1                   | Stores            | \$16 80           | \$0 00                     |          |  |
|      |                       |                                        |                   |                          | Capital Sub-Total       |                        | \$0 00               |                          |                      |                     | Capital Sub-Total |                   | \$0 00                     | \$0 00   |  |
|      |                       |                                        |                   |                          | Expense Sub-Total       |                        | \$286 80             |                          |                      |                     | Expense Sub-Total |                   | \$366 80                   | \$80 00  |  |
| 20   | Gundrill Bore         | 292 dia Gundrill                       |                   | E                        | \$10 02                 | 16                     | \$160 32             | E                        | \$76 00              | 16                  | M016618           | \$1,216 00        | \$1,055 68                 |          |  |
|      |                       | Carbide Bushing Insert                 |                   | E                        | \$61 95                 | 8                      | \$495 60             | E                        | \$117 65             | 4                   | M015809           | \$470 60          | (\$25 00)                  |          |  |
|      |                       | Whip Guide                             |                   | E                        | \$4 50                  | 40                     | \$180 00             | E                        | \$3 71               | 16                  | M015804           | \$59 36           | (\$120 64)                 |          |  |
|      |                       | Whip Guide Bearing                     |                   | E                        | \$14 95                 | 40                     | \$598 00             | E                        | \$17 65              | 24                  | M015806           | \$423 58          | (\$174 42)                 |          |  |
|      |                       | Bearing Holder                         |                   | E                        | \$120 00                | 16                     | \$1,920 00           | E                        | \$127 20             | 16                  | M015787           | \$2,035 20        | \$115 20                   |          |  |
|      |                       | Bench Center                           |                   | E                        | \$2,380 00              | 1                      | \$2,380 00           | E                        | \$1,931 00           | 1                   | M016563           | \$1,931 00        | (\$449 00)                 |          |  |
|      |                       | Magnetic Base                          |                   |                          |                         |                        | \$0 00               | E                        | \$97 26              | 2                   | M016696           | \$194 51          | \$194 51                   |          |  |
|      |                       | Dial Indicator                         |                   |                          |                         |                        | \$0 00               | E                        | \$197 00             | 2                   | M016614           | \$214 00          | \$214 00                   |          |  |
|      |                       | Plug Gage                              | BK-8059           |                          |                         |                        | \$0 00               | E                        | \$21 75              | 1                   | M016754           | \$21 75           | \$21 75                    |          |  |
|      |                       |                                        |                   |                          | Capital Sub-Total       |                        | \$0 00               |                          |                      |                     | Capital Sub-Total |                   | \$0 00                     | \$0 00   |  |
|      |                       |                                        | Expense Sub-Total |                          | \$5,573 60              |                        |                      |                          | Expense Sub-Total    |                     | \$6,135 74        | \$401 82          |                            |          |  |
| 30   | Ream Bore             | 299 Reamer                             |                   | E                        | \$97 90                 | 8                      | \$783 20             | E                        |                      | 12                  | M015802           | \$0 00            | (\$783 20)                 |          |  |
|      |                       | Headstock Reamer Bushing               |                   | E                        | \$200 00                | 2                      | \$400 00             | E                        |                      |                     |                   | \$0 00            | (\$400 00)                 |          |  |
|      |                       | Tailstock reamer Bushing               |                   | E                        | \$200 00                | 2                      | \$400 00             | E                        |                      | 2                   |                   | \$0 00            | (\$400 00)                 |          |  |
|      |                       | Whip Guide                             |                   | E                        | \$174 00                | 8                      | \$1,392 00           | E                        |                      | 2                   |                   | \$0 00            | (\$1,392 00)               |          |  |
|      |                       | 5C Serrated Collet                     |                   |                          |                         |                        | \$0 00               | E                        | \$70 00              |                     | M015807           | \$560 00          | \$560 00                   |          |  |
|      |                       | Plug Gage                              | BK-8060           | E                        | \$80 00                 | 1                      | \$80 00              | E                        | \$31 25              | 1                   | M016754           | \$31 25           | (\$48 75)                  |          |  |
|      |                       |                                        | Capital Sub-Total |                          | \$0 00                  |                        |                      |                          | Capital Sub-Total    |                     | \$0 00            | \$0 00            |                            |          |  |
|      |                       |                                        | Expense Sub-Total |                          | \$3,055 20              |                        |                      |                          | Expense Sub-Total    |                     | \$591 25          | (\$2,463 95)      |                            |          |  |

| Op # | Operation Description | Tooling, Gages, Fixture, Machines, etc     | Drawing Number | Capital or Expense | Estimated Cost per Unit | Estimated Number Req'd | Estimated Total Cost | Capital or Expense | Actual Cost per Unit | Actual Number Req'd | P O Number | Actual Total Cost | Delta (Actual - Estimated) | Comments     |
|------|-----------------------|--------------------------------------------|----------------|--------------------|-------------------------|------------------------|----------------------|--------------------|----------------------|---------------------|------------|-------------------|----------------------------|--------------|
| 40   | Rifle Bore            | 2-Stage Rifling Button                     |                | E                  | \$300 00                | 3                      | \$900 00             | E                  | \$209 00             | 4                   | M016618    | \$836 00          | (\$64 00)                  |              |
|      |                       | Plug Gage-Bore Diameter                    | BK-8061        | E                  | \$80 00                 | 1                      | \$80 00              | E                  | \$28 00              | 1                   | M016754    | \$28 00           | (\$52 00)                  |              |
|      |                       | Twist Gage                                 |                | E                  | \$1,315 00              | 1                      | \$1,315 00           | E                  | \$350 00             | 1                   | M016873    | \$350 00          | (\$965 00)                 |              |
|      |                       | Air Gauge                                  |                | C                  | \$6,080 00              | 1                      | \$6,080 00           | C                  | \$0 00               | 0                   |            | \$0 00            | (\$6,080 00)               |              |
|      |                       | Air Gauge - Bore Diameter                  |                | E                  | \$1,000 00              | 1                      | \$1,000 00           | C                  | \$2,605 38           | 1                   | M016617    | \$2,605 38        | \$1,605 38                 |              |
|      |                       | Ring Gage Masters for Air Gauge            |                | E                  | \$0 00                  | 1                      | \$0 00               | E                  | \$114 95             | 2                   | M016617    | \$229 90          | \$229 90                   |              |
|      |                       | Air Gauge - Groove Diameter                |                | E                  | \$1,000 00              | 1                      | \$1,000 00           | E                  | \$1,985 00           | 1                   | M016617    | \$1,985 00        | \$985 00                   |              |
|      |                       | Ring Gage Masters for Air Gauge            |                | E                  | \$0 00                  | 1                      | \$0 00               | E                  | \$114 95             | 2                   | M016617    | \$229 90          | \$229 90                   |              |
|      |                       | Hydraulic Pump Small Body                  |                | E                  | \$2,377 00              | 1                      | \$2,377 00           | E                  | \$2,366 00           | 1                   |            | \$2,366 00        | (\$11 00)                  |              |
|      |                       | Automatic Broach Puller for Rifling Button |                |                    |                         |                        | \$0 00               | E                  | \$953 00             | 1                   | M015811    | \$953 00          | \$953 00                   |              |
|      |                       | Rifler Headstock Bushing                   |                |                    |                         |                        | \$0 00               | E                  | \$54 50              | 1                   | M015849    | \$54 50           | \$54 50                    |              |
|      |                       | Rifler Tailstock Bushing                   |                |                    |                         |                        | \$0 00               | E                  | \$85 50              | 1                   | M015849    | \$85 50           | \$85 50                    |              |
|      |                       | Coolant Pump for new Oiling System         |                |                    |                         |                        | \$0 00               | E                  |                      | 1                   |            | \$0 00            | \$0 00                     |              |
|      |                       | Filter for new Oiling System               |                |                    |                         |                        | \$0 00               | E                  |                      | 1                   |            | \$0 00            | \$0 00                     |              |
|      |                       | Filter Bags for new Oiling System          |                |                    |                         |                        | \$0 00               | E                  |                      | 1                   |            | \$0 00            | \$0 00                     |              |
|      |                       |                                            |                |                    |                         | Capital Sub-Total      | \$6,080 00           |                    |                      |                     |            | Capital Sub-Total | \$2,605 38                 | (\$3,474 62) |
|      |                       |                                            |                |                    |                         | Expense Sub-Total      | \$5,672 00           |                    |                      |                     |            | Expense Sub-Total | \$7,117 80                 | \$445 80     |
| 50   | Wash & Stress Relieve | Barrel Basket for Furnace                  |                | C                  | \$4,708 00              | 2                      | \$9,416 00           | E                  | \$2,475 00           | 2                   | M016546    | \$4,950 00        | (\$4,466 00)               |              |
|      |                       |                                            |                |                    |                         | Capital Sub-Total      | \$9,416 00           |                    |                      |                     |            | Capital Sub-Total | \$0 00                     | (\$9,416 00) |
|      |                       |                                            |                |                    |                         | Expense Sub-Total      | \$0 00               |                    |                      |                     |            | Expense Sub-Total | \$4,950 00                 | \$4,950 00   |

| Op # | Operation Description | Tooling, Gages, Fixture, Machines, etc | Drawing Number | Capital or Expense | Estimated Cost per Unit | Estimated Number Req'd | Estimated Total Cost | Capital or Expense | Actual Cost per Unit | Actual Number Req'd | P O Number        | Actual Total Cost | Delta (Actual - Estimated) | Comments             |
|------|-----------------------|----------------------------------------|----------------|--------------------|-------------------------|------------------------|----------------------|--------------------|----------------------|---------------------|-------------------|-------------------|----------------------------|----------------------|
| 60   | Turn OD Complete      | Dial Base Gage-Design & Build          |                | C                  | \$5,000 00              | 1                      | \$5,000 00           | C                  | \$7,500 00           | 1                   |                   | \$7,500 00        | \$2,500 00                 | Estimate             |
|      |                       | Bench Centers                          |                | E                  | \$2,280 00              | 1                      | \$2,280 00           | E                  | \$1,931 00           | 1                   | M016150           | \$1,931 00        | (\$349 00)                 |                      |
|      |                       | Dial Indicator                         |                | E                  | \$50 00                 | 2                      | \$100 00             | E                  | \$107 00             | 2                   | M016614           | \$214 00          | \$114 00                   |                      |
|      |                       | Federal Series 300 Snap Gage           |                | E                  | \$656 00                | 1                      | \$656 00             | E                  |                      |                     |                   | \$0 00            | (\$656 00)                 | TBD                  |
|      |                       | 1 230 Ring Gage                        |                | E                  | \$270 00                | 2                      | \$540 00             | E                  |                      |                     |                   | \$0 00            | (\$540 00)                 | Not used             |
|      |                       | Tailstock Pilot                        |                | E                  | \$179 00                | 4                      | \$716 00             | E                  | \$179 00             | 3                   |                   | \$537 00          | (\$179 00)                 |                      |
|      |                       | Headstock Pilot                        |                | E                  | \$91 55                 | 4                      | \$366 20             | E                  | \$91 55              | 2                   |                   | \$183 10          | (\$183 10)                 |                      |
|      |                       | Tool Holder - Rough Turn               |                | E                  | \$56 00                 | 2                      | \$112 00             | E                  |                      |                     |                   | \$0 00            | (\$112 00)                 | Using one on machine |
|      |                       | Tool Holder - Finish Turn              |                | E                  | \$84 50                 | 2                      | \$169 00             | E                  |                      |                     |                   | \$0 00            | (\$169 00)                 | Using one on machine |
|      |                       | Roughing Insert                        |                | E                  | \$9 00                  | 2                      | \$18 00              | E                  | \$11 00              | 5                   |                   | \$55 00           | \$37 00                    |                      |
|      |                       | Finish Insert                          |                | E                  | \$14 63                 | 2                      | \$29 26              | E                  | \$14 63              | 5                   | Stores            | \$73 15           | \$43 89                    |                      |
|      |                       | Rohm Face Driver                       |                |                    |                         |                        | \$0 00               | E                  | \$162 00             | 3                   | M015803           | \$486 00          | \$486 00                   |                      |
|      |                       | SMW Spherical Rollers                  |                |                    |                         |                        | \$0 00               | E                  | \$656 14             | 1                   | M016626           | \$656 14          | \$656 14                   |                      |
|      |                       | Autoblock Spherical Rollers            |                |                    |                         |                        | \$0 00               | E                  | \$139 00             | 3                   | M016625           | \$390 00          | \$390 00                   |                      |
|      |                       |                                        |                |                    |                         |                        | Capital Sub-Total    | \$5,000 00         |                      |                     | Capital Sub-Total | \$7,500 00        |                            |                      |
|      |                       |                                        |                |                    |                         |                        | Expense Sub-Total    | \$4,986 46         |                      |                     | Expense Sub-Total | \$4,525 39        |                            |                      |

| Op # | Operation Description    | Tooling, Gages, Fixture, Machines, etc | Drawing Number | Capital or Expense (est) | Estimated Cost per Unit | Estimated Number Req'd | Estimated Total Cost | Capital or Expense (act) | Actual Cost per Unit | Actual Number Req'd | P O Number | Actual Total Cost | Delta (Actual - Estimated) | Comments                                                              |
|------|--------------------------|----------------------------------------|----------------|--------------------------|-------------------------|------------------------|----------------------|--------------------------|----------------------|---------------------|------------|-------------------|----------------------------|-----------------------------------------------------------------------|
| 70   | Chamber Hub End Complete | LB-300MY 250T 4-Axis Turning Center    |                | C                        | \$222,880 00            | 1                      | \$222,880 00         | C                        | \$219,700 00         | 1                   | M017435    | \$219,700 00      | (\$3,180 00)               | Okuma 10% increase in price from time of estimate to time of purchase |
|      |                          | Run-off for Above                      |                | C                        | included above          | 1                      | \$0 00               | C                        | \$5,000 00           | 1                   | M017435    | \$5,000 00        | \$5,000 00                 |                                                                       |
|      |                          | Microcentric Chuck for LB-300          |                | C                        | included above          | 1                      | \$0 00               | C                        | \$3,645 00           | 1                   | M016555    | \$3,645 00        | \$3,645 00                 |                                                                       |
|      |                          | Thru-spindle locator for LB-300        | E-K-10462      | C                        | included above          | 1                      | \$0 00               | C                        | \$5,530 00           | 1                   | M016929    | \$5,530 00        | \$5,530 00                 |                                                                       |
|      |                          | Air Gage, Set Rings                    |                | C                        | \$6,390 00              | 1                      | \$6,390 00           | C                        | \$6,393 50           | 1                   | M016617    | \$6,393 50        | \$3 50                     |                                                                       |
|      |                          | Air Comparator for Air Gage            |                | C                        | \$0 00                  | 1                      | \$0 00               | C                        | \$4,393 75           | 1                   | M016617    | \$4,393 75        | \$4,393 75                 |                                                                       |
|      |                          | Shoulder Depth Gage & Master           | D-K-10456      | C                        | \$3,780 00              | 1                      | \$3,780 00           | C                        | \$8,732 00           | 1                   | M016586    | \$8,732 00        | \$4,952 00                 |                                                                       |
|      |                          | Neck Depth Gage & Master               | D-K-10457      | C                        | \$3,780 00              | 1                      | \$3,780 00           | C                        | \$8,470 00           | 1                   | M016586    | \$8,470 00        | \$4,690 00                 |                                                                       |
|      |                          | Throat Depth Gage & Master             |                | C                        | \$3,780 00              | 1                      | \$3,780 00           | C                        |                      | 0                   |            | \$0 00            | (\$3,780 00)               |                                                                       |
|      |                          | 2 995 Length Gage                      |                | C                        | \$3,500 00              | 1                      | \$3,500 00           | C                        | \$3,500 00           | 1                   |            | \$3,500 00        | \$0 00                     | CMM Fixture for checking slot & takedown screw holes                  |
|      |                          | Heading Gage & Heading Plugs           |                | C                        | \$9,240 00              | 1                      | \$9,240 00           | C                        |                      | 0                   |            | \$0 00            | (\$9,240 00)               |                                                                       |
|      |                          | 708 C'Bore Plug Gage                   | BK-8058        | E                        | \$67 00                 | 1                      | \$67 00              | E                        | \$23 00              | 1                   | M016754    | \$23 00           | (\$44 00)                  |                                                                       |
|      |                          | 7045 C'Bore Plug Gage                  | BK-8057        | E                        | \$67 00                 | 1                      | \$67 00              | E                        | \$23 00              | 1                   | M016754    | \$23 00           | (\$44 00)                  |                                                                       |
|      |                          | C'Bore Dial Gage                       |                | E                        | \$550 00                | 1                      | \$550 00             | E                        | \$302 72             | 1                   | M016610    | \$302 72          | (\$247 28)                 |                                                                       |
|      |                          | ID Groove Caliper Gage                 |                | E                        | \$500 00                | 1                      | \$500 00             | E                        | \$686 40             | 1                   | M016610    | \$686 40          | \$186 40                   |                                                                       |
|      |                          | Chamfer Gage                           |                | E                        | \$220 00                | 1                      | \$220 00             | E                        | \$122 06             | 1                   | M016610    | \$122 06          | (\$97 94)                  |                                                                       |
|      |                          | 325 Plug Gage w/ Design                |                | E                        | \$960 00                | 1                      | \$960 00             | E                        |                      |                     |            | \$0 00            | (\$960 00)                 |                                                                       |
|      |                          | Form Gage/Locking Lug w/ Design        |                | E                        | \$570 00                | 1                      | \$570 00             | E                        | \$285 00             | 1                   | M016904    | \$285 00          | (\$285 00)                 |                                                                       |
|      | Face Barrel              | Single Point Tool Holder               |                | E                        | \$170 00                | 1                      | \$170 00             | E                        | \$170 00             | 1                   | Stores     | \$170 00          | \$0 00                     |                                                                       |
|      |                          | Cutting Insert                         |                | E                        | \$10 80                 | 2                      | \$21 60              | E                        | \$10 80              |                     | Stores     | \$21 60           | \$0 00                     |                                                                       |
|      | Rough C'Bore             | 5/8 Endmill                            |                | E                        | \$59 48                 | 2                      | \$118 96             |                          |                      |                     |            | \$0 00            | (\$118 96)                 |                                                                       |
|      |                          | Kennametal Drill Fix Insert Drill      |                |                          |                         |                        |                      | E                        | \$279 72             | 2                   | M016687    | \$559 44          | \$559 44                   | Changed tooling to inserted drill to lower tooling cost per part      |
|      |                          | Inserts                                |                |                          |                         |                        |                      | E                        | \$11 72              |                     | M016687    | \$46 88           | \$46 88                    |                                                                       |
|      |                          | Floating Holder                        |                | E                        | \$254 00                | 1                      | \$254 00             | E                        | \$295 00             |                     | M015868    | \$295 00          | \$41 00                    |                                                                       |
|      |                          | Collet                                 |                | E                        | \$15 00                 | 2                      | \$30 00              | E                        | \$10 83              | 2                   | M015868    | \$21 66           | (\$8 34)                   |                                                                       |

| Op #         | Operation Description                                | Tooling, Gages, Fixture, Machines etc | Drawing Number | Capital or Expense (est) | Estimated Cost per Unit | Estimated Number Req'd | Estimated Total Cost | Capital or Expense (act) | Actual Cost per Unit | Actual Number Req'd | P O Number | Actual Total Cost | Delta (Actual - Estimated) | Comments                                   |
|--------------|------------------------------------------------------|---------------------------------------|----------------|--------------------------|-------------------------|------------------------|----------------------|--------------------------|----------------------|---------------------|------------|-------------------|----------------------------|--------------------------------------------|
| 70<br>cont'd | Finish C'Bore                                        | Special C'Bore tool                   | C-K-10449      | E                        | \$214 00                |                        | \$428 00             | E                        | \$214 00             | 4                   |            | \$856 00          | \$428 00                   |                                            |
|              |                                                      | Floating Holder                       |                | E                        | \$254 00                | 1                      | \$254 00             | E                        | \$254 00             | 1                   | Stores     | \$254 00          | \$0 00                     |                                            |
|              |                                                      | Collet                                |                | E                        | \$15 00                 | 2                      | \$30 00              | E                        | \$10 83              | 2                   | M015868    | \$21 66           | (\$8 34)                   |                                            |
|              | Core Drill Chamber                                   | 27/64 Core Drill                      |                | E                        | \$48 38                 | 2                      | \$96 76              | E                        | \$49 77              | 2                   |            | \$99 54           | \$2 78                     |                                            |
|              |                                                      | Floating Holder                       |                | E                        | \$254 00                | 1                      | \$254 00             | E                        | \$254 00             | 1                   | Stores     | \$254 00          | \$0 00                     |                                            |
|              |                                                      | Collet                                |                | E                        | \$15 00                 | 2                      | \$30 00              | E                        | \$10 83              | 2                   | M015868    | \$21 66           | (\$8 34)                   |                                            |
|              | Rough Ream Chamber                                   | Rough Reamer                          | C-K-10450      | E                        | \$168 00                | 2                      | \$336 00             | E                        | \$168 00             | 6                   |            | \$1,008 00        | \$672 00                   |                                            |
|              |                                                      | Floating Holder                       |                | E                        | \$254 00                | 1                      | \$254 00             | E                        | \$254 00             | 1                   | Stores     | \$254 00          | \$0 00                     |                                            |
|              |                                                      | Collet                                |                | E                        | \$15 00                 | 2                      | \$30 00              | E                        | \$10 83              | 2                   | M015868    | \$21 66           | (\$8 34)                   |                                            |
|              | Finish Ream Chamber                                  | Finish Reamer                         | C-K-10451      | E                        | \$168 00                | 2                      | \$336 00             | E                        | \$168 00             | 6                   |            | \$1,008 00        | \$672 00                   |                                            |
|              |                                                      | Floating Holder                       |                | E                        | \$254 00                | 1                      | \$254 00             | E                        | \$254 00             | 1                   | Stores     | \$254 00          | \$0 00                     |                                            |
|              |                                                      | Collet                                |                | E                        | \$15 00                 | 2                      | \$30 00              | E                        | \$10 83              | 2                   | M015868    | \$21 66           | (\$8 34)                   |                                            |
|              | T-Slot Cut 925 Undercut                              | Special T-Slot Cutter                 | B-K-10447      | E                        | \$39 85                 | 2                      | \$79 70              | E                        | \$109 00             | 3                   |            | \$300 00          | \$220 30                   | Actual Tool is Carbide Tipped & TiN Coated |
|              |                                                      | Collet                                |                | E                        | \$30 00                 | 2                      | \$60 00              | E                        | \$24 65              | 2                   | M015862    | \$49 30           | (\$10 70)                  |                                            |
|              |                                                      | Side Mill/Drill Unit                  |                | E                        | \$800 00                | 1                      | \$800 00             |                          |                      |                     |            | \$0 00            | (\$800 00)                 |                                            |
|              | Mill Locking Lug profile                             | 1/4 Diameter 6-flute Endmill          |                | E                        | \$15 61                 | 2                      | \$31 22              | E                        | \$30 00              | 3                   |            | \$90 00           | \$58 78                    |                                            |
|              |                                                      | Collet                                |                | E                        | \$30 00                 | 2                      | \$60 00              | E                        | \$24 65              | 2                   | M015862    | \$49 30           | (\$10 70)                  |                                            |
|              |                                                      | Side Mill/Drill Unit                  |                | E                        | \$800 00                | 1                      | \$800 00             |                          |                      |                     |            | \$0 00            | (\$800 00)                 |                                            |
|              | Spot Drill Takedown Screw Holes                      | #3 Carbide TiN coated center drill    |                | E                        | \$18 20                 | 2                      | \$36 40              | E                        | \$18 20              | 2                   | Stores     | \$36 40           | \$0 00                     |                                            |
|              |                                                      | Collet                                |                | E                        | \$30 00                 | 2                      | \$60 00              | E                        | \$24 65              | 2                   | M015862    | \$49 30           | (\$10 70)                  |                                            |
|              |                                                      | Side Mill/Drill Unit                  |                | E                        | \$800 00                | 1                      | \$800 00             |                          |                      |                     |            | \$0 00            | (\$800 00)                 |                                            |
|              | Endmill 2 Takedown Screw Holes, Mill recoil lug Slot | 213 Special Endmill                   | A-K-10448      | E                        | \$33 95                 | 2                      | \$67 90              | E                        | \$45 00              | 3                   |            | \$135 00          | \$67 10                    | Coated tool to increase tool life          |
|              |                                                      | Collet                                |                | E                        | \$30 00                 | 2                      | \$60 00              | E                        | \$24 65              | 2                   | M015862    | \$49 30           | (\$10 70)                  |                                            |
|              |                                                      | End Mill/Drill Unit                   |                | E                        | \$1,380 00              | 1                      | \$1,380 00           |                          |                      |                     |            | \$0 00            | (\$1,380 00)               |                                            |
|              | Tap 2 Takedown Screw Holes                           | 1/4-28 Tap                            |                | E                        | \$8 73                  | 2                      | \$17 46              | E                        | \$12 68              | 2                   |            | \$25 36           | \$7.90                     |                                            |
|              |                                                      | Collet                                |                | E                        | \$30 00                 | 2                      | \$60 00              | E                        | \$24 65              | 1                   | M015862    | \$24 65           | (\$35 35)                  |                                            |
|              |                                                      | End Mill/Drill Unit                   |                | E                        | \$1,380 00              | 1                      | \$1,380 00           |                          |                      |                     |            | \$0 00            | (\$1,380 00)               |                                            |
|              |                                                      |                                       |                |                          | Capital Sub-Total       |                        | \$253,350 00         |                          |                      | Capital Sub-Total   |            | \$265,364 25      | \$12,014 25                |                                            |
|              |                                                      |                                       |                |                          | Expense Sub-Total       |                        | \$11,554 00          |                          |                      | Expense Sub-Total   |            | \$6,833 23        | (\$4,720 77)               |                                            |

| Op # | Operation Description               | Tooling, Gages, Fixture, Machines, etc       | Drawing Number | Capital or Expense (est) | Estimated Cost per Unit | Estimated Number Req'd | Estimated Total Cost | Capital or Expense (act) | Actual Cost per Unit | Actual Number Req'd | P O Number | Actual Total Cost | Delta (Actual - Estimated) | Comments                                                                                       |
|------|-------------------------------------|----------------------------------------------|----------------|--------------------------|-------------------------|------------------------|----------------------|--------------------------|----------------------|---------------------|------------|-------------------|----------------------------|------------------------------------------------------------------------------------------------|
| 80   | Cut off & Crown Muzzle              | Kitagawa Chuck                               |                | C                        | \$15,000 00             |                        | \$15,000 00          | C                        | \$5,155 00           | 1                   | M016749    | \$5,155 00        | (\$9,845 00)               | BL-208 Long Stroke Chuck - same as Ilion uses for centerfire barrels - price is for everything |
|      |                                     | Kitagawa S1552 Cylinder                      |                | C                        |                         |                        | \$3,350 00           | C                        | \$3,350 00           | 1                   | M016749    | \$3,350 00        | \$3,350 00                 | Required for Chuck                                                                             |
|      |                                     | Threaded Draw Nut                            |                | E                        |                         |                        | \$250 00             | E                        | \$250 00             | 1                   |            | \$250 00          | \$250 00                   | Required for Chuck                                                                             |
|      |                                     | Length Gage                                  |                | E                        | \$270 00                | 1                      | \$270 00             | E                        | \$350 00             | 1                   |            | \$350 00          | \$80 00                    |                                                                                                |
|      |                                     | Barrel Locator                               |                | E                        |                         | 1                      | \$0 00               | E                        | \$1,049 00           | 1                   | M016935    | \$1,049 00        | \$1,049 00                 | Could have used existing locator but concerns about barrel wobble caused addition              |
|      |                                     | Cutoff Toolholder                            |                | E                        | \$90 75                 | 2                      | \$181 50             | E                        |                      |                     |            | \$0 00            | (\$181 50)                 | Use toolholder on machine                                                                      |
|      |                                     | Cutoff Insert                                |                | E                        | \$10 16                 | 2                      | \$20 32              | E                        | \$10 16              | 1                   | Stores     | \$10 16           | (\$10 16)                  |                                                                                                |
|      |                                     | Cutoff Insert Holder                         |                | E                        | \$23 57                 | 2                      | \$47 14              | E                        |                      |                     |            | \$0 00            | (\$47 14)                  | Use toolholder on machine                                                                      |
|      |                                     | Profile Toolholder                           |                | E                        | \$66 00                 | 2                      | \$132 00             | E                        | \$10 16              | 1                   | Stores     | \$10 16           | (\$121 84)                 |                                                                                                |
|      |                                     | Profile Insert                               |                | E                        | \$10 80                 | 2                      | \$21 60              | E                        |                      |                     |            | \$0 00            | (\$21 60)                  | Use toolholder on machine                                                                      |
|      |                                     | C/Sink Tool                                  |                | E                        | \$20 00                 | 2                      | \$40 00              | E                        | \$10 16              | 1                   | Stores     | \$10 16           | (\$29 84)                  |                                                                                                |
|      |                                     | Floating Holder                              |                | E                        | \$254 00                | 2                      | \$508 00             | E                        |                      |                     |            | \$0 00            | (\$508 00)                 | Use toolholder on machine                                                                      |
|      |                                     | Chamfer Gage                                 |                | E                        | \$220 00                | 1                      | \$220 00             | E                        |                      |                     |            | \$0 00            | (\$220 00)                 | Chamfer too difficult to gage - not going to use                                               |
|      |                                     |                                              |                |                          | Capital Sub-Total       |                        | \$15,000 00          |                          | Capital Sub-Total    |                     |            | \$8,505 00        | (\$6,495 00)               |                                                                                                |
|      |                                     |                                              |                |                          | Expense Sub-Total       |                        | \$1,440 56           |                          | Expense Sub-Total    |                     |            | \$1,679 48        | \$238 92                   |                                                                                                |
| 90   | Prosec Wash Barrels                 |                                              |                |                          |                         |                        | \$0 00               |                          |                      |                     |            | \$0 00            | \$0 00                     | Add/use heat treat baskets                                                                     |
|      |                                     |                                              |                |                          | Capital Sub-Total       |                        | \$0 00               |                          | Capital Sub-Total    |                     |            | \$0 00            | \$0 00                     |                                                                                                |
|      |                                     |                                              |                |                          | Expense Sub-Total       |                        | \$0 00               |                          | Expense Sub-Total    |                     |            | \$0 00            | \$0 00                     |                                                                                                |
| 100  | Induction Harden Barrel Hub End     | Welduction Induction Hardening Machine       |                | C                        | \$166,000 00            | 1                      | \$166,000 00         | C                        | \$153,500 00         | 1                   | M017471    | \$153,500 00      | (\$12,500 00)              |                                                                                                |
|      |                                     | Rockwell 200 Hardness tester                 |                | C                        | \$12,000 00             | 1                      | \$12,000 00          | C                        | \$13,800 00          | 1                   | M016619    | \$13,800 00       | \$1,800 00                 |                                                                                                |
|      |                                     | Vari-Rest Arm for Rockwell Tester            |                | E                        |                         |                        | \$0 00               | E                        | \$890 00             | 1                   | M016581    | \$890 00          | \$890 00                   |                                                                                                |
|      |                                     | Houghton QuenchCool 600 Polymer Quench Media |                | E                        |                         |                        | \$0 00               | E                        | \$15 00              | 55                  |            | \$825 00          | \$825 00                   | Quench Media for hardening machine                                                             |
|      |                                     |                                              |                |                          | Capital Sub-Total       |                        | \$178,000 00         |                          | Capital Sub-Total    |                     |            | \$167,300 00      | (\$10,700 00)              |                                                                                                |
|      |                                     |                                              |                |                          | Expense Sub-Total       |                        | \$0 00               |                          | Expense Sub-Total    |                     |            | \$1,715 00        | \$1,715 00                 |                                                                                                |
| 110  | Wash/Pickle Barrels to remove Scale |                                              |                |                          |                         |                        | \$0 00               |                          |                      |                     |            | \$0 00            | \$0 00                     | Add/use color racks                                                                            |
|      |                                     |                                              |                |                          | Capital Sub-Total       |                        | \$0 00               |                          | Capital Sub-Total    |                     |            | \$0 00            | \$0 00                     |                                                                                                |
|      |                                     |                                              |                |                          | Expense Sub-Total       |                        | \$0 00               |                          | Expense Sub-Total    |                     |            | \$0 00            | \$0 00                     |                                                                                                |

|     |                                         |                                |           |   |             |                   |             |   |             |                   |         |             |              |                                                                                                                               |
|-----|-----------------------------------------|--------------------------------|-----------|---|-------------|-------------------|-------------|---|-------------|-------------------|---------|-------------|--------------|-------------------------------------------------------------------------------------------------------------------------------|
| 120 | Non-Destructive Test Barrels for Cracks | Eddy Current Tester            |           | C | \$75,000 00 | 1                 | \$75,000 00 | C | \$79,000 00 | 1                 |         | \$79,000 00 | \$4,000 00   | Machine is a Resonant Inspection machine made by Quasar International Eddy current or Magnaflux won't pick up internal cracks |
|     |                                         | Stamping Fixture               |           | E |             |                   | \$0 00      | E | \$2,500 00  | 1                 |         | \$2,500 00  | \$2,500 00   |                                                                                                                               |
|     |                                         | Magnaflux Stamp                |           | E |             |                   | \$9 00      | E | \$200 00    | 1                 |         | \$200 00    | \$200 00     |                                                                                                                               |
|     |                                         |                                |           |   |             | Capital Sub-Total |             |   |             | Capital Sub-Total |         | \$79,000 00 | \$4,000 00   |                                                                                                                               |
|     |                                         |                                |           |   |             | Expense Sub-Total |             |   |             | Expense Sub-Total |         | \$2,700 00  | \$2,700 00   |                                                                                                                               |
| 130 | Sight Hole                              | Sight Hole Fixture             | E-K-10452 | C | \$7,640 00  | 1                 | \$7,640 00  | C | \$3,750 00  | 1                 |         | \$3,750 00  | (\$3,890 00) |                                                                                                                               |
|     |                                         | Sight Hole Position Gage       |           | C | \$6,875 00  | 1                 | \$6,875 00  | C | \$10,000 00 | 1                 |         | \$10,000 00 | \$3,125 00   |                                                                                                                               |
|     | Spot Drill                              | ToolHolder                     |           | E | \$140 41    | 3                 | \$421 23    | E | \$140 41    | 1                 | Stores  | \$140 41    | (\$280 82)   |                                                                                                                               |
|     |                                         | Spot Drill                     |           | E | \$9 50      | 2                 | \$19 00     | E | \$9 50      | 1                 | Stores  | \$9 50      | (\$9 50)     |                                                                                                                               |
|     |                                         | Collet                         |           | E | \$14 58     | 3                 | \$43 74     | E | \$14 58     | 1                 | Stores  | \$14 58     | (\$29 16)    |                                                                                                                               |
|     | Drill Sight Hole                        | ToolHolder                     |           | E | \$140 41    | 3                 | \$421 23    | E | \$140 41    | 1                 | Stores  | \$140 41    | (\$280 82)   |                                                                                                                               |
|     |                                         | #30 Drill                      |           | E | \$0 66      | 2                 | \$1 32      | E | \$0 66      | 2                 | Stores  | \$1 32      | \$0 00       |                                                                                                                               |
|     |                                         | Collet                         |           | E | \$26 20     | 3                 | \$78 60     | E | \$26 20     | 1                 | Stores  | \$26 20     | (\$52 40)    |                                                                                                                               |
|     | Tap Sight Hole                          | ToolHolder                     |           | E | \$567 86    | 3                 | \$1,703 58  | E | \$567 86    | 1                 | Stores  | \$567 86    | (\$1,135 72) |                                                                                                                               |
|     |                                         | #6-48 tap                      |           | E | \$14 25     | 2                 | \$28 50     | E | \$14 25     | 2                 | Stores  | \$28 50     | \$0 00       |                                                                                                                               |
|     |                                         | Tap Adapter                    |           | E | \$40 05     | 3                 | \$120 15    | E | \$40 05     | 1                 | Stores  | \$40 05     | (\$80 10)    |                                                                                                                               |
|     |                                         | Thread Gage                    | BK-9013   | E | \$225 90    | 2                 | \$451 80    | E | \$45 00     | 1                 | M016755 | \$46 00     | (\$405 80)   | Thread Depth now equal on all four holes                                                                                      |
|     |                                         | Depth Gage                     | C-K-10465 | E | \$225 90    | 1                 | \$225 90    | E | \$125 00    | 1                 |         | \$125 00    | (\$100 90)   |                                                                                                                               |
|     |                                         |                                |           |   |             | Capital Sub-Total |             |   |             | Capital Sub-Total |         | \$13,750 00 | (\$765 00)   |                                                                                                                               |
|     |                                         |                                |           |   |             | Expense Sub-Total |             |   |             | Expense Sub-Total |         | \$1,139 83  | (\$2,375 22) |                                                                                                                               |
| 140 | Centerless Polish                       | Polishing Belt                 |           | E | \$9 43      | 1                 | \$9 43      | E | \$9 43      | 1                 | Stores  | \$9 43      | \$0 00       |                                                                                                                               |
|     |                                         | Barrel Holders w/ Norbide Nose |           | E | \$350 00    | 2                 | \$700 00    | E | \$40 00     | 2                 |         | \$80 00     | (\$620 00)   | Maintenance made a Handle - Norbide nose not necessary                                                                        |
|     |                                         | Length Gage for Polish Runout  |           | E |             |                   | \$0 00      | E | \$100 00    | 1                 |         | \$100 00    | \$100 00     |                                                                                                                               |
|     |                                         |                                |           |   |             | Capital Sub-Total |             |   |             | Capital Sub-Total |         | \$0 00      | \$0 00       |                                                                                                                               |
|     |                                         |                                |           |   |             | Expense Sub-Total |             |   |             | Expense Sub-Total |         | \$189 43    | (\$520 00)   |                                                                                                                               |
| 150 | Roll Mark                               | Fixture                        |           | C | \$3,730 00  | 1                 | \$3,730 00  | E | \$1,219 00  | 1                 | M018056 | \$1,219 00  | (\$2,511 00) |                                                                                                                               |
|     |                                         | Position Gage                  |           | E | \$480 00    | 1                 | \$480 00    |   | \$112 00    | 1                 |         | \$112 00    | (\$368 00)   |                                                                                                                               |
|     |                                         | Marking Roll                   |           | E | \$380 00    | 2                 | \$760 00    | E | \$366 00    | 2                 |         | \$732 00    | (\$28 00)    |                                                                                                                               |
|     |                                         |                                |           |   |             | Capital Sub-Total |             |   |             | Capital Sub-Total |         | \$0 00      | (\$3,730 00) |                                                                                                                               |
|     |                                         |                                |           |   |             | Expense Sub-Total |             |   |             | Expense Sub-Total |         | \$1,951 00  | \$711 00     |                                                                                                                               |
| 160 | Press receiver on to Barrel             | Press Fixture                  |           | C | \$5,000 00  | 1                 | \$5,000 00  | C | \$6,800 00  | 1                 |         | \$6,800 00  | \$1,800 00   | Accumulation of all components needed to build fixture in-house                                                               |
|     |                                         | Master Bolt                    |           | C | \$2,500 00  | 1                 | \$2,500 00  |   |             |                   |         | \$0 00      | (\$2,500 00) |                                                                                                                               |
|     |                                         | Locator Ring                   |           | E | \$750 00    | 1                 | \$750 00    |   |             |                   |         | \$0 00      | (\$750 00)   |                                                                                                                               |
|     |                                         |                                |           |   |             | Capital Sub-Total |             |   |             | Capital Sub-Total |         | \$6,800 00  | (\$700 00)   |                                                                                                                               |
|     |                                         |                                |           |   |             | Expense Sub-Total |             |   |             | Expense Sub-Total |         | \$0 00      | (\$750 00)   |                                                                                                                               |

| Op # | Operation Description                      | Tooling, Gages, Fixture, Machines, etc | Drawing Number | Capital or Expense (est) | Estimated Cost per Unit | Estimated Number Req'd | Estimated Total Cost | Capital or Expense (act) | Actual Cost per Unit | Actual Number Req'd | P O Number | Actual Total Cost | Delta (Actual - Estimated) | Comments |
|------|--------------------------------------------|----------------------------------------|----------------|--------------------------|-------------------------|------------------------|----------------------|--------------------------|----------------------|---------------------|------------|-------------------|----------------------------|----------|
| 170  | Check for Runout & Straighten if necessary | Bench Centers                          |                | C                        | \$4,530 00              |                        | \$4,530 00           | C                        |                      |                     |            | \$0 00            | (\$4,530 00)               |          |
|      |                                            | Hydraulic Straightening Press          |                | C                        | \$5,000 00              | 1                      | \$5,000 00           | C                        |                      |                     |            | \$0 00            | (\$5,000 00)               |          |
|      |                                            | Locator Arbor                          |                | E                        | \$500 00                | 1                      | \$500 00             | E                        |                      |                     |            | \$0 00            | (\$500 00)                 |          |
|      |                                            | Dial Indicator                         |                | E                        | \$100 00                | 2                      | \$200 00             | E                        |                      |                     |            | \$0 00            | (\$200 00)                 |          |
|      |                                            |                                        |                |                          | Capital Sub-Total       |                        | \$9,530 00           |                          | Capital Sub-Total    |                     |            | \$0 00            | (\$9,530 00)               |          |
|      |                                            |                                        |                |                          | Expense Sub-Total       |                        | \$700 00             |                          | Expense Sub-Total    |                     |            | \$0 00            | (\$700 00)                 |          |
| 180  | Angularity Straighten                      | Adapter for 597 Fixture                |                | C                        | \$1,500 00              | 1                      | \$1,500 00           | E                        | \$1,500 00           | 1                   |            | \$1,500 00        | \$0 00                     |          |
|      |                                            | Angularity Straighten Pins             |                | E                        | \$228 60                | 1                      | \$228 60             | E                        | \$228 60             | 6                   |            | \$1,371 60        | \$1,143 00                 |          |
|      |                                            |                                        |                |                          | Capital Sub-Total       |                        | \$1,500 00           |                          | Capital Sub-Total    |                     |            | \$0 00            | (\$1,500 00)               |          |
|      |                                            |                                        |                |                          | Expense Sub-Total       |                        | \$228 60             |                          | Expense Sub-Total    |                     |            | \$2,871 60        | \$2,643 00                 |          |
| 190  | Glass Bead                                 | Bottom Holder for                      |                | E                        | \$25 00                 | 12                     | \$300 00             | E                        | \$25 00              | 12                  |            | \$300 00          | \$0 00                     |          |
|      |                                            |                                        |                |                          | Capital Sub-Total       |                        | \$0 00               |                          | Capital Sub-Total    |                     |            | \$0 00            | \$0 00                     |          |
|      |                                            |                                        |                |                          | Expense Sub-Total       |                        | \$300 00             |                          | Expense Sub-Total    |                     |            | \$300 00          | \$0 00                     |          |
| 200  | Black Oxide                                | Racks                                  |                | E                        | \$1,492 00              | 6                      | \$8,952 00           | E                        | \$807 00             | 6                   |            | \$4,800 00        | (\$4,152 00)               |          |
|      |                                            | New Heaters                            |                | E                        |                         |                        | \$0 00               | E                        | \$537 00             | 4                   |            | \$2,148 00        | \$2,148 00                 |          |
|      |                                            |                                        |                |                          | Capital Sub-Total       |                        | \$0 00               |                          | Capital Sub-Total    |                     |            | \$0 00            | \$0 00                     |          |
|      |                                            |                                        |                |                          | Expense Sub-Total       |                        | \$8,952 00           |                          | Expense Sub-Total    |                     |            | \$6,948 00        | (\$2,004 00)               |          |

