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M/710 ESTIMATE - REV. 3 HIGH SPOT ONLY						
PART DESCRIPTION	Engineer Purchasing Vendor	Proposed Process	Capital Dollars	Operations Dollars	Material $	Labor $
Barrel Assembly	Santillo	Assemble & Machine	$ 125,000	$ 7,500	$ -	$ 2.44
Barrel	Parkhurst/ LeMay	Machined	$ 488,500	$ 16,100	$ 2.44	$ 5.57
Front Sight Assembly	Santillo	Assemble	$ -	$ -	$ -	$ 0.15
Take Down Screws (2)	Santillo	A/U M/700	$ -	$ -	$ 0.04	$ 0.00
Ramp	Santillo	A/U M/700	$ -	$ -	$ 0.02	$ 0.25
Sight	Santillo	A/U M/700	$ -	$ -	$ 0.04	$ -
Rear Sight Assembly	Santillo	A/U M/700	$ -	$ -	$ -	$ 0.17
Take Down Screws (2)	Santillo	A/U M/700	$ -	$ -	$ 0.04	$ 0.00
Base	Santillo	A/U M/700	$ -	$ -	$ 0.16	$ 0.17
Slide	Santillo	A/U M/700	$ -	$ -	$ 0.07	$ 0.38
Aperture	Santillo	A/U M/700	$ -	$ -	$ 0.00	$ 0.08
Elevation Screw	Santillo	A/U M/700	$ -	$ -	$ 0.02	$ -
Windage Screw	Santillo	A/U M/700	$ -	$ -	$ 0.02	$ 0.00
Rib	Santillo	A/U M/700	$ -	$ -	$ 0.02	$ 0.04
Rib Spacer	Santillo	A/U M/700	$ -	$ -	$ 0.00	$ 0.04
Bolt Assembly	Zarnoch	Finish			$ -	$ 1.31
Bolt Body	Swanson	Machined	$ 85,000	$ 500	$ 0.45	$ 0.13
Bolt Handle	Santillo	Screw Mach.	$ -	$ 500	$ 1.47	$ -
Bolt Head	Swanson	Machined	$ 198,000	$ 500	$ 1.60	$ 1.70
Bolt Head Retaining Pin	Santillo	Purchase	$ -	$ -	$ 0.15	$ -
Bolt Plug	Swanson	Synthetic	$ 28,500	$ 1,000	$ 0.03	$ 0.19
Extractor	Santillo	A/U M/700	$ -	$ -	$ 0.72	$ 0.00
Snap Ring	Santillo	Purchase	$ -	$ -	$ 0.58	$ -
Firing Pin Head	Santillo	Machined		$ 950	$ -	$ 0.12

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Firing Pin Head Blank	Ogrodnik	MIM	$ 39,000		$ 0.71	$ -
Firing Pin	Santillo	Screw Mach.		$ 1,850	$ 1.30	$ 0.06
Firing Pin Spring	Santillo	Compression Spg.			$ 0.14	$ -
R Initial Plug	Swanson	Synthetic	$ 6,000		$ 0.01	$ 0.01

PART DESCRIPTION	Engineer Purchasing Vendor	Research Proposed Process	Capital Dollars	Operations Dollars	Material $	Labor $
Fire Control Assembly	Santillo	Assemble			$ -	$ 1.25
Sear Safety Cam	Santillo	AU M/700			$ 0.26	$ 0.15
Safety Assembly	Santillo	AU M/700			$ 0.26	$ 0.09
Safety Spring	Santillo	Purchase			$ 1.25	$ -
Safety Pivot Pin	Santillo	AU M/700			$ 0.05	$ 0.00
Sear Spring	Santillo	AU M/700			$ 0.02	$ -
Trigger	Santillo	AU M/700			$ 0.01	$ 0.44
Trigger Screw Front	Santillo	AU M/700			$ 0.10	$ 0.00
Trigger Connector	Santillo	AU M/700			$ 0.94	$ 0.12
Trigger Engagement Screw	Santillo	AU M/700			$ 0.02	$ 0.00
Trigger Pin	Santillo	AU M/700			$ 0.09	$ 0.00
Trigger Spring	Santillo	AU M/700			$ 0.03	$ -
Trigger Stop Screw	Santillo	AU M/700			$ 0.06	$ 0.00
Trigger Housing Assembly	Santillo	AU M/700			$ -	$ 1.64
Trigger Housing Blank	Swanson	Synthetic	$ 15,000	$ 1,000	$ 0.12	$ 0.12
Receiver	Zarnoch	Machine	$ 108,180	$ 2,050	$ 1.68	$ 1.00

