HAS BEEN SIGNED & SENT TO THE VENDOR

AUTO-DRILL LINE 12-13-78 - REH

The order for a turnkey chip system to collect chips, recover their retained oil, and do all preliminary oil filtration ~~is being sent to Bridgeport today~~. It was accompanied by a 5-page dissertation on the research involved in choosing the vendor. It is anticipated that the fabrications to be cast into the floor concrete, will be available for installation in April 1979, to the vendor's drawings.

Sandvik was visited on 12/5 when they were starting life tests on .906" ϕ Ejector drills on 11.9" blanks of 1½" ϕ C-1140 Mod. steel. These will become useable 870-12-30 GFM blanks after turning. The test heads were fabricated from Sandvik's choice of carbides, which differ from our specs. In a surprise to them, they were able to drill over 300% further , than they had predicted. These results may make Ejector Drilling with its throw-away heads, an attractive alternative, to replace the proposed twin-jet two-flute spade type drills which require regrinding.

The Wagner Saw people were also contacted on this trip, to review the inclusion of of their controls into the overall automation. Considerable thought must be given to the handling of emergency stops for any reason, plus the subsequent start-up sequencing, to avoid cutter breakage or handling jam-ups.

All the operating units, no matter what source, will be tied together electrically from one main operating console for automatic operation. Complete system emergency stop buttons will be placed in several convient locations, within the area. In addition, each will be functional in a manual mode from its own panel.

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by R. E. Hess