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

06/15/00

710 Capital White Paper vs Actual

C:\data\DC\Mayfield\New Products\710 Capital &amp; Start up Costs.xls\Capital Spend Out

| Barrel                          | White<br>Paper   | Vendor               | PO #              | Amt              | (Under)/<br>Over | Anticipated<br>Additional<br>Spending | Anticipated<br>(Under)/<br>Over |
|---------------------------------|------------------|----------------------|-------------------|------------------|------------------|---------------------------------------|---------------------------------|
| cones                           | 9,960            |                      |                   |                  | (9,960)          |                                       | (9,960)                         |
| gages & fixtures                | 73,100           | Brookfield           | M016586           | 33,595           | (39,505)         |                                       | (39,505)                        |
|                                 |                  | Western Gauge        | M016617           |                  |                  |                                       |                                 |
|                                 |                  | Universal Machine    | M018323           |                  |                  |                                       |                                 |
| baskets                         | 6,900            | Lohn & Associates    | M016939           | 2,475            | (4,425)          |                                       | (4,425)                         |
| machine                         | 222,880          | Mathew Machinery     | M017457           | 362,987          | 140,107          |                                       | 140,107                         |
|                                 |                  | Technical Equip      | M017574           |                  |                  |                                       |                                 |
|                                 |                  | Giddings & Lewis     | M016377           |                  |                  |                                       |                                 |
|                                 |                  | Micro Centric        | M016555           |                  |                  |                                       |                                 |
|                                 |                  | Brookfield Machine   | M016929           |                  |                  |                                       |                                 |
| chuck                           | 15,000           |                      |                   |                  | (15,000)         |                                       | (15,000)                        |
| machine                         | 75,000           |                      |                   |                  | (75,000)         |                                       | (75,000)                        |
| machine                         | 166,000          | Welduction           | M017471           | 153,500          | (12,500)         |                                       | (12,500)                        |
| machine                         | 12,000           | Wilson               | M016619           | 13,800           | 1,800            |                                       | 1,800                           |
| racks                           | 6,000            |                      |                   |                  | (6,000)          |                                       | (6,000)                         |
| Total                           | 586,840          |                      |                   | 566,356          | (20,484)         | -                                     | (20,484)                        |
| <b>Bolt Head</b>                |                  |                      |                   |                  |                  |                                       |                                 |
| fix & gage                      | 42,500           |                      |                   |                  | (42,500)         |                                       | (42,500)                        |
| Superabrasive Grind Lugs        | 43,800           |                      |                   |                  | (43,800)         |                                       | (43,800)                        |
| CNC Machine                     | 174,784          | Technical Equip Sale | M017574           | 115,000          | (59,784)         |                                       | (59,784)                        |
| Total                           | 261,084          |                      |                   | 115,000          | (146,084)        | -                                     | (146,084)                       |
| <b>Bolt Body</b>                |                  |                      |                   |                  |                  |                                       |                                 |
| gage & Fixture                  | 4,500            | Regal Industries     | M016449           | 6,016            | 1,516            |                                       | 1,516                           |
| machine                         | 90,000           | Cyberteck            | M017490           | 59,675           | (30,325)         |                                       | (30,325)                        |
| tanks                           | 9,500            |                      |                   |                  | (9,500)          |                                       | (9,500)                         |
| Total                           | 104,000          |                      |                   | 65,690           | (38,310)         | -                                     | (38,310)                        |
| <b>Receiver</b>                 |                  |                      |                   |                  |                  |                                       |                                 |
| fix & gage                      | 2,500            |                      |                   |                  | (2,500)          |                                       | (2,500)                         |
| machine                         | 513,831          |                      |                   |                  | (513,831)        |                                       | (513,831)                       |
| Total                           | 516,331          |                      |                   |                  | (516,331)        | -                                     | (516,331)                       |
| <b>Range</b>                    |                  |                      |                   |                  |                  |                                       |                                 |
| 100yd range                     | 290,000          |                      |                   |                  | (290,000)        | 500,000                               | 210,000                         |
| snails                          | 30,000           | Savage Range         | M016804 & M016804 | 29,600           | (400)            |                                       | (400)                           |
| other                           | 10,000           | Farns/McIntosh       | M016266/169       | 16,644           | 6,644            |                                       | 6,644                           |
| Total                           | 330,000          |                      |                   | 46,244           | (283,756)        | 500,000                               | 216,244                         |
| <b>Purchased Parts</b>          |                  |                      |                   |                  |                  |                                       |                                 |
| Receiver Insert                 | 48,000           |                      |                   |                  | (48,000)         |                                       | (48,000)                        |
| Side Plate                      | 10,000           | Square Stamping      | M017478           | 7,500            | (2,500)          |                                       | (2,500)                         |
| Safety                          | 2,880            | Square Stamping      | M017491           | 22,800           | (1,080)          |                                       | (1,080)                         |
| Bolt Stop                       | 3,820            | Sterling Sintered    | M017486           | 6,400            | (420)            |                                       | (420)                           |
| Recoil Bracket                  | 2,325            | Square Stamping      | M017477           | 550              | (1,675)          |                                       | (1,675)                         |
| Bolt Handle Blank               | 12,800           | NA Precision         | M017484           | 16,415           | 3,615            |                                       | 3,615                           |
|                                 |                  |                      | M017532 & M017553 |                  |                  |                                       |                                 |
| Bolt Plug                       | 38,088           | Kellems & Coe        | M017443           | 38,000           | (88)             |                                       | (88)                            |
| Bolt Plug Insert                |                  | Anderson Screw       | M017479           | 2,250            | 2,250            |                                       | 2,250                           |
| Spring pin head                 | 23,000           | Megamet              | M017470           | 16,000           | (7,000)          |                                       | (7,000)                         |
| Mag Latch                       | 33,480           | Par 4 Plastics       | M017465           | 31,795           | (1,685)          |                                       | (1,685)                         |
| Magazine Box                    | 28,000           | Brainin              | M017530           | 83,000           | 55,000           |                                       | 55,000                          |
| Magazine Follower               | 33,300           | Par 4 Plastics       | M017466           | 30,267           | (3,033)          |                                       | (3,033)                         |
| Magazine Bottom                 | 47,880           | Par 4 Plastics       | M017466           | 43,519           | (4,361)          |                                       | (4,361)                         |
| Magazine Spring                 |                  | Valco/Valley         | M017497           | 16,050           | 16,050           |                                       | 16,050                          |
| Stock                           | 150,300          | Par 4 Plastics       | M017435           | 156,052          | 5,752            |                                       | 5,752                           |
|                                 |                  |                      | M017559           |                  |                  |                                       |                                 |
| PPI                             | 41,500           | Regal Industries     | M017492           | 52,400           | 10,900           |                                       | 10,900                          |
| Lock Tumbler                    |                  | Megamet              | M017480           | 19,993           | 19,993           |                                       | 19,993                          |
| Trigger                         |                  | Sterling Sintered    | M017487           | 1,435            | 1,435            |                                       | 1,435                           |
| Assembly Press                  |                  | Matthew Machinery    | M016749           | 8,509            | 8,509            |                                       | 8,509                           |
| Total                           | 499,273          |                      |                   | 552,934          | 53,661           | -                                     | 53,661                          |
| <b>Other</b>                    |                  |                      |                   |                  |                  |                                       |                                 |
| Orbital Riveter                 | -                | Orbitform            | M018075           | 11,100           | 11,100           |                                       | 11,100                          |
| Press to attach Barrel/Receiver | -                | In House             | N/A               | 5,811            | 5,811            |                                       | 5,811                           |
| Installation                    | 61,000           | Falconite            | M018451           | 1,487            | (59,513)         |                                       | (59,513)                        |
| Total                           | 61,000           |                      |                   | 18,398           | (42,602)         | -                                     | (42,602)                        |
| <b>Total Capital</b>            | <b>2,358,528</b> |                      |                   | <b>1,364,623</b> | <b>(993,905)</b> | <b>500,000</b>                        | <b>(493,905)</b>                |

04/17/2000

Status by Category

1

| Material | Material description                  | MRP Loc  | Unrestricted | Stock in trf | Restr.-use | In qual. insp. | Blocked | Stock in transi |
|----------|---------------------------------------|----------|--------------|--------------|------------|----------------|---------|-----------------|
| F104131  | 700 VS FRONT GUARD SCREW              | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F15161   | 700 FRONT GUARD SCREW BUSHING         | MA7 RM20 | 2,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F15400   | 700 TRIG SPRING                       | MA7 RM20 | 2,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F15481   | 700 TRIG STOP SCREW                   | MA7 RM20 | 2,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F15666   | 700 SEAR SAFETY CAM PL                | MA7 RM20 | 4,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F17043   | 700 SAFETY PIVOT PIN                  | MA7 RM20 | 1,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F17044   | 700 SAFETY SNAP WASHER                | MA7 RM20 | 2,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F17047   | SP10 MAGAZINE FOLLOWER PLUNGER SPRING | MA7 RM20 | 2,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F17047   | 700 SEAR SPRING                       | MA7 RM20 | 2,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F17053   | 700 TRIG SCREW FRONT                  | MA7 RM20 | 3,500.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F19461   | 700 TRIG CONNECTOR                    | MA7 RM20 | 2,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F201217  | BOLT PLUG TUMBLER SPRING - CF         | MA7 RM20 | 5,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F201224  | LOCK PLUNGER - CF                     | MA7 RM20 | 1,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300527  | 710 RECEIVER INSERT                   | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300528  | 710 PIN, SIDE PLATE                   | MA7 RM20 | 240.000      | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300529  | 710 BOLT HANDLE PIN                   | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300530  | 710 Pin, Bolt Assembly                | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300536  | 710 FIRING PIN HEAD                   | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300538  | 710 BOLT HEAD                         | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300539  | 710 Bolt Body                         | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300540  | 710 Receiver                          | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300542  | 710 Ejector                           | MA7 RM20 | 120.000      | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300543  | 710 SAFETY SPRING                     | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300545  | 710 BOLT STOP                         | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300547  | 710 THREADED INSERT, RECEIVER INSERT  | MA7 RM20 | 0.000        | 0.000        | 0.000      | 5,000.000      | 0.000   | 0.000           |
| F300551  | 710 PIN, PIVOT, TRIGGER HOUSING       | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300552  | 710 PIN, SAFETY PIVOT                 | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300560  | 710 BOLT HANDLE BLANK                 | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300561  | 710 Recoil Bracket                    | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300562  | 710 Magazine Latch                    | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300563  | 710 MAGAZINE BOX                      | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300564  | 710 MAGAZINE FOLLOWER                 | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300565  | 710 MAGAZINE BOTTOM                   | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300567  | 710 SPRING, EJECTOR                   | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300568  | 710 BOLT PLUG                         | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300571  | 710 PIN, MAGAZINE LATCH               | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300598  | 710 Spring, Magazine Latch            | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300599  | 710 SPRING, FIRING PIN                | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300405  | 710 Magazine Spring                   | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300407  | 710 SPRING, SAFETY DETENT             | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300418  | 710 TUMBLER                           | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300420  | 710 Tumbler Blank                     | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300422  | 710 SPRING RETAINER                   | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300425  | 710 REAR TAKEDOWN SCREW               | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300427  | 710 SPRING RETAINER                   | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F305315  | 710 BARREL 30-06 SPRG                 | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F305395  | 710 MAGAZINE BOX ASSEMBLY             | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F91128   | 700 TRIG ENGAGEMENT SCREW             | MA7 RM20 | 2,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F92796   | 700 BUTT PLATE FRAME                  | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F92797   | 700 BUTT PLATE INSERT                 | MA7 RM20 | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F93712   | 700 EXTRACTOR REG (7400)              | MA7 RM20 | 2,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F94555   | 700 EJECTOR PIN (SPIROL)              | MA7 RM20 | 2,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F98008   | 700 RECOIL PAD SCREW                  | MA7 RM20 | 2,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F98008   | NO MASTER #00252A115                  | MA7 RM20 | 2,000.000    | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300370  | 710 BOLT HANDLE                       | MA7 WIP  | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300403  | 710 BOLT BODY ASSEMBLY                | MA7 WIP  | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F300404  | 710 FIRING PIN ASSEMBLY               | MA7 WIP  | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |
| F305390  | 710 Bolt Head Assembly                | MA7 WIP  | 0.000        | 0.000        | 0.000      | 0.000          | 0.000   | 0.000           |

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ME0570

Confidential - SHARPER - 5.22.06r0010520 Order

Williams v. Remington

| PO                    | Type         | Vendor    | Name                            | PGp      | Order date           |
|-----------------------|--------------|-----------|---------------------------------|----------|----------------------|
| Item                  | Material     |           | Short text                      |          | Mat. group           |
| D I A                 | Plnt         | S Loc     | Order qty.                      | Un       | Curr.                |
|                       | SL           | del. date | Scheduled qty.                  | Un       | per Un               |
| M017470               | ZZ           | 106504    | MEGAMET INDUSTRIES              | M01      | 01/14/2000           |
| 00010                 |              |           | METAL INJECTION MOLD FOR 710    | C-300336 | TOOLING              |
| F MAY                 |              |           | 1.000                           | EA       | 16,000.00 USD 1 EA   |
|                       | D 03/16/2000 |           | 1.000                           | EA       |                      |
| Still to be delivered |              |           | 0.500                           | EA       | 8,000.00 USD 50.00 % |
| Still to be invoiced  |              |           | 0.500                           | EA       | 8,000.00 USD 50.00 % |
| M017480               | ZZ           | 106504    | MEGAMET INDUSTRIES              | M01      | 01/20/2000           |
| 00010                 |              |           | TOOLING MOLD / 710 LOCK-TUMBLER | B-300420 | TOOLING              |
| F MAY                 |              |           | 1.000                           | EA       | 20,000.00 USD 1 EA   |
|                       | D 03/29/2000 |           | 1.000                           | EA       |                      |
| Still to be delivered |              |           | 0.000                           | EA       | 0.00 USD 0.00 %      |
| Still to be invoiced  |              |           | 0.333                           | EA       | 6,660.00 USD 33.30 % |

SECRET

ME0571

| PO                    | Type         | Vendor | Name                                              | Pg         | Order date   |
|-----------------------|--------------|--------|---------------------------------------------------|------------|--------------|
| Item                  | Material     |        | Short text                                        | Mat. group |              |
| D I A                 | Plnt Sloc    |        | Order qty. Un                                     | Net Price  | Curr. per Un |
|                       | SL del. date |        | scheduled qty. Un                                 |            |              |
| M017467               | ZZ           | 106500 | BRAININ DEER PARK DIE & STAMPING                  | M01        | 01/13/2000   |
| 00010                 |              |        | PROTOTYPE TOOL TO MFG. E300363 9 MAG BOX TOOLING  |            |              |
| F MAY                 |              |        | 1.000 EA 12,500.00                                | USD        | 1 EA         |
|                       | D 03/09/2000 |        | 1.000 EA                                          |            |              |
| Still to be delivered |              |        | 0.340 EA 4,250.00                                 | USD        | 34.00 %      |
| Still to be invoiced  |              |        | 0.340 EA 4,250.00                                 | USD        | 34.00 %      |
| M017468               | ZZ           | 106500 | BRAININ DEER PARK DIE & STAMPING                  | M01        | 01/13/2000   |
| 00010                 |              |        | PROTOTYPE PARTS OF E300363 REV. 9 MAG BOX TOOLING |            |              |
| F MAY                 |              |        | 500.000 EA 13.17                                  | USD        | 1 EA         |
|                       | D 03/13/2000 |        | 500.000 EA                                        |            |              |
| Still to be delivered |              |        | 500.000 EA 6,585.00                               | USD        | 100.00 %     |
| Still to be invoiced  |              |        | 0.000 EA 0.00                                     | USD        | 0.00 %       |
| M017530               | ZZ           | 106500 | BRAININ DEER PARK DIE & STAMPING                  | M01        | 03/06/2000   |
| 00010                 |              |        | Design & build Progressive Die E-300363 TOOLING   |            |              |
| F MAY                 |              |        | 1.000 EA 83,000.00                                | USD        | 1 EA         |
|                       | D 06/09/2000 |        | 1.000 EA                                          |            |              |
| Still to be delivered |              |        | 0.666 EA 55,278.00                                | USD        | 66.60 %      |
| Still to be invoiced  |              |        | 0.666 EA 55,278.00                                | USD        | 66.60 %      |

DUPLICATE

83

MF0572

| PO      | Type                  | Vendor       | Name                                     | Pg  | Order date           |
|---------|-----------------------|--------------|------------------------------------------|-----|----------------------|
| Item    | Material              |              | Short text                               |     | Mat. group           |
| D I A   | Plnt Sloc             |              | Order qty.                               | Un  | Curr.                |
|         | SL del. date          |              | scheduled qty.                           | Un  | per Un               |
| M017497 | ZZ                    | 106543       | VALCO/ VALLEY TOOL AND DIE INC           | M01 | 02/04/2000           |
| 00010   |                       |              | TOOL MOLD (TO PRODUCE TO PRINT C-300405) |     | TOOLING              |
|         | F MAY                 |              | 1.000                                    | EA  | 16,055.00 USD 1 EA   |
|         |                       | D 04/27/2000 | 1.000                                    | EA  |                      |
|         | Still to be delivered |              | 0.000                                    | EA  | 0.00 USD 0.00 %      |
|         | Still to be invoiced  |              | 0.333                                    | EA  | 5,344.32 USD 33.30 % |
| M017498 | ZZ                    | 106543       | VALCO/ VALLEY TOOL AND DIE INC           | M01 | 02/04/2000           |
| 00010   |                       |              | PROTOTYPE MAGAZINE SPRING C-300405 / 710 |     | MISC                 |
|         | F MAY                 |              | 1,000.000                                | EA  | 2.50 USD 1 EA        |
|         |                       | D 03/02/2000 | 1,000.000                                | EA  |                      |
|         | Still to be delivered |              | 0.000                                    | EA  | 0.00 USD 0.00 %      |
|         | Still to be invoiced  |              | 0.000                                    | EA  | 0.00 USD 0.00 %      |
| 00020   |                       |              | FREIGHT                                  |     | MISC                 |
|         | K MAY                 |              | 1.000                                    | EA  | 11.50 USD 1 EA       |
|         |                       | D 03/02/2000 | 1.000                                    | EA  |                      |
|         | Still to be delivered |              | 0.000                                    | EA  | 0.00 USD 0.00 %      |
|         | Still to be invoiced  |              | 0.000                                    | EA  | 0.00 USD 0.00 %      |

DUPLICATE

ME0573

| PO           | Type                  | Vendor | Name                                     | PGp    | Order date   |
|--------------|-----------------------|--------|------------------------------------------|--------|--------------|
| Item         | Material              |        | Short text                               |        | Mat. group   |
| D I A        | Plnt Sloc             |        | Order qty.                               | Un     | Net Price    |
| SL del. date |                       |        | Scheduled qty.                           | Un     | Curr. per Un |
| M016378      | ZZ                    | 106467 | QUICK TEK                                | M09    | 12/14/1999   |
| 00010        |                       |        | FIX AND PROGRAM CHARGE C-300335 REV 2    |        | TOOLING      |
|              | K MAY                 |        | 1.000 EA                                 | 460.00 | USD 1 EA     |
|              | D 12/14/1999          |        | 1.000 EA                                 |        |              |
|              | Still to be delivered |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
|              | Still to be invoiced  |        | 1.000 EA                                 | 460.00 | USD 100.00 % |
| 00020        |                       |        | FIX AND PROGRAM CHARGE C-300334 REV A    |        | TOOLING      |
|              | K MAY                 |        | 1.000 EA                                 | 390.00 | USD 1 EA     |
|              | D 12/14/1999          |        | 1.000 EA                                 |        |              |
|              | Still to be delivered |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
|              | Still to be invoiced  |        | 1.000 EA                                 | 390.00 | USD 100.00 % |
| M016616      | ZZ                    | 106467 | QUICK TEK                                | M09    | 01/28/2000   |
| 00010        |                       |        | BOLT PLUG INSERT B-300346 REV D DRAWING  |        | RAW          |
|              | F MAY                 |        | 300.000 EA                               | 9.80   | USD 1 EA     |
|              | D 02/15/2000          |        | 300.000 EA                               |        |              |
|              | Still to be delivered |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
|              | Still to be invoiced  |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
| 00020        |                       |        | FREIGHT                                  |        | RAW          |
|              | K MAY                 |        | 1.000 EA                                 | 4.50   | USD 1 EA     |
|              | D 02/15/2000          |        | 1.000 EA                                 |        |              |
|              | Still to be delivered |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
|              | Still to be invoiced  |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
| M017441      | ZZ                    | 106467 | QUICK TEK                                | M01    | 12/14/1999   |
| 00010        | F300334               |        | PIN, FIRING 710                          |        | RAW          |
|              | L MAY RM20            |        | 20,150.000 EA                            | 790.00 | USD 1,000 EA |
|              | D 01/20/2000          |        | 150.000 EA                               |        |              |
|              | D 04/17/2000          |        | 20,000.000 EA                            |        |              |
|              | Still to be delivered |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
|              | Still to be invoiced  |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
| 00020        | F300335               |        | TIP, FIRING PIN 710                      |        | RAW          |
|              | L MAY RM20            |        | 20,150.000 EA                            | 510.00 | USD 1,000 EA |
|              | D 01/20/2000          |        | 150.000 EA                               |        |              |
|              | D 04/17/2000          |        | 20,000.000 EA                            |        |              |
|              | Still to be delivered |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
|              | Still to be invoiced  |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
| M017448      | ZZ                    | 106467 | QUICK TEK                                | M01    | 12/20/1999   |
| 00010        |                       |        | PROTOTYPE SAMPLES OF F300334 FIRING PIN  |        | SAMPLES      |
|              | F MAY RM20            |        | 150.000 EA                               | 5.90   | USD 1 EA     |
|              | D 01/25/2000          |        | 150.000 EA                               |        |              |
|              | Still to be delivered |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
|              | Still to be invoiced  |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
| 00020        |                       |        | PROTOTYPES SAMPLES OF F300335 PIN TIP    |        | SAMPLES      |
|              | F MAY RM20            |        | 150.000 EA                               | 7.95   | USD 1 EA     |
|              | D 01/25/2000          |        | 150.000 EA                               |        |              |
|              | Still to be delivered |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
|              | Still to be invoiced  |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
| 00030        |                       |        | PROTOTYPES SAMPLES/MEXP-0001 BOLT HD BLK |        | SAMPLES      |
|              | F MAY RM20            |        | 150.000 EA                               | 4.60   | USD 1 EA     |
|              | D 01/25/2000          |        | 150.000 EA                               |        |              |
|              | Still to be delivered |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
|              | Still to be invoiced  |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
| 00040        |                       |        | FREIGHT, INVOICE 2421                    |        | SAMPLES      |
|              | K MAY RM20            |        | 1.000 EA                                 | 9.63   | USD 1 EA     |
|              | D 01/25/2000          |        | 1.000 EA                                 |        |              |
|              | Still to be delivered |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
|              | Still to be invoiced  |        | 0.000 EA                                 | 0.00   | USD 0.00 %   |
| M017485      | ZZ                    | 106467 | QUICK TEK                                | M01    | 01/25/2000   |
| 00010        |                       |        | PROTOTYPE 710 BOLT HEAD DRILLED/MILLED   |        | 931          |
|              | F MAY                 |        | 40.000 EA                                | 22.60  | USD 1 EA     |

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MF0574

Confidential - Subject - 5.22.06r0010524 Order

Williams V. Remington

| PO      | Type     | Vendor                | Name                | PGP | Order date            |
|---------|----------|-----------------------|---------------------|-----|-----------------------|
| Item    | Material |                       | Short text          |     | Mat. group            |
| D I A   | Plnt     | S Loc                 | Order qty.          | Un  | Curr.                 |
|         |          | SL del. date          | Scheduled qty.      | Un  | per Un                |
|         |          | D 02/10/2000          | 40.000              | EA  |                       |
|         |          | Still to be delivered | 0.000               | EA  | 0.00 USD 0.00 %       |
|         |          | Still to be invoiced  | 35.000              | EA  | 791.00 USD 100.00 %   |
| M017581 | ZZ       | 106467                | QUICK TEK           |     | M01 04/13/2000        |
| 00010   | F300334  |                       | 710 PIN, FIRING     |     | RAW                   |
|         | MAY RM20 |                       | 500.000             | EA  | 6.74 USD 1 EA         |
|         |          | D 05/02/2000          | 500.000             | EA  |                       |
|         |          | Still to be delivered | 500.000             | EA  | 2,870.00 USD 100.00 % |
|         |          | Still to be invoiced  | 500.000             | EA  | 2,870.00 USD 100.00 % |
| 00020   | F300335  |                       | 710 TIP, FIRING PIN |     | RAW                   |
|         | MAY RM20 |                       | 500.000             | EA  | 6.69 USD 1 EA         |
|         |          | D 05/02/2000          | 500.000             | EA  |                       |
|         |          | Still to be delivered | 500.000             | EA  | 3,345.00 USD 100.00 % |
|         |          | Still to be invoiced  | 500.000             | EA  | 3,345.00 USD 100.00 % |

SECRET

ME0575

| PO      | Item                  | Type           | Vendor     | Name                                     | PGp        | Order date   |
|---------|-----------------------|----------------|------------|------------------------------------------|------------|--------------|
| D I A   | Material              | Plnt           | Sloc       | Short text                               | Mat. group |              |
| SL      | del. date             | Order qty.     | Un         | Net Price                                | Curr.      | per Un       |
| SL      | del. date             | scheduled qty. | Un         |                                          |            |              |
| M015738 | ZZ                    | 1881473        |            | SQUARE STAMPING MFG CORP                 | M01        | 08/25/1999   |
| 00010   |                       |                |            | EJECTOR #C-300067: COST TO ALTER TOOLING |            |              |
|         | Z MAY                 |                | 1.000      | EA                                       | 2,500.00   | USD 1 EA     |
|         |                       | D 09/17/1999   | 1.000      | EA                                       |            |              |
|         | Still to be delivered |                | 0.000      | EA                                       | 0.00       | USD 0.00 %   |
|         | Still to be invoiced  |                | 0.000      | EA                                       | 0.00       | USD 0.00 %   |
| M016903 | ZZ                    | 1881473        |            | SQUARE STAMPING MFG CORP                 | M09        | 03/07/2000   |
| 00010   |                       |                |            | BLANK DIE FOR MAGNUM HOLD OPEN C-300380  |            | TOOLING      |
|         | F MAY                 |                | 1.000      | EA                                       | 5,450.00   | USD 1 EA     |
|         |                       | D 04/10/2000   | 1.000      | EA                                       | 1000425207 | 00010        |
|         | Still to be delivered |                | 1.000      | EA                                       | 5,450.00   | USD 100.00 % |
|         | Still to be invoiced  |                | 1.000      | EA                                       | 5,450.00   | USD 100.00 % |
| 00020   |                       |                |            | FORM TOOL FOR C-300378 AND C-300380      |            | TOOLING      |
|         | F MAY                 |                | 1.000      | EA                                       | 2,000.00   | USD 1 EA     |
|         |                       | D 04/10/2000   | 1.000      | EA                                       | 1000425207 | 00020        |
|         | Still to be delivered |                | 1.000      | EA                                       | 2,000.00   | USD 100.00 % |
|         | Still to be invoiced  |                | 1.000      | EA                                       | 2,000.00   | USD 100.00 % |
| M017243 | ZZ                    | 1881473        |            | SQUARE STAMPING MFG CORP                 | M01        | 03/05/1999   |
| 00010   | F300086               |                |            | LINK LEFT BLANK                          |            | RAW          |
|         | MAY RM20              |                | 35,000.000 | EA                                       | 28.19      | USD 1,000 EA |
|         |                       | D 03/30/1999   | 14,000.000 | EA                                       | 1000095774 | 00010        |
|         |                       | D 04/06/1999   | 7,000.000  | EA                                       |            |              |
|         |                       | D 05/03/1999   | 7,000.000  | EA                                       |            |              |
|         |                       | D 06/07/1999   | 7,000.000  | EA                                       |            |              |
|         | Still to be delivered |                | 0.000      | EA                                       | 0.00       | USD 0.00 %   |
|         | Still to be invoiced  |                | 0.000      | EA                                       | 0.00       | USD 0.00 %   |
| M017244 | ZZ                    | 1881473        |            | SQUARE STAMPING MFG CORP                 | M01        | 03/05/1999   |
| 00010   | F300087               |                |            | LINK RIGHT BLANK                         |            | RAW          |
|         | MAY RM20              |                | 35,000.000 | EA                                       | 25.10      | USD 1,000 EA |
|         |                       | D 03/15/1999   | 14,000.000 | EA                                       | 1000095774 | 00010        |
|         |                       | D 04/06/1999   | 7,000.000  | EA                                       |            |              |
|         |                       | D 05/03/1999   | 7,000.000  | EA                                       |            |              |
|         |                       | D 06/07/1999   | 7,000.000  | EA                                       |            |              |
|         | Still to be delivered |                | 0.000      | EA                                       | 0.00       | USD 0.00 %   |
|         | Still to be invoiced  |                | 0.000      | EA                                       | 0.00       | USD 0.00 %   |
| M017245 | ZZ                    | 1881473        |            | SQUARE STAMPING MFG CORP                 | M01        | 03/05/1999   |
| 00010   | F300091               |                |            | HOLD OPEN BLANK                          |            | RAW          |
|         | MAY RM20              |                | 21,000.000 | EA                                       | 113.44     | USD 1,000 EA |
|         |                       | D 04/14/1999   | 7,000.000  | EA                                       | 1000095817 | 00010        |
|         |                       | D 05/06/1999   | 7,000.000  | EA                                       |            |              |
|         |                       | D 06/07/1999   | 7,000.000  | EA                                       |            |              |
|         | Still to be delivered |                | 0.000      | EA                                       | 0.00       | USD 0.00 %   |
|         | Still to be invoiced  |                | 0.000      | EA                                       | 0.00       | USD 0.00 %   |
| M017259 | ZZ                    | 1881473        |            | SQUARE STAMPING MFG CORP                 | M01        | 03/30/1999   |
| 00010   | F305015               |                |            | BARREL EXTENSION BLANK (CS)              |            | RAW          |
|         | MAY RM20              |                | 14,000.000 | EA                                       | 0.84       | USD 1 EA     |
|         |                       | D 06/08/1999   | 14,000.000 | EA                                       | 1000099647 | 00010        |
|         | Still to be delivered |                | 0.000      | EA                                       | 0.00       | USD 0.00 %   |
|         | Still to be invoiced  |                | 0.000      | EA                                       | 0.00       | USD 0.00 %   |
| M017302 | ZZ                    | 1881473        |            | SQUARE STAMPING MFG CORP                 | M01        | 05/27/1999   |
| 00010   | F300104               |                |            | Hold Open Blank (Win-Mag)                |            | RAW          |
|         | MAY RM20              |                | 8,000.000  | EA                                       | 113.44     | USD 1,000 EA |
|         |                       | D 07/01/1999   | 2,000.000  | EA                                       | 1000108682 | 00010        |
|         |                       | D 08/05/1999   | 2,000.000  | EA                                       |            |              |
|         |                       | D 09/07/1999   | 2,000.000  | EA                                       |            |              |
|         |                       | D 10/06/1999   | 2,000.000  | EA                                       |            |              |
|         | Still to be delivered |                | 0.000      | EA                                       | 0.00       | USD 0.00 %   |
|         | Still to be invoiced  |                | 0.000      | EA                                       | 0.00       | USD 0.00 %   |
| M017317 | ZZ                    | 1881473        |            | SQUARE STAMPING MFG CORP                 | M01        | 06/16/1999   |

| PO           | Type                  | Vendor | Name                        | PGp | Order date            |
|--------------|-----------------------|--------|-----------------------------|-----|-----------------------|
| Item         | Material              |        | Short text                  |     | Mat. group            |
| D I A Plnt   | S Loc                 |        | Order qty.                  | Un  | per Un                |
| SL del. date |                       |        | Scheduled qty.              | Un  |                       |
| 00010        | F330029               |        | Bolt Handle spring Blank    |     | RAW                   |
|              | MAY RM20              |        | 20,000.000                  | EA  | 1,000 EA              |
|              | D 09/09/1999          |        | 20,000.000                  | EA  | PReq 1000111761 00010 |
|              | Still to be delivered |        | 0.000                       | EA  | USD 0.00 %            |
|              | Still to be invoiced  |        | 0.000                       | EA  | USD 0.00 %            |
| M017325      | ZZ 1881473            |        | SQUARE STAMPING MFG CORP    |     | M01 06/23/1999        |
| 00010        | F300087               |        | LINK RIGHT BLANK            |     | RAW                   |
|              | MAY RM20              |        | 28,000.000                  | EA  | 1,000 EA              |
|              | D 08/03/1999          |        | 14,000.000                  | EA  | PReq 1000112687 00010 |
|              | D 11/01/1999          |        | 14,000.000                  | EA  |                       |
|              | Still to be delivered |        | 0.000                       | EA  | USD 0.00 %            |
|              | Still to be invoiced  |        | 0.000                       | EA  | USD 0.00 %            |
| M017332      | ZZ 1881473            |        | SQUARE STAMPING MFG CORP    |     | M01 07/14/1999        |
| 00010        | F300030               |        | EXTRACTOR BLANK             |     | RAW                   |
|              | MAY RM20              |        | 20,000.000                  | EA  | 1,000 EA              |
|              | D 08/23/1999          |        | 20,000.000                  | EA  | PReq 1000116137 00010 |
|              | Still to be delivered |        | 0.000                       | EA  | USD 0.00 %            |
|              | Still to be invoiced  |        | 0.000                       | EA  | USD 0.00 %            |
| M017333      | ZZ 1881473            |        | SQUARE STAMPING MFG CORP    |     | M01 07/14/1999        |
| 00010        | F300086               |        | LINK LEFT BLANK             |     | RAW                   |
|              | MAY RM20              |        | 20,000.000                  | EA  | 1,000 EA              |
|              | D 08/23/1999          |        | 20,000.000                  | EA  | PReq 1000116146 00010 |
|              | Still to be delivered |        | 0.000                       | EA  | USD 0.00 %            |
|              | Still to be invoiced  |        | 0.000                       | EA  | USD 0.00 %            |
| 00020        | F300087               |        | LINK RIGHT BLANK            |     | RAW                   |
|              | L MAY RM20            |        | 15,000.000                  | EA  | 1,000 EA              |
|              | D 08/23/1999          |        | 15,000.000                  | EA  | PReq 1000116147 00010 |
|              | Still to be delivered |        | 0.000                       | EA  | USD 0.00 %            |
|              | Still to be invoiced  |        | 0.000                       | EA  | USD 0.00 %            |
| M017334      | ZZ 1881473            |        | SQUARE STAMPING MFG CORP    |     | M01 07/14/1999        |
| 00010        | F305015               |        | BARREL EXTENSION BLANK (CS) |     | RAW                   |
|              | MAY RM20              |        | 21,000.000                  | EA  | 1 EA                  |
|              | D 08/16/1999          |        | 21,000.000                  | EA  | PReq 1000116167 00010 |
|              | Still to be delivered |        | 0.000                       | EA  | USD 0.00 %            |
|              | Still to be invoiced  |        | 0.000                       | EA  | USD 0.00 %            |
| M017357      | ZZ 1881473            |        | SQUARE STAMPING MFG CORP    |     | M01 08/03/1999        |
| 00010        | F300109               |        | Ejector Blank (Win-Mag)     |     | RAW                   |
|              | MAY RM20              |        | 10,000.000                  | EA  | 1,000 EA              |
|              | D 09/13/1999          |        | 10,000.000                  | EA  | PReq 1000119926 00010 |
|              | Still to be delivered |        | 0.000                       | EA  | USD 0.00 %            |
|              | Still to be invoiced  |        | 0.000                       | EA  | USD 0.00 %            |
| M017358      | ZZ 1881473            |        | SQUARE STAMPING MFG CORP    |     | M01 08/12/1999        |
| 00010        | F300091               |        | HOLD OPEN BLANK             |     | RAW                   |
|              | MAY RM20              |        | 5,000.000                   | EA  | 1,000 EA              |
|              | D 09/21/1999          |        | 5,000.000                   | EA  | PReq 1000120413 00010 |
|              | Still to be delivered |        | 0.000                       | EA  | USD 0.00 %            |
|              | Still to be invoiced  |        | 0.000                       | EA  | USD 0.00 %            |
| M017360      | ZZ 1881473            |        | SQUARE STAMPING MFG CORP    |     | M01 08/25/1999        |
| 00010        | F300081               |        | EJECTOR BLANK               |     | RAW                   |
|              | MAY RM20              |        | 20,000.000                  | EA  | 1,000 EA              |
|              | D 10/05/1999          |        | 10,000.000                  | EA  | PReq 1000119989 00010 |
|              | D 11/15/1999          |        | 10,000.000                  | EA  |                       |
|              | Still to be delivered |        | 0.000                       | EA  | USD 0.00 %            |
|              | Still to be invoiced  |        | 0.000                       | EA  | USD 0.00 %            |
| 00020        | K MAY RM20            |        | FREIGHT, INVOICE 18080      |     | RAW                   |
|              | D 10/05/1999          |        | 1.000                       | EA  | 1 EA                  |
|              | Still to be delivered |        | 0.000                       | EA  | USD 0.00 %            |
|              | Still to be invoiced  |        | 0.000                       | EA  | USD 0.00 %            |

