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CONTROL PROCEDURE - SERIAL NUMBERED MODEL XP-100
RECEIVER, BARREL ASSEMBLY & PISTOL ASSEMBLY

1. A record of Model XP-100 Serial Numbered Receivers and Barrel Assemblies processed in Dept. 54 & 58 will be maintained in the Control Book located in the Supervisor's Office- Bldg. 47-1 (Barrel Mfg. Area).
 - A. Monthly Inventory Report will be issued by the Supervisor of the Barrel Mfg. Area for the Serial Numbered Receivers and Barrel Assemblies that do not show progression in the process.
2. Model XP-100 Serial Numbered Receiver Control -Dept. 54
 - A. Model XP-100 Serial Numbered Receivers are to be rolled in numerical order starting with number 1011.
 - B. Dept. 54- will record and report the Model XP-100 Receivers rolled on the Serial Numbered Record Form.
 1. Serial Numbered Record Form to be delivered to the Supervisor's Office - Bldg. 47-1- Barrel Mfg. Area.
3. Model XP-100 Serial Numbered Barrel Assemblies Control-Dept. 58
 - A. Dept. 58-will record on the Serial Numbered Record Form the Model XP-100 Serial Numbered Barrel Assemblies that are started and delivered to the Dispatch Area.
 1. Serial Numbered Record Form to be delivered to Supervisor's Office - Bldg. 47-1 - Barrel Mfg. Area.
4. Model XP-100 Pistol Assembly Control-Dispatch Area -Dents. 64 & 85
 - A. Dispatch Area, upon receipt of the Model XP-100 Barrel Assemblies from the Barrel Mfg. Area, will record serial numbers on a set of three (3) III Gun Tags and attach tag to the Barrel Assembly and deliver to the enclosed Assembly Area-Bldg. 84-3 Dept. 64.
 - B. Assembler will turn in the white III card to the Time Clerk.
 1. All Assembly cards will be kept on file at the Time Clerk's desk.

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4. Model XP-100 Pistol Assembly Control-Dispatch Area -Depts. 64 & 85

- C. After Assembly, the Model XP-100 Actions, less Stock Assemblies will be put into a special truck.
 1. When truck is moved from Assembly (Dept. 64) to Proof & Test (Dept. 85), the truck will be locked. There will be two (2) IEM cards for each Action on the truck.
- D. Trucks with Model XP-100 Actions delivered to Dept. 85 (Proof & Test) will be signed for by the Supervision of the Proof & Test Area for the number of Actions on the truck.
- E. Trucks with Model XP-100 Actions returned from Dept. 85 (Proof & Test) to the Assembly Department 64, will be signed for by the Supervision of the Assembly Department for the number of Actions on the truck.
- F. After Final Assembly of the Model XP-100 Pistol (Stock Assembly to Actions) the Pistol will be inspected, cleaned and lubricated for Packing.
- G. When the Model XP-100 Pistols are packed, the red IEM Cards will be delivered to the Warehouse with the packed Pistols.
 1. Model XP-100 Packer will turn the green IEM Cards with the time sheets to the Time Clerk.
 2. Time Clerk will remove the white assembly card from the file and deliver both the white and green IEM cards to the Accounting Department.
 - A. Accounting Department will match the two (2) IEM Cards by Serial Numbers.

1. Green IEM Card	Packing
2. Red " "	Warehouse
 - B. Accounting Department will issue to the Barrel Mfg. Supervisor's Office-fig. 47-1, a monthly report of the Serial Numbered Model XP-100 Pistols delivered to the Warehouse.
- H. Model XP-100 Pistol Actions that cannot be completed and produced to the Warehouse, will be disassembled.
All three (3) IEM Cards are to be returned to the Dispatch Area for replacement.
- I. Model XP-100 Barrel Assemblies returned from the Assembly Dept. 64 for Repair or Repair are to be delivered to the Supervision of Dept. 50-fig. 48-1.

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5. Scrap Procedure - Model XP-100 Serial Numbered Receivers and Barrel Assembly

A. Model XP-100 Serial Numbered Receivers and Barrel Assemblies determined as scrap are to be reported on the Product Scrap Card by the Serial Number of the component.

1. Departments 54 & 58 will be responsible for the scrap disposition for all Model XP-100 Serial Numbered Receivers and Barrel Assemblies.

Note: Scrap from Product Engineering & Control, Research & Development and Works Engineering Sections of Model XP-100 Serial Numbered Receivers and Barrel Assemblies must be delivered to the Supervision of Dept. 58 (Bldg. 48-1) for disposal.

2. Authorized personnel assigned to prepare the Scrap Cards, will deliver the Product Scrap Cards to the Barrel Mfg. Supervisor's Office-Bldg. 47-1 for record before delivery of the components to the Scrap Area.
3. Model XP-100 Serial Numbered Receivers and Barrel Assemblies determined as scrap, must be utilitized before delivering to the Scrap Area.

6. Procedure: Withdrawal of Model XP-100 Serial Numbered Receivers, Barrel Assemblies and Pistol Assemblies from the Production Area.

A. Requests for Model XP-100 Serial Numbered Receivers, Barrel Assemblies and Pistol Assemblies by Product Engineering and Control, Research & Development and Works Engineering personnel must be approved by the Production Supervision of the Area and must be signed for by the Serial Number and name of employee receiving the components on form -M/XP-100 Components Taken From Production.

B. When the Model XP-100 Components are returned to the Production Section, the Supervision of the Area will check the components and return to the employee the signed slip.

Note: Employees signing for M/XP-100 Components are held responsible until the components are returned to the Production Section.

C. M/XP-100 Pistols taken from Proof & Test - Tent. 85

1. Employee authorized to take M/XP-100 Pistols from the Gallery will sign the form -M/XP-100 Components Taken From Production - listing the Serial Number of the Pistols.
2. Signed ticket will be returned with the balance of the Pistols in the special run truck.

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- C. M/XP-100 Pistols taken from Proof & Test - Tent. 85
 3. Signed tickets will be kept on file by the Assembly Supervision of Dept. 64- Bldg. 84-3 until the Pistol has been returned to the Assembly by the employee.
7. The enclosed Assembly Area - Bldg. 84-3 will be restricted to all employees except authorized personnel.
8. Procedure: Withdrawal M/XP-100 Pistol from Warehouse.
 - A. If, for any reason, it is found necessary to withdraw a M/XP-100 Pistol from the finished goods Warehouse, such withdrawal must be recorded on three (3) copies of form RD-5122-Deliveries from Warehouse To Work in Process.

Note: Serial Numbers of Pistols must be included on the form.
- E. Distribution of the forms to be made as follows:
 1. Tabulating Room 46-2
 2. Cost Department 46-2
 3. Barrel Mfg. Supervisor's Office 47-1

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