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H. A. Williamson
A. Prokop
W. Wood

January 18, 1950

SUBJECT: QUALITY MEETING MINUTES (WEEKLY)

TIME & PLACE: 10:00 a.m. E. J. Hock's Office-Dept. 79-Bldg. 47-3

PRESENT: E. J. Hock A. Prokop
J. Connors W. WoodOLD BUSINESS:1. Items Closed:

1. M/121 Breech Block Oper. 36- Request was made 1/12/50 to supersede RW-3001 with RW-2905 in Process Record.
2. M/121 Breech Block Oper. 35- Request was made to remove RW-3278 from Process Record.
3. M/121 Breech Block Oper. 19-3- Request was made to list RW-3039 as: For M/12 only, and to remove RW-1939 from Process Record.

II. Problems:

1. M/121 Breech Block Oper. 16, 17, 18- Process Record, Past Practice Record, and gages on job do not agree.
 - a. Still under investigation by Technical.
 - b. A. Prokop to follow.
2. M/121 Action Bar Oper. 47- Wall thickness thinner than Past Practice Record limits; span of slots wider than max. slot limits; gage W-932, Dike W-932-1, W-932-2 listed in Process Record but are not on job.
 - a. Previous discussion was that some gages can not be used because of present limits and fixture clamping characteristics.
 - b. A. Prokop requested M/Drawing change 1/17/50.
 - c. A. Prokop to follow.
3. M/121 Breech Oper. 3A-4- Position lengthwise of notch appears uncontrollable to present tolerance of .002. The observed standard deviation indicates a tolerance of .003 is used.
 - a. Operation not running at present-no work.
 - b. A. Prokop, J. Connors, W. Wood to follow.
4. M/121 Breech Block Oper. 23-A- Bevels off position.
 - a. New gage drawing completed and new gage being made.
 - b. A. Prokop to follow.

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NEW BUSINESS:

1. Problem: M/121 Trigger Oper. 18-Form Mill Back End Finish & burr. Gage RW-3037 (Template for form of finger piece) on job but not being used.

Discussion: Due to past changes in process, gage is minus one locating pin. It was decided to investigate operation to determine whether this gage is necessary or out-moded. If gage is necessary, it was decided to replace locating pin.

Assignment: A. Prokop to follow.

2. Problem: M/121 Trigger Oper. 22- Mill Notch-gage RW-3455 supercedes RW-643 per Process Record. Past Practice record lists gage change but no change in added limits.

Discussion: It was decided to review operation and equipment.

Assignment: A. Prokop to follow.

3. Problem: a. M/721-722 Gear Oper. 16, 18- No Process Records in area.

b. M/721-722-Safety Cam Oper. 16, 18-No Process Records in area.

- c. M/721-722 Gear; Safety Cam-Grinding operations 16, 18, 20 (both components)-These operations do not appear to stay consistently in control.

Discussion: a. E. Hock stated that he would check on Process Records.

- b. It was stated that the grind operations in question were under investigation by A. Prokop.

Assignment: a. A. Prokop to follow.

- b. E. Hock to follow.

4. Problem: M/272 Trigger Oper. 4-2-Grind .156-.153 dimension Front End. The present method of measuring the depth of grind with gage while the component is in the fixture does not appear to be positive enough for control. Receiver gage 64999 is listed in Process Record but is not on the job.

Discussion: It was brought out that the gage 6499 had been promised by Technical. Further, it has not been definitely determined whether the operation will be in the permanent process as it is still under investigation by Technical.

Assignment: No present assignment.

5. Problem: Quality Index Weekly- The current percent of total pieces sampled outside of tolerance was due to:
- M/121 Guard Oper. 17- Position of rear end lengthwise off position.
 - M/121 Guard Oper. 19- Position of rear end lengthwise off position; depth of abutment face too shallow.
 - M/121 Receiver-Oper. 7-Depth of clearance hole too shallow. The audit tests on this operation shows at least 2% of the total pieces sampled were outside of tolerance.

Discussion: 1. (a); (b)- An additional .002 limit was added in Past Practice Record.

(c) It was agreed that this was a production responsibility.

2. It was stated that all work in question had been screened and re-run where necessary.

3. E. Wood stated that starting with the next meeting, a machine setter would be present at these meetings.

Assignment:

None

E. Wood
For the Committee