

DAP

29th, December 1961

Reference PFT/SG P 323

FR 1/17

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COMMONWEALTH AIRCRAFT CORPORATION PTY. LTD.
Elizabeth St.
BOX 779 H P.O.

MELBOURNE
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A/F MANAGER	SUPT. INSPECTION
MR HENRY	

Attention : the MANAGER.

Subject : Longitudinal argon arc welder.

Dear Sir,

Enclosed is a proposal for the longitudinal argon arc welding equipment complete with holding fixture, welding torch, wire feed, electrical control and generator.

The proposal in its present form is rather brief, however the matter has been discussed with COMEPRE and additional information will be made available within the next week and forwarded to C.A.C. This will include a drawing of the equipment showing layout, details of fixture, maximum and minimum size of the parts which can be accomodated, and the general dimensions.

The equipment will combine all the desirable features of the various machines built by SNECMA and as stated in our earlier letter, SNECMA do not have a single machine for welding all the gauges of material used on the engine and require to use the following fixtures to cover the required range.

- (a) Fixture n° MO 6371 for light gauges and tack welding.
- (b) " MO 6636 medium gauges.
- (c) " MO 6355 heavy gauges.

The light gauge material (less than 8/10 mm) will still be hand welded at C.A.C. using a simple clamping bar which has already been ordered as a tooling item.

SNECMA have followed our progress on obtaining a universal machine and as they have now decided to purchase a similar machine, they will no doubt ensure

Handwritten signature

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that the equipment meets our requirements.

We will forward to C.A.C. by air freight catalogues showing the SCIAKY installations at North American Aviation etc... details of the fully automatic equipment, and the Nertafil equipment manufactured by L'AIR LIQUIDE Co. (SAF) of France. The price for a longitudinal SCIAKY welder is over A£ 40,000, the circumferential welder approx A£ 24,000, and the Nertafil without the main fixture £10,000, therefore the price for the complete COMEPRE equipment appears to be quite reasonable.

The Nertafil equipment, including the present SNECMA longitudinal argon arc welders would be unsuitable for the CAC conditions owing to the problem of vibrations caused by the drop hammers, however this should not effect the COMEPRE equipment owing to the tracking equipment and the fixture being combined in the one unit.

The generator included on the COMEPRE proposal will be the standard "RIOU" generator which C.A.C. proposes to purchase for the circumferential welder, including slight modifications to connect the electrical controls on the travelling torch. The input voltage shown on the proposal will be changed to meet C.A.C. requirements.

Yours faithfully,



G.H. FOSTER

1 enclosure.

CONSTRUCTIONS MÉCANIQUES DE PRÉCISION

COMÉPRÉ

Villiers-s/ Marne, le 20 DECEMBRE 1961,

N/Réf. GG/JG/MD.

V/Réf.

COMMONWEALTH AIRCRAFT
c/o S N E C M A
92, Bld. Kellermann
P A R I S 13ème.
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For the attention of Mr. THOMPSON.

P R O P O S A L

One are welding equipment able to join edge to edge sheets to make cylindrical or conical parts. The linear seam can be made internal or external.

This equipment includes:

1° - One fixture which permits the welding of cylindrical rolled sheets, minimum diameter 400 mm, maximum diameter: 2000 mm., maximum laught 1500 mm.

Its consists in a frame in welded plates, giving a great rigidity and a great steadiness. At the upper part of the frame two ranks of dies are adjustable in distance from the welding axle.

Two rails in machined steel are parallele to this axle. They guide a carriage running on ball bearings. On this carfiage are fastened: one universal torch holder, one torch, one wire feed assembly and one wire spool. The frame contains one D.C. motor with its electronic control. The moto tor drives a serew giving the motion to the carriage. The speed (welding speed) is adjustable from 0,05 l/min. up to 1m/min. with a potentiometer, and seen on the diel of a voltmeter.

Beneath the upper dies, one reacting girder, can rocks on the frame in thà vertical direction.

A spring compensate its weight. The free end can be locked in working position by a special device.

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Société à Responsabilité Limitée au Capital de 25.000 NF.

26 AVENUE JEAN-JAURÈS — VILLIERS-SUR-MARNE (S. & O.) *A 12 minutes de Paris (PARKING)*

CHÈQUES POSTAUX PARIS 2.032-05 — R. C. CORBEIL-ESSONNES 55 B 143 — N° D'ENTREPRISE 220.78.684.0011 — **TÉL. 316 & 568** par le 11

This girder hold a bar in stainless steel having grove, holes and tube to conduct argon gas. The bar is guided. It can be raised by air pressure in a special tube, to tight parts to weld. Bars and dies are easily removable.

Air regulators and valves are inside the frame.

2° - One welding current source (RIOU 350 S 5), having the following characteristics:

- Current supply..... 220 volts - 50 cycles
- Secondary voltage..... 110 DC
- Secondary current adjustable in two ranges
from 3 A to 80 A
- " 30 A to 350 A.
- Duty cycle 100 % 350 A.
- Argon delay adjustable on an electronic-timer:
1" to 14"
- Current slope down 2" to 15".

This equipment complete, ready to operate with one back bar:

Price, fob VILLIERS S/MARNE - unpacked:
..... 6270 Australian pounds
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Optionnal: Extra back bar in stainless steel - 150 Australian pounds.

Delivery: 4 mouths after receipt your order and letter of credit in a French Bank.
