

TRIP REPORT
Lancaster Glass Co.

Date: March 22, 23-1966

Persons Contacted: Mr. Schupe, Mr. Tolliver, Mr. Davidson

Object: Review HB Glass Quality & Production Status

Result: HB glassware design parameters are in good control at the vendors plant. Mask stud insertion control was locking and much of the production evidenced re-entrant fillet seals.

Discussion: All phases of HB production were inspected and reviewed for quality. Lancaster has greatly improved their Q. C. situation, much of which is due to the diligence of the Q. C. Manager, Mr. Howard Schupe. The attached data illustrates the measurements taken on stud plane and penetration.

The main problem that had not received sufficient attention was stud seal quality at the RF seal stations. Lancaster's Engineer, Mr. Tolliver, felt that an impending change in stud length would alleviate this condition. However, it was noted that somewhat haphazard changes in RF temperatures were occurring over the three shift operation. Mr. Schupe agreed that they would provide an hourly check on the quality of the stud seal in conjunction with their other Q. C. procedures.

Review of parts in process indicate that we should currently expect a high incidence of re-entrant fillet seals; however, should Mr. Schupe's vigilance improve this condition to the degree that stud plane quality has been affected, shipments of future glassware should be free of this defect.

It is anticipated that this engineering liason will continue on a bi-weekly basis; or, at least, until that time when quality conditions indicate it to be unnecessary.

WFA
W. F. Hopkins
Color Product Engineering

WFH:smd

cc: E. F. Schilling
V. C. Campbell
D. R. Coffman
C. R. Miller
P. N. Taggett
R. J. Goggins

Bldg. #15 EP
Bldg. #15 EP
Bldg. #15 EP

STUDY SUMMARY

CT

5202

DIMENSION

CHECK

for

STUD PLANE & PENT.

C SHIFT

7^{AM}3^{PM}

MUSHROOM C

DEPT.

OPERATOR

DATE 3-18-66

STUD	PLANE			Time	STUD	PENT.			
9	6	3			9	6	3		
-004	-001	-003		8:30 AM	-004	-008	-012		
-001	-001	-007			-002	-005	-017		
-001	-002	-005			-003	-007	-012		
-003	-002	-008		9:25 AM	-005	-004	-016		
-001	-001	-004			-005	-006	-010		
+004	-001	-001			-003	-005	-010		
-001	-004	-005		10:40 AM	-003	-007	-015		
+002	-001	-001			-003	-005	-013		
+002	000	-008			-002	-006	-007		
-003	-003	-003		11:40 AM	-001	-006	-013		
-002	-004	-005			000	-005	-015		
-002	-001	-005			-001	-005	-012		
-001	000	-001		12:45 P.M.	+002	-006	-008		
-003	-001	-006			+001	-003	-006		
-002	-002	-005			000	-007	-011		
-005	-001	-008		1:40 PM	+004	-009	-014		
-004	-004	-010			+006	-005	-012		
-006	-005	-010			+003	-006	-014		
-006	-002	-004		2:40 PM	+005	-009	-010		
-005	-002	-004			+002	-007	-003		
-001	-001	000			+005	-007	-006		
-006	-004	-013		3:45 PM	+005	-004	-009		
-007	-005	-009			+007	-001	-007		
-006	-006	-008			+006	-003	-012		
A-Sh, FF				4:30 PM					
-010	+003	-011			+007	-008	-005		
0	+003	-009			+005	-005	-005		
-007	+001	-014			+004	-005	-006		
				5:30 PM					
-009	+001	-015			+009	-004	-010		
-005	+001	-007			-009	-006	-014		
-012	+001	-014			+008	-005	-014		

STUDY SUMMARY

SUBJECT E202 DIVISION CHECK Per Stud Plane & Stud Penetration

FL shift 7:AM 3:00 PM

MUSHROOM C

DEPT.

