

<p style="text-align: center;"><i>— New and Revised SPL ACTION LOG —</i></p>					Meeting: SPL
					Date: 1/12/06
					Next Meeting: 1/19/06
					Location: 52-4 eng conf
Attendees from 1/12/06 meeting: Kelly, John W.; Balio, John R.; Perniciaro, Stephen; Ferreira, Louis B.; Dil Matousek, Rob A.; Mead, Joseph P.; Wilks, Gayle M.; Mroz, John B.; Reynolds, James D.; Sietsema, Glen D.					
Distribution: SPL Contact List					
No.	Date Assigned	Task	Responsibility	Due Date	
1	10/10/05	Purchasing to confirm vendors have received new prints	E Aiello	1/5/06	
2	1/5/06	CMM Brown and Sharp completion for SPL	Joe Diliberto	1/17/06	
3	11/10/05	Need 1st article approval on m7 safety 300678	Golem	1/19/06	
4	1/5/06	Set up inspection room for SPL	Joe Diliberto	1/19/06	
5	1/18/06	Replace black trigger assemblies with silver trigger assemblies	Doolittle	1/20/06	
6	1/23/06	Re-issue T&P trigger assemblies and safety assemblies	Ferreira	1/20/06	
7	12/7/05	Install drill presses	G.Wilks	1/24/06	
8	12/2/05	Internal fixtures for new process (drill jig and press fixture)	J.Doolittle	1/30/06	
9	11/18/05	Powder Metal front and rear spacers	F.Ogrodnik	1/31/06	
10	6/15/05	SPL interference in some of the current stocks	Jim Reynolds	2/1/06	

~AUTODATE

~AUTOFIELD

No.	Date Assigned	Task	Responsibility	Due Date
11	12/15/05	Coordinate the implementation of new and old stocks for the new fire control	J.Balio	2/1/06
12	1/19/06	Creep feed machine run off at Remington	J.Doolittle	2/3/06
13	12/2/05	Develop processes for rivet press and drill jigs	C.Becker	2/7/06
14	12/15/05	Cut in plan for new fire control	J.Balio	2/21/06
15	4/1/05	SOP development for new area	R.Matousek	2/21/06
16	4/1/05	Design and conduct DAT for SPL replacement for 40X	Ronkainen	TBD
17	1/18/06	Our attempt to blacken safeties with the FNC process was not successful.	Sietsema	TBD

~AUTODATE

~AUTOFIELD

@ 3 p.m.

iberto, Joseph; Luke, Kyle D.; Truax, Sheldon F.;

Action
Update by next meeting Stock print changes started on July 19, 2005 and were complete by 10/13/05
At inspection
Change structures
re print orders
Continue to expedite
Continue to expedite
Obtain first article on front and rear spacers
Develop inspection process to sort new stocks from old. Set up PPI and track per vender. Boyds S&K Revival/HS Precision Bell&Carl. McMillen/Orc

~AUTODATE

~AUTOFIELD

Action
The stocks pre change need to be pegged for use with old fire control or initiated for change.
On schedule to complete within time line
Perform study to print specifications (Doolittle to assist as needed) On schedule
write SOPs
contingent on m/7 safety approval
Investigate new non corrosive black plating process.

~AUTODATE

~AUTOFIELD

No.	Date Assigned
3	2/4/05
4	2/4/05
9	2/4/05
10	2/4/05
13	2/4/05
14	2/4/05
17	2/4/05
18	2/4/05
9	2/4/05
10	2/4/05
3	2/4/05
11	2/4/05
13	2/4/05
20	2/18/05
15	2/4/05
1	2/4/05
3	2/4/05
7	2/18/05
14	3/4/05

2	1/20/05
3	2/18/05
7	3/10/05
13	3/4/05
15	3/18/05
28	4/1/05
6	1/20/05
21	3/18/05
27	3/18/05
24	2/4/05
16	3/18/05
29	4/1/05
5	4/14/05
11	4/1/05

17	2/24/05
1	3/18/05
2	3/4/05
2	2/4/05
4	4/14/05
6	4/14/05
7	4/14/05
13	4/1/05
16	3/4/05
18	3/18/05
24	3/18/05
22	5/13/05
12	6/16/05

21	5/19/05
23	5/19/05
4	5/13/05
6	6/30/05
7	2/18/05
8	4/29/05
15	6/16/05
27	5/19/05
28	4/14/05
29	4/1/05
2	7/14/05
5	6/29/05
8	7/14/05
10	6/15/05

