

CC: E. SAFF  
 W. A. BEST D. E. MILLER  
 A. D. GORDON J. W. MILLER  
 H. J. HACKMAN R. A. WILLIAMSON  
 E. J. MOCK A. PROKOP  
 J. CONNORS W. WOOD  
 N. ALEXANDER

January 25, 1950

SUBJECT: QUALITY MEETING MINUTES (WEEKLY)  
 TIME & PLACE: 10:00 a.m. E. J. Mock's Office-Dept. 79  
 PRESENT: E. J. Mock A. Prokop  
 J. Connors W. Wood  
 N. Alexander

OLD BUSINESS:1. Items Closed:

1. M/721-722 Sear-Oper. 16, 18-Process Records have been filed in area and equipment corrected.
2. M/721-722 Safety Cam Oper. 16, 18- Process Records have been filed in area and equipment corrected.

11. Problems:

1. M/121 Breech Block Opers. 16, 17, 18-Process Record, Past Practice Record, and gages on job do not agree.
  - a. Still under investigation by Technical.
  - b. A. Prokop and J. Connors to follow.
2. M/121 Action Bar Oper. 47- Wall thickness thinner than past Practice Record limits; span of slots wider than max. gage limits; gage W-932; Blks. W-932-1, W-932-2 listed in Process Record but are not on job.
  - a. Previous discussion was that some gages cannot be used because of present tolerance and fixture clamping characteristics.
  - b. A. Prokop requested Model Drawing change 1/17/50.
  - c. A. Prokop to follow.
3. M/121 Hammer Oper. 34-4- Postion 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-Devels off position.
  - a. New gage drawing completed and new gage being made.
  - b. A. Prokop to follow.

11. Problems:

5. M/121 Trigger Oper. 18- Form Back End Finish & Burr-Gage RW-3037 on job but not being used.
  - a. New locating pin being placed in gage. If gage is found unnecessary to operation, it will be removed.
  - b. A. Prokop to follow.
6. M/121 Trigger Oper. 22- Mill Notch-Gage RW-3455 supercedes RW-643 as per Process Record. Past Practice Record lists gage change but no change in previous limits.
  - a. It was decided to follow job for one week to determine performance.
  - b. A. Prokop, W. Wood to follow.
7. M/870 Ejector Oper. 4-T-Grind .156-.153 dimension Front End- The present method of measuring the depth of grind with mics, while the component is in the fixture does not appear to be positive enough for control. Receiving gage 64999 is listed in Process Record but is not on job.
  - a. The operation is still under investigation by Technical. Gage 64999 has not been received- promised for 1/20/50.
  - b. A. Prokop to follow.

NEW BUSINESS:

1. Problem: M/121 Action Bar Oper. 51- Hand Mill Guard Clearance- Position sidewise of clearance shows too wide a variation for the tolerance. Use of mics. temporarily authorized.

Discussion: It was decided to measure the cut at a different point and to have A. Prokop review the model drawing for necessary changes.

Assignment: A. Prokop to follow.
2. Problem: M/121 Breech Block Opers. 36, 37, 38-Hand Mill Cartridge Ways 1st and 2nd; Hand Mill Bevel on Face- All 3 of these operations show depth of cut from locating side of part to be deeper than max. gage limits.

Discussion: It was pointed out that these 3 operations were run so as to blend with each other and not necessarily to gage limits. It was decided to have A. Prokop review & determine proper gage limits.

Assignment: A. Prokop to follow.

NEW BUSINESS

3. Problem: M/121 Receiver Oper. 26- Bridge Mill Top Finish  
Depth of top (full length) too deep.

Discussion:

It was decided that added limits could be given on the high side of the tolerance.

Assignment:

A. Prokop to follow.

4. Problem: M/121 Breech Block Oper. 37-1- Hand Mill 1st Heading  
Bevel- The top face of the flush pin of gage RW-3277 does not appear to be parallel with the gage steps of the gage block.

Discussion: It was stated that Technical has made a Model Drawing change which will alter this gage. Further, it was decided that the gage would be satisfactory until the change was complete.

Assignment: A. Prokop to follow.

5. Problem: M/121 Breech Block Oper. 47-5- P/M Recoil Shoulder  
Finish- Process Record lists gage RW-2839. Gage is not on job.

Discussion: It was decided to check gage drawing and correct Process Record.

Assignment: A. Prokop to follow.

Remarks: The current Weekly Quality Index was discussed and necessary corrective action was taken.

W. Wood  
For the Committee