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October 23, 1956

MEMORANDUM TO FILE

FROM: R. R. HERRIES

This document consists of 8 pages,
No. 1 of 8 copies, Series A.

Trip Report
MOCZIK TOOL AND DIE WORKS
October 10-11, 1956

A meeting was held at Moczik Tool and Die Works to discuss modifications to the tools for extrusion cladding plates in the 320-M Building at Savannah River. Those present were:

Carl De Buigne, Moczik
Joe Dion, Moczik
Alexander Mackintosh, Consultant
A. S. Ferrara, SRL
R. R. Herries, Wilm.

Following the initial trial of the extrusion cladding tools they were returned to Moczik for inspection and modification. The tools were delivered on 10/9/56 and machining began immediately.

Those present at the meeting agreed upon eighteen items modified or furnished by Moczik Tool and Die. The more important of these items are:

1. Change in design of the adapter for fastening the dummy blocks to the mandrel manipulator to avoid scoring the container.
2. Tapering the guide for easier entrance of cores into the die.
3. Reducing the width of the die housing to allow additional clearance between the die and the platen of the press.
4. Enlarging the grooves for wiring the heating elements in the die and bolster.
5. Providing a spare set of all bolts and pins.
6. Checking all components of the tools for misalignment, deformation, and ease of assembly and disassembly.

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7. Providing a deeper seal to prevent flash between the die and the container.
8. Installing calrod heating elements around the bolster to obtain a more uniform temperature distribution in the die housing.

It was found in a more recent visit to Moczik that misalignment of the guide and the mandrel tip was responsible for the core being off-center in the aluminum sheath of the first plate clad. This will also be corrected. No changes will be made to the porting of the die to alter the aluminum flow until a trial has been made with more uniform heating of the die and a properly aligned guide for the core. It is hoped that no major adjustments to the porting system will be necessary. Only minor changes to the die bearing are being made.

It was estimated that the tools would be shipped back to Savannah River about 10/29/56.

RRH/jss

**DATE
FILMED**

10/14/94

END