

11/17/98

M/710 DESIGN & ESTIMATE REVIEW NOTES

8:00 AM: Jeff Swanson

I. Receiver Insert

A. Material

1. Questioned Rev. 4 estimate material cost - Rev. 5 estimate changed to \$.47
2. Questioned material to be quoted - Glass filled Nylon - Need specifics

B. Tooling - Goal is to mold part complete w/o secondary op's

1. Quote 2 cavity mold - Rev. 5 estimate to reflect cycle time change
2. Can TRT pull adjustment screw holes as designed?
 - change screw holes to open faced to eliminate secondary op's.

3. Need positional tolerance $>.003$

4. O tolerance in question due to shrink, etc.

5. Need to sink threaded insert in tang - Rev. 5 estimate to reflect this

C. E'town Estimates:

- Material = \$3/lb.
- Part Volume = 1.8 in^3
- Cycle Time = 20.7 sec
- Part Cost = \$.40 ea.

D. Mold Flow Analysis - Needed to be done to determine accurate cycle time, material, cavitation, etc.

II. Bolt Head

A. Oper. 80 (Drill Cross Pin Hole) - Eliminated, redundant

B. Oper. 30 (Chamfer Lugs) - Eliminated, incorporated into barrel chamber

III. Bolt Plug

A. Lugs

1. Need to determine if current design is strong enough to support loading
2. Need to determine material to be used - Can we flow glass into this area

B. Mold Cycle Time - Rev. 4 estimate high, potential \$ savings

1. Revisited & corrected in Rev. 5 estimate

IV. Stock Ass'y - Rev. 5 estimate to reflect stock w/ recoil pad

A. Recoil Pad Cost - Rev. 5 estimate to reflect M/700 outsource \$

B. Stock Cost - Rev. 5 estimate to reflect M/700 outsource \$

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