

C O P Y

Ilion, New York  
January 5, 1956

J. B. MAUPIN

MODEL 572 RECEIVER FINISHING

In July, 1955, it was decided to follow the course of continuing a polished finish on M/572 Receivers and to reduce the excessive cost of scrap and repairs resulting from porosity by maintaining the "as cast" surface on the Receiver. It also was anticipated that a major reduction in polishing labor cost could be attained by polishing the outside surfaces directly with 320 grit belts rather than with 220 and then 320 grit as used when finishing after straddle milling.

Present indications are that a significant reduction has been made in the number of Receivers requiring repair and a major reduction has been made in our scrap loss.

As of this date, however, a satisfactory means of polishing in one step with 320 grit belts has not been worked out and our polishing cost is essentially the same as before.

While further data and experience is needed to develop firm cost data relative to repairs and scrap, our approximate present costs are indicated below in comparison with costs prior to the change in castings and with the objective costs as estimated last July:

	<u>Previous Cost/C</u>	<u>Objective Cost/C</u>	<u>Indicated 1/4/56 Cost/C</u>
<u>Direct Labor-Polish top, bottom &amp; panels; Roll Marks and Micro-bond</u>	\$ 17.43	\$ 8.43	\$ 17.43
<u>Industrial Relations</u>	4.18	2.02	4.18
<u>Supplies-Polish &amp; Micro-bond</u>	4.72	2.13	4.72
<u>Maintenance</u>	.14	.05	.14
<u>Repairs-(Frequency)</u>	(24 repr./100)	(7 repr./100)	(14 repr./100)
Labor	4.18	.59	2.44
Supplies	1.13	.15	.66
Maintenance	.03	--	.01
Industrial Relations	1.00	.14	.58
Sub-total Repairs	\$ 6.34	\$ .88	\$ 3.69
<u>Scrap</u>	(12%) 16.80	(4%) 4.88	(3%) 4.20
<u>Total</u>	<u>\$ 49.61</u>	<u>\$18.39</u>	<u>\$34.36</u>
<u>Reductions</u>	<u>--</u>	<u>\$31.22</u>	<u>\$15.25</u>

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E. B. Wallin, Superintendent  
- 22 - Methods & Standards Section

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