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Magazine Assembly	Santillo	A/U M/7600	$	-	$	-	$	3.31	$	0.57
Stock Assembly W/Butt Plate	Swanson	Synthetic	$	125,000	$	-	$	-	$	-
Stock Assembly W/ Recoil Pad	Swanson	Synthetic	$	160,000	$	-	$	-	$	-
Tang	Swanson	Synthetic	$	25,000	$	1,000	$	0.50	$	0.12

PART DESCRIPTION	Engineer Purchasing Vendor	Research Proposed Process	Machine Purchase	Rem. Fixed Tooling	Material $	Labor $
Build to label/Foam block/Box labels					$ 0.01	$ -
Foam Block					$ 0.07	$ -
Box and Envelope Labels					$ 0.07	$ -
Assy/Proof/Gallery/Inspect/Pack	Joy				$ 2.17	$ 5.37

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Proof/Function Ammo (4.6*.25)	Joy						$	1.15	$ -
Pack	Joy				$	1,250	$	2.24	$ -
Manual	Santillo						$	0.92	$ -
Trial and Pilot Testing									
Guns									
Ammunition (90,000 x .$.25 rds)									
Manpower (3 menx40 hrsx4weeksx$45.00)									
Totals:				**$ 1,243,180**	**$**	**34,200**	**$**	**25.38**	**$ 23.69**
Total Capital		**$ 1,243,180**							
Total Operations		**$ 34,200**							
Total Project		**$ 1,277,380**							

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Over Head $	Estimated Piece Price
$ 3.88	$ 6.32
$ 19.77	$ 27.79
$ 0.35	$ 0.50
$ 0.00	$ 0.09
$ 0.89	$ 1.16
$ -	$ 0.04
$ 0.36	$ 0.53
$ 0.00	$ 0.09
$ 0.56	$ 0.89
$ 1.02	$ 1.47
$ 0.27	$ 0.35
$ -	$ 0.02
$ 0.00	$ 0.02
$ 0.11	$ 0.17
$ 0.21	$ 0.25
$ 4.54	$ 5.85
$ 0.53	$ 1.11
$ -	$ 1.47
$ 4.85	$ 8.15
$ -	$ 0.15
$ 0.53	$ 0.75
$ 0.01	$ 0.73
$ -	$ 0.58
$ 0.23	$ 0.35

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$ -	$ 0.71
$ 0.16	$ 1.52
$ -	$ 0.14
$ 0.03	$ 0.05
Over Head $	Estimated Piece Price
$ 2.38	$ 3.63
$ 0.57	$ 0.98
$ 0.30	$ 0.65
$ -	$ 1.25
$ 0.00	$ 0.06
$ -	$ 0.02
$ 1.35	$ 1.80
$ 0.00	$ 0.10
$ 0.30	$ 1.35
$ 0.00	$ 0.03
$ 0.00	$ 0.10
$ -	$ 0.03
$ 0.00	$ 0.06
$ 3.11	$ 4.75
$ 0.35	$ 0.60
$ 3.51	$ 6.20

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$ 1.24	$ 5.12
$ -	$ 6.72
$ -	$ 10.30
$ 0.35	$ 0.98

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$ -	$ 1.15
$ -	$ 2.24
$ -	$ 0.92

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

Description	Part #	Material	Labor	Overhead	Total
Overall Gun	927478	$ 32.90	$ 23.08	$ 66.78	$ 122.76
Receiver	99304	$ 2.35	$ 4.37	$ 14.36	$ 21.08
Barrel	26291	$ 2.05	$ 2.34	$ 8.43	$ 12.82
Bolt Assy	94097	$ 6.71	$ 3.19	$ 8.92	$ 18.82
Stock	106153	$ 6.12	$ 0.51	$ 1.06	$ 7.69
Firecontrol	26345	$ 2.15	$ 2.80	$ 6.69	$ 11.64
Misc		$ 13.52	$ 9.87	$ 27.32	$ 50.71

M/710 Synthetic .30-06 Flat-

Description	Material
Overall Gun	$ 25.38
Receiver	$ 4.87
Barrel	$ 2.44
Bolt Assy	$ 11.13
Stock/Fore end	$ 6.16
Firecontrol	$ 9.09
Misc	$ (8.31)

