

Bob Orf

From: Becker, Craig
Sent: 10/24/2005 08:25:24 AM
To: Orf, Robert J.
CC:
BCC:
Subject: Weekly update, W/E 10/21

Weekly Activities

SPL Tested and evaluated the rivet grind fixture, and assembled several groups of Trigger Housing Assemblies. If the rivet head height is held correctly, the assembled housings will pass the hard gage and the CMM test. If the rivets are ground 0.001" undersize, the part will fail, as the riveted assembly will not be tight enough. It is going to be very important to monitor the grind operation. I currently have the grind fixture back in the tool room to take out a 0.0006" sump in the main holding plate. I also have been helping Jim evaluate comp screens, fixtures and gages. This project occupied 60-70% of my week.

12 Gage FETAs I have instructed BJ to gage for the 50 un-straightened parts we will build into guns. I believe he is keeping those he finds in the lab. Once we have collected a quantity, I will have you gage some so you are aware of our collection criteria.

6-40 Taps The Regal brand tap in stores was tested in another drill press that can be slowed down to 500 RPM. The current drill press/tapping head has a minimum speed of 1000 RPM. The taps work at the slower speed, so I had Bob Pendergrass request a maintenance estimate to slow down the current drill press. I am also waiting for some price info on other tap brands from Grippe. Before I can finalize any decision on which tap to keep at stores, I'll have to see what effect a slow down will have on production rates. More news to follow.

700 Triggers, Still having some issues with reamed hole size. Moving the operation to a different

location has had a marked improvement on quality. Maintenance is finalizing some repairs the normal equipment. I also issued an Engineering ticket for a 50 piece test to bypass the ream operation. The parts were drilled, heat treated and then hard reamed, bypassing the "soft" ream. Fallout was 2 set-up pieces. This test may give us a cost savings and a quality improvement if it passes further evaluation. We will need to modify gages and fixtures if we pursue this.

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