Approved For Release 2005/06/23 : CIA-RDP78B05171A000400030071-2

NPIC/TSG/RED/SDB-048-70
15 October 1970

MEMORANDUM FOR THE RECORD

SUBJECT: Delivery Schedule for Production Units of the [redacted] 1540 Light Table

25X1

1. On 5-8 October 1970 a trip was made to [redacted] 25X1
25X1 in [redacted] to review progress of the production contract for 1540 Light Tables. During this visit a problem was surfaced with respect to delivery of certain parts for the light tables.

25X1 2. On 1 October 1970 [redacted] was informed by a supplier in Oregon of die castings that they would be unable to meet a 7 October delivery date as originally estimated. Three parts, including the center film support bracket, would not be delivered until 21 October; and two other parts, the film drive housing and film drive housing cover, would not be delivered until 28 October. In the delivery schedule, as revised on
25X1 11 September 1970 by [redacted], the first table was to be shipped on 28 October after preacceptance testing on 26-28 October. Obviously, delivery of the film drive housing and cover on 28 October would negate the delivery schedule for the light tables.

25X1 3. On 8 October 1970 [redacted] Executive Vice President of 25X1
25X1 [redacted] visited the supplier in Oregon to investigate the shipping delivery schedule so as to decide on a course of action that would minimize the effects of this latest development. During the evening of 12 October, the undersigned was called by [redacted] Project Manager 25X1
responsible for production of the light tables, and advised that a course of action had been decided upon. [redacted] was resorting to a second source of 25X1
supply to provide a limited number of parts for perhaps ten light tables until the supplier in Oregon could start delivery. This second source would produce sand castings rather than die castings. The supplier is in the Los Angeles area and supplied castings for the Mod II prototype
25X1 developed by [redacted] This approach requires new casting drawings, new machining drawings, modification of the existing Mod II casting patterns, and machining the castings. All of this is expected to delay shipment of the first production 1540 Light Table from 28 October to perhaps 30 or 31 October. Presumably, therefore, preacceptance testing would take place 28-30 October rather than 26-28 October. This estimate of a further slippage of two or three days in delivery of the first table is predicated on the ability of the supplier of the sand castings to meet his predicted
25X1 delivery date. [redacted] states that this supplier has demonstrated his ability to meet deadlines in the past.

Declass Review by NGA/DoD

SECRET

GROUP 1
Excluded from automatic downgrading and declassification

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25X1

4. At present, fabrication of printed circuit boards; wiring harnesses; and sub-assemblies, such as frames and stands, is under way. Quantities of supplies are being received daily. The supplier of the die castings in Oregon appears to be the only major problem.

5. The present revised delivery schedule is as follows:

	Oct.	November				December			
Week beginning	25	1	8	15	22	29	6	13	20	27
Units/week	1	4	10	20	20	20	20	20	15	15
Cumulative total	1	5	15	35	55	75	95	115	130	145
Assuming slippage of 1 week:										
		1	8	16	20	20	20	20	20	20
		1	9	25	45	65	85	105	125	145
Assuming slippage of 2 weeks:										
			1	9	18	21	24	24	24	24
			1	10	28	49	73	97	121	145

25X1 Slipping the delivery schedule by two or three days probably does not present any great problem- [redacted] is planning to start work with two shifts immediately to catch up.

6. However, if the schedule slips by one week, and only the first table is shipped during the week of 1 November, two shifts working a six-day week becomes necessary. Something like eight tables rather than four must be produced the second week, 16 rather than 10 the third week, and 20 units each week must be produced the rest of the year to meet the contractual requirement of 145 tables by 1 January 1971. If the schedule slips by two weeks, and the first unit is shipped during the week of 8 November, substantial increases in the production rate for the tables must be accomplished. Two shifts working a seven-day week, or perhaps even three shifts, may be required.

7. As of this date, the only contractual requirement is that [redacted] will deliver 145 tables by 1 January 1971. Therefore, schedule slippage of any magnitude is not in default of the contract. However, it is the intent that the revised program schedule of 11 September 1970, outlined in paragraph 5, would become an amendment to the present contract. This

25X1

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25X1

has not yet been formally accomplished although [redacted] has indicated that such an amendment would be acceptable. It appears that [redacted] is making every effort to meet their verbal commitment and ship the first table some time during the week of 25 October 1970.

