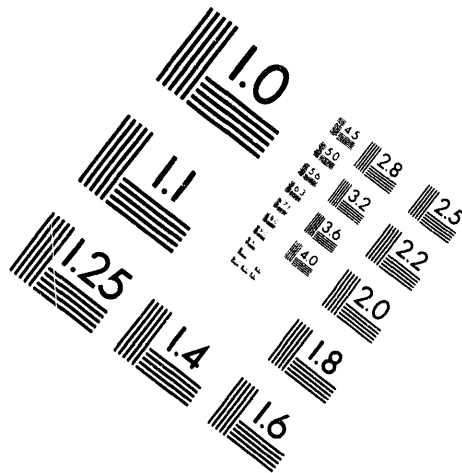
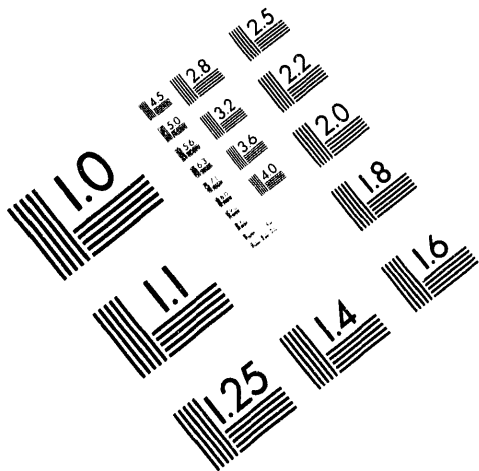




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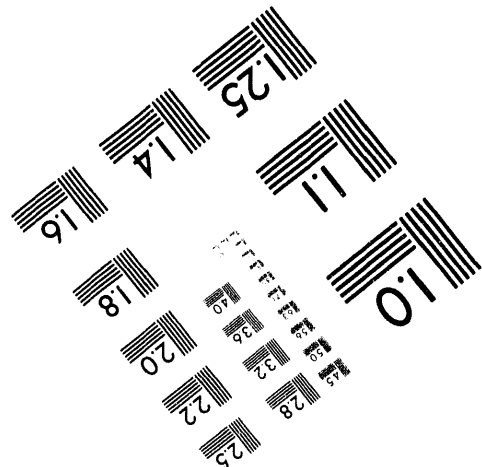
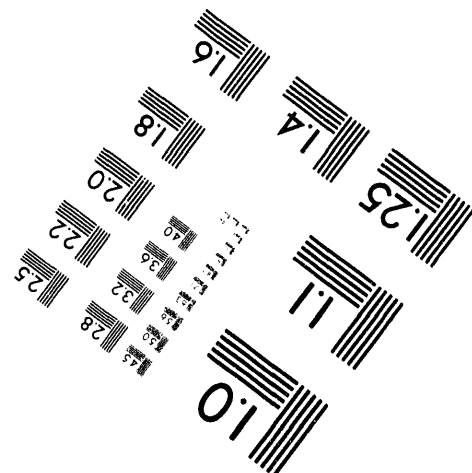
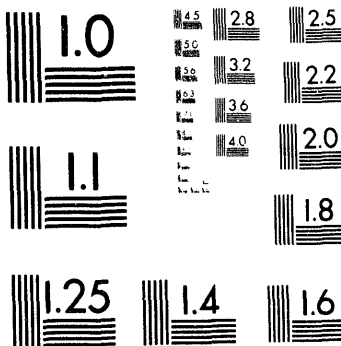
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April 20, 1945

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Du Pont Record Transfer
Wilmington - Dec. 1947

TECHNICAL DEPARTMENT

REPORT ON PRODUCTION TEST NO. 313-68-M

Recanning of Warped Slugs Segregated after the Centrifuge
by Technical Warp Gauge

INV.
9-47

Introduction:

It has been found that warped slugs which produce "non-seats" can be segregated after the centrifuging operation by use of a suitable gauge. The slugs which do not pass the gauge are quenched in water and set aside for later recovery.

The purpose of this test was to determine if the rejected slugs could be straightened, degreased and recanned by dipping them directly in the bronze and then through the subsequent steps.

Summary:

One hundred and twenty-nine slugs rejected by the warp gauge were straightened, degreased and recanned by dipping directly into the bronze bath. Eleven non-seats and one Al-Si spill over were rejected at the canning pot.

The above procedure is recommended as a possible means of treating slugs rejected in the canning operation because of warp.

Experimental Details:

The slugs which were rejected by the warp gauge were quenched immediately in water. Slugs were then accumulated from approximately two shifts of operation and the lot passed through the straightening operation, degreased and then canned.

No difficulty was encountered in wetting by the bronze bath as was expected since the slugs were already continuously coated with tin. One hundred and twenty-nine slugs were processed with eleven "non-seats" and one Al-Si spill over occurring. A rather high per cent of non-seats was to be expected among these slugs since they had all been previously rejected because of warp and straightening without stress relieving by

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April 20, 1945

some form of heat treatment would not be expected to be 100% effective. It does reduce the number of slugs which would normally be passed through chemical recovery since the 129 slugs treated here would have been recovered as "non-seats" while by the proposed procedure only twelve slugs will have to be recovered.

K. G. JONES, CHIEF SUPERVISOR
METALLURGICAL SECTION


L. D. Eubank, Area Supervisor

LDE/mb

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FILE RECORD CARD

3-2166

DATE 4/20/45

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SUBJECT Report on Prod. Test No. 313-68-M - Recanning of Warped Slugs

TO Simon-Mackey-Otto FROM L. D. Eubank

NO. OF COPIES 9 SERIES A

1. Du Pont Record Transfer Metal Coating-
Simon-Mackey Dec. 1947
Wilmington
Otto-700 file Prod. Test Reports-3 COPY 1 OF 1, SERIES-MA-

2. M. H. Wahl Rec. 4-27-45 11. _____

3. Sent to Area Eng. Mfg. Patent Group
RECEIVED BY RECEIPT. 3-4-45 10. _____

4. DESTROYED BY C/D 11834-700 N Metal Reclamation REMARKS

5. DESTROYED BY C/D 11834-300 N Metal Reclamation

6. DESTROYED BY C/D # B-0248

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9. Yellow Copy Wjhm. 4-28-45

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