Comparison: M/700 ADL minus M/710

Description	Material	Labor	Overhead	Total
Overall Gun	$ 7.52	$ (0.61)	$ 1.11	$ 8.03
Receiver	$ (2.52)	$ 2.79	$ 8.88	$ 9.15
Barrel	$ (0.39)	$ (3.27)	$ (11.38)	$ (15.04)
Bolt Assy	$ (4.42)	$ 1.05	$ 1.76	$ (1.61)
Stock	$ (0.04)	$ 0.51	$ 1.06	$ 1.53
Firecontrol	$ (6.94)	$ 1.21	$ 3.29	$ (2.45)
Misc.	$ 21.83	$ (2.90)	$ (2.50)	$ 16.45

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Labor	Overhead	Total
$ 23.69	$ 65.67	$ 114.73
$ 1.58	$ 5.48	$ 11.93
$ 5.61	$ 19.81	$ 27.86
$ 2.14	$ 7.16	$ 20.43
$ -	$ -	$ 6.16
$ 1.59	$ 3.40	$ 14.09
$ 12.77	$ 29.82	$ 34.26

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OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $
	Blank Material								$ 0.50	
10	Injection Mold		$ 25,000.00	$ 1,000.00	8162	$ 15.54	284%	0.008000		$ 0.1
			$ 25,000.00	**$ 1,000.00**					**$ 0.50**	**$ 0.1**

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Totals	**$ 50,000.00**	**$ 2,000.00**			**0.008000**	**$ 1.00**	**$ 0.2**

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Over Head $	Oper. Cost
	$ 0.50
$ 0.35	$ 0.48
$ 0.35	**$ 0.98**

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$ 0.71	$ 1.95

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OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $
	Blank Material								$ 0.12	
10	Injection Mold		$ 15,000.00	$ 1,000.00	8162	$ 15.54	284%	0.008000		$ 0.1
			$ 15,000.00	**$ 1,000.00**					**$ 0.12**	**$ 0.1**

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Totals	**$ 30,000.00**	**$ 2,000.00**			**0.008000**	**$ 0.24**	**$ 0.2**

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Over Head $	Oper. Cost
	$ 0.12
$ 0.35	$ 0.48
$ 0.35	**$ 0.60**

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$ 0.71	$ 1.19

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OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $
1	Issue From Crib				9132					
10	Demagnetize Metal Components				8772	$ 15.56	190.19%	0.000404		$ 0
20	Assemble - Stage 1				8772	$ 15.56	190.19%	0.018634		$ 0
30	Assemble - Stage 2				8772	$ 15.56	190.19%	0.031275		$ 0
40	Adjust on Comparator				8772	$ 15.56	190.19%	0.018929		$ 0
50	Assemble - Stage 3				8772	$ 15.56	190.19%	0.02412		$ 0
60	Function Check Complete				8772	$ 15.56	190.19%	0.009917		$ 0
70	Stamp Identification Deliver to Crib			$ 500.00	8772	$ 15.56	190.19%	0.001908		$ 0
	Totals		**$ -**	**$ 500.00**				**0.105187**	**$ -**	**$ 1.**

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Over Head $	Oper. Cost
$ 0.01	$ 0.02
$ 0.55	$ 0.84
$ 0.93	$ 1.41
$ 0.56	$ 0.85
$ 0.71	$ 1.09
$ 0.29	$ 0.45
$ 0.06	$ 0.09
$ 3.11	**$ 4.75**

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OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $
	Blank Material - Screw Machine								$ 1.47	
	Gaging (vendor and Remington)		$ 1,000.00	$ 500.00	Vendor					
	Totals		**$ 1,000.00**	**$ 500.00**				**0.000000**	**$ 1.47**	**$ -**

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Over Head $	Oper. Cost
	$ 1.47
$ -	$ 1.47

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OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $
	Blank Material								$ 1.60
15	Mill Lugs				8560	$ 15.40	285%		$ -
	Machine	Cinn. 100	$ 70,000.00						
	Fixtures		$ 4,000.00				Time included in Mazak Run Time		
	Tools		$ 4,000.00	$ 500.00					
	Gaging		$ 1,000.00						
25	Mazak				8560	$ 15.40	285%	0.041000	$ -
	Fixtures	New Tombstones/Collets	$ 60,000.00						
	Gaging		$4,000						
30	Chamfer Lugs				8560	$ 15.40	285%	0.018860	$ -
	Machine	Rem Spec.	$ 45,000.00						
	Fixtures		$ 5,000.00						
56	Ream Extractor Rivit Hole				8560	$ 15.40	285%	0.006880	$ -
	Fixtures		$ 1,000.00						
57	Coin Anti-Rotation Dimple				8560	$ 15.40	285%	0.006380	$ -
	Fixtures		$ 1,000.00						
60	Ream Ejt./Ejt. Retaining Hole				8560	$ 15.40	285%	0.007100	$ -
	Fixtures		$ 1,000.00						
65	Ream & C' Sink Extractor Rivot Hole. Ream Ejt. Cross				8560	$ 15.40	285%	0.015110	$ -