11	8/11/05
6	7/14/05
7	6/9/05
12	8/23/04
20	3/14/05
3	4/29/05
5	3/4/05
9	6/16/05
3	8/24/05
5	8/24/05
	9/22/05
3	9/9/05
6	7/14/05
1	7/14/05
2	2/4/05
4	6/16/05
7	12/1/05
8	11/10/05
9	12/1/05
11	12/2/05
14	12/5/05
15	7/14/05

12	12/15/05
8	12/7/05
2	12/15/05
5	12/28/05
6	12/2/05
7	1/4/06
2	4/1/05
3	12/5/05
4	12/9/05

task	Responsibility
Manpower estimates for continuous production of old fire control components	D. Shumway
Prepare facility for new line	R. Reed
Certify existing rivets 14632 needed for run off(done)	J. Diliberto
Adjust order quantities for 14,000 rivets 14632 for run off (done)	J. Brennan
RH side plate samples from Connecticut to resolve inspection methods	J. Brennan
Resolve inspection methods of RH side plate	J. Diliberto
Assign process engineer to new fire control	Orf/Perniciaro
Submit process records for the new fire control to SAP	J. Doolittle
CMM programs complete for run off	J. Diliberto
Update PPI on RH side plate	J. Doolittle
List of what is done and what needs to be done to ready manufacturing for new line. Build time line for these items	R. Reed
Assign 1st line supervisor to new fire control	K. Luke
Purchase the necessary hand tools for the new PPI	J. Diliberto
Generate list of plated parts for the SPL	J. Doolittle
Track heat treat for run off parts	G. Sietsema
Transition all PPI responsibility to Joe Diliberto	J. Diliberto
Track CMM delivery to Osgood in Lancaster NY	J. Brennan
Are there any capacity issues with our platers based on the new fire control	Brennan
Production to provide operator for Engis Run off	G. Allen/K. Luke

Run off samples: Trigger Qty = 4500; Sear safety cam Qty=4500; LH side plate Qty=2800	M.Marley
Cost out and plan new SPL components for the ability to scan product through operations in Ilion for parts used in the runoff	L.Ferreira
Shipped triggers and sears from Engis runoff to UGT. These parts will be used in the Blohm grind run off. Parts received?	Doolittle
Engis Hone 16 hr run off at Remington	J.Doolittle
Roto clip dimensional issues part 300683 safety retaining clip	Diliberto
SPL department number to be 8772	Allen
Run off samples: LH side plate Qty=4600; RH blocker Qty=5000; LH blocker Qty= 200	M.Marley
Investigate potential plating quality issues	Sietsema/ Morningstar
Resolve PPI gaging with Connecticut spring in regard to the safety	Diliberto
Lot certification for inventory of existing fire control	J.Diliberto
Material handling devices	L.Ferreira/ Allen
Run off rivet operation at Liberty tool in Rochester 4/5/05 delivered scheduled after run off	Doolittle
Need test plan for SPL T&P and number of guns required from SKU list developed	Mroz
Develop flow chart for part	Allen

Delivery of RH side plate 300691 stamping for run off 5000 pieces needed, 2000 received from Square, 2000 Received from CTS. Still need 1000 more from Square	J. Brennan
	Luke/Allen
Post new jobs for new fire control area	
	Mead
Decision needed on T&P quantities to make deliveries on time	
Blackening plating process for new safeties	G. Sietsema
Air/Hydraulic press A5 needed machine is hooked up	Allen
6470 Brown and Sharp reciprocating grinder run off complete need A5 approval	Allen
complete A5 on new spray washer	Allen
Inform Greg Foster about the new fire control for police guns	Perniciaro
Plan part orders based on T&P needs	Brennan/ L. Ferreira/ Wadas
	Mead
Computer set up for operator interface on production floor	
Plate certified triggers and sears pre UGT run off	Sietsema
	T. Butler
Eliminate any SPL interference in HS Precision and Bell & Carlson stocks or any others	
B 300696 Engagement Screw PALLADIN, B 300693 Trigger Pivot Pin DEVON need first article parts	J. Brennan

