

#4

TELECON

DATE: May 5, 1967
May 8, 1967

TO: [REDACTED] SC 2041
[REDACTED] SC 2041

FROM: [REDACTED] BKC 864

SUBJECT: T446

1. I requested that Sandia assure that the 2N 3440 transistor requirement was deleted from drawing 209859 which is the DC blower motor. Also the PS for the DC blower assembly, PS 209136 required some changes to the DC test voltages.
2. Sandia indicated that it was OK if BKC substituted Monadnock Mills P/N 293398 for P/N 293308 on drawing 871816. This is a transipad for a TO-18 transistor. However, a new P/N must necessarily be assigned and this will be 875944 for the 293398 teflon transipad. Sandia will (eventually) change the appropriate drawings to call out the new part number.
3. [REDACTED] requested that BKC stress the importance of holding the 6.500 inch dimension to our Model Shop when they are welding the main case assembly (P/N 209123) for the T446. He indicated that the drawings presently require that some additional filler metal be inserted during the butt-welding to achieve this dimension.
4. [REDACTED] indicated that BKC should tap the holes in the monitor panel P/N 209196 after plating but prior to installing the inserts. Otherwise the plating thickness compresses the insert thereby causing excessively tight screw threads. [REDACTED] has since indicated that BKC is allowing for .0005 plating on the initial tapping of these threads so that a retap will not be necessary.
5. I pointed out to [REDACTED] that when Sandia deleted the gasket, item 26, on DC blower, P/N 209136, that they had failed to call out any RTV material to make a substitute seal. Sandia will make changes to add the callout to drawing 209136.
6. I told [REDACTED] that the Ion Cover casting, P/N 209106, as received from Reute had an .060 radius on the 3.745/3.775 diameter and asked if BKC could machine this to a square corner. [REDACTED] indicated that this was not necessary.

7. I told [redacted] that the Fluoro-Carbon Corp., Anaheim, California, had quoted \$56 and \$155 respectively for machining and furnishing the material for P/N's 260246 and 260248. These are the precipitator cover and housing parts made from Kel-F. [redacted] said that due to Shamban's difficulty in molding these parts and in view of the above prices, Sandia would give BKC a request for quote for machining 22 each of these two parts for Sandia evaluation. [redacted] further stated that although officially BKC should supply the 20 T446's now on order with "Piece Part" precipitators (reference former telecon) that it would be acceptable to Sandia if we use the machined precipitators. However, BKC should consider the time involved in evaluating the machined precipitators relative to the T446 schedule. In view of these facts, [redacted] suggested that BKC at least buy the material for the "Piece Part" precipitator. Sandia is sending five copies each of the drawings required to fabricate the "Piece Part" precipitators.
8. [redacted] assured me that Sandia's drawing coordination with the Reuter Co. would assure good T446 castings and it would not be necessary for either BKC or Reuter to evaluate the voluminous drawing changes recently made to the castings.
9. I told [redacted] that the latest information from [redacted] of Oak Ridge indicates that their Product #47 (198 mc per ml Ni 63) would be acceptable for plating the P/N 209122 precipitator plate. However, due to their workload, the only way Oak Ridge could do the necessary plating at this time would be to use solid overtime. In the interests of economy, the decision was made therefore, to buy 20 mc of the above solution in preparation for doing the plating at BKC. The order for this material has subsequently been placed with Oak Ridge. Immediate delivery is expected since this is a stock item.
[redacted] had indicated earlier that their analysis showed only two measurable radioactive impurities in Product #47. These were: Silver (Au) 110 @ .03 mc per ml and scandium (Sc) @ .04 mc per ml.
10. [redacted] indicated that the 8224809 irradiated polyolefin wire was satisfactory for use on the T446.
11. I pointed out that Electromechanical Instrument Co. had informed BKC that their Model 80-P "Flag" meter was not hermetically sealed as required by drawing 875191. [redacted] said for BKC to buy the part less hermetic seal and Sandia would make the necessary print changes.

[redacted]
Department 864

cc:

[redacted] D/862
[redacted] D/610
[redacted] D/822
[redacted] D/245
[redacted] D/651
[redacted] D/864