

28th, December 1961

Reference PFI/SG P 318

ACTION COPY SENT TO ENGINE SUPT

FR 1/2

Mngr.....	Eng. Supt.....
Sec.....	A/P. Mngr.....
Asst. Sec.....	Ch. Eng. A/D.....
Ch. Acct. - 2 JAN 1962	Pers. Supt.....
Supply Sales	
Stores.....	
Ans'd.....	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 St.

MELBOURNE
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CIRCULATION / COPIES / / 6	
E.F. MNGR	FCT. ADM. SUPT.
DSGN. ENGR	MC. SHOP. SUPT.
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SERV. ENGR	ASSM. LY. SUPT.
QUAL. ENGR	FOLNCRY SUPT.
PROD. ENGR	METCAL. SUPT.
MATL. ENGR	PROCESS SUPT.
CH. TL. DSGR	TOOL. PROD. SUPT.
CH. INSP. E.F.	TOOL. ROOM. SUPT.
A/F MANAGER (2)	SUPT. INSPECTION
<i>MR HENRY ✓</i>	

Attention : the MANAGER.

Subject : High temperature - Heat treatment furnace.

Dear Sir,

Receipt is acknowledged of your letter n° 155 and the following is forwarded for your information.

The ram on the RIPOCHE furnace is a single acting ram as shown on the scale drawings supplied earlier. A canvas protection tube approx 18 inches diameter fitted with wire hoops is attached to the hearth end of the ram.

The control method is as shown in the enclosed diagram, however SNECMA suggest using one hydraulic pump with a 50% by pass valve for the slow approach which takes over approx 6" before the door closes. The hearth is lowered by opening a hand valve which the operator starts to close approx two feet before the hearth reaches floor level.

This gives an ideal acceleration and deceleration of the hearth owing to the gradual opening and closing of the valve, which takes at least 5 seconds, however it is subject to error and C.A.C. may consider making this operation automatic.

The following data on speeds & capacities may be useful.

Pump equipment : Motors 220 volts, 3 ph. 50 cy. 6 hP 14.8 amp.
Pumps 125 litres/min.
Piping size 48 mm O.D. X 40 mm I.D.

AA

Oil pressure
to raise hearth : 9 kg/Sq cms (no load).

Operation speeds : 20 seconds down (hand control)
40 " up (automatic)
Last 6" of up travel 1/2 speed.

The hearth is held up by the residual oil pressure and a hand operated safety lock is closed. If the hearth drops slightly, it is necessary to use a switch to over ride the limit switch B, and take the load off the safety lock.

S.N.E.C.M.A. consider the operating speed of the ram rather slow, and would suggest using faster speeds if purchasing new equipment, however the distortion problem should be considered and it would be difficult for C.A.C. to determine the maximum speed that could be used.

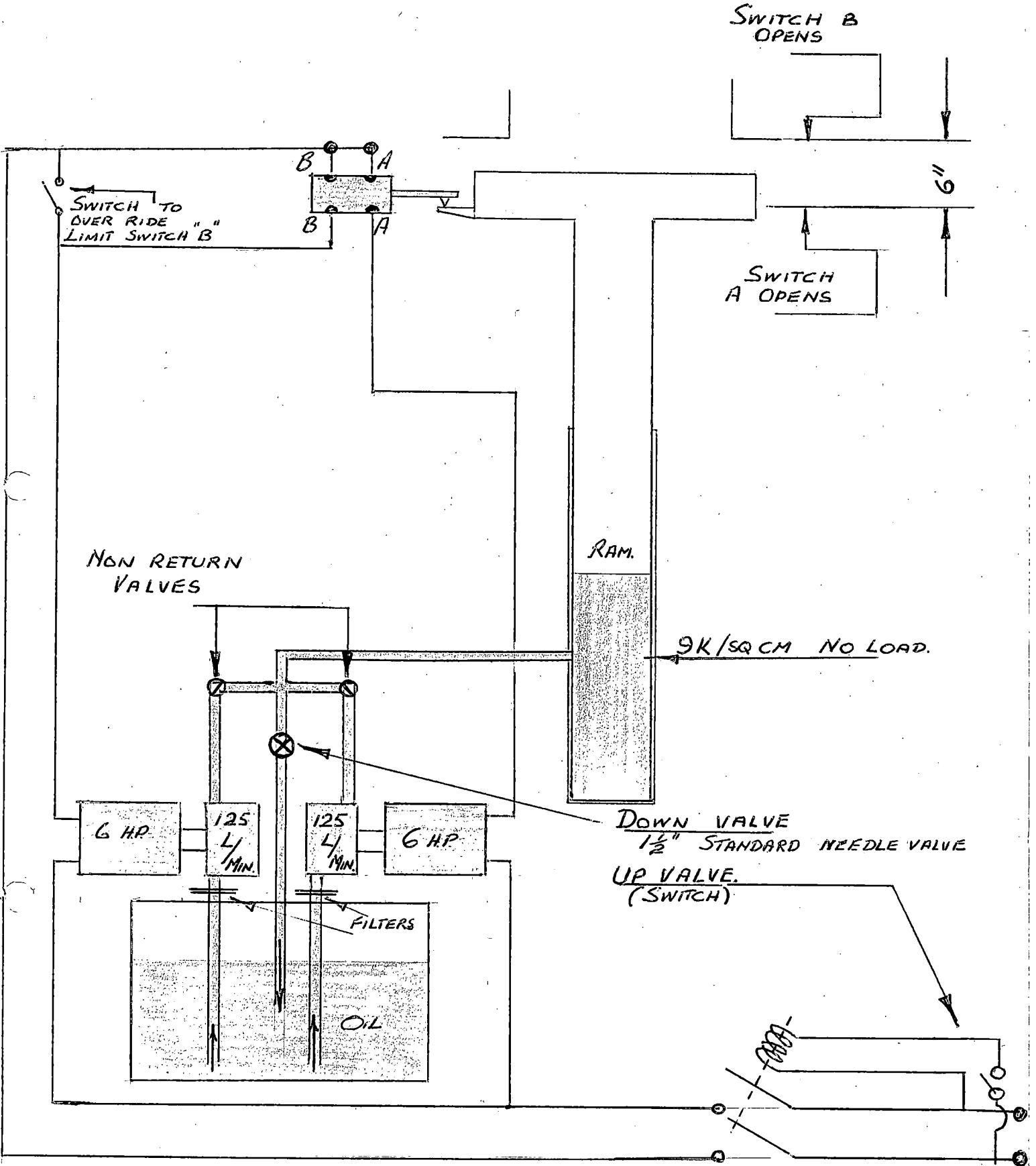
Now that it has been decided to build a furnace similar to the SNECMA furnace, we will obtain some photographs and despatch them to C.A.C, as soon as possible.

Yours faithfully,



G.H. FOSTER

I enclosure.



OPERATING DIAGRAM. ONLY
(ACTUAL CIRCUIT 3 PHASE)