

FAX

Remington.

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

TO: Jim Ackley

DATE: 8/13/1998

PHONE:

FAX: 502-765-4420

FROM: Ron Bristol

PHONE: (336) 548-8875

FAX: (336) 548-7875

TOTAL PAGES 14
(INCLUDING THIS COVER SHEET)

Jim,

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

Linda Blackard

ET36084

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

Description	Part #	Material	Labor	Overhead	Total
Overall Gun	927478	\$ 31.99	\$ 23.28	\$ 67.31	\$ 122.58
Receiver	99304	\$ 2.35	\$ 4.39	\$ 14.29	\$ 21.03
Barrel	26291	\$ 2.05	\$ 2.45	\$ 8.81	\$ 13.30
Bolt Assy	94097	\$ 6.71	\$ 3.19	\$ 8.92	\$ 18.83
Stock	106153	\$ 6.12	\$ 0.51	\$ 1.06	\$ 7.69
Firecontrol	26345	\$ 2.15	\$ 2.80	\$ 6.69	\$ 11.64

*V2004*M/710 Synthetic .30-06 Flat-Panel Receiver Option Estimated Cost

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

Comparison: M/700 ADL minus M/710

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

08/19/98

BARRON M/710 -

ADDED

↳ Bottom Receiver - 10000
 ↳ TOL
 ↳ HOP/CHARGER
 ↳ KIT HOD. ?
 ↳ SHIP TO BARRON, FOR ASSY

710-high-spot.xls

83

ET36085

30,000 - 40,000 Units

Estimate - High Spot

08 Cost Figure

PART DESCRIPTION	Engineer Purchasing Vendor	Research Proposed Process	Ref Part No	Machine Fuel/last	Rem. Fixed Tooling	Rem. Gage Tooling	Vendor Set-up Charge	Vendor Gage Tooling	Open Estimate	Material \$	Labor \$	Over Head \$	Estimated Price Price
Fire Control Assembly	Fidelity	Assemble	28345	see process	\$ 70,500.00	\$ 3,000.00							
Bar	Fidelity	Machined	97029		\$ 2,000.00	\$ 750.00							
Sear Blank	Opredink	MDX			\$ 12,000.00				\$ 5,000.00	\$ 0.35	\$ 0.10	\$ 2.18	\$ 3.63
Sear Wheel	Fidelity	Searer Mach.	91484		\$ 500.00	\$ 500.00	\$ 350.00	\$ 500.00		\$ 0.67			\$ 0.71
System Return	Fidelity	Fire Blank Stamp			\$ 18,000.00	\$ 750.00		\$ 750.00		\$ 0.40			\$ 0.40
Trigger	Fidelity	Machined	97029		\$ 43,000.00	\$ 750.00				\$ 0.60			\$ 0.60
Trigger Blank	Opredink	MDM			\$ 43,000.00				\$ 5,000.00	\$ 1.10			\$ 1.10
Trigger	Fidelity	Machined	97029		\$ 5,000.00	\$ 750.00				\$ 0.40			\$ 0.40
Trigger Blank	Opredink	MDM			\$ 45,000.00				\$ 5,000.00	\$ 1.89			\$ 1.89
Primary Pinch = 3	Fidelity	Drive-ink	0243						\$ 0.19	\$ 0.06			\$ 0.06
Secondary Pinch = 4	Fidelity	Drive-ink	0244							\$ 0.08			\$ 0.08
Ser Screw One (Safety)	Fidelity	Serew Mach.	91128							\$ 0.03			\$ 0.03
Ser Screw Two (Chuzzleau Part 1)	Fidelity	Serew Mach.	91128							\$ 0.03			\$ 0.03
Ser Screw Three (Over Travel)	Fidelity	Serew Mach.	91128							\$ 0.03			\$ 0.03
Safety Button	Opredink	MDM			\$ 24,000.00				\$ 5,000.00	\$ 1.10			\$ 1.10
Safety Lock	Fidelity	Stamping			\$ 10,000.00	\$ 950.00		\$ 950.00		\$ 0.20			\$ 0.20
Safety Lock Pin (2 Drive Lock)	Fidelity	Drive-ink	0242							\$ 0.04			\$ 0.04
Safety Armature & Bolt Lock	Fidelity	Stamp with sec.			\$ 12,500.00	\$ 750.00		\$ 750.00		\$ 0.60			\$ 0.60
Safety Actuator Pin	Fidelity	Serew Mach.	24477		\$ 500.00	\$ 500.00	\$ 350.00	\$ 500.00		\$ 0.09			\$ 0.10
Safety Detent Ball	Fidelity	Ball Bearing	23223							\$ 0.00			\$ 0.00
Safety Detent Spring	Fidelity	Stamping	97493		\$ 8,000.00	\$ 750.00		\$ 750.00		\$ 0.03			\$ 0.03
Trigger Spring	Fidelity	Compression Sprg	17047							\$ 0.02			\$ 0.02
Sear Spring	Fidelity	Compression Sprg	17047							\$ 0.02			\$ 0.02
Trigger Housing	Fidelity												
Trigger Housing Blank	Swenson	Synthetic	98129		\$ 65,000.00	\$ 1,250.00		\$ 1,250.00	\$ 500.00	\$ 0.08			\$ 0.08
Right Side Plate	Fidelity	Stamping	30741		\$ 6,000.00	\$ 1,250.00		\$ 1,250.00		\$ 0.08			\$ 0.08