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	Pin Hole											
	Fixtures		$	1,000.00								
70	Deburr Extractor Rivot					8560	$	15.40	285%	0.015110	$	-
	Dimple & Ejector Hole											
	Fixtures		$	1,000.00								
	Totals		**$**	**198,000.00**	**$**	**500.00**				**0.110440**	**$**	**1.60**

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Labor	Over Head	Oper.
$	$	Cost
		$ 1.60
$ -	$ -	$ -
$ 0.63	$ 1.80	$ 2.43
$ 0.29	$ 0.83	$ 1.12
$ 0.11	$ 0.30	$ 0.41
$ 0.10	$ 0.28	$ 0.38
$ 0.11	$ 0.31	$ 0.42
$ 0.23	$ 0.66	$ 0.90

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$ 0.23	$ 0.66	$ 0.90
$ 1.70	**$ 4.85**	**$ 8.15**

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ETE00004002

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OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $
	Blank Material								$ 0.45	
10	Cutoff, Tap	CNC Lathe	$ 85,000.00	$ 500.00	8173	$ 15.89	397%	0.008330		$ 0.1
			$ 85,000.00	**$ 500.00**					**$ 0.45**	**$ 0.1**

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Totals	**$ 170,000.00**	**$ 1,000.00**			**0.008330**	**$ 0.90**	**$ 0.2**

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Over Head $	Oper. Cost
	$ 0.45
$ 0.53	$ 0.66
$ 0.53	**$ 1.11**

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$ 1.05	$ 2.22

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ETE00004006

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $
	Material (Blank 94523)								$ 3.35	
16	Cutoff, Heat, Manual upset				8173	$ 15.89	397.98%	0.034889		$ 0.5
	Tooling		$ 13,000.00	$ 1,000.00						
18	Machine straighten				8173	$ 15.89	397.98%	0.007991		$ 0.1
			$ 13,000.00	**$ 1,000.00**					**$ 3.35**	**$ 0.6**

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Over Head $	Oper. Cost
	$3.35
$ 2.21	$ 2.76
$ 0.51	$ 0.63
$ 2.71	**$6.74**

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OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $
	Blank Material								$ 0.03	
10	Injection Mold		$ 28,500.00	$ 1,000.00	8162	$ 15.54	284%	0.012000		$ 0.1
			$ 28,500.00	**$ 1,000.00**					**$ 0.03**	**$ 0.1**

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Totals	**$ 57,000.00**	**$ 2,000.00**			**0.012000**	**$ 0.06**	**$ 0.3**

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Over Head $	Oper. Cost
	$ 0.03
$ 0.53	$ 0.72
$ 0.53	**$ 0.75**

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$ 1.06	$ 1.49

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OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $
10	Injection Mold Butt Plate				Vendor					
20	Synthetic Stock (Mold/Assy)				Vendor					
	Tooling		$ 120,000.00							
	Fixtures		$ 5,000.00							
	Stock Assy. with Butt Plate		**$ 125,000.00**							
10	Injection Mold Recoil Pad									
	Tooling (Recoil Pad/Backer)		$ 35,000.00		Vendor					
20	Synthetic Stock (Mold/Assy)				Vendor					
	Tooling		$ 120,000.00							
	Fixtures		$ 5,000.00							
	Stock Assy. with Recoil Pad		**$ 160,000.00**							
	Totals		**$ 570,000.00**	**$ -**				**0.000000**	**$ -**	**$ -**

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Over Head $	Oper. Cost
	$ 0.17
	$ 6.55
	$ 6.72
	$ 3.15
	$ 7.15
	$ 10.30
$ -	**$ 34.04**

