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February 1, 1950

SUBJECT: QUALITY MEETING MINUTES (WEEKLY)

TIME & PLACE: 1:00 p.m. E. J. MOCK'S OFFICE-DEPT. 79

PRESENT: E. J. Mock A. Prokop
J. Connors A. D. Gordon
F. Kennedy W. Wood

OLD BUSINESS:1. Items Closed:

1. M/121 Trigger Oper. 22- Operation apparently running to gage. Added limits to remain in Past Practice Record.
2. M/121 Receiver Oper. 26- Limit opened .004 on high side. Change was noted in Past Practice Record.
3. M/121 Breech Block Oper. 47-5- Gage RW-2839 removed from Process Record.
4. M/121 Trigger Oper. 18- New locating pin placed in gage RW-3037 and the gage is to be used to measure the radius of finger piece only.

11. Problems:

a. The following problems are under investigation by Technical:

1. M/121 Breech Block Oper. 16, 17, 18-Process Record, Past Practice Record, and gages at these operations do not agree.
2. M/121 Breech Block Oper. 36, 37, 38-All 3 of these operations show depth of cut from locating side of part to be deeper than max. gage limits.
3. M/121 Breech Block Oper. 37-1- 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. Further, it is understood that Technical has made a model drawing change which will alter this gage. The gage is considered satisfactory until change is complete.

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OLD BUSINESS11. Problems:

4. 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 and W-932-2 are listed in Process Record but are not on job.
5. M/870 Ejector Oper. 4-T- The present method of measuring the depth of the 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.

It was decided that production supervision would contact Technical Engineer Personnel concerned and request them to attend the next Quality Meeting in Dept. 79.

b. Further Problems:

1. M/121 Hammer Oper. 34-A- Position of notch lengthwise appears to be using wider limits than the specified tolerance of 0.002. Depth of notch appears to be consistently above or below gage limits.
 - a. A summary of Audit Tests by Product Controller shows position lengthwise of notch to be using tolerance of 0.004.
 - b. A. Prokop to investigate.
2. M/121 Breech Block Oper. 23-2- Bevels off position.
 - a. New gage drawing made but gage not completed.
 - b. A. Prokop to follow.
3. M/421 Action Bar Oper. 51- Position sidewise of clearance appears to show wider variation than tolerance. Use of mics. temporarily authorized.
 - a. A new gage has been requested to measure the cut at a different point.
 - b. A. Prokop to follow.

NEW BUSINESS:

1. Problem: M/721-2 Safety Cam Oper. 20- Grind Firing Pin Heading Surface- Set block of base gage C-53578 (for component #17945) shows about 0.0005 taper on surface to which dial indicator is zeroed.

NEW BUSINESS

Discussion: It was decided to check set block of C-53578 for taper, and to request the use of a dial unit graduated in 0.00025".

Assignment: A. Prokop to follow.

Remarks:

1. The current Weekly Quality Index was discussed and necessary corrective action was taken.
2. Period 12-7-49 to date: 27 problems presented for discussion of which 18 are closed and 9 outstanding.

W. Wood
For the Committee