710-High Spot

62980

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ET36087

30,000 - 50,000 Lines

Estimate - High Speed

On Cost Figure

PART DESCRIPTION	Engineer	Research	Part No.	Machine	Rem.	Rem.	Vendor	Vendor	Material	Labor	Over Head	Estimated
Receiver Assembly	Finley	Assembly	100196	see process	\$ 51,000.00							
Receiver (Aluminum)	Zarnach	Alum. Forging										
Bolt Guide/Bolt Release	Oprabuk	Powder Metal										
Bolt Guide/Bolt Release Sg	Finley	Torsion Sg	91433									
Barrel Clamp Screws (2)	Finley	Screw 1/4-3/4										
Barrel Clamp Nut (2)	Finley	Std. 1/4-3/4										
Magazine Release Lever	Swenson	Synthetic										
Magazine Release Pivots	Finley	Screw Nuts										
Magazine Release Springs	Finley	Torsion Sg										
Feed Arm	Finley	Stamping	91433									
Magazine Assembly	Finley	Assembly	106400									
Magazine Body	Swenson	Synthetic	98999									
Magazine Bottom	Swenson	Synthetic										
Followers	Swenson	Synthetic										
Followers Spring	Finley	Stamping	17028									
Bolt Stock Assembly	Finley	Assembly	102845									
Bolt Stock	Swenson	Synthetic	106085									
Recall Pad	Finley	Add Use	97972									
Recall Pad Screws (2)	Finley	Add Use	98006									
Bolt Stock Release Bolt	Finley	Add Use	97032									
Bolt Stock Ret. Bolt Washer	Finley	Add Use	18775									
Bolt Stock Ret. Lock Washer	Finley	Add Use	18772									
Swivel Bolt	Finley	Add Use	13156									
Fore-end Stock Assembly	Finley	Assembly										
Fore-end	Swenson	Synthetic	106490									
Fore-end Release Screws	Finley	Screw Nuts	91871									
Swivel Pad	Finley	Add Use	13158									