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OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead
10	mill ejection port, firecontrol slot						
	machine	vmc	65000.00	$ 850.00	xxxx	$ 15.80	350%
	gages		2280.00				
	fixture	haas quad indexer	28000.00				
20	mill mag port						
	machine	vmc					
	cbore drill, tap cam screw				xxxx	$ 15.80	350%
	gages		2900.00				
	fixture						
50	Metasilicate wash				xxxx	$ 15.80	350%
60	Finish File				xxxx	$ 15.80	350%
70	Roll mark Remington & model	Schmidt	5000.00	$ 600.00	xxxx	$ 15.80	350%
80	Stamp serial number	Schmidt	5000.00	$ 600.00	xxxx	$ 15.80	350%
90							

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	Totals	108180.00 2050.00			

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Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
0.021000	$ -	$ 0.33	$ 1.16	$ 1.49
0.029000	$ -	$ 0.46	$ 1.60	$ 2.06
0.000010	$ -	$ 0.00	$ 0.00	$ 0.00
0.006300	$ -	$ 0.10	$ 0.35	$ 0.45
0.003600	$ -	$ 0.06	$ 0.20	$ 0.26
0.003600	$ -	$ 0.06	$ 0.20	$ 0.26

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0.06	$ -	$ 1.00	$ 3.51	$ 4.52	

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OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead
10	press body on head				xxxx	$ 15.80	350%
	machine	Mead press	$ 12,000.00	$ 600.00			
	fixture		$ 2,200.00				
	gage		$ 1,300.00				
20	drill and pin machine	drill press	$ 8,500.00	600.00	xxxx	$ 15.80	350%
		mead press	$ 12,000.00				
	fixtures		$ 3,900.00				
	gages		$ 1,500.00				
30	Mill Cam Cut & cocking notch				xxxx	$ 15.80	350%
	cbore drill,tap bolt handle hole						
	Machine	vmc	$ 65,000.00	$ 950.00			
	Fixtures	haas quad indexer	$ 2,900.00				
	Gaging		$ 28,000.00				
40	attach handle fixture		$ 2,700.00	$ 200.00	xxxx	$ 15.80	350%
50	blast				xxxx	$ 15.00	350%
60	Color racks		$ 3,000.00	$ 200.00	xxxx	$ 15.78	278%

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Totals		$ 143,000.00	$ 2,550.00			

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Std. Run Hours	Material $	Labor $	Over Head $	Oper. Cost
0.012000		$ 0.19	$ 0.66	$ 0.85
0.015000		$ 0.24	$ 0.83	$ 1.07
0.032158	$ -	$ 0.51	$ 1.78	$ 2.29
0.01479		$ 0.23	$ 0.82	$ 1.05
0.005300		$ 0.08	$ 0.28	$ 0.36
0.004000		$ 0.06	$ 0.18	$ 0.24

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0.083248	$ -	$ 1.31	$ 4.54	$ 5.85	

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ETE00004022

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OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $
	Material (Blank 97651)								$ 2.44	
1	Issue from crib				9290					
5	Cut to length (need 26')			$ 600.00	8173	$ 15.89	397.98%	0.012437		$ 0.2
16	Heat, Manual upset and trim			$ 1,000.00	8173	$ 15.89	397.98%	0.012437		$ 0.2
18	Machine straighten				8173	$ 15.89	397.98%	0.007991		$ 0.1
20	Load furnace baskets				8105	$ 15.38	333.86%	0.001680		$ 0.0
22	Load furnace heat and quench				8105	$ 15.38	333.86%	0.000001		$ 0.0
23	Unload furnace and wash				8105	$ 15.38	333.86%	0.001470		$ 0.0
24	Load draw furnace and draw barrels				8105	$ 15.38	333.86%	0.006667		$ 0.1
25	Unload draw furnace				8105	$ 15.38	333.86%	0.000850		$ 0.0
29	Unload furnace baskets				8105	$ 15.38	333.86%	0.000520		$ 0.0
30	Tumblast				8105	$ 15.38	333.86%	0.001600		$ 0.0
31	Inspect for hardness				8105	$ 15.38	333.86%	0.004900		$ 0.0
	Crib							0.000001		

