

Mal.
% of Def.

Causes

Action being taken

N/66
FD
24%1. Sear hangs up on disconnecter
(Heat Treat Specs changed)1. DCR #11386 transmitted.
Process to be changed.
(Couchman)2. Alignment of pin holes in
stock1. Four stocks have been plugged
and redrilled but holes are
still not to M/D. Program
to be reviewed and written
up.
(Smith)552
DFU
32.7%
ABBB
14%

1. Feed ramp out of position

1. SPECIAL MACHINE - Boring bar
due June 8th. Program is to
be reviewed and written to
cover;

1. Bbl hole misaligned

a. Decision process related
to tooling including
testing program(The above two items are
inter-related and account
for nearly HALF of the
malfunctions for the 552-572)

b. New gaging requiremants

c. Estimate of cost to
build new machine so
Plant Order can be started
(Kratzert)

2. CURRENT PRODUCTION -

a. Review gaging techniques
and update Process Record.
(Kratzert &
Unsinn)b. Audit both operations
on all three shifts
(Warren)

BC

1. Causes not completely identi-
fied but thought to be caused
by thin wall at extractor cut.
Problem is with both Proof and
Standard Ammunition!1. Layout shows sufficient wall
material but cut is being
evaluated to see if more
wall thickness can be develop-
ed.
(Simpson)

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BC
con't

2. Extractor slot gage to be checked in T/R. (Baleo & Kennedy)
3. Program to do finish reaming in Production.
 - a. Experimental reamers being tried. (Smith, Balio)