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**INFORMATION REPORT INFORMATION REPORT**

**CENTRAL INTELLIGENCE AGENCY**

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**S-E-C-R-E-T**

50X1-HUM

COUNTRY Poland

REPORT

SUBJECT Krasnik Metal Products Factory  
in Krasnik

DATE DISTR. *SEPT 14 1959*

NO. PAGES 1

REFERENCES RD

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PLACE & DATE ACQ.

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SOURCE EVALUATIONS ARE DEFINITIVE. APPRAISAL OF CONTENT IS TENTATIVE.

[Redacted]

[Redacted] report on the Krasnik Metal Products Factory (KPM) in Krasnik which produces ball and roller bearings. The report contains information on plant equipment and production, as well as certain limited data on other Polish bearings plants.

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1 - City of KRASNIA

The city is located 220 kilometers from WARSAW, and 45 kilometers southwest of LUBLIN, with which it is linked by rail.

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The city, completely new, is an outgrowth of the KFWM (Krasnik Metal Products) Factory and has a population of 12,000 inhabitants. It has all the conveniences of a modern city, such as stores, schools, hospital, hotels, places of amusement, sport fields, etc. One heating plant serves the whole city.

2 - KFWM Factory

The factory is located 2 kilometers from the inhabited sector in an area of 300 hectares, of which it occupies only a small portion.

It has its own thermal electric power plant, which supplies the city as well as the factory.

It consists of 12 or 14 separate buildings, each intended, when outfitted (there is much shifting going on now) to produce a single finished product or to be used as a warehouse, office, etc. Completion is expected by the end of 1961.

The personnel, all residing in the city, total 4,000 persons. The machinery is about 50 percent of Soviet manufacture, and the remainder is mostly East German.

The factory produces ball bearings (80 percent), and roller bearings, predominantly of the conical type.

Production in 1958 was 4,600,000 actual bearings; the 7B conversion factor is estimated at from 0.8 to 0.9.

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Considering that there are about 300 annual working days (other than Sundays there are 12-13 holidays when the factory does not close), about 4 bearings per man-day were produced in 1958.

Engineer Bilsbi, the general manager of the factory, attributes the rather low production, other than to the inexperience of the workers, to disorganized supply, particularly of raw material.

It is expected to increase production to 7,000,000 in 1959 and 11,200,000 in 1965, all ball bearings, of 500 different kinds.

The manufacture of roller bearings will be centered at the new factory in POZNAN, which in 1965 should produce 2,000,000 bearings.

There is another factory in WARSAW which, with a personnel of 640 persons, produces 500,000 bearings annually (2.6 per man-day). These bearings are exclusively intended for the railroads.

A second factory is planned for WARSAW in 1962, and still another later at a place yet to be determined.

The WARSAW Polytechnic Institute has a research center for bearings, which will be assigned to the new factory.

### 3 - Forge

The forge is a new building, roomy, well lighted, and with permanently installed equipment. It has a horizontal-type forging machines with clearance ranging up to 4 inches, of German make, and two machines, one of 5 inches and the other of 7.5 inches (similar to the Ajax), of Soviet make. The last two have given much trouble, particularly because of the lubrication system.

It has several burnishing machines of Soviet and domestic make. Forgings are usually well done. There is constant difficulty in keeping production regular on account of irregularities in the supply of raw material.

### 4 - Lathe Shop

In premises partially occupied by machines for other types of production. **Gang** of about 40 four-spindle automatic lathes manufactured

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by the WMW of LEIPZIG, mostly new, for processing bars; and about 10 old  
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Pittler lathes similar to the WMW models.

They produce semifinished parts, the inner pieces requiring facing and sizing, and the outer pieces requiring facing, sizing, and grooving.

Forgings are machined (rough-turned) on lathes of Soviet make developed from the Fay model of Jones & Lamson, and turret lathes similar to the Warner & Swasey. Finishing operations are performed on various lathes, several engine, turret, and semiautomatic.

#### 5 - Grinding

Work is distributed over several places at this time.

Equipment consists of several grinding machines for facing (Diskus, Giustina, and Soviet machines of the Blanchard Duplex type), and two new Rowland machines with dual grinding wheels (one not yet in operation). The last are equipped with pneumatic self-regulating devices.

Several centerless grinding machines, the majority of Soviet make, including [model?] No. 4. Gang of oscillating grinding machines of Soviet make, similar to the old Van Normans, for grooving the outer and inner rings.

Checking and grading arrangements are primitive, and the mounting of rollers in the cage is done by hand. There is no noise control.

Grinding of the roller race of the outer rings is done on two 7002 RF machines, and on Soviet machines developed from the Heald 281.

Grinding of the roller race of the inner ring is done on simple grinding machines similar to the [model] 10002 RGIF.

Lands on the inner rings are formed with a semiautomatic machine of Soviet make equipped with a single grinding wheel.

Lands on the outer rings are formed with a WMW machine.

The six lapping machines for the roller race of inner rings are of Soviet manufacture. The work is mounted on a mandrel on a horizontal

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axis, and the table is mounted on a slide rail placed on a horizontal upper beam. The machines are defective, and only one of them was working.

#### 6 - Tapered rollers

Two-stroke stamping presses of Soviet make, not very fast machines but solid in appearance. They are equipped with clutches.

Grinding of diameter is done on a centerless machine of Soviet make, smaller than [model?] No. 2 and with a cantilevered steel cylinder. The grinding device of the cylinder is installed on each machine.

#### 7 - Cages

There are several simple presses operating with dies of elementary operation.

The work at this time is being done in the shop where the balls are produced.

#### 8 - General Services

A visit to the compressor room showed it is clean and well installed. All compressors are Hungarian Mavag models, with vertical cylinder. On the outside is a tower for cooling the water which circulates through the compressors.

#### 9 - Inspection

It is rather skimpy, and performed with elementary devices of the factory's making.

The visual inspection of the rollers is done by a few workers seated around a bench without any special equipment or illumination.

A similar arrangement was seen for the inspection of the unassembled rings and assembled bearings.

#### 10 - Assembly

Balls and rollers are mounted by hand without any special equipment.

Cleansing is done in small baskets immersed in basins of kerosene and agitated by hand.

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11 - Testing room

All the recently acquired machinery is installed in a special place, where it is being tested and the personnel <sup>who</sup> will operate it are being trained.

In a section of the same shop devoted to the manufacture of various kinds of bearings, there were observed several Soviet centerless and Messerschmidt grinders.

12 - Toolroom and maintenance

Installed in roomy premises, separate from each other.

The arrangement is good, and the equipment is fairly good also.

The machinery is of domestic make, or manufactured in Eastern countries, particularly the USSR.

The toolroom has a space enclosed by glass, and two model SIP-Genevoise punching machines. Several machines were being overhauled including 4-spindle Pittler lathes.

In the toolroom were observed youngsters of about 10 years of age, students of the 1st trade course, who practice for a few hours every day.

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