Score

770414-401-41

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ET36088

30,000 - 50,000 Units

Estimate - High Spot

Do not figure

PART DESCRIPTION	Engineer Purchasing Vendor	Research Proposed Process	Ref. Part No.	Machine Particulars	Run Fixed Tooling	Run Gage Tooling	Vendor Set-up Charge	Vendor Gage Tooling	Oper. Estimate	Material	Labor	Over Head	Estimated Price
Build to Intelliflex black/box labels													
Penon Black										\$ 0.01	\$ -	\$ -	\$ 0.01
Box and Envelope Labels										\$ 0.07	\$ -	\$ -	\$ 0.07
Assy/Final/Culley/Boxen/Pack										\$ 0.07	\$ -	\$ -	\$ 0.07
Final Day										\$ -	\$ 4.61	\$ 10.93	\$ 15.54
Final/Final/Boxen/Pack										\$ 1.15	\$ -	\$ -	\$ 1.15
Final/Final/Boxen/Pack										\$ 2.24	\$ -	\$ -	\$ 2.24
Manual					\$ 1,250.00				\$ 5,000.00	\$ 0.92	\$ -	\$ -	\$ 0.92
Machinery Moved/Installation									\$ 40,000.00				
Final and Pilot Tooling													
Crane									\$ 7,000.00				
Accumulation (30,000 x \$125 rds)									\$ 25,000.00				
Management (1 manual/1 manual/1 manual/1 manual)									\$ 21,000.00				
Totals					\$ 1,491,241.00	\$ 44,100.00	\$ 3,690.00	\$ 2,000.00	\$ 143,000.29	\$ 44.56	\$ 21.85	\$ 60.53	\$ 127.24
Total Capital					\$ 1,491,241.00								
Total Operations					\$ 200,750.29								
100% High Spot Variance					\$ 169,199.13								
Total Project					\$ 1,561,190.42								

710-high spot 88

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ET36089

M710 - Receiver

OP#	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$	Over Head \$	Oper. Cost
	Blank Material								\$ 4.87	\$ -	\$ -	\$ 4.87
5	Ream bolt hole and bbl hole	Rem Special	\$ 75,000.00	\$ 800.00	xxxx	\$ 15.80	350%	0.012000	\$ -	\$ 0.19	\$ 0.66	\$ 0.85
10	Drill and tap scope holes	Rem Special	\$ 125,000.00	\$ 800.00	xxxx	\$ 15.80	350%	0.012000	\$ -	\$ 0.19	\$ 0.66	\$ 0.85
20	Drill and tap takedown holes and magazine latch pivot	Rem Special	\$ 125,000.00	\$ 800.00	xxxx	\$ 15.80	350%	0.012000	\$ -	\$ 0.19	\$ 0.66	\$ 0.85
30	Butt mill and ream firecontrol holes and barrel clamp holes	Rem Special	\$ 125,000.00	\$ 800.00	xxxx	\$ 15.80	350%	0.012000	\$ -	\$ 0.19	\$ 0.66	\$ 0.85
40	Mill Slot	O-12	\$ 13,000.00	\$ 800.00	xxxx	\$ 15.80	350%	0.013500	\$ -	\$ 0.21	\$ 0.75	\$ 0.96
50	Metasilicate wash				xxxx	\$ 15.80	350%	0.000001	\$ -	\$ 0.00	\$ 0.00	\$ 0.00
60	Finish File				xxxx	\$ 15.80	350%	0.005000	\$ -	\$ 0.08	\$ 0.28	\$ 0.36
70	Roll mark Remington & model	Schmidt	\$ 5,000.00	\$ 600.00	xxxx	\$ 15.80	350%	0.003600	\$ -	\$ 0.06	\$ 0.20	\$ 0.26
80	Stamp serial number	Rem Special	\$ 5,000.00	\$ 600.00	xxxx	\$ 15.80	350%	0.003600	\$ -	\$ 0.06	\$ 0.20	\$ 0.26
90	Stamp "S" and "F"	Rem Special	\$ 20,000.00	\$ 250.00	xxxx	\$ 15.80	350%	0.003600	\$ -	\$ 0.06	\$ 0.20	\$ 0.26
100	Fixture Finish - wet & debrise		\$ 15,000.00	\$ 850.00	xxxx	\$ 15.80	350%	0.012500	\$ -	\$ 0.20	\$ 0.69	\$ 0.89
110	Glass Bead Blast		\$ 10,000.00	\$ 500.00	8158	\$ 15.98	359%	0.007034	\$ -	\$ 0.11	\$ 0.40	\$ 0.51
120	Powder Coat		\$ 5,000.00	\$ 500.00	8301	\$ 15.55	249%	0.003000	\$ -	\$ 0.05	\$ 0.12	\$ 0.16
	Totals		\$ 523,000.00	\$ 7,300.00				0.099835	\$ 4.87	\$ 1.58	\$ 5.48	\$ 11.93