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CONFIDENTIAL

OP #	PROCESS DESCRIPTION	MACHINE DESCRIPTION	Capital $	Ops. $	Depart. Number	Depart. Labor $	Total % Overhead	Std. Run Hours	Material $	Labor $
1	Issue from crib (105550)				9132			0.000001		
5	Drill bore - upset barrels		$ 3,500.00		8158	$ 15.76	359.44%	0.021468		$ 0.3
15	Form Turn NFT form		$ 6,000.00	$ 2,000.00	8158	$ 15.76	359.44%	0.034860		$ 0.5
20	Bore ream to remove drill rings		$ 3,000.00		8158	$ 15.76	359.44%	0.010416		$ 0.1
30	GFM form and finish		$ 10,000.00	$ 500.00	8158	$ 15.76	359.44%	0.025976		$ 0.4
56	Load furnace baskets				8105	$ 15.38	333.86%	0.001680		$ 0.0
57	De-grease				8105	$ 15.38	333.86%	0.001720		$ 0.0
58	Load work on furnace base				8105	$ 15.38	333.86%	0.002510		$ 0.0
59	Stress relieve				8105	$ 15.38	333.86%	0.000001		$ 0.0
60	Cool work				8105	$ 15.38	333.86%	0.000001		$ 0.0
61	Unload work from furnace base				8105	$ 15.38	333.86%	0.007590		$ 0.1
63	Unload furnace baskets				8105	$ 15.38	333.86%	0.001890		$ 0.0

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65	Cut-off muzzle end and crown				8158	$	15.76	359.44%	0.025000		$ 0.3
85	Turn and face breech chamber, and polish chamber	CNC Chucker	$ 450,000.00		8158	$	15.76	359.44%	0.091660		$ 1.4
		Tooling		$ 10,000.00							
		Gaging	$ 12,000.00								
OP #	**PROCESS DESCRIPTION**	**MACHINE DESCRIPTION**	**Capital $**	**Ops. $**	**Depart. Number**	**Depart. Labor $**		**Total % Overhead**	**Std. Run Hours**	**Material $**	**Labor $**
120	Magnaflux				8158	$	15.76	359.44%	0.015500		$ 0.2
125	Straighten and inspect				8157	$	15.43	325.91%	0.012000		$ 0.1
130	Rough and finish centerless polish				8157	$	15.43	325.91%	0.014400		$ 0.2
135	Hand spin Barrel				8157	$	15.43	325.91%	0.007000		$ 0.1
145	Akaline clean				8157	$	15.43	325.91%	0.000001		$ 0.0
150	Induction Harden Barrel Locking		$ 4,000.00		8157	$	15.43	325.91%	0.006000		$ 0.0
	Lugs										
150	Rotoblast				8157	$	15.43	325.91%	0.009557		$ 0.1

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160	Rollmark		$ 2,000.00	8157	$ 15.43	325.91%	0.005744		$	0.0
165	Angularity Straighten			8157	$ 15.43	325.91%	0.005744		$	0.0
170	Color			8157	$ 15.43	325.91%	0.004337		$	0.0
	Totals	**$ 488,500.00**	**$ 16,100.00**				**0.355610**	**$ 2.44**	**$**	**5.5**

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Over Head $	Oper. Cost
	$2.44
$ 0.79	$ 0.98
$ 0.79	$ 0.98
$ 0.51	$ 0.63
$ 0.09	$ 0.11
$ 0.00	$ 0.00
$ 0.08	$ 0.10
$ 0.34	$ 0.44
$ 0.04	$ 0.06
$ 0.03	$ 0.03
$ 0.08	$ 0.11
$ 0.25	$ 0.33

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Over Head $	**Oper. Cost**
$ 1.22	$ 1.55
$ 1.97	$ 2.52
$ 0.59	$ 0.75
$ 1.47	$ 1.88
$ 0.09	$ 0.11
$ 0.09	$ 0.11
$ 0.13	$ 0.17
$ 0.00	$ 0.00
$ 0.00	$ 0.00
$ 0.39	$ 0.51
$ 0.10	$ 0.13

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$ 1.42	$ 1.81
$ 5.19	$ 6.64
Over Head $	**Oper. Cost**
$ 0.88	$ 1.12
$ 0.60	$ 0.79
$ 0.72	$ 0.95
$ 0.35	$ 0.46
$ 0.00	$ 0.00
$ 0.30	$ 0.39
$ 0.48	$ 0.63

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$ 0.29	$ 0.38
$ 0.29	$ 0.38
$ 0.22	$ 0.29
$ 19.77	**$ 27.79**

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ETE00004030

FUNC: ICST ITEM COST DATA 09/08/98
DATA: INQ
ITEM: 927478 COST TYPE: 05 NEXT YEAR FORECAST OPER:
700 30-06 ADL SYN COST YIELD LOSS IND: N
CDS DATE: 090498
COST ROLLUP: Y UM: EA REV LEVEL: 21 RECOST DATE:
090498
COST CTL CD: M M/B: 1 COST OVR CD: N TEXT ID: _____
SHRINKAGE: 0 MATERIAL OH CODES: ____ ____ ____ ____
EXCEP CODES: 19,23

