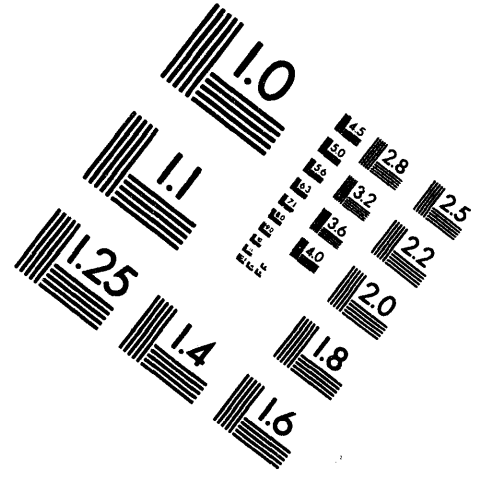
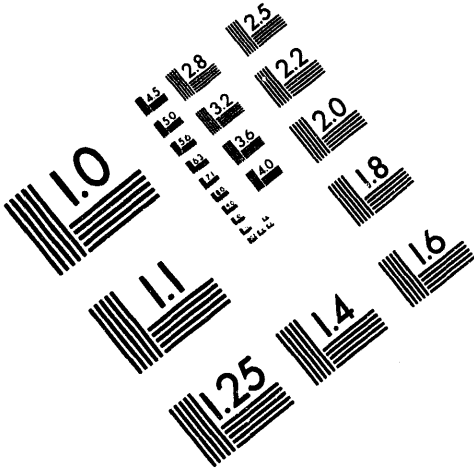




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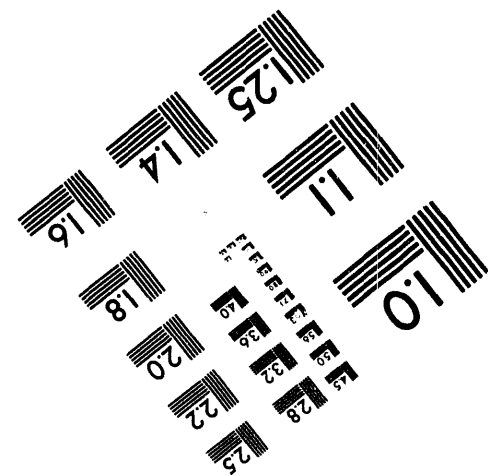
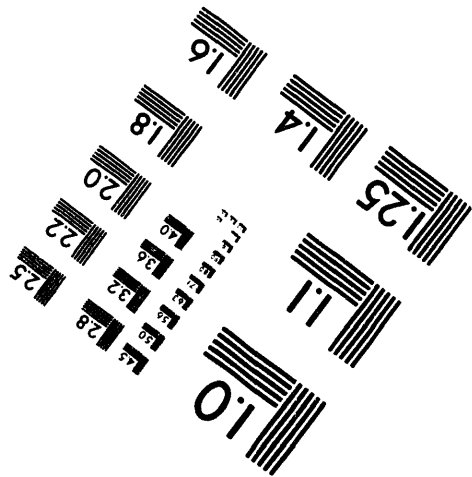
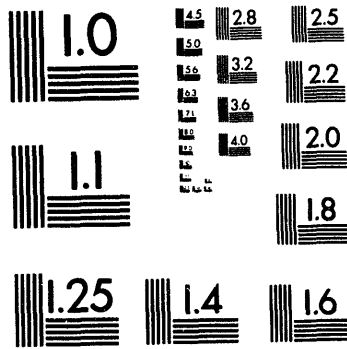
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Silver Spring, Maryland 20910
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Centimeter



Inches



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1 of 1

HW--3-2215

UNCLASSIFIED

Classification changed to

(Insert appropriate classification)

- W. C. Simon - B. H. Mackey *SWC*
- F. Otto - 700 File *Don*
- M. H. Wahl - Wilmington
- F. W. Crane
- M. H. Smith
- W. M. Sloan
- K. G. Jones
- 300 File
- Pink Copy
- Yellow Copy

by authority of *see attached file record card*

(Authority for change in classification)

by *AED Don off*

3/24/89

(Signature of person making change and verifying the information)

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April 24, 1945

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TECHNICAL DEPARTMENT

THIS DOCUMENT IS OF *2* DATE NO. *1*
OF *9* COPIES SERIES *A*

REPORT ON PRODUCTION TEST NO. 313-69-M

Reviewing Official:

C.J. Banick

C.J. Banick, AED Class. Officer

Effect of Straightening Rods before Outgassing
Upon Warped Slugs

Date *3/24/89*



Introduction:

Strains are introduced into bars by cold working in the straightening operation. If no treatment is applied to relieve the strains after the straightening operation, it is conceivable that they may be relieved in the canning process and cause warped slugs. The purpose of this test was to see if fewer non-seats would occur among slugs machined from bars that were outgassed after straightening.

Summary:

Seven hundred and thirty-five slugs from bars that were straightened before outgassing were canned by the standard procedure. One per cent non-seats and 1.9% wrinkled cans were noted at the canning pot.

It is recommended that all rods which are to be straightened be passed through the straightening operation before outgassing.

Experimental Details:

A number of typical worked bars were straightened and loaded in the outgassing chambers with the longest bars on the bottom to avoid crooking of the bars that might occur if long bars were placed on short bars or mixed at random. After the normal outgassing cycle the bars were machined and inspected. Seven hundred and thirty-five slugs were than canned by the standard procedure. The data on the test are tabulated below:

Slugs from Bars Straightened before Outgassing

<u>Lot No.</u>	<u>Type Metal</u>	<u>No. Slugs</u>	<u>Non-Seats</u>	<u>Wrinkled Cans</u>
151	K	331	2	5
153	TK	404	5	9
Totals		735	7 (1%)	14 (1.9%)

MASTER

875

April 24, 1945

It is interesting to note that the number of wrinkled cans is somewhat lower than average production.

K. G. JONES, CHIEF SUPERVISOR
METALLURGICAL SECTION

L. D. Eubank
L. D. Eubank, Area Supervisor

LDE/mb

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3

HW 4.100

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HW-- (3-2215)

DATE 4-24-45

CLASSIFICATION Confidential *DECLASSIFIED

SUBJECT Report on Production Test 313-69-M - Effect of Straightening Rods before Outgassing upon Warped Slugs

To Simon-Mackey-Otto FROM L.D. Fubank

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*Per authority TEB-1153 appendix 10, 7-16-57

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REMARKS
Ref: 4-4-45 3-2054 Prod. Test 313-69-M
NOTE: Page 1 of this doc. was revised on 8-4-45. The deleted copies of the original page 1 were destroyed. See: Certificate of Destruction dated 9-20-48.
*c6 Returned to file by F. W. Test per receipt dated 11-9-50. Filed 700-178.

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