

Sportsman M/710

Year 2000 Introduction Development Schedule

February 4, 1999

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M/710 Quad Chart

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Sportsman Model 710 Bolt Action Rifle

2/2/99

Lead Engineers: M. Keeney 241095

Project Description:

A bolt action rifle accommodating long action & magnum calibers; standard barrel lengths; synthetic & wood stocks; magazine box, and a reasonable grade trigger; accepts scope bases offered with optional adjustable sights.

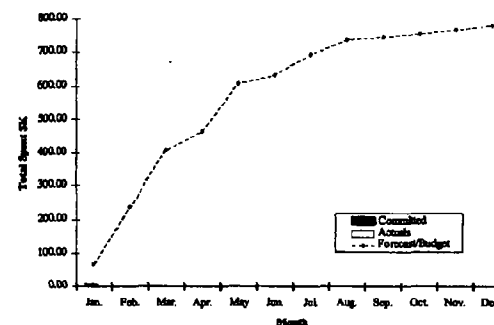
Risk Assessment:

Medium: Due to aggressive cost and process requirements.

Project Objectives:

- Reduce cost to manufacture and manufacturing lead time.
- Above average Gross profit margin (45%).
- Offered as an entry level bolt action rifle while elevating the M/700.
- Compete directly with the Savage (111FC) similar offerings.

1999 Spending



Project Milestones/Schedule:

Task Name	Finish	1999						2000
		Q4	Q1	Q2	Q3	Q4	Q1	
Sportsman M/710 (30-06)	12/3/99							
Program Approval	12/18/98							
Build EE Test - (12)	4/30/99							
EE Test	6/4/99							
Program Review - 4	6/6/99							
Final Design	8/27/99							
Build DAT Guns (40)	8/26/99							
DAT Test	8/31/99							
Design Transmittal	10/1/99							
T&P	11/12/99							
Warehouse Position	12/3/99							

Total Project Cost: Expense: \$641.51K Capital: \$340.0K

Project Status:

01/18/99

- Project Approval based on Design Review, 12/18/98
 - Manufacturing cost estimate \$109.47
 - Cosmetic prototype
- Schedule Development mtg with Manufacturing 01/6-7/99, limited offering year 2000
- Cosmetic Review 01/14/99, issues are barrel contour, bolt plug, and bolt handle
- Ordered components for two test assemblies, to be delivered by 2/1/99

Areas of Concern:

- Barrel processing/heat treatment
- Receiver Insert

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M/710 - Status

- ★ Cosmetic Review (1/14/99)
 - Barrel (potential \$2/barrel cost savings)
 - Bolt Plug
 - Bolt Handle
- ★ Schedule Development Mtg. (1/6-7/99)
 - ◆ Development Approach
 - ◆ Schedule
 - ◆ Budget

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M/710 Development Approach

- ★ Limited Offering - Long action only
 - 2001 magnum introduction
- ★ Parallel design and manufacturing development
 - basic bolt action design
 - program risks -- manuf. of barrel and receiver insert
 - ◆ Engineering Evaluation Testing (EET)
 - Design Acceptance Testing (DAT)
 - ◆ First pass of Trial and Pilot
 - production components

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M/710 Schedule

Task Name	Finish	1999					200
		Qtr 4	Qtr 1	Qtr 2	Qtr 3	Qtr 4	Qtr
Sportsman M/710 (30-06)	Fri 12/3/9						
Program Approval	Fri 12/18/9		12/18				
Build EE Test - (12)	Fri 4/30/9						
EE Test	Fri 6/4/9						
Program Review - 4	Wed 6/9/9				6/9		
Final Design	Fri 8/27/9						
Build DAT Guns (40)	Fri 6/25/9						
DAT Test	Tue 8/31/9						
Design Transmittal	Fri 10/1/9						
T&P	Fri 11/12/9						
Warehouse Position	Fri 12/3/9						