**********VALUE ADDED COSTS********** VALUE MATERIAL 0.00
0.00 M01 0.00 M02 ADDED LABOR 4.835228
0.00 M03 0.00 M04 COSTS OVERHEAD 11.349374
1.390965 O05 2.339153 O06 TOTAL 16.184602
4.540281 O07 2.345085 O08
0.00 M09 0.00 M10 COMP MATERIAL 32.903432
4.835228 L11 0.73389 O12 COSTS LABOR 18.24676
**********TOTAL COSTS********** OVERHEAD 55.435831
4.399222 M01 0.00 M02 TOTAL 106.586023
19.910904 M03 0.922696 M04
17.278015 O05 11.771131 O06 TOTAL MATERIAL 32.903432
21.847387 O07 11.493658 O08 COSTS LABOR 23.081988
7.662 M09 0.00861 M10 OVERHEAD 66.785205
23.081988 L11 4.395014 O12 TOTAL 122.770625

FUNC: ICST ITEM COST DATA 09/08/98
DATA: INQ
ITEM: 99304 COST TYPE: 05 NEXT YEAR FORECAST OPER:
700 REC LA MATTE CARBON COST YIELD LOSS IND: N
CDS DATE: 090498
COST ROLLUP: Y UM: EA REV LEVEL: 01 RECOST DATE:
090498
COST CTL CD: M M/B: 1 COST OVR CD: N TEXT ID: _____
SHRINKAGE: 0 MATERIAL OH CODES: ____ ____ ____ ____
EXCEP CODES: 19

**********VALUE ADDED COSTS********** VALUE MATERIAL 0.00
0.00 M01 0.00 M02 ADDED LABOR 4.371074
0.00 M03 0.00 M04 COSTS OVERHEAD 14.361177
4.872035 O05 2.353814 O06 TOTAL 18.732251
4.104436 O07 2.119969 O08
0.00 M09 0.00 M10 COMP MATERIAL 2.3484
4.371074 L11 0.910923 O12 COSTS LABOR 0.00
**********TOTAL COSTS********** OVERHEAD 0.00
2.3484 M01 0.00 M02 TOTAL 2.3484
0.00 M03 0.00 M04

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0.00 M03 0.00 M04
4.872035 O05 2.353814 O06 TOTAL MATERIAL 2.3484
4.104436 O07 2.119969 O08 COSTS LABOR 4.371074
0.00 M09 0.00 M10 OVERHEAD 14.361177
4.371074 L11 0.910923 O12 TOTAL 21.080651

FUNC: ICST ITEM COST DATA 09/08/98
DATA: INQ
ITEM: 26291 COST TYPE: 05 NEXT YEAR FORECAST OPER:
700 BARREL 30/06 22" COST YIELD LOSS IND: N
CDS DATE: 090498
COST ROLLUP: Y UM: EA REV LEVEL: 10 RECOST DATE:
090498
COST CTL CD: M M/B: 1 COST OVR CD: N TEXT ID: _____
SHRINKAGE: 0 MATERIAL OH CODES: ____ ____ ____ ____

**********VALUE ADDED COSTS********** VALUE MATERIAL 0.00
0.00 M01 0.00 M02 ADDED LABOR 1.977343
0.00 M03 0.00 M04 COSTS OVERHEAD 7.108154
2.705007 O05 1.085562 O06 TOTAL 9.085497
1.856724 O07 0.959012 O08
0.00 M09 0.00 M10 COMP. MATERIAL 2.046636
1.977343 L11 0.501849 O12 COSTS LABOR 0.362492
**********TOTAL COSTS********** OVERHEAD 1.326064
2.046636 M01 0.00 M02 TOTAL 3.735192
0.00 M03 0.00 M04
3.316434 O05 1.237152 O06 TOTAL MATERIAL 2.046636
2.197104 O07 1.134821 O08 COSTS LABOR 2.339835
0.00 M09 0.00 M10 OVERHEAD 8.434218
2.339835 L11 0.548707 O12 TOTAL 12.820689

FUNC: ICST ITEM COST DATA 09/08/98
DATA: INQ
ITEM: 94097 COST TYPE: 05 NEXT YEAR FORECAST OPER:
700 BOLT ASSY L/A CS F3 COST YIELD LOSS IND: N
CDS DATE: 090498
COST ROLLUP: Y UM: EA REV LEVEL: 02 RECOST DATE:
090498
COST CTL CD: M M/B: 1 COST OVR CD: N TEXT ID: _____
SHRINKAGE: 0 MATERIAL OH CODES: ____ ____ ____ ____
EXCEP CODES: 19