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ME0577

Confidential - Subject - 5.22.06r0010527ye Order

Williams v. Remington

| PO      | Type                  | Vendor  | Name                                | PGp       | Order date              |
|---------|-----------------------|---------|-------------------------------------|-----------|-------------------------|
| Item    | Material              |         | Short text                          |           | Mat. group              |
| D I A   | Plnt SLoc             |         | Order qty.                          | Un        | per Un                  |
| SL      | del. date             |         | scheduled qty.                      | Un        |                         |
|         |                       |         |                                     | Net Price | Curr.                   |
| M017376 | ZZ                    | 1881473 | SQUARE STAMPING MFG CORP            | M01       | 09/13/1999              |
| 00010   | F300104               |         | Hold Open Blank (Win-Mag)           | RAW       |                         |
|         | MAY                   | RM20    | 5,000.000                           | EA        | 13.44 USD 1,000 EA      |
|         | D 10/25/1999          |         | 5,000.000                           | EA        | PreReq 1000155158 00010 |
|         | Still to be delivered |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
|         | Still to be invoiced  |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
| M017400 | ZZ                    | 1881473 | SQUARE STAMPING MFG CORP            | M01       | 10/22/1999              |
| 00010   | F300091               |         | 597 HOLD OPEN BLANK (LONG RIFLE)    | RAW       |                         |
|         | MAY                   | RM20    | 15,000.000                          | EA        | 13.44 USD 1,000 EA      |
|         | D 12/15/1999          |         | 10,000.000                          | EA        | PreReq 1000120413 00010 |
|         | D 01/18/2000          |         | 5,000.000                           | EA        |                         |
|         | Still to be delivered |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
|         | Still to be invoiced  |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
| M017413 | ZZ                    | 1881473 | SQUARE STAMPING MFG CORP            | M01       | 11/02/1999              |
| 00010   | F300087               |         | LINK RIGHT BLANK                    | RAW       |                         |
|         | MAY                   | RM20    | 20,000.000                          | EA        | 25.10 USD 1,000 EA      |
|         | D 12/06/1999          |         | 5,000.000                           | EA        | PreReq 1000224143 00010 |
|         | D 01/13/2000          |         | 10,000.000                          | EA        |                         |
|         | D 02/07/2000          |         | 5,000.000                           | EA        |                         |
|         | Still to be delivered |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
|         | Still to be invoiced  |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
| M017418 | ZZ                    | 1881473 | SQUARE STAMPING MFG CORP            | M01       | 11/03/1999              |
| 00010   | F305015               |         | BARREL EXTENSION BLANK (CS)         | RAW       |                         |
|         | MAY                   | RM20    | 10,000.000                          | EA        | 0.84 USD 1 EA           |
|         | D 01/10/2000          |         | 5,000.000                           | EA        | PreReq 1000227147 00010 |
|         | D 02/02/2000          |         | 5,000.000                           | EA        |                         |
|         | Still to be delivered |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
|         | Still to be invoiced  |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
| M017420 | ZZ                    | 1881473 | SQUARE STAMPING MFG CORP            | M01       | 11/04/1999              |
| 00010   | F330029               |         | Bolt Handle Spring Blank            | RAW       |                         |
|         | MAY                   | RM20    | 20,000.000                          | EA        | 22.17 USD 1,000 EA      |
|         | D 12/20/1999          |         | 20,000.000                          | EA        | PreReq 1000228399 00010 |
|         | Still to be delivered |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
|         | Still to be invoiced  |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
| M017431 | ZZ                    | 1881473 | SQUARE STAMPING MFG CORP            | M01       | 11/16/1999              |
| 00010   | F300104               |         | Hold Open Blank (Win-Mag)           | RAW       |                         |
|         | MAY                   | RM20    | 10,000.000                          | EA        | 113.44 USD 1,000 EA     |
|         | D 12/01/1999          |         | 5,000.000                           | EA        | PreReq 1000243851 00010 |
|         | D 01/12/2000          |         | 5,000.000                           | EA        |                         |
|         | Still to be delivered |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
|         | Still to be invoiced  |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
| M017455 | ZZ                    | 1881473 | SQUARE STAMPING MFG CORP            | M01       | 12/21/1999              |
| 00010   | F300086               |         | LINK LEFT BLANK                     | RAW       |                         |
|         | MAY                   | RM20    | 15,000.000                          | EA        | 28.19 USD 1,000 EA      |
|         | D 01/31/2000          |         | 15,000.000                          | EA        | PreReq 1000288411 00010 |
|         | Still to be delivered |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
|         | Still to be invoiced  |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
| M017460 | ZZ                    | 1881473 | SQUARE STAMPING MFG CORP            | M01       | 12/23/1999              |
| 00010   | F305015               |         | BARREL EXTENSION BLANK (CS)         | RAW       |                         |
|         | MAY                   | RM20    | 10,000.000                          | EA        | 0.84 USD 1 EA           |
|         | D 03/10/2000          |         | 5,000.000                           | EA        | PreReq 1000291658 00010 |
|         | D 04/04/2000          |         | 5,000.000                           | EA        |                         |
|         | Still to be delivered |         | 0.000                               | EA        | 0.00 USD 0.00 %         |
|         | Still to be invoiced  |         | 3,000.000                           | EA        | 2,520.00 USD 27.84 %    |
| M017473 | ZZ                    | 1881473 | SQUARE STAMPING MFG CORP            | M01       | 01/18/2000              |
| 00010   | F300442               |         | 597 SS BBL EXTENSION BLANK MATERIAL | 11RF      |                         |
|         | MAY                   | RM20    | 4,360                               | LB        | 4.55 USD 1 LB           |
|         | D 02/10/2000          |         | 4,360                               | LB        |                         |
|         | Still to be delivered |         | 0                                   | LB        | 0.00 USD 0.00 %         |

| PO           | Type                  | Vendor     | Name                     | PGP             | Order date   |
|--------------|-----------------------|------------|--------------------------|-----------------|--------------|
| Item         | Material              |            | Short text               |                 | Mat. group   |
| D : A        | Plnt SLoc             |            | Order qty.               | Un              | Net Price    |
| SL del. date |                       |            | Scheduled qty.           | Un              | Curr. per Un |
| M017477      | Still to be invoiced  | 3,270      | LB                       | 14,878.50       | USD 75.00 %  |
| 00010        | ZZ 1881473            |            | SQUARE STAMPING MFG CORP | M01 01/19/2000  |              |
| F MAY        |                       | 1.000      | EA                       | 550.00          | USD 1 EA     |
|              | D 03/15/2000          | 1.000      | EA                       |                 |              |
|              | Still to be delivered | 0.000      | EA                       | 0.00            | USD 0.00 %   |
|              | Still to be invoiced  | 0.000      | EA                       | 0.00            | USD 0.00 %   |
| M017478      | Still to be delivered | 0.000      | EA                       | 0.00            | USD 0.00 %   |
| 00010        | ZZ 1881473            |            | SQUARE STAMPING MFG CORP | M01 01/20/2000  |              |
| F MAY        |                       | 1.000      | EA                       | 7,500.00        | USD 1 EA     |
|              | D 03/29/2000          | 1.000      | EA                       |                 |              |
|              | Still to be delivered | 0.000      | EA                       | 0.00            | USD 0.00 %   |
|              | Still to be invoiced  | 0.000      | EA                       | 0.00            | USD 0.00 %   |
| M017489      | Still to be delivered | 0.000      | EA                       | 0.00            | USD 0.00 %   |
| 00010        | ZZ 1881473            |            | SQUARE STAMPING MFG CORP | M01 01/26/2000  |              |
| F MAY        |                       | 1.000      | EA                       | 25.10           | USD 1,000 EA |
|              | D 03/15/2000          | 5,000.000  | EA                       | Preq 1000329984 | 00010        |
|              | D 03/29/2000          | 5,000.000  | EA                       |                 |              |
|              | Still to be delivered | 0.000      | EA                       | 0.00            | USD 0.00 %   |
|              | Still to be invoiced  | 0.000      | EA                       | 0.00            | USD 0.00 %   |
| M017491      | Still to be delivered | 0.000      | EA                       | 0.00            | USD 0.00 %   |
| 00010        | ZZ 1881473            |            | SQUARE STAMPING MFG CORP | M01 01/26/2000  |              |
| F MAY        |                       | 1.000      | EA                       | 19,900.00       | USD 1 EA     |
|              | D 04/11/2000          | 1.000      | EA                       |                 |              |
|              | Still to be delivered | 1.000      | EA                       | 19,900.00       | USD 100.00 % |
|              | Still to be invoiced  | 1.000      | EA                       | 19,900.00       | USD 100.00 % |
| 00020        |                       | 1.000      | EA                       | 2,900.00        | USD 1 EA     |
| F MAY        |                       | 1.000      | EA                       |                 |              |
|              | D 04/11/2000          | 1.000      | EA                       | 2,900.00        | USD 100.00 % |
|              | Still to be delivered | 1.000      | EA                       | 2,900.00        | USD 100.00 % |
|              | Still to be invoiced  | 1.000      | EA                       | 2,900.00        | USD 100.00 % |
| M017515      | Still to be delivered | 0.000      | EA                       | 0.00            | USD 0.00 %   |
| 00010        | ZZ 1881473            |            | SQUARE STAMPING MFG CORP | M01 02/17/2000  |              |
| F MAY        |                       | 5,000.000  | EA                       | 88.59           | USD 1,000 EA |
|              | D 04/18/2000          | 5,000.000  | EA                       | Preq 1000391384 | 00010        |
|              | Still to be delivered | 5,000.000  | EA                       | 442.95          | USD 100.00 % |
|              | Still to be invoiced  | 5,000.000  | EA                       | 442.95          | USD 100.00 % |
| M017522      | Still to be delivered | 0.000      | EA                       | 0.00            | USD 0.00 %   |
| 00010        | ZZ 1881473            |            | SQUARE STAMPING MFG CORP | M01 02/21/2000  |              |
| F MAY        |                       | 20,000.000 | EA                       | 11.95           | USD 1,000 EA |
|              | D 03/27/2000          | 10,000.000 | EA                       | Preq 1000398321 | 00010        |
|              | D 04/19/2000          | 10,000.000 | EA                       |                 |              |
|              | Still to be delivered | 0.000      | EA                       | 0.00            | USD 0.00 %   |
|              | Still to be invoiced  | 10,000.000 | EA                       | 119.50          | USD 50.00 %  |
| M017523      | Still to be delivered | 0.000      | EA                       | 0.00            | USD 0.00 %   |
| 00010        | ZZ 1881473            |            | SQUARE STAMPING MFG CORP | M01 02/21/2000  |              |
| F MAY        |                       | 10,000.000 | EA                       | 28.19           | USD 1,000 EA |
|              | D 04/27/2000          | 5,000.000  | EA                       | Preq 1000398324 | 00010        |
|              | D 05/22/2000          | 5,000.000  | EA                       |                 |              |
|              | Still to be delivered | 1,500.000  | EA                       | 42.29           | USD 15.00 %  |
|              | Still to be invoiced  | 10,000.000 | EA                       | 281.90          | USD 100.00 % |
| M017525      | Still to be delivered | 0.000      | EA                       | 0.00            | USD 0.00 %   |
| 00010        | ZZ 1881473            |            | SQUARE STAMPING MFG CORP | M01 02/21/2000  |              |
| F MAY        |                       | 10,000.000 | EA                       | 0.84            | USD 1 EA     |
|              | D 05/08/2000          | 5,000.000  | EA                       | Preq 1000398369 | 00010        |
|              | D 06/07/2000          | 5,000.000  | EA                       |                 |              |
|              | Still to be delivered | 4,000.000  | EA                       | 3,360.00        | USD 40.00 %  |
|              | Still to be invoiced  | 10,000.000 | EA                       | 8,400.00        | USD 100.00 % |
| M017557      | Still to be delivered | 0.000      | EA                       | 0.00            | USD 0.00 %   |
| 00010        | ZZ 1881473            |            | SQUARE STAMPING MFG CORP | M01 03/24/2000  |              |

Confidential - Subject - 5.22.06r0010529e Order

Williams V. Remington

ME0579

| PO      | Type                  | Vendor | Name                     | PGp        | Order date            |
|---------|-----------------------|--------|--------------------------|------------|-----------------------|
| Item    | Material              |        | Short text               | Mat. group |                       |
| D I A   | Plnt                  | SLoc   | Order qty.               | Un         | Net Price             |
| SL      | del. date             |        | Scheduled qty.           | Un         | Curr. per Un          |
| 00010   | F330029               |        | Bolt Handle Spring Blank | RAW        |                       |
|         | MAY RM20              |        | 20,000.000               | EA         | 22.17 USD 1,000 EA    |
|         | D 05/08/2000          |        | 20,000.000               | EA         | PReq 1000466494 00010 |
|         | Still to be delivered |        | 20,000.000               | EA         | 443.40 USD 100.00 %   |
|         | Still to be invoiced  |        | 20,000.000               | EA         | 443.40 USD 100.00 %   |
| M017564 | ZZ 1881473            |        | SQUARE STAMPING MFG CORP | M01        | 03/30/2000            |
| 00010   | F300081               |        | EJECTOR BLANK            | RAW        |                       |
|         | MAY RM20              |        | 20,000.000               | EA         | 88.59 USD 1,000 EA    |
|         | D 05/12/2000          |        | 10,000.000               | EA         | PReq 1000469281 00010 |
|         | D 07/07/2000          |        | 10,000.000               | EA         |                       |
|         | Still to be delivered |        | 20,000.000               | EA         | 1,771.80 USD 100.00 % |
|         | Still to be invoiced  |        | 20,000.000               | EA         | 1,771.80 USD 100.00 % |
| M017569 | ZZ 1881473            |        | SQUARE STAMPING MFG CORP | M01        | 04/04/2000            |
| 00010   | F300030               |        | EXTRACTOR BLANK          | RAW        |                       |
|         | MAY RM20              |        | 30,000.000               | EA         | 113.85 USD 1,000 EA   |
|         | D 05/08/2000          |        | 10,000.000               | EA         | PReq 1000471806 00010 |
|         | D 07/19/2000          |        | 10,000.000               | EA         |                       |
|         | D 09/28/2000          |        | 10,000.000               | EA         |                       |
|         | Still to be delivered |        | 16,800.000               | EA         | 200.76 USD 56.00 %    |
|         | Still to be invoiced  |        | 30,000.000               | EA         | 358.50 USD 100.00 %   |
| M017582 | ZZ 1881473            |        | SQUARE STAMPING MFG CORP | M01        | 04/13/2000            |
| 00010   | F300091               |        | 597 HOLD OPEN BLANK      | RAW        |                       |
|         | MAY RM20              |        | 10,000.000               | EA         | 113.44 USD 1,000 EA   |
|         | D 05/15/2000          |        | 10,000.000               | EA         | PReq 1000471807 00010 |
|         | Still to be delivered |        | 10,000.000               | EA         | 1,134.40 USD 100.00 % |
|         | Still to be invoiced  |        | 10,000.000               | EA         | 1,134.40 USD 100.00 % |

ME0580

Confidential - Subject - 5.22.06r0010530e Order

Williams v. Remington

| PO      | Type                  | Vendor       | Name                                     | PGp        | Order date  |
|---------|-----------------------|--------------|------------------------------------------|------------|-------------|
| Item    | Material              |              | Short text                               | Mat. group |             |
| D I A   | Plnt                  | Sloc         | Order qty.                               | Curr.      | per Un      |
| SL      | del. date             |              | Un                                       |            |             |
| M017195 | ZZ                    | 105652       | PAR 4 PLASTICS, INC.                     | M01        | 01/06/1999  |
| 00010   |                       |              | Design and build two-cavity mold         |            | TOOLING     |
|         | F MAY                 |              | 1.000 EA                                 | 22,200.00  | USD 1 EA    |
|         |                       | D 03/05/1999 | 1.000 EA                                 |            |             |
|         | Still to be delivered |              | 0.000 EA                                 | 0.00       | USD 0.00 %  |
|         | Still to be invoiced  |              | 0.000 EA                                 | 0.00       | USD 0.00 %  |
| M017435 | ZZ                    | 105652       | PAR 4 PLASTICS, INC.                     | M01        | 12/13/1999  |
| 00010   |                       |              | 1 CAVITY PRODUCTION MOLD FOR 710 STOCK   |            | TOOLING     |
|         | F MAY                 |              | 1.000 EA                                 | 145,300.00 | USD 1 EA    |
|         |                       | D 03/29/2000 | 1.000 EA                                 |            |             |
|         | Still to be delivered |              | 0.000 EA                                 | 0.00       | USD 0.00 %  |
|         | Still to be invoiced  |              | 0.333 EA                                 | 48,384.90  | USD 33.30 % |
| M017465 | ZZ                    | 105652       | PAR 4 PLASTICS, INC.                     | M01        | 01/11/2000  |
| 00010   |                       |              | 2 CAVITY PRODUCTION MOLD / 710 MAG LATCH |            | TOOLING     |
|         | F MAY                 |              | 1.000 EA                                 | 31,806.00  | USD 1 EA    |
|         |                       | D 04/24/2000 | 1.000 EA                                 |            |             |
|         | Still to be delivered |              | 0.000 EA                                 | 0.00       | USD 0.00 %  |
|         | Still to be invoiced  |              | 0.333 EA                                 | 10,591.40  | USD 33.30 % |
| M017466 | ZZ                    | 105652       | PAR 4 PLASTICS, INC.                     | M01        | 01/12/2000  |
| 00010   |                       |              | 2+2 Family Mold- 710 Follower/Box Bottom |            | TOOLING     |
|         | F MAY                 |              | 1.000 EA                                 | 73,786.00  | USD 1 EA    |
|         |                       | D 04/17/2000 | 1.000 EA                                 |            |             |
|         | Still to be delivered |              | 0.340 EA                                 | 25,087.24  | USD 34.00 % |
|         | Still to be invoiced  |              | 0.340 EA                                 | 25,087.24  | USD 34.00 % |
| M017559 | ZZ                    | 105652       | PAR 4 PLASTICS, INC.                     | M01        | 03/27/2000  |
| 00010   |                       |              | 710 STOCK DRILLING FIXTURE               |            | RAW         |
|         | F MAY                 |              | 1.000 EA                                 | 7,500.00   | USD 1 EA    |
|         |                       | D 04/20/2000 | 1.000 EA                                 |            |             |
|         | Still to be delivered |              | 0.000 EA                                 | 0.00       | USD 0.00 %  |
|         | Still to be invoiced  |              | 0.000 EA                                 | 0.00       | USD 0.00 %  |

Confidential - Subject - 5.22.06r0010531ye Order

Williams v. Remington

ME0581

## COST SUMMARY



COST SUMMARY FOR PLANT PREPARATION AND  
INSTALLATION OF NEW MACHINERY FOR MODEL 710



REMINGTON ARMS  
22 RIFFLE TRAIL  
HICKORY KY, 42051  
856-4200

MF0582

## COST SUMMARY TABLE OF CONTENTS

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| COST TO MOVE EXISTING MACHINERY .....    | PAGE 1 |
| COST FOR RIGGERS AND EQUIPMENT .....     | PAGE 2 |
| COST FOR INSTALLATION OF MACHINERY ..... | PAGE 3 |

MF0583

## REASONS FOR CHOOSING OKUMA

- 1) OPERATOR, MAINTANANCE, AND PROGRAMING FAMILIARTY.
- 2) OKUMA COMES STANDARD WITH MORE OPTIONS AT LOWER COST.
- 3) FIRST NAME BASIS WITH SERVICE DEPARTMENT AND PARTS DEPARTMENT AT GOSIGER.
- 4) ALREADY STOCK MANY SPARE PARTS FOR OKUMA IN CRIB.
- 5) OKUMA IS VERTUALY MAINTENANCE FREE.
- 6) DOWN TIME IS AT A MINIMUM.

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MF0584

**COST TO MOVE ONE OKUMA MX45**

|                                                              |                         |
|--------------------------------------------------------------|-------------------------|
| <b>COST FOR RIGGERS AND THEIR EQUIPMENT FOR ONE HALF DAY</b> | <b>\$476.00</b>         |
| <b>COST FOR THE RENTAL OF A GENI BOOM FOR ONE DAY</b>        | <b>\$525.00</b>         |
| <b>COST FOR THE RENTAL OF A SCISSOR LIFT FOR ONE DAY</b>     | <b>\$350.00*</b>        |
| <b>COST FOR EMPLOYEE LABOR</b>                               | <b>TWO MEN (24 Hrs)</b> |
| <b>COST FOR MISC. ELECTRICAL AND PLUMBING SUPPLIES</b>       | <b>\$250.00</b>         |
| <b>TOTAL</b>                                                 | <b>\$1601.00**</b>      |

\* COST N/A IF MOVE IS LESS THAN 30 FT.

\*\* THREE POSSIBLE MACHINE MOVES TO DATE (COST X THREE)

BARBER - 5.22.06r0010535

ME0585

Confidential - Subject - 5.22.06r0010535  
Order  
Williams v. Remington

## RIGGERS AND EQUIPMENT COST FOR MODEL 710 PROJECT

| MACHINE             | CONTRACTED LABOR                         | FORK LIFT | SKATES   | EMPLOYEE LABOR   | SUBTOTAL   |
|---------------------|------------------------------------------|-----------|----------|------------------|------------|
| OKUMA LT15MY        | \$288.00                                 | \$140.00  | \$40.00  | N/A              | \$468.00   |
| OKUMA LB300         | \$288.00                                 | \$140.00  | \$40.00  | N/A              | \$468.00   |
| OKUMA CROWN-V       | \$288.00                                 | \$140.00  | \$40.00  | N/A              | \$468.00   |
| OKUMA CROWN-V       | \$288.00                                 | \$140.00  | \$40.00  | N/A              | \$468.00   |
| TACO BRAZE          | N/A                                      | N/A       | N/A      | TWO MEN 4 HOURS  | N/A        |
| CHILLER (TACO)      | N/A                                      | N/A       | N/A      | TWO MEN 4 HOURS  | N/A        |
| INDUCTION UNIT      | N/A                                      | N/A       | N/A      | TWO MEN 4 HOURS  | N/A        |
| CHILLER (INDUCT.)   | N/A                                      | N/A       | N/A      | TWO MEN 4 HOURS  | N/A        |
| G&L D-8 CMM         | N/A                                      | N/A       | N/A      | TWO MEN 4 HOURS  | N/A        |
| EDDY CURRENT TESTER | (INFORMATION NOT AVAILABLE AT THIS TIME) |           |          |                  | N/A        |
|                     |                                          |           |          |                  |            |
| TOTAL COST          | \$1,152.00                               | \$560.00  | \$160.00 | TWO MEN 20 HOURS | \$1,872.00 |

BARBER - 5.22.06r0010536

MF0586

Confidential - ~~BARBER~~ - 5.22.06r0010536 Order  
Williams V. Remington

## COST FOR MACHINE INSTALLATION

| MACHINE | LT 15 MY | LB 300 | CROWN-V | CROWN-V | TACO BRAZE | CHILLER | INDUC. UNIT | CHILLER | D-8 CMM |
|---------|----------|--------|---------|---------|------------|---------|-------------|---------|---------|
|---------|----------|--------|---------|---------|------------|---------|-------------|---------|---------|

## ELECTRICAL

|             |            |          |          |          |          |          |          |          |          |
|-------------|------------|----------|----------|----------|----------|----------|----------|----------|----------|
| CONDUIT     | \$102.00   | \$102.00 | \$102.00 | \$102.00 | \$68.40  | \$68.40  | \$68.40  | \$68.40  | \$68.40  |
| TRANSFORMER | \$1,310.00 | \$720.00 | \$720.00 | \$720.00 | N/A      | N/A      | N/A      | N/A      | N/A      |
| DISCONNECTS | \$970.00   | \$315.00 | \$315.00 | \$315.00 | \$275.00 | \$435.00 | \$250.00 | \$435.00 | \$25.00  |
| FUSES       | \$125.20   | \$48.00  | \$48.00  | \$48.00  | \$13.50  | \$30.75  | \$13.50  | \$30.75  | N/A      |
| WIRE        | \$297.00   | \$105.60 | \$105.60 | \$105.60 | \$63.84  | \$24.96  | \$24.96  | \$24.96  | \$24.96  |
| FITTINGS    | \$250.00   | \$250.00 | \$250.00 | \$250.00 | \$175.00 | \$175.00 | \$175.00 | \$175.00 | \$175.00 |

## PLUMBING

|           |          |          |          |          |          |     |     |     |          |
|-----------|----------|----------|----------|----------|----------|-----|-----|-----|----------|
| PIPE      | \$134.40 | \$134.40 | \$134.40 | \$134.40 | \$134.40 | N/A | N/A | N/A | \$134.40 |
| REGULATOR | \$133.82 | \$133.82 | \$133.82 | \$133.82 | \$133.82 | N/A | N/A | N/A | \$133.82 |
| VALVES    | \$45.00  | \$45.00  | \$45.00  | \$45.00  | \$45.00  | N/A | N/A | N/A | \$45.00  |
| FITTINGS  | \$50.00  | \$50.00  | \$50.00  | \$50.00  | \$50.00  | N/A | N/A | N/A | \$50.00  |

## EQUIPMENT

|                   |            |            |            |            |            |          |          |          |                    |
|-------------------|------------|------------|------------|------------|------------|----------|----------|----------|--------------------|
| GENI BOOM         | \$156.60   | \$156.60   | \$156.60   | \$156.60   | \$156.60   | \$156.60 | \$156.60 | \$156.60 | \$156.60           |
| SCISSOR LIFT      | \$77.80    | \$77.80    | \$77.80    | \$77.80    | \$77.80    | \$77.80  | \$77.80  | \$77.80  | \$77.80            |
| SUB TOTAL         | \$3,651.82 | \$2,138.22 | \$2,138.22 | \$2,138.22 | \$1,193.36 | \$968.51 | \$766.26 | \$968.51 | \$890.98           |
| <b>TOTAL COST</b> |            |            |            |            |            |          |          |          | <b>\$13,963.12</b> |

83

ME0587

Confidential - Subject - 522506060537e Order

Williams v. Remington

BARBER - 5.22.06r0010537

Risk Page.

- Risks + BBL - MATERIAL
  - RIFLING - LOW MUST PROVE IT
  - CHAMBER - TOOLIFE & CYCLE TIMES
  - H-T - SLAVE
  - PRESS ASSY - BULGING MACHINE REDESIGN - EJECTION SYSTEM.
  - BBL GROUPING.

## + RECEIVER

- MACHINE - RUN OFF JUST LIKE BBL
- MATERIAL - HIGH IT SPLIT & CONCENTRICITY
- SURFACE FINISH OF TUBING.

## + BOLT

- RUN TIME ASSUMES 2/RUN
- DEPLATING

## + RECEIVER INSERT

- STRENGTH OF SIDEPLATE & SCREW RETENTION
- WARP
- HIGH SCRAP.

## + MAGAZINE BOX.

- + BOLT HANDLE
- ↳ EARLY TOOL

## + BOLT PLUG.

CAPACITY CON STRAINS ABOVE ~ 35,000

- FURNACE
- IT IS RECEIVER
- OR OFFLOAD MAG-BOX LOT.

GOOD TO HAVE A - (DRAWING LATH  
~ RIFLER

MF0588

1  
M/710 MTG 9/1/99

GARY, MEL, LITELY, JASON, SCOTT

DANNY, BRIAN, TOMMY, MERT, RON, CHUCK, JIMMY, JOHN

MARC, JOE.

## BARREL

- BAR STOCK MAKE LENGTH OF BAR STOCK 13' FOR MAGNUMS  
12' FOR MAGNUMS

THIS LEAVES 3" CROP CUT.

⇒ 60 DAYS

- SAMPLES TO MIKE OF 4137 STEEL FOR NEXT DAT.

- 1 SET 597, 1 SET 710.

83

⇒ - PUT CROP ENDS IN COST &amp; FIND OUT SCRAP RECOVERY

- GUNDRILL &amp; RIFLE

- STRESS RELIEVE - 13 HRS WHY SO LONG.

⇒ - IN LINE STRESS RELIEVE - RABBITA.

⇒ 60-90 DAYS

- OKUMA MAKE A BARREL VALIDATE TIMES

- TAKE RUN 1 DAY'S WORTH.

- RABBITA - IN TO ON RUN-OFF

- ORDER ALL TOOLING.

- ORDER OF EVENTS TRIAL THEN PO.

- SCRAP.

- GRIND OP DUE TO H-T OF HOB

↳ GET TO NEXT RUN-OFF

MF0589

2

⇒ NEXT 90 DAYS - GET MATERIAL & MAKE  
 SAMPLES OF NR RECEIVERS  
 BUT SHORT TUBES & TURNED  
 OP STOCK. TO SIMULATE BARREL &  
 RECEIVER

↳ GET MATERIAL

↳ JIMBOCH - MAKE A PRESS.

↳ DESIGN BY SEPT 3

83

- LOCK TITE AT ALL ASSEMBLY

- SMED - KON. HAS CONTACT FOR CHANGEOVERS

- LENGTH OF BOLT HEAD. WHY?

⇒ RABBIT BOLT HEAD LENGTH.

- DOUBLED TOOLING BETWEEN SIGITT HOLE & LB300.

MF0590

⇒ RABBIT SEND DOWN RACKS FOR COLOR  
of WHAT IS NEW BSL TRUCKS

LAST FOR ENTIRE PROCESS.

\*BOLT HEAD

- 10 BOLT HEAD BLANKS

10 BOLT HANDLES ON -A- LOAD

- CROSS HOLE .250 ON -B- LOAD

⇒ - MAKE STRAIGHT MAG BOX CUT  
- CUT ON THE BACK - SCOPE CLEARANCE OR TRANSITION

DIT TESTING.

MF0591

- ILION 2.7¢/KWH MAYFIELD #035/12WIT BASE
- DEREGULATION - OF ELECTRIC 50/50% SPLIT & PEAK TO
- ⇒ OTHER BUSINESSES
- PUBLIC FILINGS OF NEW BUSINESSES

WKY RURAL ELECTRIC

⇒ HOW TO PROVIDE SOURCE.

⇒ -- WHAT TYPE & LEAD TIME FOR TRANSFORMER

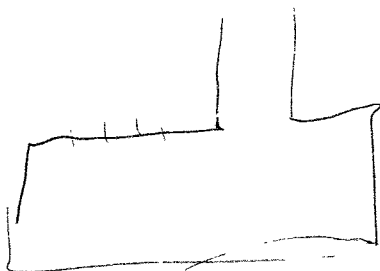
→ OKUMA LT15 - ON ILION FLOOR

⇒ HANWET CONSTRUCTION → SUPPOSED TO BUILD E TOWN

⇒ GRECO - SHOULD WE USE THEM.

⇒ DOES THIS HELP THE LITIGATION.

- LOCAL CODES AROUND THE PLANT



MF0592

5

KEY

⇒ METT- JOE JERSEY = Box at Continued Cost  
1 Box for m/547 & m/710

- PUT ALL ~~BOX~~ LETTERING ON THE EDGE OF THE  
Box. Remington -  
FIREARMS SAFETY DEPENDS ON IT.

- BULK SHIP DOCUMENT ENVELOP.

2 TYPES

PAGE 1 - SCHEDULE OF ~~ITEMS~~ ITEMS TO BE REDUCED m/m/pa/m/m/m/connector  
ILION VS MAYFIELD ENGINEERING ENGINEER & QUALIFICATION

PAGE 2  
ILION VS MAYFIELD W/ SCREWS ETC.

PAGE 3  
REAR IS LIST OF  
ADD USE ARE THERE  
ELECTRICAL  
- NEED NEW HORNS - EXPENSIVE TO REPAIRS

⇒ MAKE NEW PRINTS FOR SIDE PLATE MAY NEED TWO

⇒ TRIGGER - DO NOT PUT FINGER GROOVES SMOOTH TRIGGER

- METGAL ON THE BOX - 7 MAGAZINE BOX DESIGN.

- LARRY KIPP ON MAGAZINE BOX LETTERS -

⇒ F.

MF0593

6

⇒ M/700 EXTRACTOR - H&P PART

WHO WILL QUOTE IT OUTSIDE 400 TON PRESS  
TO GET LITTLE MORE

FRONT MIDDLE REAR BUSHINGS

KEVEL - STOCK ASSEMBLY

- SPINNER STUDS
- REAR SIGHT ASSEMBLY

83

⇒ STEEL SERVICE COUNTERS

IS WORDING CLEAR ON NET VS IN RFQ

↳ WHAT IS WORDING ON ORDER QWTP VS RELEASED.