M710-Process.xls

83

ET36090

Confidential - Subject to Protective Order

Williams v. Remington

M710 - Bolt Handle

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital		Ops.	Dept. Number	Dept. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$	Over Head \$	Oper. Cost
			\$	\$									
	Black Material Mold		\$ 10,000.00							\$ 2.75			\$ 2.75
	Gaging (vendor and Remington)		\$ 2,008.00	\$ 500.00									
10	Roun .700 diameter Gaging		\$ 2,569.00	\$ 500.00		xxxx	\$ 15.80	350%	0.008330		\$ 0.13	\$ 0.46	\$ 0.59
20	Rough Polish					xxxx	\$ 15.80	350%	0.005000		\$ 0.08	\$ 0.28	\$ 0.36
30	Hest Treat					8551	\$ 15.78	278%	0.001500		\$ 0.02	\$ 0.07	\$ 0.09
40	Laspert					8551	\$ 15.78	278%	0.000001		\$ 0.00	\$ 0.00	\$ 0.00
50	Finish Polish					xxxx	\$ 15.80	350%	0.005000		\$ 0.08	\$ 0.28	\$ 0.36
Totals			\$ 14,500.00	\$ 1,000.00					20.019831	\$ 4.75	\$ 0.31	\$ 1.08	\$ 4.14

M710-Proces3.xls

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M710 - Barrel

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

M710-Process.xls

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M710 - Barrel

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital \$	Ops. \$	Depart. Number	Depart. Labor \$	Total % Overhead	Std. Run Hours	Material \$	Labor \$	Over Head \$	Oper. Cost
1	Issue from crib (105550)				9132			0.000001				
5	Drill bore - upset barrels		\$ 3,500.00		8158	\$ 15.76	359.44%	0.019316		\$ 0.31	\$ 1.11	\$ 1.41
15	Form Turn NPT form		\$ 3,500.00		8158	\$ 15.76	359.44%	0.025162		\$ 0.40	\$ 1.43	\$ 1.82
20	Bore ream to remove drill rings		\$ 3,000.00		8158	\$ 15.76	359.44%	0.009469		\$ 0.15	\$ 0.54	\$ 0.69
30	GFM form and finish		\$ 10,000.00		8158	\$ 15.76	359.44%	0.025976		\$ 0.41	\$ 1.47	\$ 1.88
36	Load furnace baskets				8105	\$ 15.38	333.86%	0.001680		\$ 0.03	\$ 0.09	\$ 0.11
57	De-grease				8105	\$ 15.38	333.86%	0.001720		\$ 0.03	\$ 0.09	\$ 0.11
58	Load work on furnace base				8105	\$ 15.38	333.86%	0.002510		\$ 0.04	\$ 0.13	\$ 0.17
59	Stress relieve				8105	\$ 15.38	333.86%	0.000001		\$ 0.00	\$ 0.00	\$ 0.00
60	Cool work				8105	\$ 15.38	333.86%	0.000001		\$ 0.00	\$ 0.00	\$ 0.00
61	Unload work from furnace base				8105	\$ 15.38	333.86%	0.007590		\$ 0.12	\$ 0.39	\$ 0.51
63	Unload furnace baskets				8105	\$ 15.38	333.86%	0.001890		\$ 0.03	\$ 0.10	\$ 0.13
65	Cut-off muzzle end and crown				8158	\$ 15.76	359.44%	0.025000		\$ 0.39	\$ 1.42	\$ 1.81
85	Turn and face breech chamber, and polish chamber	CNC Chucker Tooling Gaging	\$ 450,000.00 \$ 10,000.00 \$ 12,000.00		8158	\$ 15.76	359.44%	0.091660		\$ 1.44	\$ 5.19	\$ 6.64

M710-Process.xls

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ET36096

M710 - Firecontrol Assy

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82

ET36097

CONFIDENTIAL

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ET36098

Confidential - Subject to Protective Order
Williams v. Remington