Add capacity review to the list. Need to determine capital requirements at various volume levels (1200-1500/day combined volume potential).	Doolittle
Need to determine manpower at various volume levels (1200-1500/day combined volume potential).	Shumway
Make two triggers assembly benches for immediate installation to transition new fire control better in 84-2	J.Wildey
What do we do with old fire control inventory once new fire control is up and running?	Perniciaro
Plan has been developed to control inventory of existing fire control. Monitor performance to schedule.	Allen
M drive sign off on SPL components	Ferreira
QC inspector for new fire control availability in August	Luke
Need to look at Mayfield and Ilion schedule requirements for 2006 and beyond.	Balio
Need SAP material status for parts being phased out	Balio
Need Ilion cut in plan to supply SPL fire controls to Mayfield and cut in plan for SPL at Ilion to replace current fire control	Ferreira
Provide J.McGlory with M24 and 40X trigger assembly components.	Doolittle
Sear safety cam 1st article inspection and approval	Diliberto
In light of the possibility that Ilion may not be able to supply Mayfield with the new fire control by January 2006, we will review as an option, the transfer of all current component manufacturing equipment to Mayfield to produce parts for the current 710 fire control.	Allen/ Becker
Brown and Sharp CMM at REMorris is not providing good data. May cause further delay in fixture adjustments.	T.Golem/ Doolittle

	Sietsema
Blocker material not to specification	
Post remaining jobs for new fire control to identify operators once machines are in and running	G.Allen
	J.Brennan
300682 Safety Pivot Pin resolve process issues with Anderson	
T&P part delivery	M.Marley
	Doolittle
Fixture and grind certification pre run off at UGT	
Change new fire control area from 8772 to 8773	Allen
Pre run off, machined complete 1000 LH side plates at REMorris	J.Doolittle
A5 on sleeve conditioning unit and demagnetizer installed with Engis bore finish system 6/14/05	Allen
Submit MIM blank 1st article approval once mold cavities are corrected to complete all four cavities.	Marley
Resolve gage correlation issues with UGT	J.Doolittle
Completed stock print updates for new fire control	T.Powers
	G.Sietsema
Run 1000 piece test on current safeties using FNC process	
Tooling costs to manufacture the new fire control are needed for 2006 budget	J.Doolittle
VMC run off at REMorris	J.Doolittle
Preliminary samples prior to first article parts.	Todd Golem
Discuss trigger assembly location for the new fire control	John Kelly
Revise PO so machine can ship	E.Aiello
Ship grinder for installation	J.Doolittle
Find supplier for 300682 and issue PO	Fitzsimmons
Develop sear spring support (Investment cast versus MIM)	G.Wilks
Update costing for new design	C.Vallabhaneni
Grinder run off at UGT	J.Doolittle

Revise floor plan and schedule review	J.Doolittle
Obtain drill presses (One two spindle and a one spindle)	G.Wilks
	J.Balio
Need set up for new crib location	
First Article on sear spring support 301441	Joe Diliberto
New tool for common side plates from Square Stamping	J.Doolittle
First Article on side plates 301435	Joe Diliberto
	J.Kelly
Determine area supervisor for new fire control area	
Update SAP, BOMs and process records	J.Doolittle
Double disk grinder carriers	J.Doolittle
VMC run off RH blockers in Ilion complete	Doolittle

Due Date	action
2/4/05	
2/21/05	Room is complete new dates set from list item 3
2/11/05	14,000 needed for run off
2/11/05	
2/7/05	Complete
2/11/05	Complete
2/18/05	Complete Craig Becker
2/18/05	Complete
3/4/05	Complete
3/4/05	Done
3/4/05	Done 2/25/05
3/4/05	Gerry Allen has assumed production responsibilities
5/18/05	Complete 3/4/05
2/21/05	Complete
2/28/05	Complete
3/4/05	Todd Golem to continue with stampings and MIM until complete.
3/4/05	J. Brennan to confirm 3/7/05 (CMM is there)
3/4/05	Brennan to confirm with Cooke by next meeting 3/18/05 (No issues
3/28/05	Complete 3/4/05 CHAD DELMEDICO current trigger drill operator

2/28/05	Triggers and sear safety cams are complete to conduct run off, parts WILL NOT be useable in guns. SSC profile in critical area out of spec and depth of ejector pin needs to be corrected on the Trigger. LH side plates are complete to conduct run off and WILL BE useable for gun build after MIM FIRST ARTICLE has been passed. LH side plate first article is under review and looks positive to pass. Complete 3/11/05
3/4/05	Brennan to confirm costing status today 3/18/05. Are all parts costed? Done 4/1/05
3/16/05	Parts received at UGT 3/22/05
4/1/05	Scheduled 3/28/05 - 4/01/05 Complete 4/1/05
4/1/05	Resolved 4/1/05
4/15/05	Complete 4/1/05
3/15/05	Runoff LH blockers due 4/8/05; all other parts are available Received
4/15/05	Test was conducted with good results and vender visit in progress
5/18/05	Doolittle and Dilibeto to review gage design by 4/15/05 complete 4/6/05
5/18/05	plan is in place
4/1/05	No issues 4/15/05
4/5/05	Complete 3/29/05 press due in 4/18/05
4/22/05	Complete 4/25/05
4/29/05	Complete 4/29/05