RISES

#1 NO FAILS DAT/TAP

#2 PRODUCTION TIME OF 710

UPSIDE - PROCESS CAPABILITIES FOR 2000

FROM MY STATE

- PURCHASING

STAFFING

- COST DIFFERENCES REED & STAMP

- STATE PROPERTY TAX

MF0594

Remington Arms Company  
710 Production Model  
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               | \$ 6,024,335               |
| Standard Mfg. Contribution Margin per Gun | \$ 36.73              | \$ 56.83                   | \$ 57.75                   | \$ 68.45                   |
|                                           | 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                   | 417,135                    | 417,135                    | 417,135                    |
| Working Capital (excluding A/R)           | N/A                   | 323,957                    | 323,957                    | 461,707                    |

MF0595

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

C:\data\DC\Mayfield\New Products\m710 estimate rev4.xls\m710 est Mayfield run times

| PART DESCRIPTION                  | Part #  | 710 Costing Model |                      |             |                  |                |                  | 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             | 2.29           | 3.56             | 4.27    |
| Barrel Assembly                   | 3305400 |                   |                      | -           | -                | -              | -                | -       |
| Barrel                            | 305315  | 4.80              | 0.3866               | 4.09        | 7.36             | 13.23          | 20.59            | 29.48   |
| 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             | 1.53           | 2.39             | 2.86    |
| Receiver Insert Assembly          | ????    |                   | 0.0050               | 0.04        | 0.08             | 0.14           | 0.23             | 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    |
| Safety Button                     |         | 0.41              | 0.0050               | 0.05        | 0.10             | 0.17           | 0.27             | 0.73    |
| Safety Plunger                    |         | 0.07              |                      | -           | -                | -              | -                | 0.07    |
| Safety Key/Cap/Bushing            |         | 0.69              |                      | -           | -                | -              | -                | 0.69    |
| 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        | 0.52             | 0.94           | 1.47             | 1.76    |
| 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             | 0.77    |
| Bolt Handle Blank                 | 300360  | 1.63              |                      | -           | -                | -              | -                | 1.63    |
| Bolt Handle Pin                   | 300329  | 0.06              |                      | -           | -                | -              | -                | 0.06    |
| Bolt Head Assembly                | 305390  |                   | 0.0580               | 0.52        | 0.93             | 1.68           | 2.61             | 3.13    |
| Bolt Head                         | 300338  | 1.75              | 0.0809               | 0.86        | 1.54             | 2.77           | 4.31             | 6.91    |
| Extractor                         | 93712   | 0.77              |                      | -           | -                | -              | -                | 0.77    |

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

C:\data\DC\Mayfield\New Products\m710 estimate rev4.xls\m710 est Mayfield run times

| PART DESCRIPTION            | Part # | 710 Costing Model |                      |             |                  |                |                  |          |
|-----------------------------|--------|-------------------|----------------------|-------------|------------------|----------------|------------------|----------|
|                             |        | Material<br>\$    | Run Rate<br>(hrs/pc) | Labor<br>\$ | Fixed<br>O.H. \$ | Var<br>O.H. \$ | Total<br>O.H. \$ | Total    |
| 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     |
| 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           | 0.32             | 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            | 28505  | 0.25              |                      | -           | -                | -              | -                | 0.25     |
| Value Added Cost of:        |        |                   |                      |             |                  |                |                  |          |
| Proof/Gallery/Inspect/Pack  |        | 1.15              | 0.1500               | 1.34        | 2.42             | 4.34           | 6.76             | 9.25     |
| Total Cost                  |        | \$ 42.55          | 0.9186               | \$ 9.10     | \$ 16.38         | \$ 29.45       | \$ 45.83         | \$ 97.48 |

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 |           | 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 59,000<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                                                                          |
| <b>Overhead Costs</b>                      |                                                      |           |                                             |            |                                    |            |                                     |           |                                     |                                                                                      |
| <b>Staffing Costs</b>                      |                                                      |           |                                             |            |                                    |            |                                     |           |                                     |                                                                                      |
| 7110500 Salaries - Exempt                  | 484,994                                              |           | 484,994                                     |            | 484,994                            |            | 484,994                             |           | 484,994                             |                                                                                      |
| 7130002 Indirect Labor                     | 257,439                                              |           | 257,439                                     |            | 257,439                            |            | 257,439                             |           | 257,439                             |                                                                                      |
| 7130005 Overtime Premium                   | 14,678                                               |           | 14,678                                      |            | 14,678                             |            | 14,678                              |           | 14,678                              |                                                                                      |
| Employee Benefits                          | 621,408                                              | 62,136    | 683,544                                     | 63,982     | 685,390                            | 105,601    | 727,009                             | 158,401   | 779,810                             | 58% Wage 25% Salary                                                                  |
| 7450501 Training                           | 14,400                                               |           | 14,400                                      |            | 14,400                             |            | 14,400                              |           | 14,400                              |                                                                                      |
| 7455010 Tuition Refund                     | 11,200                                               |           | 11,200                                      |            | 11,200                             |            | 11,200                              |           | 11,200                              |                                                                                      |
| 7510500 Employee Recreation Expense        | 8,000                                                |           | 8,000                                       |            | 8,000                              |            | 8,000                               |           | 8,000                               |                                                                                      |
| 7550500 Travel Expense                     | 18,090                                               |           | 18,090                                      |            | 18,090                             |            | 18,090                              |           | 18,090                              |                                                                                      |
| 7580500 Entertainment Expense              | 2,010                                                |           | 2,010                                       |            | 2,010                              |            | 2,010                               |           | 2,010                               |                                                                                      |
| 7660500 Subscriptions & Publications       | 1,600                                                |           | 1,600                                       |            | 1,600                              |            | 1,600                               |           | 1,600                               |                                                                                      |
| 8880500 Memberships                        | 1,630                                                |           | 1,630                                       |            | 1,630                              |            | 1,630                               |           | 1,630                               |                                                                                      |
| Total Staffing                             | 1,435,450                                            | 62,136    | 1,497,585                                   | 63,982     | 1,499,432                          | 105,601    | 1,541,061                           | 158,401   | 1,593,851                           |                                                                                      |
| <b>Materials and Supplies</b>              |                                                      |           |                                             |            |                                    |            |                                     |           |                                     |                                                                                      |
| 7650500 Operating Supplies                 | 24,268                                               | 4,405     | 28,673                                      | 5,881      | 30,149                             | 8,471      | 32,739                              | 12,706    | 36,975                              | Variable Cost by # guns Produced                                                     |
| 7840500 Safety Costs                       | 6,728                                                |           | 6,728                                       |            | 6,728                              |            | 6,728                               |           | 6,728                               |                                                                                      |
| 8230150 Prototype Work                     | 18,720                                               |           | 18,720                                      | 4,680      | 23,400                             | 4,680      | 23,400                              | 4,680     | 23,400                              | 25% increase related to 710                                                          |
| 8710002 Vending Tools                      | 17,656                                               |           | 17,656                                      | 6,909      | 24,565                             | 6,909      | 24,565                              | 10,363    | 28,019                              | Increase proportional to 597                                                         |
| 8710120 Essential Materials                | 303,826                                              | 81,120    | 384,946                                     | 100,934    | 404,760                            | 138,000    | 441,826                             | 207,000   | 515,826                             | Based on # of Machines 20% increase<br>\$5 20/597 + \$3.90/710                       |
| 8710122 Tool/Gauge/Fixtures                | 10,003                                               |           | 10,003                                      | 2,899      | 12,902                             | 2,899      | 12,902                              | 4,349     | 14,352                              |                                                                                      |
| 8710505 Vendor Rework                      | 6,835                                                |           | 6,835                                       | 1,981      | 8,816                              | 1,981      | 8,816                               | 2,922     | 9,396                               | Increase proportional to 597                                                         |
| 7670500 Maintenance Other                  | 53,574                                               |           | 53,574                                      | 10,715     | 64,289                             | 10,715     | 64,289                              | 10,715    | 64,289                              | Based on # of Machines 20% increase                                                  |
| 8710550 Maintenance Material Consumption   | 63,341                                               |           | 63,341                                      | 18,360     | 81,701                             | 18,360     | 81,701                              | 27,540    | 90,881                              | Proportional increase                                                                |
| 8710560 Maintenance Material Non Inventory | 41,102                                               |           | 41,102                                      | 11,914     | 53,016                             | 11,914     | 53,016                              | 17,870    | 58,972                              | Proportional increase                                                                |
| Total Materials and Supplies               | 546,052                                              | 85,525    | 631,577                                     | 164,272    | 710,325                            | 203,920    | 749,981                             | 298,195   | 844,248                             |                                                                                      |
| <b>Facilities and Utilities</b>            |                                                      |           |                                             |            |                                    |            |                                     |           |                                     |                                                                                      |
| 7720500 Contract Services - Not Maint      | 20,105                                               |           | 20,105                                      |            | 20,105                             | 1,000      | 21,105                              | 2,250     | 22,355                              | Uniforms for new hires                                                               |
| 7720503 Contract Services - Maint          | 40,408                                               |           | 40,408                                      |            | 40,408                             |            | 40,408                              |           | 40,408                              |                                                                                      |
| 7810500 Equipment Rental & Lease           | 2,520                                                |           | 2,520                                       |            | 2,520                              |            | 2,520                               |           | 2,520                               |                                                                                      |
| 8710132 Waste Disposal                     | 22,195                                               |           | 22,195                                      |            | 22,195                             | 6,124      | 28,319                              | 9,186     | 31,381                              |                                                                                      |
| Total Facilities and Utilities             | 85,229                                               |           | 85,229                                      |            | 85,229                             | 7,124      | 92,353                              | 11,436    | 96,665                              |                                                                                      |
| <b>Other</b>                               |                                                      |           |                                             |            |                                    |            |                                     |           |                                     |                                                                                      |
| 7820500 Non Capital Equipment              | 16,439                                               |           | 16,439                                      | 3,288      | 19,727                             | 3,288      | 19,727                              | 3,288     | 19,727                              | 20% increase due to Machine increase                                                 |
| 8820502 Postage                            | 3,389                                                |           | 3,389                                       |            | 3,389                              |            | 3,389                               |           | 3,389                               |                                                                                      |
| 8870500 Contributions & Donations          | 2,198                                                |           | 2,198                                       |            | 2,198                              |            | 2,198                               |           | 2,198                               |                                                                                      |
| 8840500 Environmental fees                 | 250                                                  |           | 250                                         |            | 250                                |            | 250                                 |           | 250                                 |                                                                                      |
| 8980500 Miscellaneous Expenses             | 3,600                                                |           | 3,600                                       |            | 3,600                              |            | 3,600                               |           | 3,600                               |                                                                                      |
| Kreda Credits                              | (33,894)                                             | (4,285)   | (58,179)                                    | (4,370)    | (58,264)                           | (7,283)    | (61,176)                            | (10,924)  | (64,818)                            | 4% of total payroll                                                                  |
| Total Other                                | (29,017)                                             | (4,285)   | (32,303)                                    | (1,082)    | (29,100)                           | (3,995)    | (32,012)                            | (7,636)   | (35,654)                            |                                                                                      |
| <b>Fixed Costs</b>                         |                                                      |           |                                             |            |                                    |            |                                     |           |                                     |                                                                                      |
| 7910500 Telephone                          | 21,648                                               |           | 21,648                                      |            | 21,648                             |            | 21,648                              |           | 21,648                              |                                                                                      |
| 8080500 Water Utilities                    | 7,800                                                |           | 7,800                                       | 2,759      | 10,559                             | 2,759      | 10,559                              | 4,138     | 11,938                              | Budget \$1,000 increase for 7,250 710.<br>Rate treated as variable                   |
| 8090500 Electrical Utilities               | 178,433                                              | 7,255     | 185,688                                     | 47,363     | 225,797                            | 69,057     | 247,490                             | 103,585   | 282,018                             | 16% increase in usage and 45% increase<br>in peak treated as variable                |
| 8130500 Depreciation                       | 705,905                                              |           | 705,905                                     | 259,530    | 965,435                            | 259,530    | 965,435                             | 259,530   | 965,435                             | Increase Capital to produce 710                                                      |
| 8440500 Property Taxes                     | 27,200                                               |           | 27,200                                      | 9,897      | 37,097                             | 9,897      | 37,097                              | 13,345    | 40,545                              | \$3,000 related to increased fixed assets<br>balance related to increase inventories |
| Total Fixed                                | 940,966                                              | 7,255     | 948,241                                     | 319,549    | 1,260,535                          | 341,242    | 1,282,228                           | 380,598   | 1,321,584                           |                                                                                      |
| Totals                                     | \$ 2,979,700                                         | \$150,630 | \$3,130,330                                 | \$ 546,721 | \$3,526,420                        | \$ 653,900 | \$ 3,633,600                        | \$840,994 | \$ 3,820,694                        |                                                                                      |
| Direct Labor Payments                      | \$ 590,227                                           | \$107,130 | \$ 697,358                                  | \$ 110,313 | \$ 700,541                         | \$ 182,070 | \$ 772,298                          | \$273,106 | \$ 863,333                          |                                                                                      |
| <b>Overhead Rates</b>                      |                                                      |           |                                             |            |                                    |            |                                     |           |                                     |                                                                                      |
| Variable Costs                             |                                                      |           | 312.9%                                      |            | 323.4%                             |            | 304.5%                              |           | 289.5%                              |                                                                                      |
| Fixed Costs                                |                                                      |           | 136.0%                                      |            | 179.9%                             |            | 166.0%                              |           | 153.1%                              |                                                                                      |
| Total                                      |                                                      |           | 448.9%                                      |            | 503.4%                             |            | 470.5%                              |           | 442.6%                              |                                                                                      |
| Overhead Increase/(Decrease) to 597        |                                                      |           | N/A                                         |            | \$ 5.51                            |            | \$ 2.18                             |           | \$ (0.64)                           |                                                                                      |
| Overhead 710                               |                                                      |           | -                                           |            | 916,516                            |            | 856,627                             |           | 1,208,633                           |                                                                                      |
| 597 Overhead Based on 2000 Budget          |                                                      |           | 3,130,330                                   |            | 2,327,332                          |            | 2,649,439                           |           | 2,649,439                           |                                                                                      |
| Overhead Impact of 710                     |                                                      |           | -                                           |            | 282,572                            |            | 127,535                             |           | (37,378)                            |                                                                                      |
|                                            |                                                      |           | 3,130,330                                   |            | 3,526,420                          |            | 3,633,600                           |           | 3,820,694                           |                                                                                      |

MF0598

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

C:\data\DC\Mayfield\New Products\{M710 estimate rev4.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  | 3,821.92  | 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<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       | 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 | 18,054.35 | 29,552.95 | 65,535.22 | 56,077.47 | 42,627.28 | 43,851.46 | 28,521.78 | 284,559.61 | 417,134.76       |

MF0599

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

C:\data\DC\Mayfield\New Products\[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                | 71,279                     | 78,602                     | 87,787                     |
| 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                       | 40.6                       | 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% Off                                     | (1.1)                 | (1.1)                      | (1.2)                      | (1.4)                      |
| Required Head Count                             | 37.9                  | 37.9                       | 41.8                       | 46.7                       |
| Actual Head Count                               | 37.5                  | 37.5                       | 37.5                       | 37.5                       |
| Over/(Under) Staffing                           | (0.4)                 | (0.4)                      | (4.3)                      | (9.2)                      |

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MF0600

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

C:\data\DC\Mayfield\New Products\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         | \$2,500          | 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        |   |
|                 | 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           | - |

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

C:\data\DC\Mayfield\New Products\710 estimate rev4.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         |        |   |        | 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 | 1,384  | Mar-00   | Apr-00 |
| 300361 | Recoil Bracket     | 2,225     | Stamping Die    | NH Stamping    | Dec-99 | 5 | 448    | 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    | MIM Mold        | Mogamet        | 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  | 33,300    | Mold            | Par 4          | Dec-99 | 5 | 6,660  | Mar-00   | Apr-00 |
| 300365 | Magazine Bottom    | 47,880    | 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 |                 |                |        |   |        |          |        |

|              |             |  |    |         |
|--------------|-------------|--|----|---------|
| Total        | \$2,297,528 |  |    | 253,430 |
| Installation | \$61,000    |  | 10 | 6,100   |

\$2,358,528259,530

REMINGTON ARMS COMPANY, INC.  
FIREARMS - MAYFIELD

08/30/99

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| 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)              |                 |
| Safety Button              | 0.41                | 0.0050          |
| Safety Plunger             | 0.07                |                 |
| Safety Key/Cap/Bushing     | <b>0.69</b>         |                 |
| 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>   |

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

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MF0603

Final Assembly

0.0050

(1.96) 0.0883

CONFIDENTIAL 83

MF0604

**REMINGTON ARMS COMPANY, INC.**  
**FIREARMS - MAYFIELD**

08/30/99

C:\data\DC\Mayfield\New Products\I[M710 estimate rev4.xls]Working Capital

|                                               |                |                |
|-----------------------------------------------|----------------|----------------|
| Units of 710                                  | <u>20,000</u>  | <u>30,000</u>  |
| 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                         | 141,831        | 212,747        |
| Work In Process                               |                |                |
| 597 WIP approaching 18 turns                  |                |                |
| .75 Months in Inventory                       | 110,285        | 155,044        |
| Finished Goods                                |                |                |
| Sale better than 597                          |                |                |
| 1 Month in Inventory                          | <u>162,464</u> | <u>229,851</u> |
| Total Inventory                               | 449,081        | 649,392        |
| Increase in A/P                               |                |                |
| 45 Days of Raw Material & Cutters             | <u>125,123</u> | <u>187,685</u> |
| Increase in Working Capital                   | <u>323,957</u> | <u>461,707</u> |

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## 710 Barrel Run-Rate Summary-R3

| No. | Operation                                                                                                            | Estimated Run-Rate for Capacity/Constraint Planning(hr./part) | Comments                                                                                                | Estimated Run-Rate for Cost Planning(hr./part) | Comments                                                         |
|-----|----------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------|---------------------------------------------------------------------------------------------------------|------------------------------------------------|------------------------------------------------------------------|
| 1   | Cut to Length                                                                                                        | 0.004167                                                      |                                                                                                         | 0.000000                                       | Grouped with Gundrill                                            |
| 2   | Gundrill Bore                                                                                                        | 0.053353                                                      |                                                                                                         | 0.053353                                       | Constraint Operation in Cell - assumes one Machine running 710   |
| 3   | Ream Bore                                                                                                            | 0.045649                                                      |                                                                                                         | 0.045649                                       | Constraint Operation in Cell - assumes one Machine running 710   |
| 4   | Rifle Bore                                                                                                           | 0.000000                                                      |                                                                                                         | 0.000000                                       | Grouped with Reamer                                              |
| 5   | Wash & Stress Relieve                                                                                                | 0.073187                                                      | 597 rate / .443 (177 M/710 bbls in a load vs 400 M/597 bbls).<br><b>CONSTRAINT OPERATION FOR BARREL</b> | 0.000413                                       | Material Handling Time only divided by 177                       |
| 6   | Turn O.D. & Inspect for Runout                                                                                       | 0.027713                                                      |                                                                                                         | 0.027713                                       | Constraint Operation in Cell - assumes both Machines running 710 |
| 7   | Cut-off & Crown Muzzle End                                                                                           | 0.011667                                                      | a/u 597 rate                                                                                            | 0.000000                                       | Grouped with Turn O.D.                                           |
| 8   | Face, Chamber, Machine Hub End, Drill & Tap Takedown Screw Holes, Mill Recoil Lug Slot & 100% Inspect Chamber Finish | 0.061459                                                      | LB-300 MY Turning Center                                                                                | 0.061459                                       | LB-300 MY Turning Center                                         |
| 9   | Drill & Tap Sight Screw Holes                                                                                        | 0.020197                                                      | Modify current 597 BBL Assy Fixture                                                                     | 0.000000                                       | Grouped with Chamber Operation                                   |
| 10  | Proseco Wash Barrels                                                                                                 | 0.000190                                                      | Material Handling Time Only divided by 177                                                              | 0.000190                                       | Material Handling Time Only divided by 177                       |
| 11  | Induction Heat Treat Hub                                                                                             | 0.006000                                                      | a/u Ilion's rate                                                                                        | 0.006000                                       | a/u Ilion's rate                                                 |
| 12  | Alkaline Wash/Pickle Barrel                                                                                          | 0.000556                                                      | 2 minute cycle time divided by 25 bbls per rack                                                         | 0.000556                                       | 2 minute cycle time divided by 25 bbls per rack                  |
| 13  | Eddy Current Test Barrel                                                                                             | 0.015500                                                      | a/u Ilion's rate for Magnaflex                                                                          | 0.015500                                       | a/u Ilion's rate for Magnaflex                                   |
| 14  | Centerless Polish Barrel                                                                                             | 0.004167                                                      | a/u 597 rate                                                                                            | 0.004167                                       | a/u 597 rate                                                     |
| 15  | Press Receiver onto Barrel                                                                                           | 0.023370                                                      | a/u Ilion's rate                                                                                        | 0.023370                                       | a/u Ilion's rate; Constraint Operation in Cell                   |
| 16  | Inspect for Runout & Straighten if Necessary                                                                         | 0.012000                                                      | a/u Ilion's rate                                                                                        | 0.000000                                       | Grouped with Assembly Operation                                  |
| 17  | Roll Mark                                                                                                            | 0.003000                                                      | a/u 597 rate                                                                                            | 0.003000                                       | a/u 597 rate                                                     |
| 18  | Angularity Straighten Muzzle & Inspect Bore                                                                          | 0.006667                                                      | a/u 597 rate                                                                                            | 0.006667                                       | a/u 597 rate                                                     |
| 19  | Centerless or Spin Polish (repair)                                                                                   | 0.004167                                                      | a/u 597 rate                                                                                            | 0.000                                          | repair only                                                      |
| 20  | Glass Bead                                                                                                           | 0.005556                                                      | a/u 597 rate                                                                                            | 0.005556                                       | a/u 597 rate                                                     |
| 21  | Black Oxide                                                                                                          | 0.004167                                                      | a/u 597 rate, Material Handling Time Only                                                               | 0.004167                                       | a/u 597 rate, Material Handling Time Only                        |
|     | Totals                                                                                                               | 0.408042                                                      |                                                                                                         | 0.257758                                       |                                                                  |

## 710 Barrel Run-Rate Summary-R3

**General Assumptions:**

- 25" barrel length
- 4140 Re-sulfurized, cold drawn steel used
- All calculated run-rates based on std. reference information contained in *Machining Data Handbook, 3rd Edition*, for Material Group 4 (resulfurized medium carbon alloy steel, Bhn 200-250)
- All run-rates listed above are based on 100% efficiency

**Unknowns/Variables:**

- Exact grouping of DeHoff cell
- Exact grouping of turn/chamber cell
- How much hand deburring will be needed at barrel chamber (machine deburring tool included in chamber run-rate)
- How much (if any) polishing will be required after barrel is assembled to receiver
- How much straightening will be required after barrel is assembled to receiver
- Is assembly equipment used by Ilion sufficient to perform task?
- Will induction H.T. leave scale that can't be removed by alkaline wash/pickling?
- Efficiency will be less than 100%
- How much time will eddy current testing be vs magnaflux?
- Exact material to be used for barrel

**As a result of these unknowns, the number used for the budgetary analysis is 150% of the total run-rate given above, or .38664 hr.**

**The difference between budgetary run-rate & 100% efficient run-rate listed above is .1288 hrs, or app. \$2.15**

710 Bolt Head Summary-R3

| No. | Operation                                                | Estimated Run-Rate for Capacity/Constraint Planning(hr./part) | Comments                                                         | Estimated Run-Rate for Cost Planning(hr./part) | Comments                                                    |
|-----|----------------------------------------------------------|---------------------------------------------------------------|------------------------------------------------------------------|------------------------------------------------|-------------------------------------------------------------|
| 1   | CNC Machine Bolt Face Complete                           | 0.01981                                                       | "A" pallet load on CNC Mill                                      | 0.01981                                        | VMC (Okuma Crown-V) with pallet changer & Rotary indexer    |
| 2   | Superabrasive Grind Lugs                                 | 0.01887                                                       | Edgetek                                                          | 0.01887                                        | Edgetek                                                     |
| 3   | CNC Machine Bolt Head Retaining Pin Hole                 | 0.00756                                                       | "B" pallet load on CNC Mill                                      | 0.00756                                        | VMC (Okuma Crown-V) with pallet changer & Rotary indexer    |
| 4   | CNC Machine Cam Cuts, Ejector Retaining Pin Hole, Deburr | 0.01724                                                       | Twin Head Rotary Indexer mounted adjacent to pallets on CNC mill | 0.01724                                        | Twin Head Rotary Indexer mounted adjacent to pallets on VMC |
| 5   | Punch Form Extractor Rotation Notch                      | 0.00638                                                       | a/u Ilion Rate                                                   | 0.00638                                        | a/u Ilion Rate                                              |
| 6   | Vendor Heat Treat & Inspect for Hardness                 | 0.00000                                                       |                                                                  | 0.00000                                        |                                                             |
| 7   | Black Oxide                                              | 0.00133                                                       | Material Handling Time                                           | 0.00133                                        | Material Handling Time                                      |
|     | Totals                                                   | 0.07119                                                       |                                                                  | 0.07119                                        |                                                             |

**General Assumptions:**

- Bolt head blank includes rear firing pin hole, front firing pin hole, & rough C'bore
- Bolt handle run rate not included in the "A" pallet loading; bolt handle run-rate listed on separate sheet
- All calculated run-rates based on std. reference information contained in *Machining Data Handbook, 3rd Edition*, for Material Group 4 (resulfurized medium carbon alloy steel, Bhn 200-250)
- All run-rates listed above are based on 100% efficiency

**Unknowns/Variables:**

- Fixturing difficult due to lack of good datum surfaces; plan to use ejector pin hole for locating most difficult cuts. Fixture loading might be tedious as a result.
- Some cuts are difficult to access & measure; plan to use receiver CMM with rotary head & tip changer to measure difficult cuts
- Number of features included in blank not known; an additional loading and/or different method of cutting cam relief cuts on lugs might be required.
- Run-rates listed above assume single loadings for each part; palletized fixtures could reduce the run-rates to load/unload times if sufficient # of pieces can be fit onto each pallet.
- Efficiency will be less than 100%

**As a result of these unknowns, the number used for the budgetary analysis is 114% of the total run-rate given above, or .0809**

**The difference between budgetary run-rate & 100% efficient run-rate listed above is .0097 hrs. or app. \$0.10**

# 710 Bolt Handle Summary

| No. | Operation                        | Estimated Run-Rate for Capacity/Constraint Planning(hr./part) | Comments                    | Estimated Run-Rate for Cost Planning(hr./part) | Comments                    |
|-----|----------------------------------|---------------------------------------------------------------|-----------------------------|------------------------------------------------|-----------------------------|
| 1   | CNC Machine Bolt Handle Complete | 0.00913                                                       | "A" pallet load on CNC Mill | 0.00913                                        | "A" pallet load on CNC Mill |
| 2   | Tumble                           | 0.00100                                                       | Material Handling Time      | 0.00100                                        | Material Handling Time      |
|     | Totals                           | 0.01013                                                       |                             | 0.01013                                        |                             |

## **General Assumptions:**

- Bolt Handle Blank is investment cast part and comes in already bent
- Bolt head run rate not included in the "A" pallet loading; bolt head run-rate listed on separate sheet
- All calculated run-rates based on std. reference information contained in *Machining Data Handbook, 3rd Edition*, for Material Group 2 (low carbon steel, Bhn 125-175)
- All run-rates listed above are based on 100% efficiency

## **Unknowns/Variables:**

- Fixturing difficult due to lack of good datum surfaces; Mike Keeney looking at alternate design; Fixture loading might be tedious with current design.
- Run-rates listed above assume single loadings for each part; palletized fixtures could reduce the run-rates to load/unload times if sufficient # of pieces can be fit onto each pallet.
- Will parting lines be sufficiently smoothed by tumbling?
- Efficiency will be less than 100%

**As a result of these unknowns, the number used for the budgetary analysis is 118% of the total run-rate given above, or .012**

**The difference between budgetary run-rate & 100% efficient run-rate listed above is .00187 hrs, or app. \$0.02**

| No. | Operation            | Estimated Run-Rate for Capacity/Constraint Planning(hr./part) | Comments                | Estimated Run-Rate for Cost Planning(hr./part) | Comments                                                            |
|-----|----------------------|---------------------------------------------------------------|-------------------------|------------------------------------------------|---------------------------------------------------------------------|
| 1   | CNC Machine Complete | 0.08372                                                       | Actual machine run time | 0.00397                                        | 5 minute bar load time divided by 21 pcs per bar (12 ft. bar stock) |
| 2   | Vibratory Deburr     | 0.00153                                                       | Material Handling Time  | 0.00153                                        | Material Handling Time                                              |
|     | Totals               | 0.08525                                                       |                         | 0.00550                                        |                                                                     |

**General Assumptions:**

- Receiver comes in as 12' tube stock, finish O.D. & undersized I.D.
- Bolt body run rate not included; bolt body run-rate listed on separate sheet
- All calculated run-rates based on std. reference information contained in *Machining Data Handbook, 3rd Edition*, for Material Group 2 (low carbon steel, Bhn 125-175)
- All run-rates listed above are based on 100% efficiency

**Unknowns/Variables:**

- Straightness required of tube stock in order to work in bar feeder - how much will specifying a particular spec increase price?
- Size of remnant piece off each bar (scrap)
- Will vibratory deburring be sufficient to deburr part (a/u 597 vibratory bowl)?
- Will tube stock O.D. have sufficient finish to avoid polishing prior to assembly?
- What will machine up-time be? Machine critical to success of 710.

**No difference between budgetary number & total given above. Run-rate is load/unload time only for both operations.**

710 Bolt Body Run-Rate Summary

| No. | Operation                                 | Estimated Run-Rate for Capacity/Constraint Planning(hr./part) | Comments                     | Estimated Run-Rate for Cost Planning(hr./part) | Comments                                                             |
|-----|-------------------------------------------|---------------------------------------------------------------|------------------------------|------------------------------------------------|----------------------------------------------------------------------|
| 1   | Machine Complete from Bar Stock           | 0.03265                                                       | Machining Time               | 0.00321                                        | 5 minute bar load time divided by 26 pcs. Per bar (12 ft. bar stock) |
| 2   | Wash                                      | 0.00100                                                       | Material Handling Time       | 0.00100                                        | Material Handling Time                                               |
| 3   | Assemble & Braze Bolt Handle to Bolt Body | 0.01160                                                       | a/u Ilion Rate               | 0.01160                                        | a/u Ilion Rate                                                       |
| 4   | Deplate & Wash                            | 0.00100                                                       |                              | 0.00100                                        |                                                                      |
| 5   | Eddy Current Test                         | 0.00641                                                       | a/u Ilion Rate for Magnaflux | 0.00641                                        | a/u Ilion Rate for Magnaflux                                         |
| 6   | Glass Bead Bolt Body                      | 0.00556                                                       | a/u 597 Rate                 | 0.00556                                        | a/u 597 Rate                                                         |
| 7   | Black Oxide                               | 0.00200                                                       | Material Handling Time       | 0.00200                                        | Material Handling Time                                               |
|     | Totals                                    | 0.06021                                                       |                              | 0.03077                                        |                                                                      |

**General Assumptions:**

- Bolt Body comes in as 12' tube stock, finish O.D. & finish I.D.
- All calculated run-rates based on std. reference information contained in *Machining Data Handbook, 3rd Edition*, for Material Group 2 (low carbon steel, Bhn 125-175)
- All run-rates listed above are based on 100% efficiency

**Unknowns/Variables:**

- Straightness required of tube stock in order to work in bar feeder - how much will specifying a particular spec increase price?
- Size of remnant piece off each bar (scrap)
- Will tube stock O.D. have sufficient finish to avoid polishing?
- What will machine up-time be? Machine critical to success of 710
- Will concentricity between O.D. & I.D. actually be .01 or less?
- Will it be necessary to eddy current test bolt body after braze?

**No difference between budgetary number & total given above. Run-rate is load/unload time only for both operations.**

# In-House Manufacturing Summaries

| Component   | Constraint Operation  | Constraint Machine    | Constraint Run Rate per Operation | Constraint Run Rate per Machine | Capacity @ 80% Efficiency | % of Total Time needed to run each part | % of Capacity to Make 20,000 guns per Year | % of Capacity to Make 40,000 guns per Year | % of Capacity to Make 60,000 guns per Year |
|-------------|-----------------------|-----------------------|-----------------------------------|---------------------------------|---------------------------|-----------------------------------------|--------------------------------------------|--------------------------------------------|--------------------------------------------|
| Barrel      | Stress Relieve        | Furnace               | 0.07317                           | 0.07317                         | 55,107                    | 100%                                    | 36%                                        | 73%                                        | 109%                                       |
| Receiver    | Machine Complete      | LT-15 Turning Center  | 0.08372                           | 0.11637                         | 34,648                    | 72%                                     | 58%                                        | 115%                                       | 173%                                       |
| Bolt Body   | Machine Complete      | LT-15 Turning Center  | 0.03265                           | 0.11637                         | 34,648                    | 28%                                     | 58%                                        | 115%                                       | 173%                                       |
| Bolt Head   | Machine Face          | VMC w/ Pallet Changer | 0.01981                           | 0.05552                         | 72,628                    | 36%                                     | 28%                                        | 55%                                        | 83%                                        |
| Bolt Handle | Machine Complete      | VMC w/ Pallet Changer | 0.01090                           | 0.05552                         | 72,628                    | 20%                                     | 28%                                        | 55%                                        | 83%                                        |
| Bolt Head   | Machine .250 Hole     | VMC w/ Pallet Changer | 0.00756                           | 0.05552                         | 72,628                    | 14%                                     | 28%                                        | 55%                                        | 83%                                        |
| Bolt Head   | Machine Cam Cuts, etc | VMC w/ Pallet Changer | 0.01724                           | 0.05552                         | 72,628                    | 31%                                     | 28%                                        | 55%                                        | 83%                                        |

## **Assumes:**

- 1 Turning Center to turn both receiver blanks and bolt body blanks
2. VMC runs both parts on a single pallet; total run rate is sum of the Bolt Head & Bolt Handle
3. Equal numbers of bolt heads & bolt handles are machined at same time
4. Capacity Constraints based on the following:  
 \* 80% of theoretical machine run rate (parts per hour) X 21 hr/day X 240 days per year

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Constraint Summary

BARBER - 5.22.06r0010562

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Confidential - Subpoena - 5.22.06r0010562 - Order

Williams v. Remington

710 Receiver Run-Rate Summary

| No. | Operation                    | Estimated Run-Rate<br>(min./part) |  | Estimated Run-Rate<br>(hr./part) | Comments |
|-----|------------------------------|-----------------------------------|--|----------------------------------|----------|
| 1   | Inspect Purchased Part Blank | 0.25                              |  | 0.00417                          |          |
| 2   | CNC Machine Complete         | 2.77                              |  | 0.04624                          |          |
|     | Totals                       | 3.02                              |  | 0.05041                          |          |

Assumptions:

Purchase Part Blank consists of:

- \* 1.046 I.D.
- \* 1.227 C'Bore
- \* .320 Datum C Fire Control Slot
- \* Bolt Handle Cam / Clearance Cut
- \* Top Tang Cut
- \* Bolt Stop Face, Drill Point, and .279 Hole

All Other Machining done in-house

[illegible][illegible]

## Capital

|             |          |
|-------------|----------|
| Part Name   | Receiver |
| Part Number | 300340   |

|                  |                  |
|------------------|------------------|
| Operation Name   | Machine Complete |
| Operation Number |                  |

## Capital Required

| Machine or Fixture                                     | Dollars       |  | Expected Delivery |
|--------------------------------------------------------|---------------|--|-------------------|
| Okuma LT-15 MY Twin Spindle/Twin Turret Turning Center | \$ 389,200.00 |  | 12 wks ARO        |
| Manual Touch Setter for LT-15MY                        | \$ 22,203.00  |  |                   |
| LNS THB 42-LC Bar Feeder (Single Bar)                  | \$ 16,570.00  |  |                   |
| Okuma Part Catcher for RH Turret                       | \$ 11,385.00  |  |                   |
| Side Chip Conveyor                                     | \$ 10,530.00  |  |                   |
| Barfeeder Modification                                 | \$ 2,673.00   |  |                   |
| Barfeeder Interface                                    | \$ 2,420.00   |  |                   |
| Extra Memory (2100-ft.)                                | \$ 3,710.00   |  |                   |
| Signal Tower                                           | \$ 1,400.00   |  |                   |
| Tool Life Management                                   | \$ 1,740.00   |  |                   |
| G&L Discovery CMM                                      | \$ 52,000.00  |  |                   |
|                                                        |               |  |                   |
|                                                        |               |  |                   |
|                                                        |               |  |                   |
|                                                        |               |  |                   |
|                                                        |               |  |                   |
| TOTAL CAPITAL                                          | \$ 513,831.00 |  |                   |

8/27/99

Receiver Machine Complete Operation Detail

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MF0615

M/710 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              | \$4.92   |             |          | 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       | \$10,100         |          |             | 0.0277   | 0.111          | 5,161           | Feb-00 |
|           | Face&Chamber               | gages       | \$33,300         |          |             | 0.0000   | 0.000          | 0               | Apr-00 |
|           | Face&Chamber               | machine     | \$222,880        |          |             | 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          | 3,200           | 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 |
|           | Roll mark                  | fix & gages | \$6,300          |          |             |          |                |                 |        |
|           | Angularity Straighten      | fix & gages | \$3,500          |          |             |          |                |                 |        |
|           | Centerless Polish          | 0           | \$0              |          |             |          | 0.186          | 400             |        |
|           | Glass Bead Blast           | fixtures    | \$2,500          |          |             |          |                | 2,500           |        |
|           | Color                      | racks       | \$6,000          |          |             |          | 0.060          | 2,000           | Apr-00 |
|           | TOTAL                      |             | 586,840.000      | 4.920    | 0.000       | 0.119    | 5.152          |                 |        |

|           |                                                  |            |             |       |        |        |       |       |        |
|-----------|--------------------------------------------------|------------|-------------|-------|--------|--------|-------|-------|--------|
| Bolt Head | Inspect Purchased Part Blank                     | gage       | \$2,500     |       |        |        |       | 800   | Feb-00 |
|           | Superabrasive Grind Lugs                         | fix & gage | \$43,800    |       |        | 0.0189 | 0.394 | 3,315 | Feb-00 |
|           | CNC Machine Bolt Face Complete                   | fix & gage | \$174,784   |       |        | 0.0198 | 0.268 | 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   |        |
|           | Total                                            |            | 261,084.000 | 0.000 | 0.150  | 0.071  | 0.973 |       |        |

|                  |                        |         |                  |            |               |            |                 |        |
|------------------|------------------------|---------|------------------|------------|---------------|------------|-----------------|--------|
| <b>Bolt Body</b> | Inspect Purchased Part | gage    | \$2,000          | \$0.74     |               |            |                 | Jan-00 |
|                  | Blank                  | machine | \$0              |            | 0.0360        | 0.199      | 6,761           | Feb-00 |
|                  | Machine Cam Cuts       | machine | \$90,000         |            | 0.0083        | 0.050      | 15,000          | Mar-00 |
|                  | Assemble Braze Bolt    | tanks   | \$9,500          |            | 0.0010        | 0.000      | 0               | Jan-00 |
|                  | Deplate                |         | \$0              |            | 0.0083        | 0.000      | 0               |        |
|                  | Eddy Current Test      | fix     | \$2,500          |            |               |            |                 | Jan-00 |
|                  | Glass Bead Blast       |         | \$0              |            | 0.0013        | 0.000      | 0               |        |
|                  | Black Oxide            |         |                  |            |               |            |                 |        |
|                  | <b>Total</b>           |         | <b>\$104,000</b> | <b>\$1</b> | <b>0.0549</b> | <b>\$0</b> | <b>\$21,761</b> |        |

|                 |                         |      |                  |            |               |            |                 |        |
|-----------------|-------------------------|------|------------------|------------|---------------|------------|-----------------|--------|
| <b>Receiver</b> | Inspect Purchased Part  | gage | \$2,500          | \$1.76     |               |            |                 | Jan-00 |
|                 | Blank                   |      |                  |            |               |            |                 |        |
|                 | Machine A&B load        |      | \$513,831        |            | 0.0083        | 0.941      | 12,480          | Feb-00 |
|                 |                         |      |                  |            |               |            |                 | Feb-00 |
|                 | Vibratory tumble deburr |      | \$0              |            | 0.0083        |            |                 |        |
|                 | <b>Total</b>            |      | <b>\$516,331</b> | <b>\$2</b> | <b>0.0133</b> | <b>\$1</b> | <b>\$12,480</b> |        |

|                        |                          |         |                |            |               |            |                |        |
|------------------------|--------------------------|---------|----------------|------------|---------------|------------|----------------|--------|
| <b>Barrel Assembly</b> | Press Receiver to Barrel | fixture | \$0            |            | 0.0273        | 0.150      | 750            | Dec-99 |
|                        | Inspect for straightness | gage    | \$3,500        |            | 0.0120        | 0.005      | 700            | Dec-99 |
|                        | <b>Total</b>             |         | <b>\$3,500</b> | <b>\$0</b> | <b>0.0393</b> | <b>\$0</b> | <b>\$1,450</b> |        |

llion Equip

|                       |               |                   |                  |            |               |            |                |        |
|-----------------------|---------------|-------------------|------------------|------------|---------------|------------|----------------|--------|
| <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     |                   |                  |            | 0.0000        |            |                |        |
|                       | Bolt Body     |                   |                  |            | 0.0566        |            |                |        |
|                       | Firing Pin    |                   |                  |            | 0.0000        |            |                |        |
|                       | Trigger Plate | comparator \$8000 |                  |            | 0.0355        |            |                |        |
|                       | Gun Build     |                   |                  |            | 0.0355        |            | 4,000          |        |
|                       | Pack          |                   |                  |            | 0.0472        |            |                |        |
|                       | <b>Total</b>  |                   | <b>\$330,000</b> | <b>\$0</b> | <b>0.1748</b> | <b>\$0</b> | <b>\$4,000</b> |        |

HYD PRESS 2500  
Heading Plugs

TOTALS Mayfield

\$1,801,755

\$7

\$0

0.4716

\$7.47

\$39,691

## Purchased Parts

| Part # | Part Name          | Tool            | Capital     | Material | Ext<br>Process | Run Time | Variable Tools | Pre-op Start Up | Vendor          | Payments |        |        |
|--------|--------------------|-----------------|-------------|----------|----------------|----------|----------------|-----------------|-----------------|----------|--------|--------|
| 300327 | Receiver Insert    | Mold            | 48,000      | \$0.62   |                |          |                |                 | Hanson          | Jun-99   |        |        |
| 300333 | Side Plate         | Stamping Di     | 10,000      | \$0.09   |                | 0 0010   |                |                 |                 | Dec-99   | Mar-00 | Apr-00 |
| 300334 | Safety Arm         | Stamping Di     | 23,880      | \$0.31   | \$0.03         | 0 0010   |                | 2,000           | NH Stamping     | Dec-99   | Mar-00 | Apr-00 |
| 300345 | Bolt Stop          | PM              | 6,820       | \$0.19   | \$0.03         | 0 0010   |                |                 | Sterling        | Dec-99   | Mar-00 | Apr-00 |
| 300361 | Recoil Bracket     | Stamping Di     | 550         | \$0.19   |                | 0 0010   |                |                 | square stamping | Dec-99   | Mar-00 | Apr-00 |
| 300360 | Bolt Handle Blank  | Invest Cast Die | 12,800      | \$1.63   |                | 0 0083   |                | 250             | Fansteel        | Dec-99   | Mar-00 | Apr-00 |
| 300366 | Bolt H. Braze Shim | Use Paste       | 0           | \$0.00   |                | 0 0000   |                | 300             | Lucas Milhaupt  | Dec-99   | Mar-00 | Apr-00 |
| 300368 | Bolt Plug          | Mold            | 38,088      | \$0.25   |                | 0 0000   |                |                 | Par 4           | Dec-99   | Mar-00 | Apr-00 |
| 300336 | Firing pin head    | MIM Mold        | 23,000      | \$1.45   | \$0.05         | 0 0010   |                | 1,000           | Megamet         | Dec-99   | Mar-00 | Apr-00 |
| 300362 | Mag Latch          | Mold            | 33,480      | \$0.25   |                | 0 0000   |                |                 | Par 4           | Dec-99   | Mar-00 | Apr-00 |
|        | Mag Box Assy       | 0               | 0           |          |                | 0 0055   |                |                 |                 |          |        |        |
| 300363 | Magazine Box       | Mold            | 28,000      | \$2.79   |                | 0 0000   |                | 3,000           | Morrissey       | Dec-99   | Mar-00 | Apr-00 |
| 300364 | Magazine Follower  | Mold            | 33,300      | \$0.26   |                | 0 0000   |                | 300             | Par 4           | Dec-99   | Mar-00 | Apr-00 |
| 300365 | Magazine Bottom    | Mold            | 47,880      | \$0.26   |                | 0 0000   |                | 300             | Par 4           | Dec-99   | Mar-00 | Apr-00 |
|        | Stock              | Mold            | 150,300     | \$5.38   |                | 0 0000   |                | 600             | Par 4           | Dec-99   | Mar-00 | Apr-00 |
|        | Styrofoam Bed      | Die             | 0           |          |                | 0 0000   |                |                 | Tuscorora       |          | Mar-00 |        |
|        |                    |                 | \$456,098   |          |                |          |                |                 |                 |          |        |        |
|        | Bolt body material |                 |             |          |                |          |                | 12,400          |                 |          |        |        |
|        | Receiver Material  |                 |             |          |                |          |                | 29,400          |                 |          |        |        |
|        | set-up charges     |                 |             |          |                |          |                | 3,515           |                 |          |        |        |
|        | Total              |                 | \$2,257,853 | \$35.93  | \$0.26         | 1.4336   | \$22.41        | \$216,586.00    |                 |          |        |        |
| 300366 | Obsolete           |                 |             |          |                |          |                |                 |                 |          |        |        |

## Possible Capital Additions

18900 Styrofoam bed die  
8000 Comparator  
10000 Mag box Delta  
side plate delta if  
12000 fine blanked

### Three sided Carts for 710 barrels after cutoff (4 carts)

| <u>Material</u>                                      | <u>Quantity</u> | <u>Cost</u> | <u>Total</u> |
|------------------------------------------------------|-----------------|-------------|--------------|
| Swivel Castors 4"                                    | 8               | \$ 11.49    | \$ 91.92     |
| Rigid Castors 4"                                     | 8               | \$ 9.86     | \$ 78.88     |
| 2" x 3/16" Angle Iron (90 ft needed) sold in 20 ft   | 7               | \$ 14.00    | \$ 98.00     |
| 1 1/2" x 3/16" Flat Steel(15 ft needed) sold in 20ft | 1               | \$ 7.65     | \$ 7.65      |
| Paint                                                | 40              | \$ 0.99     | \$ 39.60     |
| Labor (cost per hour)                                | 15              | \$ 50.00    | \$ 750.00    |
| Total sent out                                       |                 |             | \$ 1,066.05  |
| Total in house                                       |                 |             | \$ 316.05    |

Castors -Grainger- p.2134 Stk# 1G197 & 1G200  
 Steel quoted by Joey at Barclay Metal  
 Labor estimated at \$50.00 for outside vendor

MAKE SMALL LOT CARTS FOR  
 RABBIT SEND DOWN RACKS

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ME0619

## Heat Treat Baskets

| <u>Vendor</u>                      | <u>Material</u>  | <u>Quantity</u> | <u>Cost</u> | <u>Total</u> |
|------------------------------------|------------------|-----------------|-------------|--------------|
| Barry Irvan<br>(270)345-2730       | Inkonel          | 2               | \$ 4,000.00 | \$ 8,000.00  |
| Universal Machine<br>(270)856-3790 | Inkonel          | 2               | \$ 3,885.00 | \$ 7,770.00  |
|                                    | 316 SS           | 2               | \$ 2,368.00 | \$ 4,736.00  |
| Lohn & Associates<br>(440)729-7390 | 316 SS<br>330 SS | 2               | \$ 2,354.00 | \$ 4,708.00  |

ME0620

## Coloring Racks

Price quoted by ARC. (815)754-6660 Brahm Greve

| <u>Material</u>                                           | <u>Quantity</u> | <u>Price</u> | <u>Total</u> |
|-----------------------------------------------------------|-----------------|--------------|--------------|
| Racks to carry 50 barrels for passivation and black oxide | 1/2             | \$ 2,487.00  | \$ 4,974.00  |
|                                                           | 3/5             | \$ 1,865.00  |              |
|                                                           | 6/9             | \$ 1,492.00  |              |
| Racks to carry 100 bolts and 100 bolt heads               | 1/2             | \$ 2,380.00  | \$ 4,760.00  |
|                                                           | 3/5             | \$ 1,785.00  |              |
|                                                           | 6/9             | \$ 1,428.00  |              |

Price for 2 racks for barrels and 2 racks for bolt and bolt heads

**TOTAL \$ 9,734.00**

MF0621

# **Bead Blaster**

Barrel Bottom

Manuf. McMaster-Carr

## Material

1 1/2" Delrin Rod

Each Rod has a 5feet max.