OPERATOR

DATE 5-22-66

0	Stud Plane			Time	Stud Penetration		
	6	2			9	6	3
+010	000	+013	↑ 206005 ↓	8:45 AM	-007	-006	-013
+002	-014	+014			-008	-005	-014
+008	-002	+009			-010	-006	-015
+006	-002	+009		9:35 AM	-012	-006	-015
+001	-001	+011			-007	-004	-016
+004	000	+015			-003	-006	-015
+000	-003	+010		10:30 AM	-007	-007	-020
+007	-007	+011			000	-010	-020
+011	000	+011			-002	-005	-016
+012	000	+012		11:30 AM	000	-005	-015
+003	000	+017	changed all chucks		-003	-010	-017
+012	000	+019			+009	-021	-026
+004	-001	+009		1:10 PM	-004	-009	-018
+003	-003	+005			-006	-007	-017
+006	000	+007			-003	-006	-019
+008	-005	+008		1:45 PM	+000	-007	-020
+000	-006	+005			-003	-009	-018
000	-005	+006			-006	-010	-020

SUBJECT E202 DIMENSION CHECK FOR STUD PLANE & STUD FOUNDATION

12. 11. 1971 7:00 am. 3:00 P.m.

M 15 NR COM A

OPERATOR

DATE 3-22-66

[illegible]

STUDY SUMMARY

SUBJECT

5202 DIMENSION CHECK FOR STUD PLANE & PENT
A-SHIFT 3-11 MUSHKON @

DEPT.

OPERATOR

DATE 3-19-66

STUD 9	PLANE 6	3			TIME	STUD 9	PENT 6	3	
-003	-005	+003			6:30 PM	+001	+002	-019	
-003	-003	-005				+002	+005	-022	
+003	+004	+005				+003	+006	-023	
0	-004	+003			7:30 PM	-002	-006	-015	
+002	-002	+007				-002	-006	-016	
+004	-005	+009				-004	-016	-014	
-002	-002	+005			8:30 PM	-004	-005	-016	
-011	-003	+002				+004	-003	-014	
-004	-003	+003				-002	-004	-015	
-002	-001	+007			9:00 PM	-002	-008	-014	
0	-003	-004				-006	-004	-016	
0	-001	+009				-007	-007	-017	
-002	-004	+006			10:30 PM	-002	-008	-021	
-001	-004	+009				-007	-010	-018	
-003	-004	-005				-006	-007	-019	
+001	-003	+003	A shift.	11:30		-005	-006	-014	
+004	-003	+006		PM.	11:30	-001	-004	-013	
+002	-003	+005			PM.	-000	-002	-015	
+003	-001	+005	"B" shift.	12:30		-002	-004	-011	
001	-004	+005		AM.		-006	-007	-011	
006	-002	+006				-005	-004	-010	
+001	-002	+006				-002	-004	-018	
-001	-003	+007			1:30	-002	-004	-019	
-004	-002	+008			A.M.	+002	-003	-019	
000	-002	+004				-003	-005	-014	
002	-002	+008			2:30	-003	-002	-017	
-003	-002	+006			A.M.	-005	-008	-009	
+001	-003	+006				-002	-002	-015	
002	-003	+009			4:00 A.M.	-002	-006	-018	
000	-005	+005				000	-001	-018	
		"C" Machine	Shut Down AT	3:00 A.M.					
			4AM is	Final Reading					

STUDY SUMMARY

SUBJECT

SP12 DIMENSIONAL CHECK for STUD PLANE + PENT.

DEPT.

