

5/26/48
Revised 11/5/48NEW ARMS RELEASE PROCEDURE

The following is the procedure to be followed from the time a new Model, new gauge or Cal., or major design change of current Model is released from Technical, until guns may be released for shipment.

Complete New Model1. Technical Division

- A. Release new Model to plant "New Arms," division, for tooling.
- B. Obtain one of first guns from pilot run for pilot test. (See 6-D-1).
 - (1) Should with very few exceptions be made up of production or pilot components.
 - (2) One exception may be use of a few Model parts to complete assembled gun.
 - (3) A plant order number for this test to be obtained from plant gallery.
- C. Obtain 6 - 10 completed guns from first 50 of regular production, for final test.
 - (1) These may be made up of production or pilot components. (See 6D-2).
 - (2) A plant order number for this test to be obtained from plant gallery.
 - (3) Guns to be on memo order issued by Planning Dept. and cleared thru warehouse.
- D. Issue report promptly of progress of results from tests B and C above.
- E. Return all guns after completion of tests to Custom Repair for credit.
- F. One copy of all reports to chief supervisor of inspection.

2. "New Arms." Division

- A. Development of process and records of components - establish samples.
- B. Tool design and procurement.
- C. Pilot run (trouble shoot).
- D. Assembly and final inspection.
 - (1) Establish process, records and samples.
- E. Notify supervisor final inspection that assembly is started.

2. New York, New York

Department of the Army Divisions

and information.

...turned over to plant as soon

factory parts have been completed.

3. Process Engineering ("Current Area") (After turnover to Plant).

- A. Follow production (trouble shoot).
- B. Notification of changes in process record to Methods and Standards.
- C. Watch for improvement and simplification of operations and equipment.
- D. Notify design (tool) of requests for changes in equipment.

4. Tool Design (After turnover to plant)

- A. Receive and maintain drawings, etc.
- B. Notification of changes made to process engineering.
- C. Write plant orders and notify plant order Dept. request for alterations or new equipment.

5. Assembly

- A. Assemble per process record.
 - (1) Request assistance from Process Engineer for assistance as needed.
 - (2) Notify foreman of first inspection that guns are ready for first inspection.

6. Inspection

- A. First Inspection foreman to:
 - (1) Train Inspector per process record (See 2-D)
 - (2) Advise acceptable guns to gallery foreman.
 - (3) Maintain record of rejects.
- B. Gallery foreman to:
 - (1) Contact supervisor for test procedure.
 - a. Testing program to be set up by chief supervisor of inspection.
 - (2) Instruct and train personnel.
 - (3) Obtain necessary new equipment.
 - (4) Maintain record of performances.
 - (5) Turn acceptable guns over to foreman of final inspection.
 - (6) Issue plant order per 1-B-3 and 1-D-1 above for testing.
- C. Final Inspection foreman to:
 - (1) Train inspector per process record (See 2-D).
 - (2) Maintain record of rejects.
 - (3) Advise supervisor and place passed guns in sub-warehouse

8. Inspection (Cont)**D. Supervisor of final inspection to:**

- (1) Turn one of first guns over to Technical for preliminary tests.
- (2) Notify Technical at completion of first 50 guns.
 - a. Guns to be put into sub-warehouse and to be drawn out immediately by Technical.
- (3) See that Technical select 8 - 10 guns for final test.
- (4) Follow up Technical to see that tests are completed promptly and reported.
- (5) Summarize reports from 6A-3, 6B-4 and 6C-2 and turn over to chief supervisor of inspection.

E. Chief supervisor of inspections:

- (1) Call meeting of plant committee.
 - a. Report on tests and reports. (See 9-D-6).
 - b. If reports satisfactory continue prod.
 - c. If reports unsatisfactory guns returned to New Arms Division or Technical for equipment or Model design change and must follow previous procedure again.
 - d. If reports satisfactory issue approval to planning to pack and ship guns.

NEW GAGE OR CALIBRE

1. Same as new Model.

MAJOR DESIGN CHANGE

1. Process Engineering ("Current Arms").

A. Design change (combination of several related components, directly connected with the function or appearance of current arm).**(1) Development**

- a. Turn over to Technical for approval marked prints, etc. for suggested change. (Development by P.E.)
 - 1- Technical present same to products committee for approval.
- b. Turn complete suggestion over to Technical for their development, etc. and products committee approval.

B. Development of process records of components - establish samples.**C. Follow production of first parts (trouble sheet).****D. Watch for simplification of oper. and equipment.**

1. Process Engineering (Cont)

- E. Notify inspection when parts are ready.
- F. Notify tool design of change in equipment.
- G. Issue changes, etc. to Methods and Standards. (Process Records).

2. Tool Design

- A. Receive Model drawings from Technical.
- B. Develop necessary tools for production.
- C. Issue necessary forms and plant orders for change in equipment or new equipment plant order department and P.E.
- D. Notify Process Engineering when completed.

3. Inspection

- A. Follow production (component parts) per Process Record.
- B. Assembly foreman
 - (1) Notify foreman of first inspection that guns are ready for first inspection.
- C. First inspection foreman to:
 - (1) Train inspector per process record (See 1-B).
 - (2) Move acceptable guns to gallery foreman.
 - (3) Maintain record of rejects.
- D. Gallery foreman to:
 - (1) Contact foreman for test procedure.
 - a. Testing program to be set up by chief supervisor of inspection.
 - (2) Instruct and train personnel.
 - (3) Obtain necessary new equipment.
 - (4) Maintain record of performance.
 - (5) Turn acceptable guns over to foreman final inspection.
- E. Final Inspection foreman to:
 - (1) Train inspectors per process record (See 1-B).
 - (2) Maintain record of rejects.
 - (3) Advise supervisor and place passed guns in sub-warehouse.
- F. Supervisor of Final Inspection:
 - (1) Summarize reports from SF-3 and SF-4 and turn over to chief supervisor of inspection.
- G. Chief supervisor of Inspection:
 - (1) Call meeting of plant committee.
 - a. Report on tests and reports. (See SF-1).

8. Inspection (Cont)

G. Chief supervisor of Inspection (Cont)

- b. If reports satisfactory continue production.
 - c. If reports unsatisfactory, necessary changes must be made and preceding procedure must be followed again.
- (2) If reports are satisfactory issue approval to planning to pack and ship guns.