Quoted by Universal Machine

| <u>Stock #</u> | <u>Pg. #</u> | <u>Quantity</u> | <u>Cost</u> | <u>Total</u> |
|----------------|--------------|-----------------|-------------|--------------|
| 8572K25        | 2882         | 2               | \$ 7.98     | \$ 15.96     |
|                |              | <b>Total</b>    | <b>\$</b>   | <b>15.96</b> |
|                |              | 24              | \$ 21.00    | \$ 504.00    |

## Tables

| <u>Material Description</u>                        | <u>Page #</u> | <u>Stock #</u> | <u>Quantity</u> | <u>Cost</u>  | <u>Total</u>       |
|----------------------------------------------------|---------------|----------------|-----------------|--------------|--------------------|
| 2" Square Tubing 3/16" wall                        |               |                | 340             | \$ 3.12      | \$ 1,060.80        |
| 4" Flat Steel 1/4" thick                           |               |                | 26              | \$ 32.06     | \$ 833.56          |
| 48" x 24" Plastic Laminated Top                    | 1148          | 5169T51        | 8               | \$ 72.98     | \$ 583.84          |
| 60" x 36" Laminated Hard Maple Top                 | 1148          | 4882T16        | 4               | \$ 182.53    | \$ 730.12          |
| 24" x 36" 1/4" Steel Plate Top                     |               |                | 1               | \$ 25.00     | \$ 25.00           |
| All Priced by McMaster-Carr except Steel Plate Top |               |                |                 | <b>Total</b> | <b>\$ 3,233.32</b> |

|                                                                |      |         |     |              |                    |
|----------------------------------------------------------------|------|---------|-----|--------------|--------------------|
| 2" Square Tubing 3/16" wall                                    |      |         | 340 | \$ 1.80      | \$ 612.00          |
| 4" Flat Steel 1/4" thick                                       |      |         | 26  | \$ 0.95      | \$ 24.70           |
| 48" x 24" Plastic Laminated Top                                | 1148 | 5169T51 | 8   | \$ 72.98     | \$ 583.84          |
| 60" x 36" Laminated Hard Maple Top                             | 1148 | 4882T16 | 4   | \$ 182.53    | \$ 730.12          |
| 24" x 36" 1/4" Steel Plate Top                                 |      |         | 1   | \$ 25.00     | \$ 25.00           |
| Metal Priced By Barclay Metal and Tops Priced by McMaster-Carr |      |         |     | <b>Total</b> | <b>\$ 1,975.66</b> |

|                                |      |         |    |              |                     |
|--------------------------------|------|---------|----|--------------|---------------------|
| Workbenches from McMaster-Carr | 1142 | 9961T34 | 16 | \$ 626.13    | \$ 10,018.08        |
|                                |      |         |    | <b>Total</b> | <b>\$ 10,018.08</b> |

## Bolt Holders

| <u>Material</u>                       | <u>Quantity</u> | <u>Cost</u>           | <u>Total</u>     |
|---------------------------------------|-----------------|-----------------------|------------------|
| 1" x 4" lumber (sold in 10ft. Sticks) | 11              | \$ 3.00               | \$ 33.00         |
| 1/4" plywood (sold in 4'x8' Sheets)   | 1               | \$ 13.00              | \$ 13.00         |
| Wood glue                             | 1               | \$ 5.00               | \$ 5.00          |
| Outside Vendor (per hour)             | 10              | \$ 50.00              | \$ 500.00        |
|                                       |                 | <b>Total sent out</b> | <b>\$ 551.00</b> |
|                                       |                 | <b>Total in-house</b> | <b>\$ 51.00</b>  |

All lumber quoted by Myers Lumber, 247-6800

ME0624

## Plastic totes

| <u>Material</u>      | <u>Size</u>            | <u>Stock #</u> | <u>Quantity</u> | <u>Cost</u> | <u>Total</u>    |
|----------------------|------------------------|----------------|-----------------|-------------|-----------------|
| Small Tall Totes     | 9 3/16"x6 9/16"x5 1/2" | TB91060        | 24              | \$ 8.60     | \$ 206.40       |
| Small Dividers Long  |                        | DL91060        | 96              | \$ 1.30     | \$ 124.80       |
| Small Dividers Short |                        | DS91060        | 96              | \$ 1.20     | \$ 115.20       |
| Small Tote Tops      |                        | CO91060        | 96              | \$ 3.70     | \$ 355.20       |
| Large Totes          | 20 5/8"x15 5/8"x7 1/2" | TB93080        | 4               | \$ 24.30    | \$ 97.20        |
| Large Dividers Long  |                        | DL93080        | 96              | \$ 3.00     | \$ 288.00       |
| Large Dividers Short |                        | DS93080        | 96              | \$ 2.40     | \$ 230.40       |
| <b>Total</b>         |                        |                |                 | <b>\$</b>   | <b>1,417.20</b> |

Small totes will be used for sending Bolt Heads out to vendor for Heat Treat.  
 Large totes will be used for storing receivers after being machined.

# Summary

| <u>Description</u> |           | <u>High Price</u> |              | <u>Low Price</u>    |
|--------------------|-----------|-------------------|--------------|---------------------|
| Carts for cutoff   | \$        | 1,066.05          | \$           | 316.05              |
| Heat Treat Baskets | \$        | 8,000.00          | \$           | 4,708.08            |
| Coloring Racks     | \$        | 9,734.00          | \$           | 9,734.00            |
| Bead Blaster       | \$        | 504.00            | \$           | 15.96               |
| Work Benches       | \$        | 10,048.08         | \$           | 1,975.66            |
| Plastic Totes      | \$        | 1,417.20          | \$           | 1,417.20            |
| Bolt Holders       | \$        | 551.00            | \$           | 51.00               |
| <b>Total</b>       | <b>\$</b> | <b>31,290.33</b>  | <b>Total</b> | <b>\$ 18,217.95</b> |

*TOTAL IS INCREMENTAL*

*↳ ENOUGH BOLT HSS TO ONE BATCH*

*↳ PERMIT BUY ~~TOTES~~, TOTES*

Remington Arms Co.  
Mayfield KY  
By: S. Truax

100 Meter Range

100 Meter Range Project-Mayfield 1999

BARBER - 5.22.06-0010577

|          |  |         | Capital           |                               |
|----------|--|---------|-------------------|-------------------------------|
| Mayfield |  | E'Town  |                   |                               |
| 265,000  |  |         | Jays Construction | Range Construction Estimate   |
|          |  | 445,714 | Osborne           | Range Construction Estimate   |
| 6,000    |  |         |                   | Excavation needed for range   |
| 1,000    |  | 464     |                   | Soil Test                     |
| 15,000   |  | 13,143  | Donaldson Co inc. | Torrit Filter & Installation  |
| 16,000   |  | 28,000  |                   | HAVC                          |
| 8,000    |  | 12,000  |                   | Electric                      |
| 1,500    |  | 6,500   |                   | Plumbing                      |
| 2,000    |  | 1,521   |                   | Security System               |
| 3,000    |  | 2,600   |                   | Electronic Locking System     |
| 28,600   |  | 30,210  | Savage Range Sys  | Bullet Traps for Proof & Test |
| 10,000   |  |         | Ilion (Bob Joy)   | Proof Jack (New Design 9/30 ) |
| 6,000    |  |         |                   | Conveyor for lead disposal    |
|          |  | 26,642  |                   | Other E'Town Expenses         |
| 362,100  |  | 566,794 | Total             |                               |

|       |       |  | Mayfield Cost |                           |
|-------|-------|--|---------------|---------------------------|
| 1,000 |       |  |               | Storage Racks             |
| 2,000 |       |  |               | Shooting Benches          |
| 1,500 |       |  |               | Work Benches              |
| 1,000 |       |  |               | Hand Tools, Totes, & Misc |
| 2,000 |       |  |               | Target Roll Holders (2)   |
| 7,500 | Total |  |               |                           |

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MF0627

Confidential - Subject - 5.22.06-0010577 Order

Williams V. Remington

## COST PER MONTH AT \$.065 PER KWH

| MACHINE             | KWH                                    | COST AT FULL LOAD | KWH            | COST AT NORMAL LOAD |
|---------------------|----------------------------------------|-------------------|----------------|---------------------|
|                     | AT FULL LOAD                           | AT \$.065 PER KWH | AT NORMAL LOAD | AT \$.065 PER KWH   |
| OKUMA LT15MY        | 14691.6                                | \$954.95          | 4848.23        | \$315.13            |
| OKUMA LB300MY       | 9180                                   | \$596.70          | 3029.4         | \$196.91            |
| G&L CORDAX CMM D-8  | 734.4                                  | \$47.74           | 242.35         | \$15.75             |
| OKUMA 4018          | 7623.07                                | \$495.50          | 2515.61        | \$163.51            |
| OKUMA 4018          | 7623.07                                | \$495.50          | 2515.61        | \$163.51            |
| HEAT TREAT          | 10164.09                               | \$660.67          | 3354.15        | \$218.02            |
| INDUCTION UNIT      | 8968.32                                | \$582.94          | 2959.54        | \$192.37            |
| CHILLER             | 2541.02                                | \$165.17          | 838.54         | \$54.51             |
| CHILLER             | 2541.02                                | \$165.17          | 838.54         | \$54.51             |
| EDDY CURRENT TESTER | INFORMATION NOT AVAILABLE AT THIS TIME |                   |                |                     |
| TOTALS              | 64066.39                               | \$4,164.34        | 21141.97       | \$1,374.22          |

## SUMMARY OF ADDED ELECTRIC USE FOR 710 PROJECT

AVERAGE OF EXISTING KW USAGES 248400KW

ESTIMATED INCREASED USAGE PER MONTH 21142 KW

THIS YIELDS AN INCREASE OF APPROXIMATELY 8.5% MORE POWER THAN IS CURRENTLY BEING USED

ME0629

Confidential - ~~Sub~~ Barber - 5.22.06r0010579

Order

Williams v. Remington

## POWER CONSUMPTION

|                                   | KILO-VOLT AMPS | AMPS |
|-----------------------------------|----------------|------|
| TOTAL POWER AVAILABLE             | 2500           | 3000 |
|                                   |                |      |
| AVERAGE POWER CONSUMPTION TO DATE | 764            | 919  |
|                                   |                |      |
| TOTAL REMAINING POWER             | 1736           | 2081 |

| 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 | COMMENTS/ASSUMPTIONS                                       |
| Lock Detent                 |        | \$ 0.08        |                      |              |               |                |                  |                |                                                            |
| Lock Spring                 |        | \$ 0.01        |                      |              |               |                |                  |                |                                                            |
| Lock Key and Cap            |        | \$0.69         |                      |              |               |                |                  |                |                                                            |
| Firing Pin                  | 300334 | \$ 0.27        | 0.0010               | o            |               |                |                  |                |                                                            |
| Firing Pin Tip              | 300335 | \$ 1.50        | 0.0015               |              | \$ 0.10       |                |                  |                |                                                            |
| Firing Pin Head             | 300336 | \$ 1.45        | 0.0020               | o            | \$ 0.05       |                |                  |                | Parmatech MIM part                                         |
| Firing Pin Spring           | 300399 | \$ 0.14        |                      |              |               |                |                  |                | Ilion 700 cost                                             |
| Front Sight                 | 94084  | \$ 0.82        |                      | o            |               |                |                  |                | Higher due to Ilion part, not outsourced                   |
| Front Sight Ramp            | 94657  | \$ 1.13        | 0.0020               | o            |               |                |                  |                | Ilion 700 cost                                             |
| Front Sight Ramp Screws (2) | 28505  | \$ 0.09        |                      | o            |               |                |                  |                | m597                                                       |
| Rear Sight Assembly         | 103146 |                |                      | n/a          |               |                |                  |                | level for drawings only                                    |
| Elevation Screw             | 90906  | \$ 0.02        |                      |              |               |                |                  |                | m597                                                       |
| Rear Sight Aperture         | 94333  | \$ 0.14        | 0.0010               | o            |               |                |                  |                | m597                                                       |
| Rear Sight Base             | 103531 | \$ 0.97        | 0.0010               | o            |               |                |                  |                | m597                                                       |
| Rear Sight Slide            | 94335  | \$ 0.47        | 0.0050               | o            |               |                |                  |                | m597                                                       |
| 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            |               |                |                  |                |                                                            |

| 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 | COMMENTS/ASSUMPTIONS                      |
| Sling Swivel Stud (2) | 300096 | \$ 0.14         |                      |              |                |                |                  |                | M/597 Price                               |
| Takedown Screw (2)    | ????   | \$ 0.16         |                      |              |                |                |                  |                |                                           |
| Rear Takedown Screw   | ????   | \$ 0.08         |                      |              |                |                |                  |                |                                           |
| Magazine Assembly     | 305395 |                 | 0.0083               |              |                |                |                  |                | 30 sec to assemble in house               |
| Magazine Box          | 300363 | \$ 2.79         | 0.0040               |              |                |                |                  |                | Ilion quote;no quotes to date m700 \$2.02 |
| Magazine Follower     | 300364 | \$ 0.26         |                      |              |                |                |                  |                | PAR 4                                     |
| Magazine Bottom       | 300365 | \$ 0.26         |                      |              |                |                |                  |                | PAR 4                                     |
| Magazine Spring       | 300405 | \$ 0.42         |                      |              |                |                |                  |                | M/700 spring price;no quotes              |
| Gallery;inspect;pack  |        | 1.15            | 0.1500               |              |                |                |                  |                | Estimate of 6 min + 50%,.25 for ammo      |
| <b>Total Cost</b>     |        | <b>\$ 41.43</b> | <b>0.9186</b>        |              | <b>\$ 0.30</b> |                |                  |                |                                           |
|                       |        |                 |                      |              |                |                |                  |                |                                           |
|                       |        |                 |                      |              |                |                |                  |                |                                           |
|                       |        |                 | 51.7505              |              |                |                |                  |                |                                           |
|                       |        |                 | <b>\$ 0.30</b>       |              |                |                |                  |                |                                           |
|                       |        |                 | 41.4313              |              |                |                |                  |                |                                           |
|                       |        |                 | 93.4818              |              |                |                |                  |                |                                           |

| M/700 Costs - 8/27/99             |        |             |                   |           |            |             |               |             | COMMENTS/ASSUMPTIONS                                       |
|-----------------------------------|--------|-------------|-------------------|-----------|------------|-------------|---------------|-------------|------------------------------------------------------------|
| PART DESCRIPTION                  | Part # | Material \$ | Run Rate (hrs/pc) | Labor a/o | endor H \$ | Var O.H. \$ | Total O.H. \$ | Piece Price |                                                            |
|                                   |        |             |                   |           |            |             |               |             |                                                            |
| Document Envelope Assembly        | 1748   | \$ 0.09     |                   |           |            |             |               |             | M/597 document envelope 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     |                   |           |            |             |               |             |                                                            |
| Document Envelope Assembly total  |        |             |                   |           |            |             |               |             |                                                            |
| 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/710 Capital

## In House Capital

| Part Name | Operation                  | Equipment   | Capital Required |        |
|-----------|----------------------------|-------------|------------------|--------|
|           |                            |             |                  |        |
| Barrel    | Cut off                    |             | \$0              |        |
|           | 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 Grinding Lugs                      | 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      |        |

| 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 |
| Trigger                  | 15280  | \$ 1.53     |                   |           |            |             |               |             |
| Trigger Connector        | 19461  | \$ 1.03     |                   |           |            |             |               |             |
| Trigger Screw Front      | 17053  | \$ 0.10     |                   |           |            |             |               |             |
| Trigger Engagement Screw | 91128  | \$ 0.03     |                   |           |            |             |               |             |
| Trigger Spring           | 15400  | \$ 0.03     |                   |           |            |             |               |             |
| Trigger Stop Screw       | 15481  | \$ 0.06     |                   |           |            |             |               |             |
| Safety                   | 300408 | \$ 0.31     |                   |           |            |             |               |             |
| Safety Pivot Pin         | 300352 | \$ 0.06     |                   |           |            |             |               |             |
| Safety Spring            | 300407 | \$ 0.05     |                   |           |            |             |               |             |
| Bolt Stop                | 300345 | \$ 0.19     | 0.0010            |           |            |             |               |             |
| Receiver Plug Screws (4) | 17034  | \$ 0.12     |                   |           |            |             |               |             |
| Recoil Bracket           | 300361 | \$ 0.19     | 0.0010            |           |            |             |               |             |
| Bolt Body Assembly       | 300403 |             | 0.0275            |           |            |             |               |             |
| Bolt Body                | 300339 | \$ 0.74     | 0.0032            |           |            |             |               |             |
| Bolt Handle              | 300370 |             | 0.0120            |           |            |             |               |             |
| Bolt Handle Blank        | 300360 | \$ 1.63     |                   |           |            |             |               |             |
| Bolt Handle Pin          | 300329 | \$ 0.06     |                   |           |            |             |               |             |
| Bolt Head Assembly       | 305390 |             | 0.0580            |           |            |             |               |             |
| Bolt Head                | 300338 | \$ 1.60     | 0.0809            |           |            |             |               |             |
| Extractor                | 93712  | \$ 0.77     |                   |           |            |             |               |             |
| Ejector                  | 300342 | \$ 0.16     | 0.0010            |           |            |             |               |             |
| Ejector Spring           | 300367 | \$ 0.03     |                   |           |            |             |               |             |
| Ejector Pin              | 94555  | \$ 0.01     |                   |           |            |             |               |             |
| Bolt Assembly Pin        | 300330 | \$ 0.10     | 0.0010            |           |            |             |               |             |
| Firing Pin Assembly      | 300404 |             | 0.0070            |           |            |             |               |             |
| Bolt Plug                | 300368 | \$ 0.25     |                   |           |            |             |               |             |
| Bolt Plug Insert         | 300346 | \$ 0.29     |                   |           |            |             |               |             |
| Lock Tumbler             |        |             | 0.0050            |           |            |             |               |             |

Ilion 700, quoting issues

Ilion 700

Ilion 700

Ilion 700

Ilion 700

Ilion 700

May increase with additional bend \$0.07

new part

Assume outside PMPd base on a similar size parts quoted for the m99 and 597.

M597

Square Stamping

Ilion run times due to experience. High -not grouped.

5 min bar change

load unload time at machining

Investment cast using the m597 bolt @\$1.80 and bolt handle at \$.80 as a guide.

150% would be .0875

Assumed Ilion quoted blank cost. Run time assumes full cut time could drop to .034 depending on machine

597 \$0.02

Second loading raises price from a normal pin.

Added , not in estimates

Par 4

Higher \$ risk, unquoted part

## New Parts

| Part # | Part Name             | Material \$ | ilion<br>Quotes or<br>Estimates |
|--------|-----------------------|-------------|---------------------------------|
| 300327 | Receiver Insert       | 0.62        |                                 |
| 300333 | Side Plate            |             | 0 09                            |
| 300334 | Safety Am             | 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 | Finng 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 18        |                                 |
| 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 02                            |
| 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        |                                 |
|        | Carton Assy (Ilion)   | 2 05        |                                 |

|                                        |        |
|----------------------------------------|--------|
| Total Material \$ New<br>known to date | 22 628 |
| % of Total anticipated                 | 53.73% |

|                                                         |        |
|---------------------------------------------------------|--------|
| Total Material \$<br>Estimated or from<br>M/700 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% |
|-------------------------------------------|--------|

## 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               | Gnp Cap                 | 0.18        |                            |
| 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 31.86% % of total

= major concerns

MF0636

MATT

## PURCHASED PARTS CAPITAL LIST TOP 5

| Part #          | Part Name                | Capital       | Tool | Supplier   |
|-----------------|--------------------------|---------------|------|------------|
|                 | Stock                    | 150,000       | Mold | Par 4      |
| 300364 & 300364 | Bottom / Follower Family | 78,786        | Mold | Par 4      |
| 300327          | Receiver Insert          | 48,000        | Mold | Hanson     |
| 300368          | Bolt Plug                | 36,000        | Mold | Kellum Coe |
| 300362          | Mag Latch                | 33,480        | Mold | Par 4      |
| 300363          | Mag Box                  | Not Available |      | ?          |

## PURCHASED PARTS PIECE PRICE TOP 5

| Part # | Part Name   | Piece Price                    | Supplier         |
|--------|-------------|--------------------------------|------------------|
| 300340 | Receiver    | complete 20.26<br>partial 3.50 | Crosst<br>Kenmar |
|        | Stock       | 5.27                           | Hanson           |
| 300339 | Bolt Body   | 2.35                           | G.S. Precision   |
| 300370 | Bolt Handle | 1.63                           | Fansteel         |
| 103530 | Sight Base  | 1.60                           | Megamet          |

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MF0637

Revised  
08-31-99

# QUOTES ON MODEL 710

## PM PARTS:

| PART NUMBER | DESCRIPTION     | VENDOR                     | RFQ SENT | DUE BACK | QUOTE                                                                   | SET-UP             |
|-------------|-----------------|----------------------------|----------|----------|-------------------------------------------------------------------------|--------------------|
| C-300345    | BOLT STOP       | STERLING SINTERED<br>ILION | 07/19/99 | 08/15/99 | 20M=\$219.20/M; 40M=<br><b>\$190.60/M</b> ; 120M=\$184.60/M<br>\$.57/EA | <b>\$6,820.00</b>  |
| C-91852     | SAFETY BUTTON   | STERLING SINTERED<br>ILION | 07/19/99 | 08/15/99 | 20M=\$108.30/M;<br><b>40M=\$95.80/M</b> ; 120M=\$85.90<br>\$.12/EA      | <b>\$4,700.00</b>  |
| C-15373     | SIGHT           | STERLING S'NTERED<br>ILION | 07/19/99 | 08/15/99 | \$.82/EA                                                                |                    |
| C-15280     | TRIGGER         | STERLING SINTERED<br>ILION | 07/19/99 | 08/15/99 | \$1.53/EA                                                               |                    |
| C-15666     | SEAR SAFETY CAM | STERLING SINTERED<br>ILION | 07/19/99 | 08/15/99 | 20M=\$759.50/M; 40M=<br><b>\$683.45/M</b> ; 120M=\$625.80/M<br>\$.94/EA | <b>\$11,300.00</b> |
| C-93906     | APERTURE        | STERLING SINTERED<br>ILION | 07/19/99 | 08/15/99 | 20M=\$155.65/M; 40M=<br><b>\$124.65/M</b> ; 120M=\$105.90/M<br>\$.33/EA | <b>\$5,210.00</b>  |

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ME0638

Confidential - Subject - 5.22.06 P0010588

Williams V. Remington

| MIM PARTS   |                 |           |          |          |                                                     |                                              |                                                       |
|-------------|-----------------|-----------|----------|----------|-----------------------------------------------------|----------------------------------------------|-------------------------------------------------------|
| PART NUMBER | DESCRIPTION     | VENDOR    | RFQ SENT | DUE BACK | QUOTE                                               | SET-UP                                       | LEAD TIME                                             |
| C-300336    | FIRING PIN HEAD | PARMATECH | 07/19/99 | 08/15/99 | 20M=NO QUOTE;<br>40M=\$2.19/EA; 60M=\$1.91/EA       | \$25,000=TOOLING COST<br>\$4,000=FIXTURES    | MOLD DELIVERY =12-14 WKS;<br>SAMPLES 4-6 WKS LATER    |
|             |                 | MEGAMET   | 07/19/99 | 08/15/99 | 20M=\$1.50/EA;<br>40M=\$1.45/EA; 60M=\$1.35/EA      | \$15,000=MOLD;<br>\$7,500=FURNACE<br>FIXTURE |                                                       |
| C-93907     | REAR SLIDE      | PARMATECH | 07/19/99 | 08/15/99 | 80M=\$1.37/EA;<br>100M=\$1.19/EA;<br>200M=\$1.13/EA | \$38,000=TOOLING COST<br>\$4,000=FIXTURES    | MOLD DELIVERY 12-14 WEEKS;<br>SAMPLES 4-6 WEEKS LATER |
|             |                 | MEGAMET   | 07/19/99 | 08/15/99 | 80M=\$1.20/EA;<br>100M=\$1.15/EA;<br>200M=\$1.10/EA | \$15,000=MOLD;<br>\$2,500=FURNACE<br>FIXTURE |                                                       |
| C-103530    | BASE            | PARMATECH | 07/19/99 | 08/15/99 | 80M=\$1.84/EA;<br>100M=\$1.60/EA;<br>200M=\$1.53/EA | \$29,000=TOOLING COST;<br>\$8,000=FIXTURES   | MOLD DELIVERY 12-14 WEEKS;<br>SAMPLES 4-6 WEEKS LATER |
|             |                 | MEGAMET   | 07/19/99 | 08/15/99 | 80M=\$1.65/EA;<br>100M=\$1.60/EA;<br>200M=\$1.50/EA | \$15,000-MOLD;<br>\$2,500=FURNACE<br>FIXTURE |                                                       |
|             |                 |           |          |          |                                                     |                                              |                                                       |
|             |                 |           |          |          |                                                     |                                              |                                                       |
|             |                 |           |          |          |                                                     |                                              |                                                       |

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ME0639

Confidential - Subject - 5.22.06r0010589 Order

Williams v. Remington

| SCREW MACHINE                   |                                  |                       |          |          |                                                                |                 |           |
|---------------------------------|----------------------------------|-----------------------|----------|----------|----------------------------------------------------------------|-----------------|-----------|
| PART NUMBER                     | DESCRIPTION                      | VENDOR                | RFQ SENT | DUE BACK | QUOTE                                                          | SET-UP          | LEAD TIME |
| C-300334-C300335<br>(ONE-PIECE) | FIRING PIN AND<br>FIRING PIN TIP | ANDERSON SCREW        |          |          | 20M=\$2709.60/M;<br><b>40M=\$2699.70/M;</b><br>60M=\$2697.60/M |                 |           |
|                                 |                                  | AUTOMATIC SWISS       |          |          | NO QUOTE-SIGNIFICANTLY<br>MORE EXPENSIVE                       |                 |           |
| B-300330                        | ASSEMBLY PIN                     | AUTOMATIC SWISS       | 08/19/99 | ASAP     | 20M=\$.15/EA; <b>40M=\$.12/EA;</b><br>60M=\$.10/EA             | <b>\$450.00</b> | 6 WKS.    |
|                                 |                                  | SWISS PRECISION MACH. | 08/19/99 | ASAP     | 20M=\$.226/EA; 40M=<br>\$.184/EA; 60M=\$.177/EA                | \$380.00        | 6-8 WKS.  |
|                                 |                                  | ISELI                 | 08/19/99 | ASAP     | 20M=\$.26/EA; 40M=\$.24/EA;<br>60M=\$.235/EA                   | \$350.00        |           |
| A-300329                        | BOLT HANDLE PIN                  | AUTOMATIC SWISS       | 08/19/99 | ASAP     | 20M=\$.10/EA; <b>40M=\$.08/EA;</b><br>60M=\$.06/EA             | <b>\$450.00</b> | 6 WKS.    |
|                                 |                                  | SWISS PRECISION MACH. | 08/19/99 | ASAP     | 20M=\$.122/EA; 40M=<br>\$.106/EA; 60M=\$.101/EA                | \$150.00        | 6-8 WKS.  |
|                                 |                                  | ISELI                 | 08/19/99 | ASAP     | 20M=\$.13/EA; 40M=\$.12/EA;<br>60M=\$.11/EA                    | \$200.00        |           |
| B-300351                        | PIVOT PIN                        | AUTOMATIC SWISS       | 08/19/99 | ASAP     | 20M=\$.09/EA; 40M=\$.07/EA;<br>60M=\$.06/EA                    | \$450.00        | 6 WKS.    |
|                                 |                                  | SWISS PRECISION MACH. | 08/19/99 | ASAP     | 20M=\$.10/EA; <b>40M=<br/>\$.075/EA;</b> 60M=\$.068/EA         | <b>\$150.00</b> | 6-8 WKS.  |
|                                 |                                  | ISELI                 | 08/19/99 | ASAP     | 20M=\$.25/EA; 40M=\$.22/EA;<br>60M=\$.21/EA                    | \$225.00        |           |
|                                 |                                  |                       |          |          |                                                                |                 |           |
|                                 |                                  |                       |          |          |                                                                |                 |           |
|                                 |                                  |                       |          |          |                                                                |                 |           |

MF0640

| SCREW MACHINE |                  |                        |          |          |                                                |          |           |
|---------------|------------------|------------------------|----------|----------|------------------------------------------------|----------|-----------|
| PART NUMBER   | DESCRIPTION      | VENDOR                 | RFQ SENT | DUE BACK | QUOTE                                          | SET-UP   | LEAD TIME |
| B-300352      | SAFETY PIVOT PIN | AUTOMATIC SWISS        | 08/19/99 | ASAP     | NO QUOTE-CAN'T MEET TOLERANCE                  |          |           |
|               |                  | SWISS PRECISION MACH.  | 08/19/99 | ASAP     | 20M=\$.206/EA; 40M=\$.163/EA; 60M=\$.157/EA    | \$275.00 | 6-8 WKS.  |
|               |                  | ISELI                  | 08/19/99 | ASAP     | 20M=\$.14/EA; 40M=\$.11/EA; 60M=\$.10/EA       | \$225.00 |           |
| A-300348      | SLIDE PLATE PIN  | SWISS PRECISION MACH   | 08/19/99 | ASAP     | 60M=\$.093/EA; 120M=\$.086/EA.; 180M=\$.085/EA | \$275.00 | 6-8 WKS.  |
|               |                  | ISELI                  | 08/19/99 | ASAP     | 60M=\$.08/EA; 120M=\$.07/EA; 180M=\$.06/EA     | \$225.00 |           |
| A-300342      | EJECTOR          | SWISS PRECISION MACH.  | 08/19/99 | ASAP     | 20M=\$.189/EA; 40M=\$.153/EA; 60M=\$.148/EA    | \$325.00 | 6-8 WKS.  |
|               |                  | ISELI                  | 08/19/99 | ASAP     | 20M=\$.11/EA; 40M=\$.08/EA; 60M=\$.07/EA       | \$400.00 |           |
| B300371       | LATCH PIN        | AUTOMATIC SWISS        | 08/19/99 | ASAP     | 20M=\$.08/EA; 40M=\$.06/EA; 60M=\$.04/EA       | \$250.00 | 6 WKS.    |
|               |                  | SWISS PRECISION MACH.. | 08/19/99 | ASAP     | 20M=\$.102/EA; 40M=\$.076/EA; 60M=\$.071/EA    | \$150.00 | 6-8 WKS.  |
|               |                  | ISELI                  | 08/19/99 | ASAP     | 20M=\$.07/EA; 40M=\$.05/EA; 60M=\$.04/EA       | \$225.00 |           |
| C-EXP-0283    | DETENT BUSHING   | ISELI                  | 08/20/99 | ASAP     | NO QUOTE-DUE TO RAW MATERIAL                   |          |           |
|               |                  |                        |          |          |                                                |          |           |
|               |                  |                        |          |          |                                                |          |           |
|               |                  |                        |          |          |                                                |          |           |
|               |                  |                        |          |          |                                                |          |           |
|               |                  |                        |          |          |                                                |          |           |
|               |                  |                        |          |          |                                                |          |           |

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ME0641

| SCREW MACHINE PARTS |                                      |                         |          |          |                                                   |            |           |
|---------------------|--------------------------------------|-------------------------|----------|----------|---------------------------------------------------|------------|-----------|
| PART NUMBER         | DESCRIPTION                          | VENDOR                  | REQ SENT | DUE BACK | QUOTE                                             | SET-UP     | LEAD TIME |
| D-300339            | BOLT BODY                            | ANDERSON SCREW          | 07/21/99 | 08/19/99 | UNABLE TO QUOTE-NOT SUITABLE FOR THEIR EQUIP.     |            |           |
|                     |                                      | ISELI                   | 07/21/99 | 08/19/99 | UNABLE TO QUOTE-PROBLEM WITH RAW MATERIAL         |            |           |
|                     |                                      | AUTOMATIC SWISS         | 07/21/99 | 08/19/99 | UNABLE TO QUOTE-NOT SUITABLE FOR THEIR EQUIP.     |            |           |
|                     |                                      | G. S. PRECISION         |          |          | 20M=\$2.54/EA; 40M=\$2.35/EA;<br>60M=\$2.21/EA    |            | 20-22WKS. |
| C-300335            | FIRING PIN TIP<br>(SUPREME DESIGN)   | ISELI                   | 07/21/99 | 08/19/99 | 20M=\$.23/EA; 40M=\$.20/EA;<br>60M=\$.19/EA       | 225.00     |           |
|                     |                                      | SUPREME                 | 07/21/99 | 08/19/99 | 20M=\$1.27/EA; 40M=\$1.165/EA;<br>60M=\$1.113/EA  | \$1,000.00 |           |
| D-300334            | FIRING PIN<br>(SUPREME DESIGN)       | ISELI                   | 07/21/99 | 08/19/99 | 20m=\$1.19/EA; 40m=\$1.15/EA;<br>60m=\$1.14/EA    | \$400.00   |           |
|                     |                                      | SUPREME                 | 07/21/99 | 08/19/99 | 20M=\$2.593/EA; 40M=\$2.493/EA;<br>60M=\$2.443/EA | \$1,500.00 |           |
| C-300334            | FIRING PIN<br>(REMINGTON DESIGN)     | ANDERSON SCREW PRODUCTS | 07/21/99 | 08/19/99 | 20M=\$275.80/M; 40M=\$268.60/M;<br>60M=\$265.20/M | \$800.00   |           |
|                     |                                      | AUTOMATIC SWISS         | 07/21/99 | 08/19/99 | 20M=\$.57/EA; 40M=\$.52/EA;<br>60M=\$.49/EA       | \$250.00   |           |
| C-300335            | FIRING PIN TIP<br>(REMINGTON DESIGN) | AUTOMATIC SWISS         | 07/21/99 | 08/19/99 | 20M=\$1.60/EA; 40M=\$1.50/EA;<br>60M=\$1.40/EA    | \$250.00   |           |
|                     |                                      | ANDERSON SCREW          | 07/21/99 | 08/19/99 | 20M=\$2096.00/M; 40M=\$2090.90/M; 60M=\$2088.40/M |            |           |
|                     |                                      |                         |          |          |                                                   |            |           |
|                     |                                      |                         |          |          |                                                   |            |           |



| STAMPINGS   |                |                                  |          |          |                                                                                                                                  |                        |           |
|-------------|----------------|----------------------------------|----------|----------|----------------------------------------------------------------------------------------------------------------------------------|------------------------|-----------|
| PART NUMBER | DESCRIPTION    | VENDOR                           | RFQ SENT | DUE BACK | QUOTE                                                                                                                            | SET-UP                 | LEAD TIME |
| E-300363    | MAGAZINE BOX   | TABER BUSHNELL, INC.             | 07/22/99 | 08/19/99 | NO QUOTE-NOT IN CAPABILITIES                                                                                                     |                        |           |
|             |                | NEW HAMPSHIRE STAMPING CO., INC. | 07/22/99 | 08/19/99 | NO QUOTE                                                                                                                         |                        |           |
|             |                | MORRISSEY, INC.                  | 08/06/99 | 08/26/99 | NO QUOTE-NOT SUIT. FOR VENDOR                                                                                                    |                        |           |
|             |                |                                  |          |          |                                                                                                                                  |                        |           |
| D-300344    | SAFETY         | TABER BUSHNELL, INC.             | 07/22/99 | 08/19/99 | NO QUOTE-NOT IN CAPABILITIES                                                                                                     |                        |           |
|             |                | NEW HAMPSHIRE STAMPING CO., INC. | 07/22/99 | 08/19/99 | 20M=\$316.00/M;<br>40M=\$310.00/M;<br>60M=\$308.00/M                                                                             | \$23,880.00            | 14-15 WKS |
|             |                | SQUARE STAMPING                  |          |          | <del>40M=\$299.37/M</del>                                                                                                        | <del>\$11,400.00</del> | 8 WKS.    |
|             |                |                                  |          |          | 10M=\$127.48/M;<br>20M=\$122.94/M;<br>40M=\$120.67/M;<br>60M=\$119.92/M.<br>MADE FROM<br>C1008 STEEL,<br>.187" +/- .003<br>THICK |                        |           |
|             |                | SQUARE STAMPING                  |          |          |                                                                                                                                  |                        |           |
|             |                |                                  |          |          |                                                                                                                                  |                        |           |
| B-300361    | RECOIL BRACKET | SQUARE STAMPING                  | 08/19/99 | ASAP     | 10M=\$193.59/M;<br>20M=\$189.05/M;<br><del>40M=\$186.78/M</del> ;<br>60M=\$186.03/M                                              | \$550.00               | 8 WKS.    |
|             |                | TABER BUSHNELL                   | 08/19/99 | ASAP     | NO QUOTE-NOT IN CAPABILITIES                                                                                                     |                        |           |
|             |                | NEW HAMPSHIRE STAMPING CO., INC. | 08/19/99 | ASAP     | 20M=\$244.00/M;<br>40M=\$240.00/M;<br>60M=\$238.00/M                                                                             | \$2,225.00             | 5 WKS     |
|             |                |                                  |          |          |                                                                                                                                  |                        |           |
|             |                |                                  |          |          |                                                                                                                                  |                        |           |