**********VALUE ADDED COSTS********** VALUE MATERIAL 0.00
0.00 M01 0.00 M02 ADDED LABOR 3.056465
0.00 M03 0.00 M04 COSTS OVERHEAD 8.64044

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0.00    M03     0.00    M04  COSTS  OVERHEAD       8.64044
2.195494  O05     1.538787  O06     TOTAL        11.696905
2.87002   O07     1.482383  O08
0.00    M09     0.00    M10  COMP   MATERIAL      6.713761
3.056465  L11     0.553756  O12  COSTS  LABOR        0.13608
****************TOTAL COSTS****************      OVERHEAD       0.281116
0.00    M01     0.00    M02     TOTAL         7.130957
6.713761  M03     0.00    M04
2.218428  O05     1.590348  O06  TOTAL  MATERIAL      6.713761
2.997799  O07     1.548382  O08  COSTS  LABOR        3.192545
0.00    M09     0.00    M10     OVERHEAD      8.921556
3.192545  L11     0.566599  O12     TOTAL        18.827862
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FUNC: ICST                ITEM COST DATA                    09/08/98
DATA:                                          INQ
ITEM: 106153          COST TYPE: 05  NEXT YEAR FORECAST       OPER:
700 SYN STK LA ADL       COST YIELD LOSS IND: N
                                        CDS DATE: 090498
COST ROLLUP: Y    UM: EA      REV LEVEL:  01        RECOST DATE:
090498
COST CTL CD: M    M/B: 1      COST OVR CD: N          TEXT ID: ________
SHRINKAGE:  0             MATERIAL OH CODES: ____ ____ ____ ____

*************VALUE ADDED COSTS************* VALUE  MATERIAL       0.00
0.00    M01     0.00    M02  ADDED  LABOR        0.51008
0.00    M03     0.00    M04  COSTS  OVERHEAD      1.062905
0.016833  O05     0.24545  O06     TOTAL        1.572985
0.478965  O07     0.247389  O08
0.00    M09     0.00    M10  COMP   MATERIAL      6.122
0.51008   L11     0.074268  O12  COSTS  LABOR        0.00
****************TOTAL COSTS****************      OVERHEAD       0.00
0.00    M01     0.00    M02     TOTAL         6.122
0.12    M03     0.00    M04
0.016833  O05     0.24545  O06  TOTAL  MATERIAL      6.122
0.478965  O07     0.247389  O08  COSTS  LABOR        0.51008
6.002   M09     0.00    M10     OVERHEAD      1.062905
0.51008   L11     0.074268  O12     TOTAL        7.694985
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FUNC: ICST                ITEM COST DATA                    09/08/98
DATA:                                          INQ
ITEM: 26345           COST TYPE: 05  NEXT YEAR FORECAST       OPER:
700 TRIG ASSB            COST YIELD LOSS IND: N
                                        CDS DATE: 090498
COST ROLLUP: Y    UM: EA      REV LEVEL:  02        RECOST DATE:
090498
COST CTL CD: M    M/B: 1      COST OVR CD: N          TEXT ID: ________
SHRINKAGE:  0             MATERIAL OH CODES: ____ ____ ____ ____
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SHRINKAGE: 0 MATERIAL OH CODES: ____ ____ ____ ____
EXCEP CODES: 23

**********VALUE ADDED COSTS********** VALUE MATERIAL 0.00
0.00 M01 0.00 M02 ADDED LABOR 1.248409
0.00 M03 0.00 M04 COSTS OVERHEAD 2.37535
0.019975 O05 0.540061 O06 TOTAL 3.623759
1.172257 O07 0.605479 O08
0.00 M09 0.00 M10 COMP MATERIAL 2.155935
1.248409 L11 0.037578 O12 COSTS LABOR 1.546905
**********TOTAL COSTS********** OVERHEAD 4.317292
0.004186 M01 0.00 M02 TOTAL 8.020132
1.864717 M03 0.028061 M04
0.924139 O05 1.316439 O06 TOTAL MATERIAL 2.155935
2.722089 O07 1.416104 O08 COSTS LABOR 2.795314
0.253 M09 0.005971 M10 OVERHEAD 6.692642
2.795314 L11 0.313871 O12 TOTAL 11.643891

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