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Files

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F. G. Stroke

RESEARCH & DEVELOPMENT (GEN) 4/11/52

SIZING AND REDUCING URANIUM BY THE "ROCKRITE" PROCESS

SYMBOL: PO:FGS:vj

On January 9, 1952 I took two 6-foot rods, 1-1/16"D, hot rolled at Lackawanna, to the Tube Reducing Company in Wallington, NJ, for the purpose of conducting an experiment in which an attempt would be made to reduce by the "Rockrite Process" the rod to 1" in diameter.

The operation was satisfactory although the amount of reduction taken on the rods was not great enough to iron out some of the heavier laps and seams in the surface.

The machine operated at the lowest speed with a feed of 1/8" per stroke and 80 strokes per minute. A heavy paste 8 lubricant was applied to the rod prior to "rocking"; a soluble oil type coolant was directed onto the bar by a circulating pump. The heavy lubricant was G. Whitfield Richard's #332, a powdered mica in chlorinated paraffine.

The finish gauge on the first sample varied from 1.0035" to 1.0055", on the second, 1.0035" to 1.006". The reduction in cross section area was approximately 11%.

Mr. Engle of the Tube Reducing Company thought that greater reductions could be made and that as a consequence, a better surface finish could be obtained.

It was agreed that larger reductions could be taken, preferably on longer diameter hot rolled stock. I will plan to give them some 1-7/16" diameter hot rolled stock as soon as a "rocking" set-up is available which will give a relatively heavy reduction, 20% - 25%, on this size rod.

OFFICE →	Production				
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