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MF0644

|  |                                                                                  |
|--|----------------------------------------------------------------------------------|
|  | 40M=\$68.99/M;<br>60M=\$68.23/M. F.<br>STEEL                                     |
|  | 10M=\$80.97/M;<br>20M=\$76.44/M;<br>40M=\$74.17/M;<br>60M=\$73.41/M. F.<br>STEEL |
|  | 10M=\$110.80/M;<br>20M=\$106.27/M;<br><b>40M=\$104.00/M;</b><br>60M=\$103.24/M   |

ME0645

**Subj: 5.2.2.2061000535 Order**

| PLASTICS                       |                               |                 |          |          |                                                             |             |          |
|--------------------------------|-------------------------------|-----------------|----------|----------|-------------------------------------------------------------|-------------|----------|
| PART NUMBER                    | DESCRIPTION                   | VENDOR          | RFO SENT | DUE BACK | QUOTE                                                       | SET-UP      | EAD TIM  |
| D-300365                       | BOX BOTTOM                    | PAR 4 PLASTIC   | 07/23/99 | 08/19/99 | 20M=\$.256/EA; 40M=\$.241/EA; 60M=\$.226/EA; 100M=\$.205/EA | \$47,880.00 | 15 WKS   |
|                                |                               | KELLUM AND COE  | 07/23/99 | 08/19/99 | 20M=\$.287/EA; 40M=\$.282/EA; 60M=\$.278/EA                 | \$41,000.00 |          |
|                                |                               | COMPLEX TOOLING | 07/23/99 | 08/19/99 |                                                             |             |          |
|                                |                               | HI-TECH MOLD    | 07/23/99 | 08/19/99 | \$ .55/EA (60M EST. YRLY)                                   | \$22,500.00 | 8-10 WKS |
| D-300364                       | FOLLOWER                      | PAR 4 PLASTIC   | 07/23/99 | 08/19/99 | 20M=\$.259/EA; 40M=\$.217/EA; 60M=\$.207/EA; 100M=\$.193/EA | \$33,300.00 | 14 WKS   |
|                                |                               | KELLUM AND COE  | 07/23/99 | 08/19/99 | 20M=\$.247/EA; 40M=\$.242/EA; 60M=\$.238/EA                 | \$27,500.00 |          |
|                                |                               | COMPLEX TOOLING | 07/23/99 | 08/19/99 |                                                             |             |          |
|                                |                               | HI-TECH MOLD    | 07/23/99 | 08/19/99 | \$ .56/EA (60M PER YR)                                      | \$15,300.00 | 8-10 WKS |
| D-300365& D-300364 FAMILY MOLD | MAGAZINE BOX BTM AND FOLLOWER | PAR 4 PLASTIC   |          |          | #300364: FOLLOWER=\$.093/EA; #300365: MAG BOX BTM=\$.105/EA | \$78,786.00 | 18 WKS   |
| C-200257                       | BOLT PLUG                     | PAR 4 PLASTIC   | 07/23/99 | 08/19/99 | 20M=\$.249/EA; 40M=\$.239/EA; 60M=\$.215/EA                 | \$38,088.00 | 12 WKS.  |
|                                |                               | KELLUM AND COE  | 07/23/99 | 08/19/99 | 20M=\$.215/EA; 40M=\$.213/EA; 60M=\$.211/EA                 | \$36,000.00 |          |
|                                |                               | COMPLEX TOOLING | 07/23/99 | 08/19/99 |                                                             |             |          |
|                                |                               | HI-TECH MOLD    | 07/23/99 | 08/19/99 | \$ .61/EA (EST. 60M YRLY)                                   | \$19,800.00 | 8-10 WKS |
|                                |                               |                 |          |          |                                                             |             |          |
|                                |                               |                 |          |          |                                                             |             |          |
|                                |                               |                 |          |          |                                                             |             |          |
|                                |                               |                 |          |          |                                                             |             |          |
|                                |                               |                 |          |          |                                                             |             |          |
|                                |                               |                 |          |          |                                                             |             |          |

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ME0646

Confidential - ~~Shaver~~ - 5.22.06r0010596 Order

Williams v. Remington







| FASTENERS   |                   |                       |          |          |                                               |        |
|-------------|-------------------|-----------------------|----------|----------|-----------------------------------------------|--------|
| PART NUMBER | DESCRIPTION       | VENDOR                | RFQ SENT | DUE BACK | QUOTE                                         | SET-UP |
| B91128      | SCREW, TRIG. ENG. | EVANSVILLE BOLT & NUT | 07/23/99 | 08/19/99 | 20M=\$6.45/C; 40M=\$4.18/C;<br>60M=\$3.32/C   |        |
|             |                   | FASTENAL              | 07/23/99 | 08/19/99 | 20M=\$40.25/M; 40M=\$32.65/M<br>60M=\$29.05/M |        |
|             |                   |                       |          |          |                                               |        |
| B17053      | SCREW, TRIG STOP  | EVANSVILLE BOLT & NUT | 07/23/99 | 08/19/99 | 20M=\$6.80/C; 40M=\$3.78/C;<br>60M=\$3.07/C   |        |
|             |                   | FASTENAL              | 07/23/99 | 08/19/99 | 20M=\$39.50/M; 40M=\$32.40/M<br>60M=\$28.80/M |        |
|             |                   |                       |          |          |                                               |        |
| A-15481     | SCREW, TRIG STOP  | EVANSVILLE BOLT & NUT | 07/23/99 | 08/19/99 | 20M=\$6.72/C; 40M=\$4.45/C;<br>60M=\$3.66/C   |        |
|             |                   | FASTENAL              | 07/23/99 | 08/19/99 | 20M=\$41.50/M; 40M=\$32.40/M<br>60M=\$29.25/M |        |
|             |                   |                       |          |          |                                               |        |
| A-90906     | SCREW ELEVATION   | EVANSVILLE BOLT & NUT | 07/23/99 | 08/19/99 | 20M=\$5.64/C; 40M=\$4.95/100;<br>60M=\$3.96/C |        |
|             |                   | FASTENAL              | 07/23/99 | 08/19/99 | 20M=\$36.00/M; 40M=\$27.00/M<br>60M=\$24.00/M |        |
|             |                   |                       |          |          |                                               |        |
| A-94555     | PIN, SPIROL       | EVANSVILLE BOLT & NUT | 07/23/99 | 08/19/99 | 20M=\$1.35/C; 60M=\$1.12/C                    |        |
|             |                   | FASTENAL              | 07/23/99 | 08/19/99 | 20M=\$15.00/M; 40M=\$13.88/M                  |        |
|             |                   |                       |          |          |                                               |        |
|             |                   |                       |          |          |                                               |        |
|             |                   |                       |          |          |                                               |        |
|             |                   |                       |          |          |                                               |        |
|             |                   |                       |          |          |                                               |        |
|             |                   |                       |          |          |                                               |        |

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ME0650



~~Confidential - Subjunctive Order~~

| <b>COLD FINISHED ROUND BAR STOCK</b> |                                                                              |                |                 |                 |                                                                 |                  |
|--------------------------------------|------------------------------------------------------------------------------|----------------|-----------------|-----------------|-----------------------------------------------------------------|------------------|
| <b>PART NUMBER</b>                   | <b>DESCRIPTION</b>                                                           | <b>VENDOR</b>  | <b>RFQ SENT</b> | <b>DUE BACK</b> | <b>QUOTE</b>                                                    | <b>LEAD TIME</b> |
|                                      | ANNEAL-COLD<br>DRAWN 241 MAX<br>BHN                                          | REPUBLIC STEEL |                 |                 | \$57.50/CWT                                                     | 14-16 WEEKS      |
|                                      | QUENCH AND<br>TEMPER COLD<br>DRAWN STRESS<br>RELIEVED TURNED<br>AND POLISHED | REPUBLIC STEEL |                 |                 | COLD<br>DRAWN=\$64.00/CWT<br>TURNED AND<br>POLISHED=\$69.00/CWT | 20-22 WKS        |
|                                      | TUBING BOLT                                                                  | FEDERAL STEEL  | 08/03/99        | 08/15/99        | 10M FT=\$1.2400/FT                                              | 14-18 WKS.       |
|                                      | TUBING RECEIVER                                                              | FEDERAL STEEL  | 08/03/99        | 08/15/99        | 10M FT=\$2.9400/FT                                              | 5-6 WKS.         |

| SPRINGS     |                   |                   |          |          |                                                |         |
|-------------|-------------------|-------------------|----------|----------|------------------------------------------------|---------|
| PART NUMBER | DESCRIPTION       | VENDOR            | RFQ SENT | DUE BACK | QUOTE                                          | SET-UP  |
| A-300367    | EJECTOR SPRING    | INDUSTRIAL SPRING | 08/19/99 | ASAP     | 20M=\$31.00/M; 40M=\$25.80/M; 60M=\$22.10/M    |         |
|             |                   | P.J. SPRING       | 08/19/99 | ASAP     | 20M=\$19.80/M; 40M=\$11.40/M; 60M=\$9.40/M     | 4-6 WKS |
|             |                   | MIDSTATE SPRING   | 08/19/99 | ASAP     | 20M=\$.0152/EA; 40M=\$.0108/EA; 60M=\$.0093/EA |         |
|             |                   |                   |          |          |                                                |         |
|             |                   |                   |          |          |                                                |         |
| A-300398    | LATCH SPRING      | INDUSTRIAL SPRING | 08/19/99 | ASAP     | 20M=\$25.70/M; 40M=\$19.40/M; 60M=\$16.40/M    |         |
|             |                   | P.J. SPRING       | 08/19/99 | ASAP     | 20M=\$26.20/M; 40M=\$18.20/M; 60M=\$15.80/M    | 4-6 WKS |
|             |                   | MIDSTATE SPRING   | 08/19/99 | ASAP     | 20M=\$.0279/M; 40M=\$.0201/EA; 60M=\$.0179/EA  |         |
|             |                   |                   |          |          |                                                |         |
|             |                   |                   |          |          |                                                |         |
| A-300399    | FIRING PIN SPRING | INDUSTRIAL SPRING | 08/19/99 | ASAP     | 20M=\$108.00/M; 40M=\$102.00/M; 60M=\$97.00/M  |         |
|             |                   | P.J. SPRING       | 08/19/99 | ASAP     | 20M=\$103.00/M; 40M=\$87.50/M; 60M=\$83.10/M   | 4-6 WKS |
|             |                   | MIDSTATE SPRING   | 08/19/99 | ASAP     | 20M=\$.1008/EA; 40M=\$.0870/EA; 60M=\$.0824/EA |         |
|             |                   |                   |          |          |                                                |         |
|             |                   |                   |          |          |                                                |         |
|             |                   |                   |          |          |                                                |         |
|             |                   |                   |          |          |                                                |         |
|             |                   |                   |          |          |                                                |         |
|             |                   |                   |          |          |                                                |         |
|             |                   |                   |          |          |                                                |         |

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ME0653

## COST DISCREPANCIES BETWEEN LIST AND QUOTES

**Carton Assembly 1444**

Ilion box is \$2.05      New carton cost with styrofoam bed and box is \$1.32  
 Tooling for the styrofoam bed would be \$18,900.00. Difference of .73 cents.  
 30,000 times .73 = \$21,900.00 this would pay for the tool in a year with an  
 additional savings of \$3000.00. Also, there is a possibility of ammortizing the  
 tooling charges for the first six months, as we did with the 597 box.

**Receiver 300340**

Cost shown is \$1.76 indicating raw material only. If for any reason we could not  
 make this part in house, or we choose to forego the capitol expense, the lowest  
 outside quote is \$20.00 for one complete to print, or around \$3.50 with machining  
 to still be done to some degree.

**Sear Safety Cam 15666 (Add Use)**

Current cost is \$.94 from Ilion. An option, is to invest \$11,300.00 in tooling costs  
 from another supplier and lower the piece price to \$.68 each. Tooling cost would  
 be recovered in approximately 18 months. 30,000 times the \$.26 cent difference  
 is \$7800.00 per year.

**Pin, Pivot 300351**

List shows \$.18 cents each, lowest quote is \$.07 cents each

**Pin, Safety Pivot 300352** → *same*

List shows \$.06 cents each, lowest quote is \$.11 cents each

**Trigger 15280 (Add Use)****Front Sight 94084 (Add Use)**

Both of these parts have the Ilion cost shown. An alternate sources quotes are  
 not back yet, however, we may have an opportunity like the Sear Safety Cam to  
 save in piece price up to 28% after tooling cost.

**Screw, Front Trigger 17053 (Add Use)**

Provided by Ilion cost is \$.11 cents each, with Mayfield supplier cost is \$.03 cents each.

**Screw, Trigger Stop 15481 (Add Use)**

Provided by Ilion cost is \$.06 cents each, with Mayfield supplier cost is \$.03 cents each.

**Bolt Body 300339**

Cost on list (.74) is based on Mayfield investing in the capitol equipment to mfg in house.  
 Should we have to or choose to go to an outside source, machining cost could jump to  
 around \$2.00 each partially machined.

MF0654

**Pin, Bolt Handle 300329**

List shows \$.06 cents each. Lowest quote is \$.08 cents each

40M is \$0.08  
60M is \$0.06

**Bolt Head 300338**

No quotes are back from the first request. A second request to four different suppliers are still out. Due back anytime.

**Ejector 300342**

List cost shows \$.16 cents each, lowest quote is \$.08 cents each.

**Spring, Ejector 300367**

List cost shows \$.03 cents each, lowest quote is \$.01 cent each.

**Pin, Bolt Assy. 300330**

List cost shows \$.10 cents each, lowest quote is \$.12 cents each

40M - 12¢  
60M - 10¢

**Firing Pin and Tip (one piece design) 300334 & 300335**

This cost is not on your list. This design is quoted at \$2.70 each. Matt to explain differences of drawings.

**Bolt Plug Insert 300346**

List cost shows \$.29 cents each, lowest quote is \$.78 cents each.

**Bolt Plug 300368**

List cost shows \$.25 cents each, lowest quote is \$.21 cents each.

**Firing Pin Head 300336**

List cost shows \$1.50 each, lowest quote is \$1.45 each.

**Firing Pin Spring 300339**

List cost shows \$.14 cents each, lowest quote is \$.08 cents each.

**Magazine Box 300363**

No quotes returned. Will re-source to new vendors.  
Reasons were: not equipped for this part

**Magazine Box Bottom and Follower (Family Mold) 300364 & 300365**

Follower cost is \$.09, and Bottom cost is \$.10 each. Tooling is \$78,786.00, which is \$3000.00 less than single tools for the same parts. These piece prices are also less than half of the piece price of the single tool quotes.

**Magazine Spring 17028 (Add Use)**

List shows part #17028, my RFQ was for drawing #300399, are these the same part? My quote is \$.10 each, list cost is \$.42 each.

MF0655

| New Parts |                       |          |          | Comments                                               |                         |
|-----------|-----------------------|----------|----------|--------------------------------------------------------|-------------------------|
| Part #    | Part Name             | Material | PPI \$   |                                                        | important               |
| 300327    | Receiver Insert       | 0.62     | \$4,500  | CMM inspection w/ fixture,                             | .003 step height        |
|           |                       |          | 800      | Function gage                                          |                         |
|           |                       |          | 350      | Special .700 dia plug gage                             |                         |
| 300333    | Side Plate            |          | 0        | thickness micrometers                                  |                         |
|           |                       |          | 1500     | Comp Screen & fix                                      | hole spacing            |
| 300334    | Safety Arm            | 0.31     | 2400     | Comp Screen & fix                                      | 2 views                 |
|           |                       |          | 0        | Plug gage                                              | pivot hole              |
|           |                       |          | 0        | heat treat                                             |                         |
| 300345    | Bolt Stop             | 0.19     | 1500     | Comp Screen & fix                                      | 2 views                 |
| 300361    | Recoil Bracket        |          |          | mic and caliper                                        |                         |
| 300360    | Bolt Handle Blank     | 1.63     | 2500     | Comp Screen & fix                                      | 2 views                 |
| 300366    | Bolt H. Braze Shim    |          |          | micrometer for thickness                               |                         |
| 300368    | Bolt Plug             | 0.213    | 800      | Function gage                                          |                         |
| 300336    | Firing pin head       | 1.45     | 1500     | Comp Screen & fix                                      |                         |
| 300362    | Mag Latch             | 0.186    |          | Pin and caliper                                        |                         |
| 300363    | Magazine Box          |          | 4500     | CMM inspection w/ fixture,                             |                         |
| 300364    | Magazine Follower     | 0.242    | 3000     | Comp Screen & fix                                      | glass plate with spring |
| 300365    | Magazine Bottom       | 0.282    | 0        | Caliper                                                |                         |
|           | Stock                 |          | 4500     | CMM inspection w/ fixture,                             |                         |
| 300347    | Threaded Insert       | 0.04     | 200      | mic and caliper & thread gage                          |                         |
| 300328    | Side Plate Pin (2)    | 0.12     | 0        | mic and caliper                                        |                         |
| 300351    | Pivot Pins (3)        |          | 0        | mic and caliper                                        |                         |
| 300352    | Safety Pivot Pin      |          | 0        | mic and caliper & check on comparator                  |                         |
| 300343    | Safety Spring         |          | 0        | obsolete                                               |                         |
| 300329    | Bolt Handle Pin       |          | 0        | mic and caliper                                        |                         |
| 300342    | Ejector               |          | 3000     | comp screen & fixture-caliper & mic                    |                         |
| 300330    | Bolt Assy Pin         |          | 0        | mic and caliper-gage pin                               |                         |
| 300346    | Bolt Plug Insert      |          | 3000     | comp screen & fixture-2 profiles                       | plug gage and mic       |
| 300334    | Firing Pin            | 0.27     | 200      | mic and caliper-comparator for straightness-heat treat | thread gage             |
| 300335    | Firing Pin Tip        | 1.5      | 3300     | mic and caliper-comp screen-thread gage 12-28 unf-2b   |                         |
| 300399    | Firing Pin Spring     |          | 0        | mic and caliper-comparator for length-                 |                         |
|           | Middle Screw Bushing  |          | 0        | plug gage and mic                                      |                         |
|           | Rear Screw Bushing    |          | 0        | plug gage and mic                                      |                         |
| 300398    | Mag Latch Spring      |          | 0        | mic and comp for angle                                 |                         |
| 300371    | Mag Latch Pin         |          | 0        | mic and caliper                                        |                         |
| 300096    | Spring Swivel Stud    |          | 0        | check thread length                                    |                         |
|           | Take Down Screw R     |          | 200      | thread gage-comp for length                            | check head type         |
|           | Take Down Screw M     |          | 200      | thread gage-comp for length                            | check head type         |
|           | Take Down Screw F     |          | 0        | thread gage-comp for length                            | check head type         |
|           |                       | 0        |          |                                                        |                         |
| 300338    | Bolt Head Blank       |          | 120      | comp screen                                            |                         |
|           | Barrel Blank          |          | 0        |                                                        |                         |
|           | Receiver Blank        |          | 0        | mic and caliper                                        | O.D and I.D.            |
|           | Bolt Body             |          | 0        | mic and caliper                                        | O.D and I.D.            |
| 300367    | Ejector Spring        |          | 0        | mic and caliper                                        |                         |
| 300405    | Magazine Spring       | 0.42     | 3000     | hardness-caliper-comp screen and fixture               |                         |
|           | Total Material \$ New |          |          |                                                        |                         |
|           | known to date         | 7.053    | \$41,070 |                                                        |                         |

MF0656

## Add Use from M700

| Part # | Part Name               | Material | PPI  | \$ |                                                                                    |
|--------|-------------------------|----------|------|----|------------------------------------------------------------------------------------|
| 1444   | Carton Assy             | 2.05     | 0    |    |                                                                                    |
| 15666  | Sear Safety Cam         | 0.94     | 3000 |    | hardness test-screen and fixture                                                   |
| 17047  | Sear Spring             | 0.02     | 0    |    | mic and caliper                                                                    |
| 15280  | Trigger                 | 1.53     | 3000 |    | gage pin-comp screen & fixture                                                     |
| 19461  | Trigger Connector       | 1.48     | 3000 |    | hardness test-mic and caliper comp screen and fixture                              |
| 17053  | Trigger Front Screw     | 0.11     | 300  |    | thread gage-mic                                                                    |
| 91128  | Engagement Screw        | 0.03     | 300  |    | thread gage-mic                                                                    |
| 15400  | Trigger Spring          | 0.03     | 0    |    | pin gage-mic                                                                       |
| 15481  | Trigger Stop Screw      | 0.06     | 300  |    | thread gage-mic                                                                    |
| 17044  | Snap Washer             | 0.09     | 120  |    | heat treat-comp screen                                                             |
| 17034  | Receiver Plug Screws    | 0.13     | 0    |    | mic and thread gage-we have gage                                                   |
| 93712  | Extractor               | 0.78     | 3300 |    | heat treat-comp screen and fixture build fixture w/3 magnets new anvil for hardnes |
| 94555  | Ejector Pin             | 0.01     | 0    |    | mic and caliper                                                                    |
| 94084  | Front sight             | 0.82     | 0    |    | nothing                                                                            |
| 94657  | front Sight Ramp        | 1.13     | 400  |    | check dove tail cut with gage                                                      |
| 28505  | Front Sight Ramp Screws | 0.09     | 0    |    | mic-caliper-thread gage-heat treat-angle on comp                                   |
| 90906  | Elevation Screw         | 0.02     | 0    |    | thread gage-mic                                                                    |
| 94333  | Rear Sight Aperature    | 0.14     | 0    |    | just visual                                                                        |
| 103531 | Rear Sight Base         | 0.97     | 0    |    | just visual                                                                        |
| 94335  | Rear Sight Slide        | 0.47     | 0    |    | just visual                                                                        |
| 90904  | Windage Screw           | 0.02     | 0    |    | just visual                                                                        |
| 28505  | Rear Sight Base Scre    | 0.09     | 0    |    | just visual                                                                        |
| 15161  | Front Screw Bushing     | 0.13     | 0    |    | plug gage-mic-caliper                                                              |
| 97971  | Grip Cap                | 0.18     | 0    |    | caliper-visual                                                                     |
| 97973  | Recoil Pad              | 1.63     | 400  |    | visual caliper diameter (cost)                                                     |
| 98008  | Recoil Pad Screws       | 0.05     | 0    |    | visual caliper                                                                     |

\$14,120

83

55,190

MF0657

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

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**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% 83

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

Remington Arms Company, Inc.  
Sportsman Model 710 Centerfire Rifle - Option X  
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                     | \$ 221.11                       | \$ 217.51 | \$ 217.51 | \$ 217.51 |

10/5/99

MF0659

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

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MF0660

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

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MF0661

Updated 10/08/99

| QUOTES ON MODEL 710 |                            |                            |          |          |                                                                    |             |                 |
|---------------------|----------------------------|----------------------------|----------|----------|--------------------------------------------------------------------|-------------|-----------------|
| PM PARTS:           |                            |                            |          |          |                                                                    |             |                 |
| PART NUMBER         | DESCRIPTION                | VENDOR                     | RFQ SENT | DUE BACK | QUOTE                                                              | SET-UP      | LEAD TIME       |
| C-300345            | BOLT STOP                  | STERLING SINTERED<br>ILION | 07/19/99 | 08/15/99 | 20M=\$219.20/M; 40M=<br>\$190.60/M; 120M=\$184.60/M<br>\$.57/EA    | \$6,820.00  |                 |
| C-91852             | SAFETY BUTTON              | STERLING SINTERED<br>ILION | 07/19/99 | 08/15/99 | 20M=\$108.30/M;<br>40M=\$95.80/M; 120M=\$85.90<br>\$.12/EA         | \$4,700.00  |                 |
| C-15373             | SIGHT                      | STERLING SINTERED<br>ILION | 07/19/99 | 08/15/99 | NO QUOTE-CANNOT DO W/O A SAMPLE<br>\$.82/EA                        |             |                 |
| C-15280             | TRIGGER                    | STERLING SINTERED<br>ILION | 07/19/99 | 08/15/99 | 20M=\$738.05/M;<br>40M=\$724.70/M;<br>120M=\$690.50/M<br>\$1.53/EA | \$19,750.00 | SAMP-12<br>WKS. |
| C-15280 RE 31       | TRIGGER (NO<br>SERRATIONS) | STERLING SINTERED          |          |          | 20M=\$377.10/M;<br>40M=\$367.55/M; 120M=<br>\$347.70/M             | \$15,225.00 |                 |
| C-15666             | SEAR SAFETY CAM            | STERLING SINTERED<br>ILION | 07/19/99 | 08/15/99 | 20M=\$759.50/M; 40M=<br>\$683.45/M; 120M=\$625.80/M<br>\$.94/EA    | \$11,300.00 | SAMP=<br>12 WKS |
| C-93906             | APERTURE                   | STERLING SINTERED<br>ILION | 07/19/99 | 08/15/99 | 20M=\$155.65/M; 40M=<br>\$124.65/M; 120M=\$105.90/M<br>\$.33/EA    | \$5,210.00  | SAMP=<br>12 WKS |

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ME0662

Confidential - Subject - 5.22.06r0010612

Williams v. Remington

| MIM PARTS   |                 |           |          |          |                                                                                                                                                                                                                            |                                                                                                                               |                                                                                  |
|-------------|-----------------|-----------|----------|----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------|
| PART NUMBER | DESCRIPTION     | VENDOR    | RFQ SENT | DUE BACK | QUOTE                                                                                                                                                                                                                      | SET-UP                                                                                                                        | LEAD TIME                                                                        |
| C-300336    | FIRING PIN HEAD | PARMATECH | 07/19/99 | 08/15/99 | 20M=NO QUOTE;<br>40M=\$2.11/EA FOR 1-CAV.;<br>\$1.26/EA FOR 2-CAV.;<br>\$1.81/EA FOR 3-CAV.;<br>\$1.95/EA FOR 4-CAV.<br>60M=\$1.86/EA FOR 1-CAV;<br>\$1.12/EA FOR 2-CAV.;<br>\$1.56/EA FOR 3-CAV.;<br>\$1.74/EA FOR 4-CAV. | ONE CAVITY<br>MOLD=\$24,000;<br>TWO-CAVITY<br>MOLD=\$32,600;<br>SINTERING<br>FIXTURES=\$3,000;<br>TAPPING<br>FIXTURES=\$2,000 | MOLD<br>DELIVERY 10-<br>152 WKS;<br>SAMPLES 4-6<br>WKS AFTER<br>MOLD<br>DELIVERY |
|             |                 | MEGAMET   | 07/19/99 | 08/15/99 |                                                                                                                                                                                                                            | \$15,000=MOLD;<br>\$7,500=FURNACE<br>FIXTURE                                                                                  |                                                                                  |
| C-93907     | REAR SLIDE      | PARMATECH | 07/19/99 | 08/15/99 | 80M=\$1.87/EA; 100M=\$1.69/EA; 200M=\$1.58/EA                                                                                                                                                                              | TWO-CAVITY<br>MOLD=\$45,500;<br>SINTERING<br>FIXTURES=\$4,000;<br>TAPPING<br>FIXTURES=\$2,000                                 | MOLD<br>DELIVERY 12-<br>14 WEEKS;<br>SAMPLES 4-6<br>WEEKS<br>LATER               |
|             |                 | MEGAMET   | 07/19/99 | 08/15/99 | 80M=\$1.20/EA;<br>100M=\$1.15/EA;<br>200M=\$1.10/EA                                                                                                                                                                        | \$15,000=MOLD;<br>\$2,500=FURNACE<br>FIXTURE                                                                                  |                                                                                  |
| C-103530    | BASE            | PARMATECH | 07/19/99 | 08/15/99 | 80M=\$1.69/EA;<br>100M=\$1.50/EA;<br>200M=\$1.44/EA                                                                                                                                                                        | TWO-CAVITY<br>MOLD=\$37,800;<br>SINTERING AND<br>SIZING<br>FIXTURES=\$6,000                                                   | MOLD<br>DELIVERY 10-<br>12 WEEKS;<br>SAMPLES 4-6<br>WEEKS<br>LATER               |
|             |                 | MEGAMET   | 07/19/99 | 08/15/99 | 80M=\$1.65/EA;<br>100M=\$1.60/EA;<br>200M=\$1.50/EA                                                                                                                                                                        | \$15,000=MOLD;<br>\$2,500=FURNACE<br>FIXTURE                                                                                  |                                                                                  |

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ME0663

| SCREW MACHINE PARTS |                                         |                            |          |          |                                                       |            |           |
|---------------------|-----------------------------------------|----------------------------|----------|----------|-------------------------------------------------------|------------|-----------|
| PART NUMBER         | DESCRIPTION                             | VENDOR                     | REQ SENT | DUE BACK | QUOTE                                                 | SET-UP     | LEAD TIME |
| C-300335            | FIRING PIN TIP<br>(SUPREME<br>DESIGN)   | ISELI                      | 07/21/99 | 08/19/99 | 20M=\$.23/EA; 40M=\$.20/EA;<br>60M=\$.19/EA           | 225.00     |           |
|                     |                                         | SUPREME                    | 07/21/99 | 08/19/99 | 20M=\$1.27/EA; 40M=\$1.165/EA;<br>60M=\$1.113/EA      | \$1,000.00 |           |
| D-300334            | FIRING PIN<br>(SUPREME<br>DESIGN)       | ISELI                      | 07/21/99 | 08/19/99 | 20m=\$1.19/EA; 40m=\$1.15/EA;<br>60m=\$1.14/EA        | \$400.00   |           |
|                     |                                         | SUPREME                    | 07/21/99 | 08/19/99 | 20M=\$2.593/EA; 40M=\$2.493/EA;<br>60M=\$2.443/EA     | \$1,500.00 |           |
| C-300334            | FIRING PIN<br>(REMINGTON<br>DESIGN)     | ANDERSON SCREW<br>PRODUCTS | 07/21/99 | 08/19/99 | 20M=\$275.80/M; 40M=\$268.60/M;<br>60M=\$265.20/M     | \$800.00   |           |
|                     |                                         | AUTOMATIC SWISS            | 07/21/99 | 08/19/99 | 20M=\$.57/EA; 40M=\$.52/EA;<br>60M=\$.49/EA           | \$250.00   |           |
|                     |                                         | QUICK TEK                  |          |          | 20M=\$.98/EA; 40M=\$.84/EA;<br>60M=\$.82/EA           |            |           |
| C-300335            | FIRING PIN TIP<br>(REMINGTON<br>DESIGN) | AUTOMATIC SWISS            | 07/21/99 | 08/19/99 | 20M=\$1.60/EA; 40M=\$1.50/EA;<br>60M=\$1.40/EA        | \$250.00   |           |
|                     |                                         | ANDERSON SCREW             | 07/21/99 | 08/19/99 | 20M=\$2096.00/M; 40M=<br>\$2090.90/M; 60M=\$2088.40/M |            |           |
|                     |                                         | QUICK TEK                  | 09/03/99 | 09/23/99 | 20M=\$1.37/EA; 40M=\$1.31/EA;<br>60M=\$1.28/EA        |            |           |
|                     |                                         |                            |          |          |                                                       |            |           |
|                     |                                         |                            |          |          |                                                       |            |           |
|                     |                                         |                            |          |          |                                                       |            |           |

| SCREW MACHINE                               |                                  |                       |          |          |                                                                |                 |              |
|---------------------------------------------|----------------------------------|-----------------------|----------|----------|----------------------------------------------------------------|-----------------|--------------|
| PART<br>NUMBER                              | DESCRIPTION                      | VENDOR                | RFQ SENT | DUE BACK | QUOTE                                                          | SET-UP          | LEAD<br>TIME |
| C-<br>300334-<br>C300335<br>(ONE-<br>PIECE) | FIRING PIN AND<br>FIRING PIN TIP | ANDERSON SCREW        |          |          | 20M=\$2709.60/M;<br><b>40M=\$2699.70/M;</b><br>60M=\$2697.60/M |                 |              |
|                                             |                                  | AUTOMATIC SWISS       |          |          | NO QUOTE-SIGNIFICANTLY<br>MORE EXPENSIVE                       |                 |              |
| B-300330                                    | BOLT ASSEMBLY<br>PIN             | AUTOMATIC SWISS       | 08/19/99 | ASAP     | 20M=\$.15/EA; <b>40M=\$.12/EA;</b><br>60M=\$.10/EA             | <b>\$450.00</b> | 6 WKS.       |
|                                             |                                  | SWISS PRECISION MACH. | 08/19/99 | ASAP     | 20M=\$.226/EA; 40M=<br>\$.184/EA; 60M=\$.177/EA                | \$380.00        | 6-8 WKS.     |
|                                             |                                  | ISELI                 | 08/19/99 | ASAP     | 20M=\$.26/EA; 40M=\$.24/EA;<br>60M=\$.235/EA                   | \$350.00        |              |
| A-300329                                    | BOLT HANDLE PIN                  | AUTOMATIC SWISS       | 08/19/99 | ASAP     | 20M=\$.10/EA; <b>40M=\$.08/EA;</b><br>60M=\$.06/EA             | <b>\$450.00</b> | 6 WKS.       |
|                                             |                                  | SWISS PRECISION MACH. | 08/19/99 | ASAP     | 20M=\$.122/EA; 40M=<br>\$.106/EA; 60M=\$.101/EA                | \$150.00        | 6-8 WKS.     |
|                                             |                                  | ISELI                 | 08/19/99 | ASAP     | 20M=\$.13/EA; 40M=\$.12/EA;<br>60M=\$.11/EA                    | \$200.00        |              |
| B-300351                                    | PIVOT PIN                        | AUTOMATIC SWISS       | 08/19/99 | ASAP     | 20M=\$.09/EA; 40M=\$.07/EA;<br>60M=\$.06/EA                    | \$450.00        | 6 WKS.       |
|                                             |                                  | SWISS PRECISION MACH. | 08/19/99 | ASAP     | 20M=\$.10/EA; <b>40M=<br/>\$.075/EA;</b> 60M=\$.068/EA         | <b>\$150.00</b> | 6-8 WKS.     |
|                                             |                                  | ISELI                 | 08/19/99 | ASAP     | 20M=\$.25/EA; 40M=\$.22/EA;<br>60M=\$.21/EA                    | \$225.00        |              |
|                                             |                                  |                       |          |          |                                                                |                 |              |
|                                             |                                  |                       |          |          |                                                                |                 |              |
|                                             |                                  |                       |          |          |                                                                |                 |              |

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MF0665

Confidential - Subject - 5.22.06r0010615 Order

Williams v. Remington

| SCREW MACHINE  |                  |                        |          |          |                                                |          |              |
|----------------|------------------|------------------------|----------|----------|------------------------------------------------|----------|--------------|
| PART<br>NUMBER | DESCRIPTION      | VENDOR                 | RFQ SENT | DUE BACK | QUOTE                                          | SET-UP   | LEAD<br>TIME |
| B-300352       | SAFETY PIVOT PIN | AUTOMATIC SWISS        | 08/19/99 | ASAP     | NO QUOTE-CAN'T MEET TOLERANCE                  |          |              |
|                |                  | SWISS PRECISION MACH   | 08/19/99 | ASAP     | 20M=\$.206/EA; 40M=\$.163/EA; 60M=\$.157/EA    | \$275.00 | 6-8 WKS.     |
|                |                  | ISELI                  | 08/19/99 | ASAP     | 20M=\$.14/EA; 40M=\$.11/EA; 60M=\$.10/EA       | \$225.00 |              |
| A-300348       | SLIDE PLATE PIN  | SWISS PRECISION MACH   | 08/19/99 | ASAP     | 60M=\$.093/EA; 120M=\$.086/EA.; 180M=\$.085/EA | \$275.00 | 6-8 WKS.     |
|                |                  | ISELI                  | 08/19/99 | ASAP     | 60M=\$.08/EA; 120M=\$.07/EA; 180M=\$.06/EA     | \$225.00 |              |
| A-300342       | EJECTOR          | SWISS PRECISION MACH.  | 08/19/99 | ASAP     | 20M=\$.189/EA; 40M=\$.153/EA; 60M=\$.148/EA    | \$325.00 | 6-8 WKS.     |
|                |                  | ISELI                  | 08/19/99 | ASAP     | 20M=\$.11/EA; 40M=\$.08/EA; 60M=\$.07/EA       | \$400.00 |              |
| B300371        | LATCH PIN        | AUTOMATIC SWISS        | 08/19/99 | ASAP     | 20M=\$.08/EA; 40M=\$.06/EA; 60M=\$.04/EA       | \$250.00 | 6 WKS.       |
|                |                  | SWISS PRECISION MACH.. | 08/19/99 | ASAP     | 20M=\$.102/EA; 40M=\$.076/EA; 60M=\$.071/EA    | \$150.00 | 6-8 WKS.     |
|                |                  | ISELI                  | 08/19/99 | ASAP     | 20M=\$.07/EA; 40M=\$.05/EA; 60M=\$.04/EA       | \$225.00 |              |
| C-EXP-0283     | DETENT BUSHING   | ISELI                  | 08/20/99 | ASAP     | NO QUOTE-DUE TO RAW MATERIAL                   |          |              |
|                |                  |                        |          |          |                                                |          |              |
|                |                  |                        |          |          |                                                |          |              |
|                |                  |                        |          |          |                                                |          |              |
|                |                  |                        |          |          |                                                |          |              |
|                |                  |                        |          |          |                                                |          |              |
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| PLASTICS                       |                               |                 |              |          |                                                                                                                            |             |          |
|--------------------------------|-------------------------------|-----------------|--------------|----------|----------------------------------------------------------------------------------------------------------------------------|-------------|----------|
| PART NUMBER                    | DESCRIPTION                   | VENDOR          | RFG SENT     | DUE BACK | QUOTE                                                                                                                      | SET-UP      | EAD TIM  |
| D-300365                       | BOX BOTTOM                    | PAR 4 PLASTIC   | 07/23/99     | 08/19/99 | 20M=\$.256/EA; 40M=\$.241/EA; 60M=\$.226/EA; 100M=\$.205/EA                                                                | \$47,880.00 | 15 WKS   |
|                                |                               | KELLUM AND COE  | 07/23/99     | 08/19/99 | 20M=\$.287/EA; 40M=\$.282/EA; 60M=\$.278/EA                                                                                | \$41,000.00 |          |
|                                |                               | COMPLEX TOOLING | 07/23/99     | 08/19/99 |                                                                                                                            |             |          |
|                                |                               | HI-TECH MOLD    | 07/23/99     | 08/19/99 | \$55/EA (60M EST. YRLY)                                                                                                    | \$22,500.00 | 8-10 WKS |
| D-300364                       | FOLLOWER                      | PAR 4 PLASTIC   | 07/23/99     | 08/19/99 | 20M=\$.259/EA; 40M=\$.217/EA; 60M=\$.207/EA; 100M=\$.193/EA                                                                | \$33,300.00 | 14 WKS   |
|                                |                               | KELLUM AND COE  | 07/23/99     | 08/19/99 | 20M=\$.247/EA; 40M=\$.242/EA; 60M=\$.238/EA                                                                                | \$27,500.00 |          |
|                                |                               | COMPLEX TOOLING | 07/23/99     | 08/19/99 |                                                                                                                            |             |          |
|                                |                               | HI-TECH MOLD    | 07/23/99     | 08/19/99 | \$56/EA (60M PER YR)                                                                                                       | \$15,300.00 | 8-10 WKS |
| D-300365& D-300364 FAMILY MOLD | MAGAZINE BOX BTM AND FOLLOWER | PAR 4 PLASTIC   | (2 + 2 MOLD) |          | #300364: FOLLOWER=\$.093/EA; #300365: MAG BOX BTM=\$.105/EA                                                                | \$78,786.00 | 18 WKS   |
|                                |                               | KELLEMS AND COE | (4 + 4 MOLD) |          | #300364: FOLLOWER=20M=\$.247/EA; 40M=\$.242/EA; 60M=\$.238/EA; #300365=BOT TOM=20M=\$.314/EA; 40M=\$.309/EA; 60M=\$.305/EA | \$61,000.00 |          |
|                                |                               |                 |              |          |                                                                                                                            |             |          |
|                                |                               |                 |              |          |                                                                                                                            |             |          |
|                                |                               |                 |              |          |                                                                                                                            |             |          |
|                                |                               |                 |              |          |                                                                                                                            |             |          |
|                                |                               |                 |              |          |                                                                                                                            |             |          |
|                                |                               |                 |              |          |                                                                                                                            |             |          |