25X1
25X1

[redacted]

25X1

SDB/RED/TSG/NPIC

Distribution:
Original - Route and File
1 - SDB/RED/TSG/NPIC

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MLT 1540

New Schedule

REVISED 3/1-

PROGRAM SCHEDULE

YR: 1970 | 1971

MO: AUG | SEPT | OCT | NOV | DEC | JAN | FEB | MAR | APR | MAY | JUNE | JULY

WK: 2 9 16 23 30 6 13 20 27 4 11 18 25 1 8 15 22 29 6 13 20 27 3 10 17 24 31 7 14 21 28 7 14 21 28 4 11 18 25 2 9 16 23 30 6 13 20 27 4 11 18

600000 - MLT 1540 TOP ASS'Y
- PER WK
- CUM

600101-1 STAND W/MOTOR.
(1) Per TILT & ELEV.
- PER WK.
- CUM

600102 DR. ELEV. ASS'Y
(1) Per
- PER WK.
- CUM

600101-2 STAND W/
(1) Per MANUAL ELEV.
- PER WK
- CUM

600101-3 STAND W/MAN-
(1) Per UAL ELEV. &
MANUAL TILT
- PER WK
- CUM

FMA 910 WPI

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MLT 1540

REVISED 9-11-70

| PROGRAM SCHEDULE | YR | 1970 | | |

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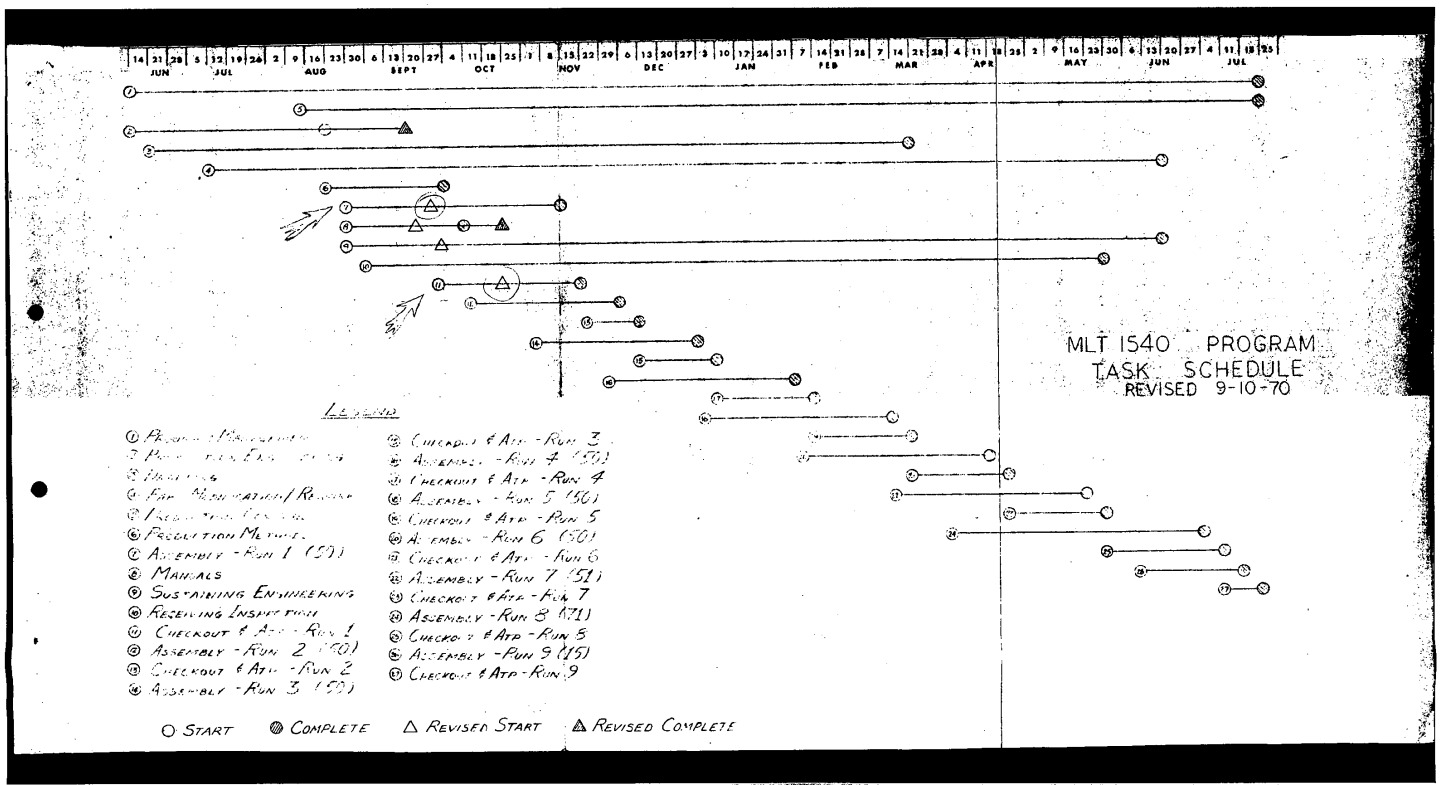

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SUB ASSY.
* 2ND LEVEL SUB ASSY.