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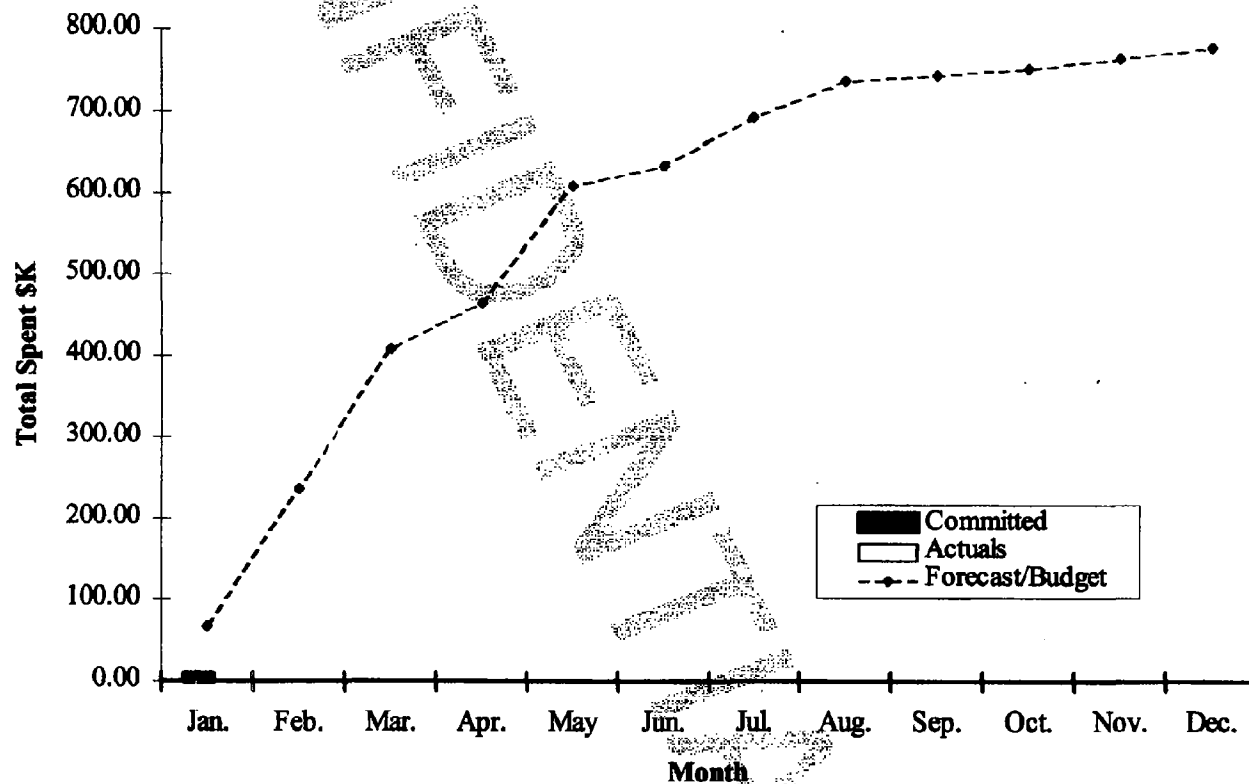
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M/710 Spendout

1999 Spending



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M/710 Net R&D Budget

Total Spendout \$779,775
Capital Investment - \$340,000
Net R&D Spendout \$439,775

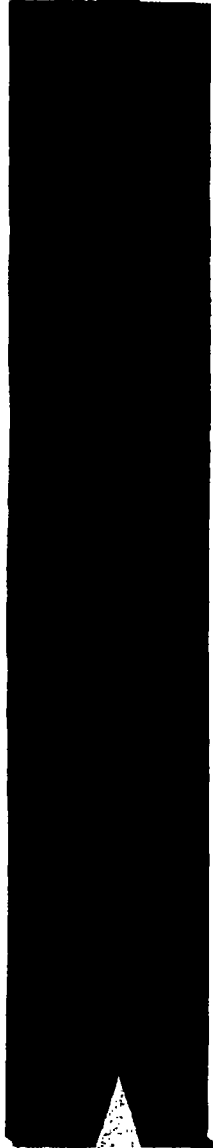
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M/710 Capital Investments

- ★ Barrel Assembly Fixture \$20,000
- ★ Receiver Insert Tooling \$100,000
- ★ Bolt Plug Tooling \$55,000
- ★ Stock Tooling \$125,000
- ★ Grip Cap Tooling \$40,000

Total \$340,000

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M/710 Summary

- ★ Aggressive Schedule
 - EET Program Milestone, Review 6/9/99
 - Supplier Management
 - ◆ Delivery Date Commitment
- ★ Manufacturing Priority
- ★ Non Budgeted Capital Expenditure

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