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| PLASTICS (CONTINUED) |             |                       |          |          |                                                                |              |            |
|----------------------|-------------|-----------------------|----------|----------|----------------------------------------------------------------|--------------|------------|
| PART NUMBER          | DESCRIPTION | VENDOR                | RFQ SENT | DUE BACK | QUOTE                                                          | SET-UP       | LEAD TIME  |
| C-300362             | LATCH       | PAR 4 PLASTIC         | 07/23/99 | 08/19/99 | 20M=\$.245/EA;<br>40M=\$.231/EA;<br>60M=\$.212/EA              | \$33,480.00  | 14 WKS     |
|                      |             | KELLUM AND COE        | 07/23/99 | 08/19/99 | 20M=\$.191/EA;<br>40M=\$.186/EA;<br>60M=\$.182/EA              | \$39,000.00  |            |
|                      |             | COMPLEX TOOLING       | 07/23/99 | 08/19/99 |                                                                |              |            |
|                      |             | HI-TECH MOLD          | 07/23/99 | 08/19/99 | \$.58/EA (EST 60M YRLY)                                        | \$18,000.00  | 8-10 WKS   |
|                      |             |                       |          |          |                                                                |              |            |
|                      |             |                       |          |          |                                                                |              |            |
|                      | STOCK       | PAR 4 PLASTIC         | 07/23/99 | 08/19/99 | 20M=\$5.38/EA;<br>40M=\$5.27/EA;<br>60M=\$5.17/EA              | \$150,300.00 | 21 WKS.    |
|                      |             | COMPLEX TOOLING       | 07/23/99 | 08/19/99 |                                                                |              |            |
|                      |             |                       |          |          |                                                                |              |            |
|                      |             | THE HANSON GROUP      |          |          | \$11.02/EA=20% GF POLY;<br>\$11.37/EA=20% POLY USING IQC TECH. | \$105,500.00 |            |
|                      |             | HI-TECH MOLD AND TOOL |          |          | \$18.06/EA (EST. 60M YRLY)                                     | \$249,600.00 | 24-27 WKS. |
|                      |             |                       |          |          |                                                                |              |            |
| C-200257             | BOLT PLUG   | PAR 4 PLASTIC         | 7/23/99  | 8/19/99  | 20M=\$.249/EA;<br>40M=\$.239/EA;<br>60M=\$.215/EA              | \$38,088.00  | 12 WKS.    |
|                      |             |                       |          |          | 20M=\$.215/EA;<br>40M=\$.213/EA;<br>60M=.211/EA                | \$36,000.00  |            |
|                      |             | KELLUM AND COE        | 7/23/99  | 8/19/99  |                                                                |              |            |
|                      |             | COMPLEX TOOLING       | 7/23/99  | 8/19/99  |                                                                |              |            |
|                      |             |                       |          |          |                                                                |              |            |
|                      |             | HI-TECH MOLD          | 7/23/99  | 8/19/99  | \$.61/EA (EST. 60M YRLY)                                       | \$19,800.00  | 8-10 WKS   |
|                      |             |                       |          |          |                                                                |              |            |

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| MACHINING   |             |                                      |          |          |                                                |                           |                                    |
|-------------|-------------|--------------------------------------|----------|----------|------------------------------------------------|---------------------------|------------------------------------|
| PART NUMBER | DESCRIPTION | VENDOR                               | RFQ SENT | DUE BACK | QUOTE                                          | SET-UP                    | LEAD TIME                          |
| D-300339    | BOLT BODY   | NOLTE SCREW MACHINE                  | 07/26/99 | 08/19/99 |                                                |                           |                                    |
|             |             | KEN MAR TOOL                         | 07/26/99 | 08/19/99 | 20M=\$2.20/EA; 40M=\$2.10/EA;<br>60M=\$2.05/EA | PINK                      |                                    |
|             |             | KEN MAR TOOL                         | 07/26/99 | 08/19/99 | 20M=\$2.05/EA; 40M=\$1.95/EA;<br>60M=\$1.90/EA | YELLOW                    |                                    |
|             |             | TCR                                  | 08/06/99 | 08/26/99 | NO QUOTE-LACK PROPER EQUIPMENT                 |                           |                                    |
|             |             | BETTY MACHINE                        | 08/06/99 | 08/26/99 | NO QUOTE--NOT EQUIPPED TO MAKE                 |                           |                                    |
|             |             | ANDERSON SCREW                       | 07/21/99 | 08/19/99 | UNABLE TO QUOTE-NOT SUITABLE FOR THEIR EQUIP.  |                           |                                    |
|             |             | ISELI                                | 07/21/99 | 08/19/99 | UNABLE TO QUOTE-PROBLEM WITH RAW MATERIAL      |                           |                                    |
|             |             | AUTOMATIC SWISS                      | 07/21/99 | 08/19/99 | UNABLE TO QUOTE-NOT SUITABLE FOR THEIR EQUIP.  |                           |                                    |
|             |             | QUICK TEK MFG.                       | 09/03/99 | ASAP     | NO QUOTE                                       |                           |                                    |
|             |             | NORTHWEST SWISSMATIC<br>MFG          |          | 09/20/99 | NO QUOTE-NOT EQUIPPED                          |                           |                                    |
|             |             | NORTHWEST AUTOMATIC<br>WAUCONDA TOOL |          |          |                                                |                           |                                    |
| D-300339    | BOLT BODY   | G. S. PRECISION                      |          |          | 20M=\$2.54/EA; 40M=\$2.35/EA;<br>60M=\$2.21/EA | COM-<br>PLETE TO<br>PRINT | 20-22 WKS.                         |
|             |             |                                      |          |          |                                                |                           |                                    |
|             |             |                                      |          |          |                                                |                           |                                    |
|             |             |                                      |          |          |                                                |                           |                                    |
| C-300370    | BOLT HANDL  | FANSTEEL ESCAST                      | 08/03/99 | 08/19/99 | 1.63/EA                                        | \$12,575.00               | 11 WKS=<br>SAMP.<br>8 WKS=<br>PROD |
|             |             |                                      |          |          |                                                |                           |                                    |
|             |             |                                      |          |          |                                                |                           |                                    |
|             |             |                                      |          |          |                                                |                           |                                    |
|             |             |                                      |          |          |                                                |                           |                                    |

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| MACHINING                                                                    |             |                                   |          |          |                                                          |                           |           |
|------------------------------------------------------------------------------|-------------|-----------------------------------|----------|----------|----------------------------------------------------------|---------------------------|-----------|
| PART NUMBER                                                                  | DESCRIPTION | VENDOR                            | RFQ SENT | DUE BACK | QUOTE                                                    | SET-UP                    | LEAD TIME |
| E-300340                                                                     | RECEIVER    | CROSROL (COMPLETE)                | 07/26/99 | 08/19/99 | 20M=\$21.75/EA;<br>40M=\$20.26/EA;<br>60M=\$19.51/EA**** | COM-<br>PLETE TO<br>PRINT |           |
|                                                                              |             | NOLTE SCREW MACHINE               | 07/26/99 | 08/19/99 |                                                          |                           |           |
|                                                                              |             | KEN MAR TOOL                      | 07/26/99 | 08/19/99 | 20M=\$3.70/EA; 40M=\$3.55/EA;<br>60M=\$3.30/EA           | PINK                      |           |
|                                                                              |             | KEN MAR TOOL                      | 07/26/99 | 08/19/99 | 20M=\$3.50EA; 40M=\$3.35/EA;<br>60M=\$3.10/EA            | YELLOW                    |           |
|                                                                              |             | TCR                               | 08/06/99 | 08/26/99 | NO QUOTE-LACK PROPER EQUIPMENT                           |                           |           |
|                                                                              |             | BETTY MACHINE                     | 08/05/99 | 08/26/99 | NO QUOTE--NOT EQUIPPED TO MAKE                           |                           |           |
|                                                                              |             | QUICK TEK MFG                     | 09/03/99 | ASAP     | NO QUOTE                                                 |                           |           |
|                                                                              |             | NORTHWEST SWISSMATIC              |          | 09/20/99 | NO QUOTE-NOT EQUIPPED                                    |                           |           |
|                                                                              |             | NORTHWEST AUTOMATIC<br>DEER CREEK |          |          |                                                          |                           |           |
| E-300338                                                                     | BOLT HEAD   | NOLTE SCREW MACHINE               | 07/26/99 | 08/19/99 |                                                          |                           |           |
|                                                                              |             | KEN MAR TOOL                      | 07/26/99 | 08/19/99 | NO QUOTE (NO REASON CITED)                               |                           |           |
|                                                                              |             | TCR                               | 08/06/99 | 08/26/99 | NO QUOTE-LACK PROPER EQUIPMENT                           |                           |           |
|                                                                              |             | BETTY MACHINE                     | 08/06/99 | 08/26/99 | NO QUOTE-NOT EQUIPPED TO MAKE                            |                           |           |
|                                                                              |             | QUICK TEK MFG                     | 09/03/99 | ASAP     | 20M=\$8.47/EA; 40M=\$7.74EA;<br>60M=\$7.51/EA            | \$5,650.00                |           |
|                                                                              |             | ANDERSON SCREW                    | 09/23/99 | ASAP     |                                                          |                           |           |
| BLANK                                                                        | BOLT HEAD   | QUICK TEK                         | 09/03/99 | 09/23/99 | 20M=\$3.96/EA; 40M=\$3.86/EA;<br>60M=\$3.82/EA           |                           |           |
|                                                                              |             | ANDERSON SCREW                    | 09/23/99 | ASAP     |                                                          |                           |           |
|                                                                              |             |                                   |          |          |                                                          |                           |           |
| ****PRICES QUOTED INCLUDE ALL TOOLS, FIXTURES, GAUGES, PROGRAMS, AND SET UP. |             |                                   |          |          |                                                          |                           |           |

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| FASTENERS   |                   |                       |          |          |                                               |        |
|-------------|-------------------|-----------------------|----------|----------|-----------------------------------------------|--------|
| PART NUMBER | DESCRIPTION       | VENDOR                | RFQ SENT | DUE BACK | QUOTE                                         | SET-UP |
| B91128      | SCREW, TRIG. ENG. | EVANSVILLE BOLT & NUT | 07/23/99 | 08/19/99 | 20M=\$6.45/C; 40M=\$4.18/C;<br>60M=\$3.32/C   |        |
|             |                   | FASTENAL              | 07/23/99 | 08/19/99 | 20M=\$40.25/M; 40M=\$32.65/M<br>60M=\$29.05/M |        |
|             |                   |                       |          |          |                                               |        |
| B17053      | SCREW, TRIG STOP  | EVANSVILLE BOLT & NUT | 07/23/99 | 08/19/99 | 20M=\$6.80/C; 40M=\$3.78/C;<br>60M=\$3.07/C   |        |
|             |                   | FASTENAL              | 07/23/99 | 08/19/99 | 20M=\$39.50/M; 40M=\$32.40/M<br>60M=\$28.80/M |        |
|             |                   |                       |          |          |                                               |        |
| A-15481     | SCREW, TRIG STOP  | EVANSVILLE BOLT & NUT | 07/23/99 | 08/19/99 | 20M=\$6.72/C; 40M=\$4.45/C;<br>60M=\$3.66/C   |        |
|             |                   | FASTENAL              | 07/23/99 | 08/19/99 | 20M=\$41.50/M; 40M=\$32.40/M<br>60M=\$29.25/M |        |
|             |                   |                       |          |          |                                               |        |
| A-90906     | SCREW ELEVATION   | EVANSVILLE BOLT & NUT | 07/23/99 | 08/19/99 | 20M=\$5.64/C; 40M=\$4.95/100;<br>60M=\$3.96/C |        |
|             |                   | FASTENAL              | 07/23/99 | 08/19/99 | 20M=\$36.00/M; 40M=\$27.00/M<br>60M=\$24.00/M |        |
|             |                   |                       |          |          |                                               |        |
| A-94555     | PIN, SPIRAL       | EVANSVILLE BOLT & NUT | 07/23/99 | 08/19/99 | 20M=\$1.35/C; 60M=\$1.12/C                    |        |
|             |                   | FASTENAL              | 07/23/99 | 08/19/99 | 20M=\$15.00/M; 40M=\$13.88/M                  |        |
|             |                   |                       |          |          |                                               |        |
|             |                   |                       |          |          |                                               |        |
|             |                   |                       |          |          |                                               |        |
|             |                   |                       |          |          |                                               |        |
|             |                   |                       |          |          |                                               |        |
|             |                   |                       |          |          |                                               |        |







#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 96 | \$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                | \$4,893 90  | \$5,000 00   |              |                   | Turn O D & Inspect                 |
| 70   | 70    | Cut-off & Crown Muzzle End                                                                                                  | Clamping Chuck                 |        |          |     | \$ -        | 0 000000       |                      |             |              |              |                   |                                    |
|      |       |                                                                                                                             |                                |        |          |     | \$ -        | 0 011670       | \$0 08               | \$1,440 56  | \$15,000 00  |              |                   | M710 Cutoff and Crown Operation    |
|      |       |                                                                                                                             |                                |        |          |     |             | 0 080145       |                      |             |              |              |                   |                                    |
| 80   | 80    | Face, Chamber, Machine Hub End, Drill & Tap Takedown Screw Holes, Mill Recoil Lug Slot & 100% Inspect Chamber Finish Gaging | Okuma LB-300 Chamber operation |        |          |     | \$ -        |                | \$0 00               | \$0 00      | \$222,880 00 |              |                   | M710 Chamber Operation             |
|      |       |                                                                                                                             |                                |        |          |     |             |                |                      |             | \$0 00       |              |                   |                                    |
| 90   | 90    | Wash & Magnaflux Barrel                                                                                                     |                                |        |          |     |             | 0 013100       |                      |             |              |              |                   |                                    |
| 100  | 100   | Drill & Tap Sight Screw Holes Gaging                                                                                        |                                |        |          |     |             | 0 090000       |                      |             |              |              |                   |                                    |
| 110  | 110   | Induction Heat Treat Hub                                                                                                    |                                |        |          |     |             | 0 000000       |                      |             |              |              |                   |                                    |
| 120  | 120   | Press Receiver onto Barrel Gaging                                                                                           |                                |        |          |     |             | 0 023378       |                      |             |              |              |                   |                                    |
| 130  | 130   | Inspect for Runout & Straighten if Necessary                                                                                |                                |        |          |     |             | 0 000000       |                      |             |              |              |                   |                                    |
| 140  | 140   | Roll Mark                                                                                                                   |                                |        |          |     |             | 0 003000       |                      |             |              |              |                   |                                    |
| 150  | 150   | Angularly Straighten Muzzle & Inspect Bore                                                                                  |                                |        |          |     |             | 0 006667       |                      |             |              |              |                   |                                    |
| 160  | 160   | Centerless Polish                                                                                                           |                                |        |          |     |             | 0 004467       |                      |             |              |              |                   |                                    |
| 170  | 170   | Glass Bead                                                                                                                  |                                |        |          |     |             | 0 005556       |                      |             |              |              |                   |                                    |
| 180  | 180   | Black Oxide                                                                                                                 |                                |        |          |     |             | 0 004167       |                      |             |              |              |                   |                                    |
|      |       | TOTALS                                                                                                                      |                                |        |          |     | \$ 4 800    | 0 246988       | \$0 59               | \$25,694 14 | \$255,960 00 | \$0 00       | 0 00              |                                    |

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## 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          | 2.29        |                                 |
| 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 18        |                                 |
| 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 08                            |
|        | Rear Screw Bushing    |             | 0 05                            |
| 300405 | Mag Latch Spring      |             | 0.02                            |
| 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        |                                 |
|        | Carton Assy (Ilion)   | 2.05        |                                 |

|                                     |        |
|-------------------------------------|--------|
| Total Material \$ New known to date | 22.628 |
| % of Total anticipated              | 53.73% |

|                                                  |        |
|--------------------------------------------------|--------|
| Total Material \$ Estimated or from M700 costing | 6.07   |
| % of Total anticipated                           | 14.41% |

|                     |        |
|---------------------|--------|
| Total Add Use Parts | 13.42  |
| Add Use is          | 31.86% |

|                                        |        |
|----------------------------------------|--------|
| % of total material cost know by quote | 85.59% |
|----------------------------------------|--------|

## Add Use from M700

| Part # | Part Name               | Material \$ | Quotes from Mayfield |
|--------|-------------------------|-------------|----------------------|
| 1444   | Carton Assy             | 2 05        |                      |
| 15666  | Sear Safety Cam         | 0.94        |                      |
| 17047  | Sear Spring             | 0.02        |                      |
| 15280  | Trgger                  | 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 18        |                      |
| 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 31.86% % of total

MF0681

## Add Use from M700

| Part #              | Part Name               | Material | Quotes from 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 Screw   | 0.09     |                      |
| 15151               | Front Screw Bushing     | 0.13     |                      |
| 97971               | Grip Cap                | 0.18     |                      |
| 97973               | Recoil Pad              | 1.63     |                      |
| 98008               | Recoil Pad Screws       | 0.05     | 0.012                |
| 17028               | Magazine Spring         | 0.42     |                      |
| Total Add Use Parts |                         | \$13.42  |                      |

1601 WSRAT \$0.603  
 1609 TOP \$0.150

MF0682

| Part # | Part Name           | Dwg #   | Rev# | Ilion<br>SAP<br>Cost | Mayfield<br>Quote | Mayfield<br>Requirement<br>From Ilion for<br>2000 | Mayfield<br>Requirement<br>From Ilion for<br>2001 | Comments                                                                                                |
|--------|---------------------|---------|------|----------------------|-------------------|---------------------------------------------------|---------------------------------------------------|---------------------------------------------------------------------------------------------------------|
| 17047  | Sear Spring         | A-17047 | 26   | \$0.023              | \$0.038           | 7250                                              | 0                                                 | Purchase from Ilion in 2000 and buy from our own source in 2001                                         |
| 19461  | Trigger Connector   | C-19461 | 21   | \$1.476              |                   | 7250                                              | 20,000                                            | Re-evaluate in 2000. Several secondaries currently done in Ilion.                                       |
| 15400  | Trigger Spring      | A-15400 | 11   | \$0.031              | \$0.062           | 7250                                              | 0                                                 | Purchase from Ilion in 2000 and buy from our own source in 2001                                         |
| 17044  | Snap Washer         | B-17044 | 26   | \$0.090              |                   | 7250                                              | 0                                                 | Purchase direct from Ilion vendor and secondary heat treat to be done by Mayfield source.               |
| 93712  | Extractor           | C-93712 | 2    | \$0.783              |                   | 7250                                              | 0                                                 | Purchase direct from Ilion vendor and secondary heat treat to be done by Mayfield source.               |
| 94555  | Ejector Pin         | A-94555 | 1    | \$0.014              | \$0.014           | 7250                                              | 0                                                 | Purchase from Ilion in 2000 and buy from our own source in 2001                                         |
| 15161  | Front Screw Bushing | B-15161 |      | \$0.149              |                   | 7250                                              | 20,000                                            | Purchase from Ilion or Ilion source.                                                                    |
| 97971  | Grip Cap            | C-97971 | -    | \$0.180              |                   | 7250                                              | 20,000                                            | Maintained by Ilion                                                                                     |
| 97973  | Recoil Pad          | D-97973 | 26   | \$1.610              |                   | 7250                                              | 20,000                                            | Maintained by Ilion                                                                                     |
| 1444   | Carton Corr.        |         |      | \$1.963              | \$0.444           | 0                                                 | 0                                                 | Cost savings suggests, Mayfield to purchase tool and Ilion to purchase direct from the Mayfield vendor. |

1601

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MF0683

|  |               |  |  |  |         |   |   |                                                                                                         |
|--|---------------|--|--|--|---------|---|---|---------------------------------------------------------------------------------------------------------|
|  | Carton Insert |  |  |  | \$0.870 | 0 | 0 | Cost savings suggests, Mayfield to purchase tool and Ilion to purchase direct from the Mayfield vendor. |
|--|---------------|--|--|--|---------|---|---|---------------------------------------------------------------------------------------------------------|

CONFIDENTIAL

| Part # | Part Name            | Dwg #   | Rev# | Ilion<br>SAP<br>Cost | Mayfield<br>Quote | Mayfield<br>Requirement<br>From Ilion for<br>2000 | Mayfield<br>Requirement<br>From Ilion for<br>2001 | Comments                                                                     |
|--------|----------------------|---------|------|----------------------|-------------------|---------------------------------------------------|---------------------------------------------------|------------------------------------------------------------------------------|
| 15666  | Sear Safety Cam      | C-15666 | 24   | 0.952                | 0.759             | 7250                                              | 20,000                                            | Secondaries<br>completed in Ilion.<br>Part received in<br>Mayfield complete. |
| 15280  | Trigger              | C-15280 | 31   | 1.91                 | 0.738             | 0                                                 | 0                                                 | Possible trigger re-<br>designed for M710.<br>Otherwise 20,000 in<br>2001.   |
| 94084  | Front sight          | C-15373 | 26   | 0.806                | 0.82              | 7250                                              | 20,000                                            | Vibratory deburr,<br>black oxide and paint<br>in Mayfield                    |
| 94657  | front Sight Ramp     | B-28510 | 33   | 1.18                 | ---               | 7250                                              | 20,000                                            | Vibratory deburr and<br>black oxide in<br>Mayfield                           |
| 94333  | Rear Sight Aperature | C-93905 | 9    | 0.35                 | 0.294             | 7250                                              | 20,000                                            | Vibratory deburr and<br>black oxide in<br>Mayfield                           |
| 103531 | Rear Sight Base      | C-10353 | 3    | 1.01                 | 1.65              | 7250                                              | 20,000                                            | Vibratory deburr and<br>black oxide in<br>Mayfield                           |
| 94335  | Rear Sight Slide     | C-93904 | 7    | 1.27                 | 1.2               | 7250                                              | 20,000                                            | Vibratory deburr and<br>black oxide in<br>Mayfield                           |

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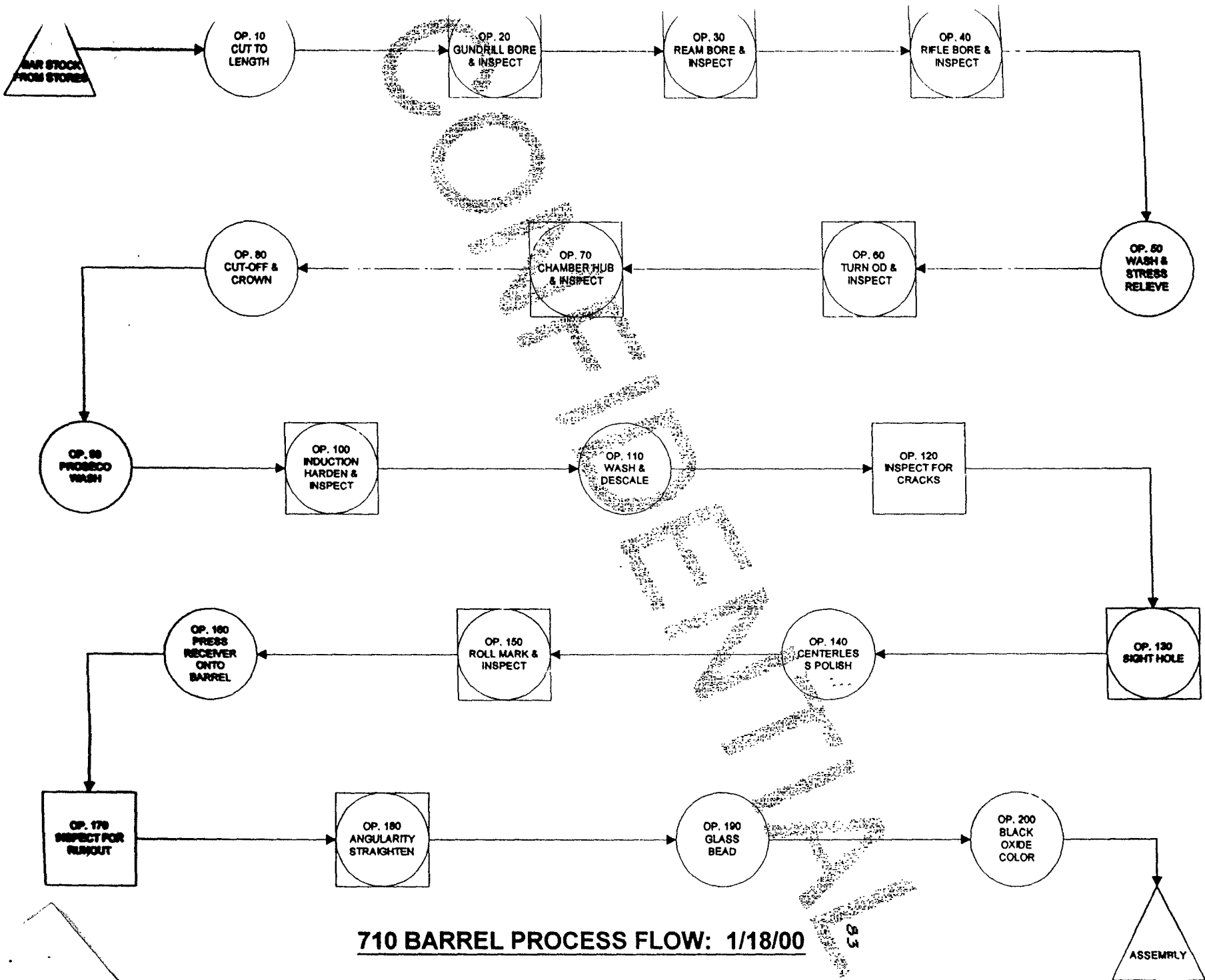
MF0685

Confidential - ~~BARBER~~ - 5.22.06r0010635 Order

Williams v. Remington

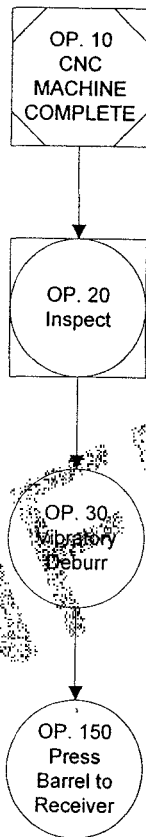
| Part # | Part Name               | Dwg #   | Rev# | Ilion<br>SAP<br>Cost | Mayfield<br>Quote | Mayfield<br>Requirement<br>From Ilion for<br>2000 | Mayfield<br>Requirement<br>From Ilion for<br>2001 | Comments |
|--------|-------------------------|---------|------|----------------------|-------------------|---------------------------------------------------|---------------------------------------------------|----------|
| 17053  | Trigger Front Screw     | B-17053 | 32   | 0.105                | 0.039             | 7250                                              | 0                                                 |          |
| 91128  | Engagement Screw        | B-91128 | 7    | 0.027                | 0.04              | 7250                                              | 20,000                                            |          |
| 15481  | Trigger Stop Screw      | A-15481 | 9    | 0.062                | 0.041             | 7250                                              | 0                                                 |          |
| 17034  | Receiver Plug Screws    | B-17034 | 34   | 0.033                | 0.038             | 29000                                             | 80,000                                            |          |
| 28505  | Front Sight Ramp Screws | B-28505 | 21   | 0.047                | 0.039             | 7250                                              | 0                                                 |          |
| 90906  | Elevation Screw         | A-90906 | 19   | 0.023                | 0.006             | 7250                                              | 20,000                                            |          |
| 90904  | Windage Screw           | B-90904 | 8    | 0.022                | 0.163             | 7250                                              | 0                                                 |          |
| 28505  | Rear Sight Base Screws  | B-28505 | 11   | 0.047                | 0.038             | 14500                                             | 0                                                 |          |
| 98008  | Recoil Pad Screws       | A-98008 | 7    | 0.266                | 0.012             | 7250                                              | 0                                                 |          |

MF0686



710 BARREL PROCESS FLOW: 1/18/00

ME0687



RECEIVER

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### Product Routing

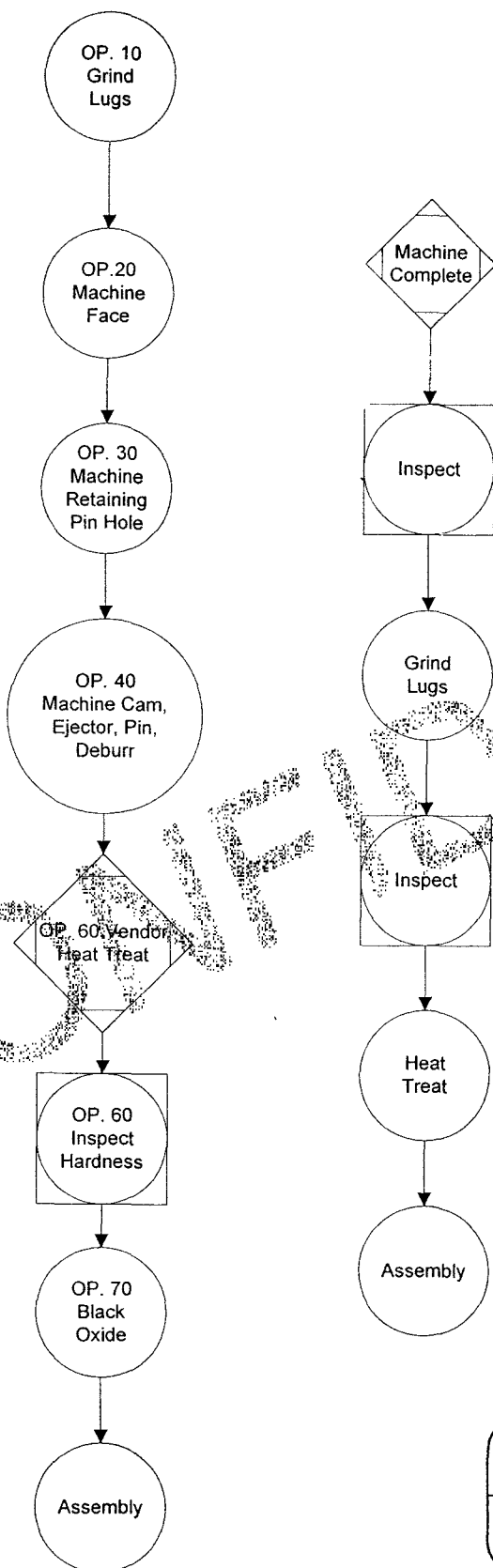
M710

1/31/00

Plant Layout  
Team

MF0688

Probable Path



BOLT HEAD

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Product Routing

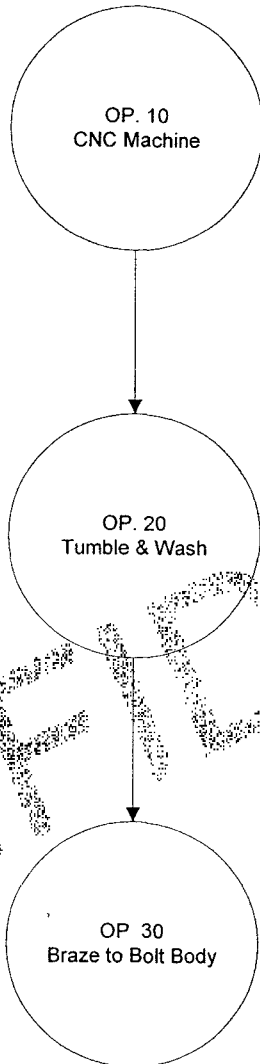
M710

2/1/00

Plant Layout  
Team

MF0689

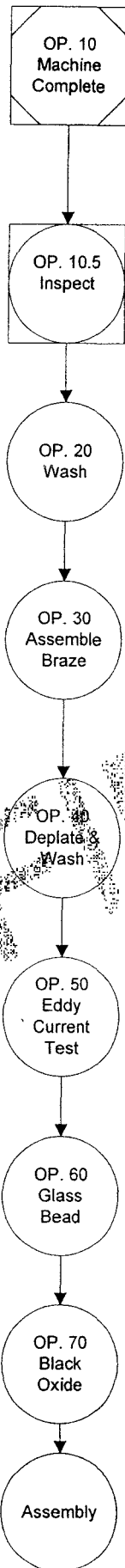
## BOLT HANDLE



### Product Routing

|      |         |                   |
|------|---------|-------------------|
| M710 | 1/31/00 | Plant Layout Team |
|------|---------|-------------------|

MF0690



BOLT BODY 83

### Product Routing

|      |         |                   |
|------|---------|-------------------|
| M710 | 1/31/00 | Plant Layout Team |
|------|---------|-------------------|

MF0691

## TAKEDOWN SCREW MOVEMENT TEST

### **Objective:**

Measure the movement if any that occurs with the takedown screws when subjected to sudden shock and vibrations from normal handling/shooting.

### **Tests 1:**

1. Set torque of front and middle screw to 40 ft/lbs.; hand tighten back screw.
  - Tap on gun stock in several locations on shooter's left and right
  - Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.
2. Set torque of front and middle screw to 60 ft/lbs.; hand tighten back screw.
  - Tap on gun stock in several locations on shooter's left and right
  - Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.

### **Test 2:**

3. Set torque of front and middle screw to 40 ft/lbs.; hand tighten back screw.
  - Tap on gun stock in several locations on shooter's left and right
  - Retighten screws
  - Tap on gun stock in several locations on shooter's left and right
  - Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.
4. Set torque of front and middle screw to 60 ft/lbs.; hand tighten back screw.
  - Tap on gun stock in several locations on shooter's left and right
  - Retighten screws
  - Tap on gun stock in several locations on shooter's left and right
  - Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.

### **Tests 3:**

5. Set torque of front and middle screw to 40 ft/lbs.; hand tighten back screw.
  - Tap on gun stock in several locations on shooter's left and right
  - Retighten screws
  - Tap on gun stock in several locations on shooter's left and right

MF0692

- Retighten screws
  - Tap on gun stock in several locations on shooter's left and right
  - Retighten screws
  - Tap on gun stock in several locations on shooter's left and right
  - Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.
6. Set torque of front and middle screw to 60 ft/lbs.; hand tighten back screw.
- Tap on gun stock in several locations on shooter's left and right
  - Retighten screws
  - Tap on gun stock in several locations on shooter's left and right
  - Retighten screws
  - Tap on gun stock in several locations on shooter's left and right
  - Retighten screws
  - Tap on gun stock in several locations on shooter's left and right
  - Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.

#### Tests 4:

7. Set torque of front and middle screw to 40 ft/lbs.; hand tighten back screw.
- Tap on gun stock in several locations on shooter's left and right
  - Retighten Screws
  - Shoot (1) proof + (2) regular rounds
  - Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.
8. Set torque of front and middle screw to 60 ft/lbs.; hand tighten back screw.
- Tap on gun stock in several locations on shooter's left and right
  - Retighten Screws
  - Shoot (1) proof + (2) regular rounds
  - Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.

#### Tests 5:

9. Bias stock so that it seats in a natural position before setting screws. Set torque of front and middle screw to 40 ft/lbs.; hand tighten back screw.
- Shoot (2) regular rounds
  - Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.

MF0693

10. Bias stock so that it seats in a natural position before setting screws. Set torque of front and middle screw to 50 ft/lbs.; hand tighten back screw.

- Shoot (2) regular rounds
- Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.

11. Bias stock so that it seats in a natural position before setting screws. Set torque of front and middle screw to 60 ft/lbs.; hand tighten back screw.

- Shoot (2) regular rounds
- Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.

#### TEST 6:

12. Bias stock so that it seats in a natural position before setting screws. Set torque of front and middle screw to 40 ft/lbs.; torque back screw to 20 ft/lbs. 83

---USE 4 guns

- Shoot (5) magazines (20) regular rounds
- Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.

-----OPTIONAL TEST 13 BASED ON TIME CONSTRAINT, PROCEED TO 14-----

13. Bias stock so that it seats in a natural position before setting screws. Set torque of front and middle screw to 50 ft/lbs.; torque back screw to 20 ft/lbs.

---USE 4 guns

- Shoot (5) magazines (20) regular rounds
- Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.

14. Bias stock so that it seats in a natural position before setting screws. Set torque of front and middle screw to 60 ft/lbs.; torque back screw to 20 ft/lbs.

---USE 4 guns

- Shoot (5) magazines (20) regular rounds
- Measure torque w/ torque wrench-measurement should be taken from force needed to loosen screw.

## RESULTS:

## TEST 1.1

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 40     | 32.5      | 18.75       |
| Middle | 40     | 38.5      | 3.75        |
| Back   | 10     | 8         | 20          |

## TEST 1.2

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 60     | 45        | 25          |
| Middle | 60     | 42.5      | 29.2        |
| Back   | 10     | 9         | 10          |

## TEST 2.3

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 40     | 30        | 25          |
| Middle | 40     | 35        | 12.5        |
| Back   | 10     | 9         | 10          |

## TEST 2.4

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 60     | 48        | 20          |
| Middle | 60     | 44        | 26.7        |
| Back   | 10     | 8         | 20          |

## TEST 3.5

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 40     | 35        | 12.5        |
| Middle | 40     | 39        | 2.5         |
| Back   | 10     | 10        | 0           |

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MF0695

## TEST 3.6

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 60     | 45        | 25          |
| Middle | 60     | 48        | 20.0        |
| Back   | 10     | 10        | 0           |

## TEST 4.7

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 40     | 20        | 50          |
| Middle | 40     | 28        | 30.0        |
| Back   | 10     | 8         | 20          |

## TEST 4.8

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 60     | 32        | 46.66666667 |
| Middle | 60     | 40        | 33.3        |
| Back   | 10     | 9         | 10          |

## TEST 5.9

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 40     | 25        | 37.5        |
| Middle | 40     | 35        | 12.5        |
| Back   | 10     | 5         | 50          |

## TEST 5.10

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 50     | 25        | 50          |
| Middle | 50     | 32        | 36.0        |
| Back   | 10     | 0         | 100         |

MF0696

## TEST 5.11

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 60     | 53        | 11.6666667  |
| Middle | 60     | 50        | 16.7        |
| Back   | 10     | 10        | 0           |

## TEST 6.12-1

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 40     | 10        | 75          |
| Middle | 40     | 28        | 30.0        |
| Back   | 20     | 18        | 10          |

## TEST 6.12-2

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 40     | 20        | 50          |
| Middle | 40     | 28        | 30.0        |
| Back   | 20     | 14        | 30          |

## TEST 6.12-3

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 40     | 19        | 52.5        |
| Middle | 40     | 30        | 25.0        |
| Back   | 20     | 14        | 30          |

## TEST 6.12-4

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 40     | 18        | 55          |
| Middle | 40     | 30        | 25.0        |
| Back   | 20     | 13        | 35          |

## AVERAGE TEST RESULT of 6-12:(1-4)

|         | Reduction | % Reduction |
|---------|-----------|-------------|
| FRONT:  | 16.75     | 58.2        |
| MIDDLE: | 29        | 27.5        |
| BACK:   | 14.75     | 63.2        |

MF0697

## TEST 6.14-1

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 60     | 30        | 50          |
| Middle | 60     | 32        | 46.7        |
| Back   | 20     | 15        | 25          |

## TEST 6.14-2

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 60     | 18        | 70.0        |
| Middle | 60     | 42        | 30.0        |
| Back   | 20     | 18        | 10          |

## TEST 6.14-3

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 40     | 28        | 30          |
| Middle | 40     | 40        | 0.0         |
| Back   | 20     | 16        | 20          |

## TEST 6.14-4

|        | Target | Reduction | % Reduction |
|--------|--------|-----------|-------------|
| Front  | 60     | 25        | 58.33333333 |
| Middle | 60     | 38        | 36.7        |
| Back   | 20     | 15        | 35          |

## AVERAGE TEST RESULT of 6-14:(1-4)

|         | Reduction | % Reduction |
|---------|-----------|-------------|
| FRONT:  | 25.25     | 57.91       |
| MIDDLE: | 38        | 36.67       |
| BACK:   | 15.5      | 74.12       |

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MF0698

710 TRAIL & PILOT SERIES- B  
11/15/00

## PRELIMINARY MEASUREMENTS &amp; CHECKS

BLUE INDICATES BELOW SPEC.  
RED INDICATES ABOVE SPEC.

