

TO: J. E. Wujciga

May 20, 1968

RE: Victocor Body With Yieldable Fire Ring Design

Part No. 3842 - 3859

When I looked at the partial close die, it was in such bad shape that in my opinion this die could not perform in production. This die was overhauled. The 30° angle was added, all analysis cards and prints were corrected. Samples were made and approved.

Part No. 3862

All dies were checked out, corrected and had inspection approval after we established the new diameter in the partial close die.

The problem in this gasket was - partial closing was not deep enough. We reset the stop blocks to correct this.

Part No. 3415 - 3419

There were no wire rings in our plant, or on order, so no samples were made. About six months ago, Product and Tool Engineering reworked these dies. Production Control will notify Tool Engineering and Inspection when orders are being released so we can then make parts before production, using production wire rings.

Part No. 3420 - 3849 - 3850

These are new jobs and had just left our tool room. Arrangements have been made to flange these jobs. Through inspection, these dies were checked and all stop blocks set, even after they left the tool room.

Problems discovered on yieldable wire rings showed me that every step in making the parts were involved and related. In the blanking of body gaskets, we must have as burr free a condition as possible. I traced this right to the repair department, where excessive burrs result in flanges not closing properly. Blanking of the flanges must have proper radius to aid in the 180° inter radius. Partial close die must have right diameter, or uneven heel and overlap condition results. Final close die must be kept clean and care taken not to damage the support rings. Victocor #300 seems to give the biggest problem in steel chips. For example, on Part No. 3847-M of 1,733 gaskets inspected, 550 were reworked. Of the 550 reworked, 500 were because of steel chip marks around the stainless steel flange.

The following steps have been taken to minimize our problem.

All analysis cards have been changed to show what diameter the flanges shall be partial closed to. The Inspectors and Production Foreman have been told of the problems and have taken corrective steps. The Press Operators are aware of the problems. Inspection Department has started to weigh the partly closed flanges to detect double flanges.

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