5/6/05	Complete 4/29/05
4/18/05	creep feed grinder by 5/16/05 Identify 1st shift operator for Chevalier VMC by 5/31/05 Identify QC inspector by 5/12/05(OGP QL30 comparator is here). These operators will be needed for run
4/19/05	SKU list is complete and quantities have been established. Publish list by 5/2/05. Doolittle
5/18/05	Complete Change process and prints to reflect new plating
5/20/05	Complete
5/27/05	Complete
5/27/05	Complete
6/10/05	Complete
6/10/05	Complete all guns in on hand
6/15/05	Computer systems have been chosen. Computer systems are not budgeted. Purchase of new systems will be determined at end of project
TBD	Complete no plating issues observed.
As needed	Tim Butler has reviewed all stock prints and confirmed they all should accept the SPL per print. Tim will contact HS Precision and Bell & Carlson to address the interference. Going forward Tim will contact the appropriate engineer to update PPI to check the needed characteristics Complete
6/24/05	300696 and 300693 failed 1st article need new samples, 300693 and 300696 complete

8/30/05	Complete 6/24/05, New Grinder 7 months from date of PO. Still waiting on VMC timing.
8/30/05	Complete 6/24/05
7/8/05	Complete and ready for use
7/14/05	Use up old inventory in current product
7/14/05	BI weekly Report on sub assemblies 1000 behind as of 6/30/05 Remove due to decision on using old inventory for current product
7/14/05	Drive sign off process Complete
8/15/05	QC inspector will need to be available during process run offs at Ilion and process training. Agreed between Joe D and Kyle L for 8/8/05
TBD	On hold until process in place
TBD	John Balio is going to investigate this with John Kelly
TBD	On hold for process completion. Ilion will need to perform at 1000 units per day before we commit to a supply date. Kevin Lance and Gerald Vicars are the contacts for Mayfield.
7/15/05	Complete 7/15/05
7/31/05	Complete on 2 out of 4 cavities 8/24/05
8/11/05	Identify equipment and propose idea to Kevin Lance plant manager of Mayfield. Equipment has been identified. Remove topic for discussion at a future date.
8/18/05	Complete. Brown and Sharp CMM issues have been resolved with the information I have available.

8/26/05	RH blocker heat treat samples 50 this week and 50 next week, Material has been corrected 8/26/05
8/31/05	complete 8/31/05
9/8/05	25000 1st article pieces available from Anderson. Another 25000 are on order. Remove 9/9/05
9/16/05	Complete 9/01/05
TBD	UGT provided 50 of each part run to process by ? All fixture and gage locators are being modified. Need date on fixture return? Remove since gage correlation has been achieved. 9/9/05
7/23/05	Complete 9/9/05
9/15/05	Complete 9/19/05
9/22/05	Complete 9/22/05
9/15/05	All MIM components for the new fire control have first article approval for all cavities. Completed 10/18/05
10/21/05	complete 10/31/05
10/13/05	completed 10/13/05
11/11/05	FNC process is used to color the safeties black and is non-corrosive. Testing complete successfully by 11/11/05
11/18/05	Estimated \$1000 per day for tooling
12/7/05	Complete 12/6/05
12/9/05	Complete 12/9/06
12/15/05	Still under review
12/15/05	Complete 12/15/05
12/15/05	Ship 12/19 due in 12/20/05
12/15/05	Complete
12/15/05	Complete 12/15/05
12/15/05	Complete 12/15/05
12/16/05	Complete 11/10

12/20/05	Complete
1/13/06	PO placed delivery 1/13/06
12/30/05	Parts ready for the production in the new TPA machining & sub-assembly (housing assembly) area will go through crib 24. Purchased blanks that need lilon processing with go through 31. MIM parts that need further process will go through 11. If the actual trigger assembly operation stays on the 4 th floor, then the parts ready for this operation will pass through 29.
1/5/06	complete
1/6/06	complete
1/7/06	Complete
1/12/06	Complete Rob Matousek (machine area) and Sheldon Truax (trigger assembly)
1/13/06	Complete 1/13/06
1/13/06	complete
1/17/2006	