TEST LAB TRACKING NUMBER- TLW0300

## PROOF TEST &amp; MAGNAFLUX COMPLETED AT MAYFIELD

| GUN ID #               | SERIAL NUMBER | INSPECT FOR PROOF STAMP | INSPECT FOR MAGNAFLUX STAMP | HEADSPACE, REM. SPEC GAUGES                                                                              | TRIGGER PULL WITH SPRING SCALE |      |      |         | FIRING PIN INDENT WITH COPPER CRUSHERS |       |       |         | SEAR TO TRIGGER ENGAGEMENT  |        |        |         | SEAR LIFT                   |        |        |         |
|------------------------|---------------|-------------------------|-----------------------------|----------------------------------------------------------------------------------------------------------|--------------------------------|------|------|---------|----------------------------------------|-------|-------|---------|-----------------------------|--------|--------|---------|-----------------------------|--------|--------|---------|
|                        |               |                         |                             |                                                                                                          | TLW0300J                       |      |      |         | TLW0300H                               |       |       |         | TLW0300I out of stock @ 20X |        |        |         | TLW0300I out of stock @ 20X |        |        |         |
|                        |               |                         |                             |                                                                                                          | 1                              | 2    | 3    | AVERAGE | 1                                      | 2     | 3     | AVERAGE | 1                           | 2      | 3      | AVERAGE | 1                           | 2      | 3      | AVERAGE |
| B-1                    | 71001124      | YES                     | YES                         | MIN.+002                                                                                                 | 5                              | 5    | 5.5  | 5.17    | 0.017                                  | 0.017 | 0.018 | 0.0173  | 0.0297                      | 0.0298 | 0.0288 | 0.0274  | 0.0122                      | 0.0139 | 0.0133 | 0.0131  |
| B-2                    | 71001184      | Y                       | Y                           | MIN.+002                                                                                                 | 5.25                           | 5.5  | 5.5  | 5.25    | 0.018                                  | 0.017 | 0.018 | 0.0177  | 0.0277                      | 0.0278 | 0.0268 | 0.0274  | 0.0127                      | 0.0132 | 0.0131 | 0.0130  |
| B-3                    | 71001244      | Y                       | Y                           | MIN.+002                                                                                                 | 4.25                           | 4.75 | 4.25 | 4.42    | 0.017                                  | 0.016 | 0.018 | 0.0170  | 0.0282                      | 0.0291 | 0.0272 | 0.0282  | 0.015                       | 0.0145 | 0.0147 | 0.0147  |
| B-4                    | 71001288      | Y                       | Y                           | MIN.+001                                                                                                 | 5                              | 4.5  | 4.25 | 4.58    | 0.018                                  | 0.016 | 0.018 | 0.0173  | 0.032                       | 0.0311 | 0.0307 | 0.0313  | 0.0151                      | 0.0173 | 0.0167 | 0.0164  |
| B-5                    | 71001421      | Y                       | Y                           | MIN.+001                                                                                                 | 4.25                           | 4    | 4    | 4.08    | 0.018                                  | 0.018 | 0.017 | 0.0177  | 0.0268                      | 0.027  | 0.026  | 0.0266  | 0.0134                      | 0.0123 | 0.0113 | 0.0123  |
| B-6                    | 71001462      | Y                       | Y                           | MIN.+001                                                                                                 | 4.75                           | 4.25 | 4.25 | 4.42    | 0.018                                  | 0.016 | 0.017 | 0.0163  | 0.0262                      | 0.0261 | 0.0259 | 0.0261  | 0.012                       | 0.0124 | 0.0121 | 0.0122  |
| B-7                    | 71001504      | Y                       | Y                           | MIN.+001                                                                                                 | 5.5                            | 5.25 | 5    | 5.25    | 0.017                                  | 0.016 | 0.016 | 0.0163  | 0.0294                      | 0.0299 | 0.0294 | 0.0296  | 0.0154                      | 0.0139 | 0.0136 | 0.0143  |
| B-8                    | 71001511      | Y                       | Y                           | OUT OF TEST. TRIGGER LOCATED TO THE RIGHT OF CENTER IN TRIGGER GUARD. GUN HELD FOR MARKETING EVALUATION. |                                |      |      |         |                                        |       |       |         |                             |        |        |         |                             |        |        |         |
| B-9                    | 71001524      | Y                       | Y                           | MIN.+001                                                                                                 | 5.5                            | 5.25 | 5.25 | 5.33    | 0.017                                  | 0.018 | 0.017 | 0.0173  | 0.0265                      | 0.0267 | 0.0281 | 0.0271  | 0.0138                      | 0.0132 | 0.0145 | 0.0138  |
| B-10                   | 71001529      | Y                       | Y                           | MIN.+001                                                                                                 | 5.5                            | 5.25 | 5.25 | 5.33    | 0.017                                  | 0.018 | 0.017 | 0.0173  | 0.0287                      | 0.0283 | 0.0302 | 0.0291  | 0.0123                      | 0.0141 | 0.0141 | 0.0135  |
| B-11                   | 71001534      | Y                       | Y                           | MIN.+002                                                                                                 | 4.5                            | 5    | 4.5  | 4.67    | 0.017                                  | 0.017 | 0.017 | 0.0170  | 0.0311                      | 0.031  | 0.0306 | 0.0309  | 0.0141                      | 0.0137 | 0.0131 | 0.0136  |
| B-12                   | 71001535      | Y                       | Y                           | MIN.+001                                                                                                 | 5.5                            | 5    | 4.75 | 5.08    | 0.019                                  | 0.018 | 0.018 | 0.0183  | 0.0273                      | 0.0283 | 0.0286 | 0.0281  | 0.0144                      | 0.0137 | 0.013  | 0.0137  |
| B-13                   | 71001539      | Y                       | Y                           | MIN.+001                                                                                                 | 5.5                            | 5    | 5    | 5.17    | 0.017                                  | 0.017 | 0.017 | 0.0177  | 0.0291                      | 0.0295 | 0.0299 | 0.0295  | 0.0152                      | 0.0143 | 0.0146 | 0.0147  |
| B-14                   | 71001559      | Y                       | Y                           | MIN.+002                                                                                                 | 5                              | 5    | 5    | 5.00    | 0.019                                  | 0.019 | 0.02  | 0.0193  | 0.0314                      | 0.0308 | 0.0315 | 0.0312  | 0.013                       | 0.0126 | 0.0149 | 0.0135  |
| B-15                   | 71001578      | Y                       | Y                           | MIN.                                                                                                     | 4.5                            | 4.75 | 4.5  | 4.58    | 0.017                                  | 0.017 | 0.017 | 0.0170  | 0.029                       | 0.0279 | 0.0293 | 0.0287  | 0.0162                      | 0.0163 | 0.0158 | 0.0161  |
| B-16                   | 71001580      | Y                       | Y                           | MIN.+001                                                                                                 | 5.75                           | 5.5  | 6    | 5.75    | 0.017                                  | 0.018 | 0.018 | 0.0177  | 0.0307                      | 0.0304 | 0.0313 | 0.0308  | 0.0156                      | 0.0161 | 0.0158 | 0.0158  |
| B-17                   | 71001583      | Y                       | Y                           | MIN.+002                                                                                                 | 5                              | 5    | 5.25 | 5.08    | 0.017                                  | 0.018 | 0.019 | 0.0180  | 0.036                       | 0.0375 | 0.0366 | 0.0367  | 0.0137                      | 0.0135 | 0.0137 | 0.0136  |
| B-18                   | 71001584      | Y                       | Y                           | MIN.+001                                                                                                 | 4.75                           | 6    | 6.25 | 5.67    | 0.018                                  | 0.018 | 0.017 | 0.0170  | 0.0291                      | 0.0272 | 0.0286 | 0.0283  | 0.014                       | 0.0138 | 0.0138 | 0.0139  |
| B-19                   | 71001595      | Y                       | Y                           | MIN.+001                                                                                                 | 5                              | 5.5  | 5.25 | 5.25    | 0.018                                  | 0.018 | 0.019 | 0.0187  | 0.0286                      | 0.0282 | 0.0286 | 0.0285  | 0.0119                      | 0.0119 | 0.011  | 0.0116  |
| B-20                   | 71001605      | Y                       | Y                           | MIN.+001                                                                                                 | 5                              | 4.5  | 4.75 | 4.75    | 0.018                                  | 0.016 | 0.017 | 0.0163  | 0.0262                      | 0.0271 | 0.026  | 0.0264  | 0.0175                      | 0.0153 | 0.0165 | 0.0164  |
| B-21                   | 71001613      | Y                       | Y                           | BELOW MIN.                                                                                               | 5.75                           | 5.75 | 5.25 | 5.58    | 0.017                                  | 0.017 | 0.018 | 0.0173  | 0.0256                      | 0.0256 | 0.0251 | 0.0254  | 0.0151                      | 0.0146 | 0.0145 | 0.0147  |
| B-22                   | 71001623      | Y                       | Y                           | MIN                                                                                                      | 4.75                           | 4.75 | 5.25 | 4.92    | 0.016                                  | 0.018 | 0.018 | 0.0173  | 0.0271                      | 0.0273 | 0.0282 | 0.0269  | 0.0134                      | 0.0134 | 0.0144 | 0.0137  |
| B-23                   | 71001632      | Y                       | Y                           | MIN.+001                                                                                                 | 5                              | 4.75 | 5.25 | 5.00    | 0.018                                  | 0.016 | 0.017 | 0.0170  | 0.0267                      | 0.0271 | 0.0278 | 0.0272  | 0.0126                      | 0.015  | 0.0157 | 0.0144  |
| B-24                   | 71001634      | Y                       | Y                           | MIN.+001                                                                                                 | 5.5                            | 5.5  | 5.25 | 5.42    | 0.019                                  | 0.017 | 0.017 | 0.0177  | 0.0279                      | 0.0278 | 0.0288 | 0.0282  | 0.0145                      | 0.0141 | 0.0149 | 0.0145  |
| B-25                   | 71001643      | Y                       | Y                           | MIN.+001                                                                                                 | 4.25                           | 4    | 4.5  | 4.25    | 0.018                                  | 0.017 | 0.018 | 0.0177  | 0.0301                      | 0.0304 | 0.0312 | 0.0306  | 0.0156                      | 0.013  | 0.0149 | 0.0145  |
| B-26                   | 71001647      | Y                       | Y                           | MIN.+001                                                                                                 | 5                              | 5    | 5    | 5.00    | 0.017                                  | 0.017 | 0.017 | 0.0170  | 0.0269                      | 0.0285 | 0.0292 | 0.0282  | 0.0129                      | 0.0138 | 0.0135 | 0.0134  |
| B-27                   | 71001724      | Y                       | Y                           | MIN.+002                                                                                                 | 5.75                           | 4.75 | 4.25 | 4.92    | 0.019                                  | 0.019 | 0.02  | 0.0193  | 0.0298                      | 0.0304 | 0.0299 | 0.0300  | 0.0163                      | 0.0173 | 0.0175 | 0.0170  |
| B-28                   | 71001760      | Y                       | Y                           | MIN.+002                                                                                                 | 5.25                           | 4.75 | 4.5  | 4.83    | 0.016                                  | 0.017 | 0.016 | 0.0163  | 0.0344                      | 0.036  | 0.0367 | 0.0357  | 0.0171                      | 0.0127 | 0.0149 | 0.0149  |
| B-29                   | 71001782      | Y                       | Y                           | MIN.+002                                                                                                 | 4.25                           | 4.75 | 5    | 4.67    | 0.019                                  | 0.019 | 0.018 | 0.0187  | 0.0294                      | 0.0293 | 0.0303 | 0.0297  | 0.0162                      | 0.0154 | 0.0157 | 0.0158  |
| B-30                   | 71001789      | Y                       | Y                           | MIN.+002                                                                                                 | 4.25                           | 4.5  | 4.5  | 4.42    | 0.019                                  | 0.017 | 0.019 | 0.0183  | 0.0284                      | 0.0285 | 0.0307 | 0.0292  | 0.0128                      | 0.0138 | 0.0131 | 0.0132  |
| TEST AVERAGE           |               |                         |                             |                                                                                                          | 4.96                           |      |      |         | 0.01752                                |       |       |         | 0.02906                     |        |        |         | 0.0132                      |        |        |         |
| SPEC = 4.0 TO 5.5 LBS. |               |                         |                             |                                                                                                          |                                |      |      |         | SAAMI MIN. = .017                      |       |       |         | SPEC = .020 TO .025         |        |        |         | SPEC = .006 TO .018         |        |        |         |

## COMMENTS FROM TECHNICIANS-

STOCK TAKE DOWN SCREWS ARE NOT TIGHTENED TO TORQUE SPEC, SOME ARE BARELY TIGHTENED AT ALL.  
SCOPE RING TO MOUNT SCREWS ARE NOT TIGHT

Bore Sight.

83

ME0699

Confidential - Subject - 5.22.06r0010649 Order

Williams V. Remington

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NOTE- MAR ON RECEIVER OUT OF BOX  
NOTE- MISSING REAR TAKE DOWN SCREW OUT OF BOX, NOTHING IN BOX

NOTE- SAFETY IN FIRE POSITION OUT OF BOX

NOTE- MAR ON STOCK OUT OF BOX

MF0700



**Precision Products Machine & Fab., Inc.**

Phone: (912)375-9169

P.O. BOX 1390/ 220 LATIMER ST.  
HAZLEHURST, Ga. 31539

Fax: (912)375-9161

**From:** Tim Kauger  
**To:** Matt Golemboski  
**Fax #:** 1-270-856-4203  
**Subject:** Quote #2257  
**Date:** November 1, 2000  
**Pages:** 2 pgs., including cover sheet  
**Comments:**

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MF0701



**Precision Products Machine & Fab., Inc.**

Phone: (912)376-9169

P.O. BOX 1380/ 220 LATIMER ST.  
HAZLEHURST, Ga. 31539

Fax: (912)376-9161

**From:** Tim Kauger  
**To:** Matt Golemboski  
**Fax #:** 1-270-856-4203  
**Subject:** Quote #2257  
**Date:** November 1, 2000  
**Pages:** 2 pgs., including cover sheet  
**Comments:**

CONFIDENTIAL

MF0702

Confidential

Remington Arms Co.

## Memo

**To:** 710 team  
**From:** Joe Zajk  
**CC:** 710Nov16  
**Date:** 11/16/00  
**Re:** M/710 Meeting

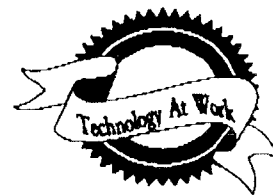
| Action Items                                                                                                                                                                                                                              | Person Responsible    | Completion Date   |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------|-------------------|
| Engagement Screw Modifications<br><ul style="list-style-type: none"> <li>Delivery of new production parts</li> </ul>                                                                                                                      | Mett                  | 11/30             |
| Assembly, Gallery, & Final inspection Procedures – Process Records<br>Changes to area from T&P build experience<br><ul style="list-style-type: none"> <li>Right tooling</li> <li>Space / designated areas for assembly storage</li> </ul> | Jerry / John / Calvin | ASAP              |
| Order preset T-Handle Torque Wrenches for all takedown screws                                                                                                                                                                             | John / Jerry          | ASAP              |
| Serial Number Fixture<br><ul style="list-style-type: none"> <li>Design</li> <li>Build</li> </ul>                                                                                                                                          | Joe                   | 11/15             |
| Resonant Inspection Machine<br><ul style="list-style-type: none"> <li>Cut P.O. by 11/17</li> </ul>                                                                                                                                        | Joe                   | 11/17             |
| Accuracy Device<br><ul style="list-style-type: none"> <li>Status of assembly</li> </ul>                                                                                                                                                   | Kristan / Maintenance | 11/16             |
| Sight Hole Gage<br><ul style="list-style-type: none"> <li>Build Gage – prints out for quote</li> </ul>                                                                                                                                    | Joe                   | P.O. cut by 11/17 |
| Bolt Stop<br><ul style="list-style-type: none"> <li>Status of delivery of parts to Rev. 39</li> </ul>                                                                                                                                     | Mett                  | 11/16/7           |

● Page 1

MF0703

|                                                                                                                                                                  |                      |                                  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|----------------------------------|
| Bolt Plug Insert                                                                                                                                                 |                      |                                  |
| <ul style="list-style-type: none"><li>• Status of Campbell's parts</li><li>• Status of production parts from Anderson Screw</li></ul>                            | Mett<br>Mett         | 11/17<br>11/17                   |
| Screen all guns build for tightness of takedown screws and that all screws are present                                                                           | Production           | ASAP once torque wrenches are in |
| 710 Scope Mounting                                                                                                                                               |                      |                                  |
| <ul style="list-style-type: none"><li>• Determine torque for tightening scope mount screws</li><li>• Order appropriate torque wrench to tighten screws</li></ul> | John<br>John / Jerry | ASAP<br>ASAP                     |
|                                                                                                                                                                  |                      |                                  |

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**Precision Products Machine & Fab., Inc.**

Phone: (912)375-9159

P.O. BOX 1390 / 58 LATIMER ST.  
HAZLEHURST, Ga. 31539

Fax: (912)375-9161

November 1, 2000

Remington Arms Company, Inc.  
Mayfield Plant  
22 Rifle Trail  
PO Box 99  
Hickory, KY 42051

Attn: Mr. Matt Golemboski

Re: Est. #2257

We offer our quote for labor and materials necessary to supply your requirement for Bolt Heads.

20,000 pcs. Bolt Head, ref. dwg. #E-300338:

Partially machined to point of sample provided \$4.90 each

Completely machined including undercuts \$6.15 each

Prices include labor, material, and packaging.

F.O.B. Hazlehurst, Ga.

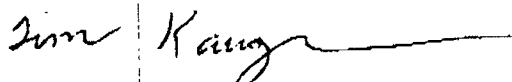
Note: (1) SPC printouts to be provided with shipments according to Remington's requirements.

(2) As per conversation with Matt Golemboski, undercuts will be excluded from SPC data.

(3) Proper alternate methods for measuring undercuts will be later determined between Remington Arms Company and Precision Products Machine.

Submitted by:

PRECISION PRODUCTS MACHINE & FAB., INC.

  
Tim Kauger

MF0705

11/7/10'2 w/latest rev. on bolt plug insert

11/1/00

ser. no's

1 71001232

2 1470

3 1249

4 1463

5 1242

6 1238

7 1245

8 1212

9 1218

10 1460

11 1210

12 1230

13 1250

14 1480

15 1229

16 1191

17 1217

18 1489

19 1223

20 1336

- Joe Proofed

83

11/2/00

TO: JOE  
SHELLY  
MATT  
FROM: JERRY

THESE ARE THE 20 - 11/7/10'2 WITH  
THE LATEST BOLT PLUG INSERT  
REV. "V"

MF0706

| SerialNbr | ModelID | Status   | StatusDate          | UpdatedBy |
|-----------|---------|----------|---------------------|-----------|
| 71001001  | 710     | Scrapped | Sep 20 2000 11:22AM | hutsonlr  |
| 71001002  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001003  | 710     | Scrapped | Sep 20 2000 11:22AM | hutsonlr  |
| 71001007  | 710     | Scrapped | Sep 20 2000 11:22AM | hutsonlr  |
| 71001011  | 710     | Scrapped | Sep 20 2000 11:20AM | hutsonlr  |
| 71001012  | 710     | Scrapped | Sep 15 2000 9:35AM  | hutsonlr  |
| 71001017  | 710     | Scrapped | Sep 20 2000 11:20AM | hutsonlr  |
| 71001021  | 710     | Scrapped | Sep 15 2000 9:35AM  | hutsonlr  |
| 71001026  | 710     | Scrapped | Sep 20 2000 11:22AM | hutsonlr  |
| 71001027  | 710     | Scrapped | Oct 17 2000 8:56AM  | hutsonlr  |
| 71001031  | 710     | Scrapped | Oct 17 2000 8:56AM  | hutsonlr  |
| 71001035  | 710     | Scrapped | Sep 15 2000 9:35AM  | hutsonlr  |
| 71001038  | 710     | Scrapped | Sep 15 2000 9:34AM  | hutsonlr  |
| 71001043  | 710     | Scrapped | Sep 20 2000 11:20AM | hutsonlr  |
| 71001044  | 710     | Scrapped | Oct 17 2000 8:56AM  | hutsonlr  |
| 71001050  | 710     | Scrapped | Sep 15 2000 9:35AM  | hutsonlr  |
| 71001051  | 710     | Scrapped | Sep 7 2000 1:32PM   | hutsonlr  |
| 71001052  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001053  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001054  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001057  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001058  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001066  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001071  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001072  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001076  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001078  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001082  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001084  | 710     | Scrapped | Sep 20 2000 11:20AM | hutsonlr  |
| 71001085  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001086  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001089  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001090  | 710     | Scrapped | Sep 20 2000 11:20AM | hutsonlr  |
| 71001101  | 710     | Scrapped | Oct 23 2000 4:19PM  | hutsonlr  |
| 71001110  | 710     | Scrapped | Oct 17 2000 8:56AM  | hutsonlr  |
| 71001120  | 710     | Scrapped | Oct 17 2000 8:56AM  | hutsonlr  |
| 71001143  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001145  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001146  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001155  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001158  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001159  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001161  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001164  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001165  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001166  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001169  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001170  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001172  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001173  | 710     | Scrapped | Sep 20 2000 11:22AM | hutsonlr  |
| 71001177  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001178  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001180  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001183  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001187  | 710     | Scrapped | Sep 20 2000 11:22AM | hutsonlr  |
| 71001188  | 710     | Scrapped | Sep 20 2000 11:22AM | hutsonlr  |
| 71001189  | 710     | Scrapped | Sep 20 2000 11:21AM | hutsonlr  |
| 71001190  | 710     | Scrapped | Sep 7 2000 1:32PM   | hutsonlr  |
| 71001191  | 710     | Scrapped | Sep 20 2000 11:23AM | hutsonlr  |

MF0707

|          |     |          |                     |          |
|----------|-----|----------|---------------------|----------|
| 71001192 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001195 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001197 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001198 | 710 | Scrapped | Sep 20 2000 11:22AM | hutsonlr |
| 71001199 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001200 | 710 | Scrapped | Sep 20 2000 11:22AM | hutsonlr |
| 71001201 | 710 | Scrapped | Sep 20 2000 11:22AM | hutsonlr |
| 71001203 | 710 | Scrapped | Sep 20 2000 11:22AM | hutsonlr |
| 71001204 | 710 | Scrapped | Sep 20 2000 11:22AM | hutsonlr |
| 71001206 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001248 | 710 | Scrapped | Oct 17 2000 8:56AM  | hutsonlr |
| 71001255 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001257 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001259 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001260 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001263 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001264 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001266 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001270 | 710 | Scrapped | Sep 20 2000 11:20AM | hutsonlr |
| 71001271 | 710 | Scrapped | Sep 20 2000 11:20AM | hutsonlr |
| 71001272 | 710 | Scrapped | Sep 20 2000 11:20AM | hutsonlr |
| 71001273 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001274 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001276 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001281 | 710 | Scrapped | Sep 20 2000 11:22AM | hutsonlr |
| 71001283 | 710 | Scrapped | Sep 20 2000 11:22AM | hutsonlr |
| 71001284 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001285 | 710 | Scrapped | Sep 20 2000 11:22AM | hutsonlr |
| 71001287 | 710 | Scrapped | Sep 15 2000 9:35AM  | hutsonlr |
| 71001291 | 710 | Scrapped | Sep 15 2000 9:36AM  | hutsonlr |
| 71001293 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001294 | 710 | Scrapped | Sep 20 2000 11:23AM | hutsonlr |
| 71001295 | 710 | Scrapped | Sep 20 2000 11:22AM | hutsonlr |
| 71001301 | 710 | Scrapped | Sep 20 2000 11:20AM | hutsonlr |
| 71001303 | 710 | Scrapped | Sep 20 2000 11:22AM | hutsonlr |
| 71001304 | 710 | Scrapped | Sep 20 2000 11:20AM | hutsonlr |
| 71001305 | 710 | Scrapped | Sep 15 2000 9:35AM  | hutsonlr |
| 71001306 | 710 | Scrapped | Sep 15 2000 9:35AM  | hutsonlr |
| 71001307 | 710 | Scrapped | Sep 15 2000 9:36AM  | hutsonlr |
| 71001309 | 710 | Scrapped | Sep 15 2000 9:34AM  | hutsonlr |
| 71001310 | 710 | Scrapped | Sep 15 2000 9:35AM  | hutsonlr |
| 71001312 | 710 | Scrapped | Sep 15 2000 9:35AM  | hutsonlr |
| 71001314 | 710 | Scrapped | Sep 15 2000 9:35AM  | hutsonlr |
| 71001315 | 710 | Scrapped | Sep 15 2000 9:36AM  | hutsonlr |
| 71001316 | 710 | Scrapped | Sep 15 2000 9:35AM  | hutsonlr |
| 71001317 | 710 | Scrapped | Sep 15 2000 9:36AM  | hutsonlr |
| 71001318 | 710 | Scrapped | Sep 15 2000 9:35AM  | hutsonlr |
| 71001319 | 710 | Scrapped | Sep 15 2000 9:35AM  | hutsonlr |
| 71001320 | 710 | Scrapped | Sep 15 2000 9:36AM  | hutsonlr |
| 71001321 | 710 | Scrapped | Sep 15 2000 9:34AM  | hutsonlr |
| 71001323 | 710 | Scrapped | Sep 15 2000 9:35AM  | hutsonlr |
| 71001330 | 710 | Scrapped | Sep 15 2000 9:35AM  | hutsonlr |
| 71001332 | 710 | Scrapped | Oct 23 2000 4:19PM  | hutsonlr |
| 71001334 | 710 | Scrapped | Sep 20 2000 11:22AM | hutsonlr |
| 71001335 | 710 | Scrapped | Oct 23 2000 4:19PM  | hutsonlr |
| 71001342 | 710 | Scrapped | Oct 23 2000 4:18PM  | hutsonlr |
| 71001343 | 710 | Scrapped | Oct 23 2000 4:19PM  | hutsonlr |
| 71001344 | 710 | Scrapped | Sep 7 2000 1:32PM   | hutsonlr |
| 71001347 | 710 | Scrapped | Oct 23 2000 4:19PM  | hutsonlr |
| 71001443 | 710 | Scrapped | Oct 17 2000 8:56AM  | hutsonlr |
| 71001455 | 710 | Scrapped | Oct 17 2000 8:56AM  | hutsonlr |

MF0708

|          |     |          |             |         |          |
|----------|-----|----------|-------------|---------|----------|
| 71001456 | 710 | Scrapped | Oct 17 2000 | 8:56AM  | hutsonlr |
| 71001458 | 710 | Scrapped | Oct 17 2000 | 8:56AM  | hutsonlr |
| 71001487 | 710 | Scrapped | Oct 17 2000 | 8:56AM  | hutsonlr |
| 71001498 | 710 | Scrapped | Sep 20 2000 | 11:23AM | hutsonlr |

(124 row(s) affected)

58 guns made thru 10/29  
182

500  
-180  
320

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MF0709

Golemboski, Matt R.

**From:** Cook, Todd D.  
**Sent:** Wednesday, October 11, 2000 5:21 PM  
**To:** Danner, Dale  
**Cc:** Zajk, Joseph J; Golemboski, Matt R.  
**Subject:** Draft of response on Tool House Question

Gentlemen:

This is probably the hardest plastics-related question of the year. Below is a review of experiences we have had here with mold making and molding vendors:

#### Hi-Tech Mold and Tool (Louisville, KY)

We have had very good experiences with Hi-Tech Mold and Tool, including engineering changes to the NAS stock that were very complicated. Hi-Tech concentrates on production molding, breaking even on tooling as part of their strategy. We have not done a mold project with them in over a year because they were unsuccessful in converting prototype work into production work. I have heard that business is softening and that they might be looking for projects to quote soon. They would want to do production molding as well. Since they have mold making and molding in-house at the same site, mold check out concerns are less complicated. They are short-staffed in engineering, but the founder and tool shop manager are both good tool makers with lots of experience and they have an engineer whose creativity is amazing at times. The only down side to in-house sampling is that they are near capacity on big presses which might lead to delays in sampling during mold development.

#### Kellems and Coe Tool Corporation (New Albany, IN)

We have had good results from Kellems and Coe on mold development, including magazines and some NAS engineering changes. They have more engineering capability than Hi-Tech but concentrate on tooling with molding as a new side effort, so tooling prices are higher. Kellems would not have a press to sample a stock mold and sample check-out is a very important part of doing this right.

#### Collins Engineering (Dixon, KY)

Collins Engineering has done a lot of engineering changes on the NAS stock mold as well. They have the tool making and creativity to handle the job. However, Collins is staffed small on the engineering side, requiring them to do the work quickly would mean hiring additional contract help in mold engineering, which is available. Danny Marsh, the owner of Collins takes his responsibilities to deliver work that performs as promised seriously and will correct problems with no charge, but they are slower due to their size. Collins has Pioneer Plastics right next door who have molded all the NAS samples since October 1999 (there have been quite a few). Pioneer is a reasonable molder, but makes mostly commodity parts in commodity plastics. They do have fast mold setting ability, a number of good processing people, and competitive pricing to offer that might work well as part of development. I wouldn't rule them out as a possible molder, but we would be nearing their technical limits with these jobs.

#### Juno, Inc. (Plymouth, MN)

We have sourced several prototype molds from Juno, Inc. of Plymouth, MN with good success. They have the engineering resources and the molding capacity in Plymouth to complete this type of work as well as a molding plant near Hickory (Blytheville, AR). Their pricing was competitive on both molds and molding. Juno has not done a mold project for us in more than a year due to their inability to convert prototype mold and molding work into production mold building and molding work. Juno was very responsive on concerns about dimensions that were out of tolerance on parts and did many internal inspections of parts and tools on their own as part of the process to measure parts and correct the tool before the customer gets the parts.

#### Three Rivers Tool Corporation (Oneida Rostone, Oneida Molded Plastics, Phoenix, NY)

Three Rivers Tool, a vendor Iion uses frequently, is capable of making the mold, but is also short on the engineering side--to the point that they initially said the NAS stock could not be molded. They built the simplified original stock mold successfully fairly quickly (8 weeks) and cheaply to avoid alienating a big customer. They have molding capability, but located in the next village over from the tool shop.

We do not have experience with any other mold shops in mold this size. Manufacturing has used the Hanson Group, now United Plastics Group, which is now one of the largest injection molders in the country. They have the engineering capability and the tool making ability to make the mold. However, they were not solid performers in mold prove out. They did, as far as I know, provide good delivery and addressed other issues in a timely manner. They were not nor will they ever be inexpensive.

I could speculate that several companies I have worked with in the past could handle this effort. Cascade Engineering from Grand Rapids, MI has the engineering, mold making, and molding capacity to handle a job like this. They specialize in engineering resins and newer processes, like gas-assist. They are good but not cheap. Responsiveness is very dependent upon work load as they are a large shop. I also spoke to their Sales/Mktg. manager briefly and they have a license for the M&C process. I will visit there when I am in Michigan on Research efforts Oct 23-25 and give you a little report on it. This is a \$200 million company--no small potatoes.

Other shops I have heard about from past days in appliances who do bigger molds and molding: Triangle Tool, ABC, and Ivanhoe (although they do more multi-cavity molds than most). I will provide more research on this and try to identify some other shops for you to look at. My ultimate goal would be a list of three very competent moldmakers that you could shop for the best deal.

Comments welcome.

Todd

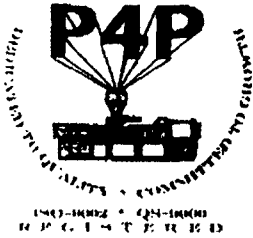
-----  
**From:** Danner, Dale  
**Sent:** Wednesday, October 11, 2000 11:25 AM  
**To:** Cook, Todd D.  
**Cc:** Zajk, Joseph J; Golemboski, Matt R  
**Subject:** Tools House Identification

Todd,  
Mayfield has asked us for three tool house recommendations capable of technically handling mold development consistent with the M/710 stock. Throw in recommendations as well for houses you believe can handle the more complicated NAS stock - if you have any. . . . .

Copy Golemboski/Ziak and me with your recommendations. . . .  
Thks,  
Dale

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CONFIDENTIAL



# PAR 4 PLASTICS, INC.

(270) 965-9141  
Fax (270) 965-9560

351 Industrial Drive  
P.O. Box 385  
Marion, KY 42064

10/10/00

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

*FYI  
APPROVED?  
mm  
10/12*

Dear Metty,

Please issue a P.O. for the following work on the 710 Stock Mold, which has been completed at "Remingtons" request.

|                      |                                         |                     |
|----------------------|-----------------------------------------|---------------------|
| #1. Mold Tech,       | Bench and blend                         | \$ 3,000.00         |
|                      | Tribecoat strip and recoat              | \$ 3,525.00         |
|                      | Texture repair and satinizing           | \$ 2,300.00         |
|                      | Shipping, two trips                     | \$ 750.00           |
| #2. Quality Tooling, | Reblue parting lines, repair waterlines | \$ 1,925.00         |
|                      | <b>Total</b>                            | <b>\$ 11,500.00</b> |

Sincerely  
PAR 4 PLASTICS, INC.

Sam Todd  
Dir. Sales/Marketing

MF0712

FYI  
MM  
9/25

9/25/00

TO: MR. LARRY KNIGHT  
FROM: MS. METTY MORGAN  
RE: NEW CARTON PART #'S

LARRY, BELOW ARE THE NEW PART NUMBERS THAT WE WILL BE USING FOR THE  
NEW 710 CARTON:

|                         |         |
|-------------------------|---------|
| CARTON ASSEMBLY         | F305487 |
| FLAT CARTON FROM ORPACK | F300504 |
| FOAM BED FROM TUSCARORA | F300805 |

YOU WILL RECEIVE APPROXIMATELY 5000 BEDS AT A TIME, AND ABOUT  
10,000 (36 PALLETS OF 300) OF THE CORRUGATED FLATS AT A TIME.

ASSEMBLY WILL BE JUST LIKE WHAT YOU ARE DOING NOW FOR THE 597.  
FOLD THE BOX, INSERT BED AND DOCUMENT ENVELOPE ASSEMBLY, DELIVER  
TO THE PLANT, TWICE A WEEK.

IF YOU HAVE ANY QUESTIONS, GIVE ME A CALL AT 856-4204

MM

83

MF0713

Tuscarora Incorporated  
1479 Parker Road  
Conyers, GA 30094  
800 347-3626  
770 922-3513  
Fax 770 922-1471



COPY  
FYI  
REVISED  
NEGOTIATED  
DECREASE  
Will cut  
Today  
mm  
9/15

REMINGTON ARMS  
ATTN: METTE MORGAN  
22 RIFLE TRAIL  
HICKORY, KY 42051

cc: MATTHEW VASSAR  
vassar@tuscarora.com

E-Mail:  
Phone: 270-256-4204  
Fax: 270-856-3233

|                                                   |             |                             |                         |
|---------------------------------------------------|-------------|-----------------------------|-------------------------|
| WE ARE PLEASED TO SUBMIT THE FOLLOWING QUOTATION: |             | QUOTATION NO. 146-00-0799-B |                         |
| ANTICIPATED PRODUCTION PLANT<br>Lewisburg, TN     |             | FOB<br>Lewisburg, TN        |                         |
| DATE 09/15/00                                     | INQUIRY NO. | PRICE PER SET               | TERMS Net 30 Days       |
| PART NO., DRAWING NO. OR DESCRIPTION              |             | QUANTITY                    | PRICE PER               |
| 710 COMBO PACK<br>MOLDED PACK - BASE & LID        |             | 30,000/YR                   | \$1.495 SET<br>was 1.90 |
|                                                   |             | was 19,216.00               |                         |
| TOOLING CHARGE                                    |             | \$17,716.00                 |                         |
| NUMBER OF CAVITIES                                |             | 2                           |                         |
| WEEKLY PRODUCTION                                 |             |                             |                         |

## REMARKS:

1. MATERIAL: 1.5# EPS

TUSCARORA INCORPORATED

TOOLING DELIVERY: ( 6-8 ) WEEKS AFTER RECEIPT OF  
ORDER AND APPROVED DRAWINGS.

QUOTATION SUBJECT TO CONDITIONS ON REVERSE SIDE.

Form #311

Issue Date: November 17, 1998

Revision Date: November 19, 1999

By *Chris Disney*

SG

Chris Disney  
Account Manager

1-800-245-3034, Ext. 875

MF0714

7/3/00

## Remington Follower

D.S.M. - PartsR.T.P. - Parts

Weights

CAV. #1 = 4.5 grs.

CAV. #2 = 4.6 grs.

#1. = 5.5

2. = 5.5

Dimension #

CAV. #1 #2

CAV. #1, #2.

1. 1.022 , 1.025  
O.K. O.K.1.028 , 1.030  
+ .003 + .0032. .834 , .837  
O.K. O.K..837 , .839  
O.K. O.K.3. 3.380 , 3.378  
O.K. O.K.3.383 , 3.383  
O.K. O.K.4. .264 , .263  
+ .003 + .002.268 , .266  
O.K. O.K.5. 1.252 , 1.249  
O.K. O.K.1.259 , 1.255  
+ .004 O.K.6. .146 , .146  
O.K. O.K..148 , .146  
O.K. O.K.

MF0715

# P.S.M.  
#1, #2  
7. 2.774, 2.775  
O.K. O.K.

8. .320, .318  
(-.002) (-.004)

9. .757, .756  
O.K. O.K.

10. .676, .675  
(-.004) (-.005)

11. .512, .513  
(-.008) (-.007)

12. .051, .052  
O.K. O.K.

13. .053, .049  
O.K. O.K.

14. .203, .205  
O.K. O.K.

# R.T.P.  
#1, #2  
2.779, 2.780  
O.K. O.K.

.319, .320  
(-.003) (-.002)

.757, .757  
O.K. O.K.

.676, .678  
(-.004) (-.002)

.513, .513  
(-.007) (-.007)

.051, .052  
O.K. O.K.

.047, .047  
O.K. O.K.

.207, .205  
(+.002) O.K.

MF0716