OPERATOR

DATE 3-19-66

STUD	PLANE			TIME	STUD	PENT.			
9	6	3			9	6	3		
-001	-002	-005		8:45	+001	+004	+008		
-002	+003	-002		Am.	-002	+005	+011		
+005	000	+005			000	+002	-017		
+003	000	+003		9:35 Am.	000	+005	-017		
+003	-001	+004			-001	+004	-017		
000	+001	+001			+003	+002	-013		
+005	000	+005		10:40 Am.	-003	-014	-011		
+005	-001	+005			-007	-010	-014		
+006	000	+006			-005	-011	-013		
+002	+004	-002		11:50 Am.	000	+001	-010		
+001	-003	+001			000	+004	-010		
+006	-002	+006			+002	+004	-011		
+001	+006	-004		1:00 PM	+001	+002	-013		
-001	-001	+003			+001	+002	-012		
0	0	+005			+003	+002	-010		
-003	-001	-001		1:30 PM	+001	+007	-013		
-003	+002	-005			+001	+005	-012		
+001	-003	+001			0	+003	-012		
-002	+005	-002		2:45 PM	+001	+004	-015		
0	0	+005			+002	+005	-017		
0	-001	+006			+005	+004	-023		
0	-001	+005		3:30 PM	+004	+005	-020		
-001	+002	0			+005	+005	-020		
-001	-001	+002			+004	+005	-020		
A-SH, PI				4:30 PM					
+002	-002	-003			+004	+003	-018		
-013	+003	0			+001	+003	-019		
-015	-003	0			+003	+006	-015		
-001	-002	-004		5:30 PM	0	-001	-001		
-000	-003	-005			0	+004	+005		
0	-003	-003			+001	0	+003		

SUBJECT

Ex. 02 Dimension check For Stud Plate & Penetration

"6" left. 11 pm - 7 A.M.

Mushroom "C"

EPT.

OPERATOR

DATE 3-18-66

STUD		Phone		STUD		Phone	
4	6	3		Time	9	6	3
004	+001	+003			000	-002	-001
004	000	-001		4:30	000	000	000
000	000	-005		A.M.	-003	-002	+002
005	000	+001			-002	+001	+006
001	+004	-005		5:30	-001	-001	+001
003	+001	-002		A.M.	-002	-001	+002
002	+004	-001			000	+003	+004
005	+003	+001		6:30	+002	000	+002
02	-001	-004		A.M.	+001	-001	+002

STUDY SUMMARY

JT 5002 DIMENSIONS CHECK for Stud PLANE & PENT
 1-SHIFT 3-11 Mushroom @

DEPT. OPERATOR DATE 3-12-66

STUD	PLANE			STUD	PENT		
9	6	3		TIME	9	6	3
4004	4001	+001		6:30 PM	-005	-002	-008
4007	-001	+001			-004	-003	-002
4004	+005	0			-005	-004	-010
4004	+001	0		7:30 PM	-003	-002	-007
4001	0	-004			-007	-005	-011
4002	-002	-003			-004	-003	-006
4004	4003	-007		9:00 PM	-001	-003	-007
4002	4002	+005			-001	-006	-011
4003	4005	-005			-005	-004	-002
4002	4004	-001		9:30 PM	-004	-004	-004
-003	+003	-003			-001	+005	-011
4006	-002	-002			-004	-001	-006
4001	4003	-007		10:50 PM	-001	-002	-003
4003	0	-003			-003	-002	-009
4005	-003	-004			-002	-003	-005
	11: PM	7: AM,					
005	000	+001			-005	-001	-009
006	+003	000		11:20 PM,	-005	-005	-006
004	+004	-005			-007	+001	-009
004	-001	+001			-002	-004	-004
001	000	000		12:30 A.M.,	+001	-002	-002
001	+002	-001			-003	-005	-005
003	-001	+002			-002	000	-006
003	+002	+002		1:30 A.M.,	-002	000	-006
002	-004	+004			-004	-004	-004
003	+002	+003			-003	-003	-006
006	+004	+006		2:30 A.M.,	-002	-001	+001
004	+006	+004			-002	-002	-001
003	-001	000			000	+001	-002
002	-001	+001		3:30 A.M.,	-002	-002	-003
004	000	+004			-002	-003	-001