

CC: H. R. Dorr  
D. E. Miller  
R. D. Conboy  
C. W. Borden  
J. Strong  
J. Hammond  
E. K. Wheat  
J. R. Brand  
R. H. Grace

June 26, 1946

TO: S. M. Alvis  
FROM: H. J. Hackman  
SUBJECT: INSTALLATION OF CUPRODINE AND CYANIDE DEPLATE  
FACILITIES FOR MODEL 721-722

A meeting was held in R. H. Grace's office, 6-21-46, to discuss the Cuprodine and Deplate requirements to be used in conjunction with draw rifling for Model 721-722 barrels.

It was brought out that there was some question by the Plant on draw rifling. This was further discussed in a meeting with yourself and Mr. Brown and as a result a letter dated June 4th was sent Mr. Dorr by yourself covering draw rifling for Models 510-511-512-550 and 513 Sporter.

The process for the Model 721-722 as now proposed covers the use of draw rifling. To the best of knowledge now available by the Technical Chem. & Met. Group, it is necessary to Cuprodine before draw rifling. Since it is necessary to Cuprodine it will also be necessary to remove the Cuprodine by some method. R. H. Grace is checking with the vendors of Cuprodine to obtain samples of a process for removing Cuprodine which does not require the use of cyanide. At present Cuprodine is being removed by Cyanide Deplate but the decision on deplating equipment should be held until final tests have been made by R. H. Grace.

The Plant requested the holding up of project FI-173 which is the project to cover Cuprodine and Decuprodine facilities for the Plant on the basis of their acceptance of draw rifling and the question concerning the proposed cyanide Decuprodine operations. Technical has sufficient experimental facilities available to Cuprodine pilot run barrels and by using Plant Heat Treat facilities can Decuprodine the pilot barrels. There will be no production facilities available to turn over to the Plant for Cuprodine. It is therefore recommended that R. & M. prepare a project, as agreed in the meeting for production Cuprodine facilities for the Model 721-722. By copy of this letter we are suggesting R. & M. proceed with this project if agreeable with the Plant.

Since the meeting, it has been called to our attention that the Decuprodine facilities now available in the Plant Heat

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are scheduled to be removed. It was brought out in the meeting that with cyanide deplate facilities the Plant would be able to handle the Decuprodine in the present Heat Treat Area. By copy of this letter we are requesting the Plant Works Engineer to review the heat treat setup as it is possible that they will want to postpone the removal of the Decuprodine facilities until such a time as a final decision has been reached on the best method of removing the Cuprodine after draw rifling.

H. J. Hackman  
Technical Department

HJH/VGDeR/EC

By:

  
V. G. DeReusNOTE TO JOHN STRONG:-

Attached is a copy of the Technical letter to Mr. Dorr on draw rifling.

EXHIBIT 1  
(Continued)

INCOMPLETE 6/1/46

< \*1. Induction hardening and draw of Receivers to determine if work can be done on Tocco or if project required for two electric Lindberg furnaces at \$1,000 each. P.E. & C. recommends holding for Pilot Line to determine requirements. Letter C. W. Borden 4/18/46.

2. Breakdown of equipment in Project FTI-5 to determine Model Shop - Technical and M/721 production equipment. Plant meeting of Plant- R&M and Technical held 5/28/46.

3. Layouts - See layout report.

4. Charges to FTI-5 - FI-123 ~~has~~ reviewed to correct charges.

*Accounting provided up to date definition of tooling and machinery classifications.*

\*Carry-over from 5/1/46 report.

EXHIBIT 1

INCOMPLETE 5/1/46 - COMPLETE 6/1/46 - ALSO NEW PROBLEMS COMPLETED

1. Type truck for material handling within manufacturing area.

Plant agreed to use conveyor rack truck for processing receivers up to centerless grind operation. 40 trucks included in Project FI-180. *Project approved Trucks on order.*

2. Handling and Storing Equipment-

Items required not now on hand included as part of Project FI-180. *Project approved items on order.*

3. Comparator Inspection-

Project FI-178 covers request for inspection comparator. *Project approved Comparator on order.*

4. Location of M/721 Assembly Operations-

Plant advised all operations possible would be performed in 46-1 or 48-1 - M/721 areas.

5. Charges for changes in design and new tooling for substitute machines-

Charges to be placed against contingencies on FI-123 and FII-5. The change in schedule of three months may make certain substitute operations unnecessary.

6. Plant moves in order to accommodate incoming equipment-

Areas being cleared. ~~Delays in machine shipments due to factory and railroad difficulties assisted in giving adequate time to prepare space. Certain unforeseen problems will be encountered, such as placement of Cincinnati Grinder #5, due to wheel storage and filter equipment not originally anticipated.~~

7. Plant raised question on Accounting ability to handle new part numbering system in Tabulating Room. Letter - R.C. Gilbert to A. J. Brown dated 5/2/46.

R & M checked with Plant Accounting and found Accounting had arrangements to handle, and equipment available.

8. Ethyl cellulose protection of tools recommended by Chem. & Met. and R & M.

Plant agreed to use on all tools including M/721 for protection of cutting edges. Equipment required included in Project FI-180. *Equipment on order.*