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MONSANTO RESEARCH CORPORATION

Inter-Office Correspondence

From LOCATION : Mound Laboratory, Miamisburg, Ohio

cc :

DATE : October 20, 1966

MOUND LABORATORY-MONSANTO  
CENTRAL FILE NO. 66-10-398

SUBJECT : LRL-MD Coordination Meeting Minut  
October 6, 1966

ALMD66103981341

TO : Distribution

The following information briefly summarizes the status of various programs and the results of action item discussions in the second LRL-MD Coordination Meeting.

Program Status

XW-63 Program -- LRL is making recommendations and guidance is expected by the end of October.

XW-62 Program -- LRL expects to use the MC-1991-2. Hope to use also an XW-68. CER in 3/67 has been slipped to 6/67 for detonators with FPU in 12/68.

MC-1991 -- Pantex will determine how many units to return to Mound after determining requirements. Lot 212 has been test fired satisfactorily. LRL will consider returning some of their QA sample to supply Pantex. 2200 cables have been ordered from Bendix with delivery expected in 5 months. SANL's will probably not be filled by Mound till next summer.

MC-1690 -- Lot 401 and about 350 of Lot 402 have been fired for requalification. Lots 208, 209, 210 are completed and ready for test firing. Mound is waiting for Pantex deliveries for further testing against the 900 required.

Action Items

MC-1991

1. Procure new gaging for head thickness, loaded cups, final assembly. MD-QC Gages are on order and delivery is expected about ~~September~~ <sup>November</sup> 1, 1966. Open set-up can be used.

MOUND LSDR PROJECT  
(funded through DOE's OPENNESS INITIATIVE)  
Record Copy held at Mound Facility

MOUND DECLASSIFICATION REVIEW	
DETERMINATION (CIRCLE NUMBER(S))	
1. CLASSIFICATION RETAINED	<input type="checkbox"/>
2. CLASSIFICATION CHANGED TO:	<input type="checkbox"/>
3. CONTAINS NO DOE CLASSIFIED INFO	<input type="checkbox"/>
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5. CLASSIFICATION CANCELLED	<input checked="" type="checkbox"/>
6. CLASSIFIED INFO BRACKETED	<input type="checkbox"/>
7. OTHER (SPECIFY):	<input type="checkbox"/>
1ST REVIEW DATE: 3/12/82	
2ND REVIEW DATE: 3/30/81	
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MLM-CC-5, eff. 2, dated 3/1/93

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MC-1991 (Continued)

2. Develop "Crimping party concept."  
MD-P and PE. Proposals made to LRL, approvals sought.
3. Radiographic inspection as per ACO UC 250155-25-P2.  
MD-QC. Manual is being written.
4. Height inspection as per ACO UC 250155-25-P2.  
MD-QC. Data will be forwarded to LRL within several weeks following meeting.
5. Prepare listing of detonators from previous lots falling outside specifications on heights. List to include height, standard deviation, average height, location or weapon serial number.  
MD-QC. Information available 10/7/66.
6. Results of dirty powder study.  
MD-P and PE. The study reveals that new cans of powder are clean and therefore the powder is becoming contaminated during use. Opened powder will no longer be returned to bulk cans. Loaded detonators will be covered in their trays.

The PETN Committee reported they are working toward better drum acceptance analytical procedures. Of 4 lots tested, 2 had satisfactory MC-1991 Tu and 1E26 threshold test.

7. Investigate likelihood of chipping during crimping in previous lots.  
MD-P. It is likely that cocked heads in the past were removed, relocated and crimped.

The matter of polling production workers was discussed and due to the problems of; 1) causing too much inventiveness, 2) being a policy matter it was decided that if LRL wished to pursue this it should be on the Department Director's level.

MC-1991 (Continued)

8. Design fixture for holding head and loaded cup and assembling mechanically rather than manually.  
MD-PE. Fixtures in design and machine shop.
9. Develop equipment for recording height measurement.  
MD-QC. Operation presently done manually. The Advanced Development Group is working on measurement recording system.
10. Chip studies. Effect on firing.  
MD-D. Study completed. Chip on pellet in proximity to cable caused no degradation, nor was there a height correlation. Large chips close to BW caused late firing.
11. Radiography of cracked heads.  
MD-D. X-ray did not pick up.

MC-1960

1. Design gaging for individual parts and final assembly.  
MD-QC. Planned to wait for 1991 results. LRL said to proceed.
2. Institute "crimping party" concept with cost estimate, feasibility study.  
MD-P and PE. Awaiting MC-1991 evaluation.
3. Examine powder.  
MC-P and PE. Same results as MC-1991.

MC-1E26C

1. Place letter concerning circumstances of test firing of Lots 101 and 102 in Lot Record Book.  
MD-QC. Letters are in Lot Record Book and Lots 101 and 102 shipped.

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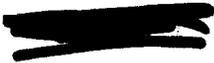
Action items for next LRL-MD Coordination Meeting

1. Investigate automatic collection of height and reject rate data. P and QC.
2. Supply ACO to make MC-1991 overall height measurement with label as reference measurement only. LRL
3. Clarify feed-back desired from production line. LRL
4. Fire MC-1991's with head cracks between electrodes. DEV.
5. Required manual change to permit powder removal from head-cable assemblies to use as fiducials. P
6. Provide specification to allow for fiducial production. LRL
7. Investigate feasibility of in-line x-ray of MC-1690 and 1991 loaded items in I Building. PE and P
8. Expedite procurement of MC-1991 labels for next lot. P. Control.
9. Height study required to arrive at number of MC-1991 reject at Pantex and to decide when to ship Lot 213. PE and QC.
10. Send copies of past failure investigations to LRL. PE
11. Manuals and specification changes should be pursued in preparation for QAP-10 Survey on November 14.

The next coordination meeting is planned for November 18, 1966.

ORIGINAL SIGNED BY

R. D. Schaefer

  
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