DATE 7-20-70

MLT 1540

PROGRAM SCHEDULE

YR: 1970 | 1971
MO: AUG | SEPT | OCT | NOV | DEC | JAN | FEB | MAR | APRIL | MAY | JUNE | JULY
WK: 32 | 36 | 40 | 44 | 48 | 52 | 1 | 5 | 9 | 13 | 17 | 21 | 25

WK: 1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47

TOP ASSY. #600000
(1 PER) SHIP
1 3 6 8 10 12 15 15 15 15 15 15 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 8 1
CUM
1 4 10 18 28 40 55 70 85 100 115 130 140 150 160 170 180 190 200 210 220 230 240 250 260 270 280 290 300 310 318 319

* STAND ASSY. #600101
(1 PER) PER WEEK
5 6 3 6 8 10 12 15 15 15 15 15 15 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10 8 7
CUM
5 11 14 20 28 38 50 65 80 95 110 125 140 150 160 170 180 190 200 210 220 230 240 250 260 270 280 290 300 310 318 325

** DR. ELEV. ASSY. # 600102
(1 PER) PER WEEK
7 7 7 7 7 7 7 7 10 10 10 10 12 12 15 15 15 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10
CUM
7 14 21 28 35 42 49 56 66 76 86 96 108 120 135 150 165 175 185 195 205 215 225 235 245 255 265 275 285 295 305 315

* MOTOR TILT & ELEV #600101-1
(1 PER) PER WEEK
7 7 7 7 7 7 7 7 10 10 10 10 12 12 15 15 15 10 10 10 10 10 10 10 10 10 10 10 10 10 10 10
CUM
7 14 21 28 35 42 49 56 66 76 86 96 108 120 135 150 165 175 185 195 205 215 225 235 245 255 265 275 285 295 305 315

* MANUAL ELEV. #600101-2
(1 PER) PER WEEK
10 10 10 8
CUM
10 20 30 38

* MANUAL & MAN. TILT #600101-3
(1 PER) PER WEEK
1
CUM
1

FORM 910 WPI

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ATTACHMENT 5

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REVISED 9-11-70

MLT 1540

PROGRAM SCHEDULE

| | YR | 1970 | | |

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MLT 1540

REVISED 9-11-70

PROGRAM SCHEDULE	YR / MO / WK	1970 AUG.	SEPT.	OCT	NOV.	DEC.	1971 JAN	FEB	MAR	APR	MAY	JUNE	JULY
600200 BRIDGE ASS'Y													
(1) Per	PER WK			1 4	1 0	1 0	1 0	1 0	1 0	1 0	1 0	1 0	1 0
	CUM			1 5	2 5	3 5	4 5	5 5	6 5	7 5	8 5	9 5	10 5
600202 MICROSCOPE ASS'Y													
(1) Per	PER WK			1 4	1 0	1 0	1 0	1 0	1 0	1 0	1 0	1 0	1 0
	CUM			1 5	2 5	3 5	4 5	5 5	6 5	7 5	8 5	9 5	10 5
600300 LIGHT TABLE ASS'Y													
(1) Per	PER WK			1 4	1 0	1 0	1 0	1 0	1 0	1 0	1 0	1 0	1 0
	CUM			1 5	2 5	3 5	4 5	5 5	6 5	7 5	8 5	9 5	10 5
600240 END ROLLER													
(2) Per	PER WK			2 8	2 0	2 0	2 0	2 0	2 0	2 0	2 0	2 0	2 0
	CUM			2 0	3 0	4 0	5 0	6 0	7 0	8 0	9 0	10 0	11 0
600260 LIFTER ROLLER													
(2) Per	PER WK			2 8	2 0	2 0	2 0	2 0	2 0	2 0	2 0	2 0	2 0
	CUM			2 0	3 0	4 0	5 0	6 0	7 0	8 0	9 0	10 0	11 0
600270 CENTER ROLLER													
(2) Per	PER WK			2 8	2 0	2 0	2 0	2 0	2 0	2 0	2 0	2 0	2 0
	CUM			2 0	3 0	4 0	5 0	6 0	7 0	8 0	9 0	10 0	11 0
600204 FILM REEL ASS'Y													
(4) Per	PER WK			4 8	4 0	4 0	4 0	4 0	4 0	4 0	4 0	4 0	4 0
	CUM			4 0	8 0	12 0	16 0	20 0	24 0	28 0	32 0	36 0	40 0
600250 CNTL. PNL. ASS'Y													
(1) Per	PER WK			1 4	1 0	1 0	1 0	1 0	1 0	1 0	1 0	1 0	1 0
	CUM			1 5	2 5	3 5	4 5	5 5	6 5	7 5	8 5	9 5	10 5

