

95-19

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I N T E R O F F I C E M E M O R A N D U M

Date: 04-Oct-1995 08:59am EDT
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TO: See Below

Subject: B61-11 Design/Production Issues
File: OUTBOX 011852

The following B61-11 design and production issues were discussed during a telephone conversation between Don McCoy, SNLA Program Manager, and myself on 10-3-95.

. SNLA/DOE proposes pulling the FPU up nine months. I told McCoy that DU machining operations are expected to restart this week, but that full resumption will about three months to implement. This date would be extremely difficult for Y-12 to support. McCoy suggested that, as a last resort, the cases could be machined by a vendor.

. McCoy expects that structural case requirements will firm up soon, perhaps by 10/13/95. The design will be the more robust of the three under consideration, with a solid nose and with greater wall thickness. McCoy wants to use the B61 ACME thread definition and use the aluminum Threaded Ring from B61 teardowns. If they make this choice they will have to address potential strength, corrosion and galling issues. He said that if a steel ring is chosen, Kansas City would likely get the assignment. I told him we have enough problems with tightly toleranced ACME threads without making mating components in different facilities.

. McCoy was unsure of the justification for the requirement to nickle plate the case IC. I told him that in the case of W61 the justification was corrosion protection and electrical conductivity. The same concerns almost certainly apply to this program. He said that if the powder coat paint requirement is an issue at Y-12, he will consider an epoxy paint.

. At this time McCoy expects to use an existing suspension lug from B61 teardowns. If necessary, a shim will be added to make the lug foot radius compatible with the case diameter.

. McCoy asked about availability of Liners from B61 teardowns to support the new program. I told him I understand that several case/Liner subassemblies are at Pantex awaiting Y-12 release to ship.

. Sandia needs "three or four" case/Liner subassemblies for planned tests. These cases could be a significant part of our learning curve. It is important that we be in position to support the delivery dates.

The next program planning meeting is scheduled at Kansas City on October 20th. I'll keep you apprised of developments.

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