

26th, December 1961

Reference HAK/SG P 305

ACTION COPY SENT
TO ENGINE SUPT

FR/4

Mngr..... <input checked="" type="checkbox"/>	Eng. Supt..... <input checked="" type="checkbox"/>
Sec.....	A/F Mng.
Asst. Sec.....	Ch. Eng. A/D.
Ch. Acct. - 2 JAN 1962	Pers. Supt.....
Stores.....	Supply Sales
Ansdr.....	Init.....

MISSION AUSTRALIENNE
S.N.E.C.M.A.
70, bld Kellermann

PARIS 13e
France

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

MELBOURNE
Australia

Attention : the MANAGER.

Subject : Precision Investment Casting Production
ATAR 9C engine.

Dear Sir,

Further to our letter P 249, please find enclosed herewith three copies of REPORT no. 4 : Precision investment casting production - Feed stock material requirements, together with one advance copy of drawings for Investment Castings.

CIRCULATION / COPIES / 16	
E.F. MNGR	FCT. ADM. SUPT.
DSGN. ENGR <input checked="" type="checkbox"/>	MC. SHOP. SUPT.
DEV. ENGR	PRODUCN. SUPT.
SERV. ENGR	ASSM. LY. SUPT.
QUAL. ENGR	FOUNDRY SUPT.
PRD. ENGR	METCAL. SUPT.
MATL. ENGR	PROCESS SUPT. <input checked="" type="checkbox"/>
CH. TL. DSGR	TOOL. PRD. SUPT.
CH. INSP. E. F.	TOOL. ROOM. SUPT.
A/F MANAGER	SUPT. INSPECTION

Yours faithfully,

G.H. Foster

G.H. FOSTER

AA

REPORT No 4

Precision Investment Casting Production.

Feed stock material requirements.

Enclosed herewith please find one copy of drawings for investment castings used on ATAR 9C. See attachment to this report for a complete list of the drawings referred to along with other relevant data.

The enclosed drawings are a spare copy being forwarded for information purposes and in advance of the official drawing office copies that will, or have been supplied, with the relevant engine section drawings.

In some cases it will be noted that a casting (-9) drawing is not supplied. S.N.E.C.M.A. have advised that there is no drawing in these cases.

An effort has been made to evaluate the metal feed stock requirements to produce castings at C.A.C. The exact information of what castings and quantity to be cast is not at this stage clearly resolved, hence the data being supplied will need checking and confirming with Materials Control Section at some later date.

It is suggested that when castings to be produced and quantities are confirmed, then the following ordering action be taken.

For Austenal Process Castings :

<u>Material designation</u>	<u>Quantity</u>	<u>Ordering action</u>
Z 12 C NK DW 20	700 lb	Order from SNECMA
* Z 15 CNS 20	120 lb	" " "
35 CD 4	700 lb	" " "
Z 20 CNW 22	2.2 tons	Order from CAC Store or Australian source.
KC 25 NW.	60 lb.	Order from SNECMA.

* Order as Z 12 CNS 20.

For Shell Process castings :

KC 25 NW	2.5 tons	Order from SNECMA
Z 12 CNKDW 20	1 ton	" " "
35 CD 4	1300 lb	" " "

00000000000000000000



INVESTMENT CASTINGS - AUSTENAL PROCESS. ATAR 9 C.

<u>Casting Part No.</u>	<u>Finished Part No.</u>	<u>Part Name</u>	<u>No. off per engine</u>	<u>C C&K</u>	<u>Material</u>	<u>Est. weight of casting + runner.</u>	<u>No. off to be made at C.A.C.</u>	<u>Remarks</u>
502.506.360.9	502.506.360.0	Biellette	6	CK	Z20CNW22	1 lb.	115	
50I.150.116.9	50I.150.116.0	Verrou	2	C	Z15CNS20)	0.8 lb	17	
					or Z20CNW22)			
50I.150.117.9	50I.150.117.0	Verrou	2	C	" "	0.8 lb	17	
50I.150.118.9	50I.150.118.0	"	4	C	" "	0.8 lb	39	
	50I.286.014.0	Noyeu	1	C	Z20CNW22	2 lb		
50I.204.002.9	50I.204.002.0	Bossage	1	C	25 CD 4	0.5 lb		
50I.704.019.9	50I.704.019.0	Coude	1	C	25 CD 4 or 35 CD 4	4 lb		
50I.702.140.9	50I.702.140.0	Chape	1	C	25 CD 4	1.0 lb		
502.500.464.9	502.500.464.0	Bossage	5	CK	Z20CNW22	3lb	95	
502.506.305.9	502.506.305.0	"	15	CK	Z20CNW22	2 lb	295	
	502.500.391.0	"	5	CK	"	4 lb	95	
502.551.421.9	502.553.305.0	"	1	CK	"	2 lb	15	
50I.551.017.9	502.551.017.0	Oeillet	4	CK	Z15CNS20	0.8 lb	75	
502.705.257.9	502.705.257.0	Embout double	18	CK	Z12CNKDW20	1 lb	350	
	502.705.323.0	Support	36	CK	Z20CNW22	0.8 lb	710	
502.705.145/9	502.705.145.0	Bras de guidage	18	CK	"	1 lb	350	
502.705.146.9	502.705.146.0	" "	18	CK	"	1 lb	350	
	502.551.018.0	Plaque	21	CK	35 CD 4	0.8 lb	410	
502.506.444.9	502.506.444.0	Double arrivée	1	CK	KC 25 NW	2 lb	15	

INVESTMENT CASTINGS - SHELL PROCESS ATAR 9C.

	50I.652.30I.0	Aube redresseur	54	CK	KC 25 NW	3 lb	424	
	502.705.015.0	Support de vérin	8	CK	35 CD 4	4 lb	150	
	502.705.018.0	" "	1	CK	"	4 lb	15	
	502.705.315.0	Double chape	18	CK	Z12CNKDW20	4 lb	350	
	502.705.016.0	Volet commandé	18	CK	KC 25 NW	4 lb	350.	