FMA 910 WPI

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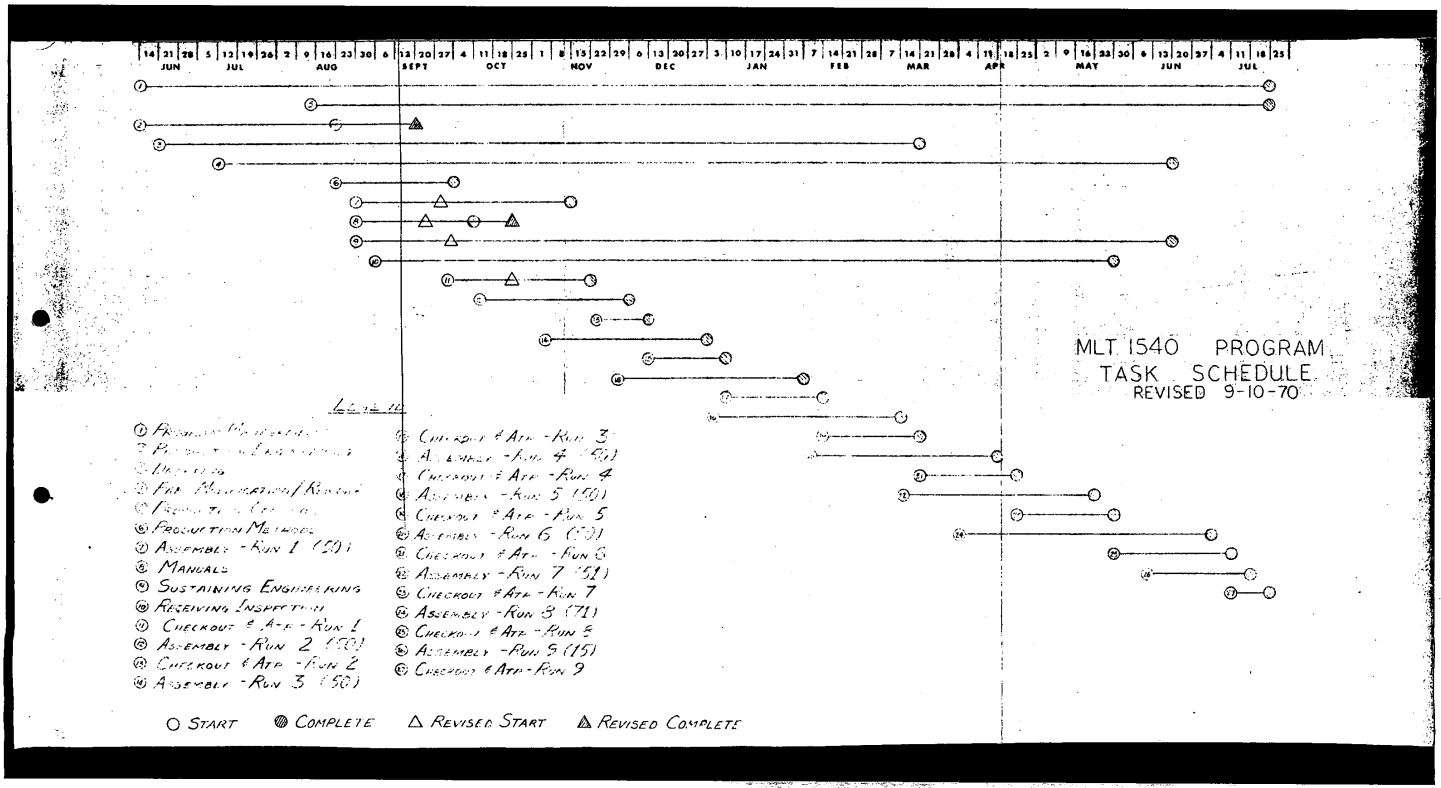

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X1

[redacted] 1540 Chronology

9 Mar 1970	Table delivered in crates
11 Mar	Table assembled at NPIC
12 Mar	T+E started
24 Mar	Y-drive repaired
25 Mar	2nd y-drive repair
27 Mar	3rd y-drive repair
30 Mar	Final y-drive repair
1 Apr	Parallelism of mount & viewing surfaces adjusted by EPB
6 Apr	Memorandum test report states that the y-drive is unsatisfactory
ca. 22 Apr	Film drive failure
wk. 13 Apr	Replaced lamps

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X1

[ ] Payment

Contractual delivery date - 23 February 1970
[23 Feb a holiday, therefore 24 Feb becomes delivery date for table] [ ] 2

Table delivered 9 March 1970:

25 Feb to 27 Feb - 3 working days
2 Mar to 6 Mar - 5
9 Mar, delivery - 1
Delivered 9 working days late
10-11 Mar, assembly - 2
11 working days late
12 Mar, T+E started - 1
12 working days late
24, 25, 27, 30 Mar, y-drive repair (final repair 30 Mar) - 12
24 working days late

Penalties:

9 Mar delivery,
11 Mar assembly,
24 Mar max penalty [ ] 2

Maximum penalty [ ] 2

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