
M E M O R A N D U M

DATE: May 24, 2006
TO: Jim Rabbia
FROM: Mike Santillo
RE: M/710 Rev 2 High Spot Estimate Review meeting -
8/26/98
CC: J. Mead, D. Diaz, M. Keeney, J. Swanson, W. Zarnoch, M. LeMay, J. Parkhurst

The Process Engineering group met today to begin the high spot estimating process for the revised M/710. The following is a synopsis of the foreseeable issues regarding manufacture and manufacturing cost of the proposed design changes. The premise of the meeting was to review the original high-spot estimate done by Ilion on 6/9/98, review the proposed design concept, identify potential manufacturing issues and assign components to engineers for estimation. Below are the issues discussed with significant points pertaining to each.

Barrel - Summary

- Blank Size -
 - Requires a new 3-pass upset blank
 - New blank can be upset on manual machine only
 - New blank requires new tooling
 - Increased cycle time
 - Capacity
- Drilling - DEHOFFs
 - Requires all new cups
 - Capacity
- Turning - Monarchs
 - Requires all new heads
 - Capacity
- GFM
 - Requires new collets
- Chamber & Hub -
 - Requires a new CNC Chucker - Tight internal machining tolerances
 - Requires new depth gages

Tang - Summary

- Subsequent part - attach fire control & assemble to stock

Tang - Summary

- Removal of bolt with cam screw @ bottom of receiver, hidden in stock