

INFORMATION REPORT

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SUBJECT Gorki Milling Machine Works No. 113

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1. The Gorki Milling Machine Works No. 113 (Gorkovski Zavod Frezernykh Stankov or GZFS) at Gorki is located on the left bank of the Oka River, in the southwestern part of the town about half a kilometer from the river. The number 113 was used during the war but now is generally omitted.
2. The works comes under the Chief Directorate of Machine Tool Industry of the Ministry of Machine Tool Construction of the USSR.
3. The plans for the Gorki Milling Machine Works were completed in 1931 and construction was begun in 1932. In 1934, the first part of the works was completed, was equipped with machine tools (mostly of foreign make), and began production. In the same year, the works turned out the first experimental slab-milling machines (prodolno-frezerny stanok). In 1938, the second part of the works was completed and went into full production. Construction took place during the war, when four buildings were erected, and is still continuing. The works, including two buildings which have not yet been completed, occupies an area of about 105,000 square meters.
4. The approximate number of personnel is 6,000, employed in three shifts of eight hours each.

Type of Product

5. Before the war, the works manufactured the following types of milling machines:
 - a. Slab-milling machines (prodolno-frezerny stanok) types 6G55, 6G65, etc.
 - b. Console-milling machines (konsolno-frezerny stanok) types 6283, 682 (3.8 KW), 683 (7.8 KW), 612 (3.8 KW), 6B12 (4.3 KW), 6B82 (4.3 KW), and 615 (7.8 KW).

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c. Specialized machine tools of the following types: 6S101, 6S96g, 6S96d, 6s125, 6S145, 6S119, 6S131, etc.

d. Heavy machines type 616P, etc.

In 1940, the output exceeded 4,400 machines.

6. On the outbreak of war, about 65% of the productive capacity of the works was converted to war production and the remaining 35% continued to be devoted to the production of machine tools. The works turned out a large number of parts for the tank industry (mainly for Tank Works No. 112 at Gorki), for the (then) People's Commissariat of Armaments, and for the (then) People's Commissariat of Munitions.
7. After the war, the works reverted to peacetime production. It is now producing milling machines and, in addition, consumer goods; and at irregular intervals executes orders for factories of the war industry. Some types of milling machines are turned out in large-scale series, some in small series, some in small numbers, and some in individual units. Large-scale series include the milling machines which were turned out in 1940 and subsequently modernized.
8. The following alterations to milling machines have taken place:
- a. Console milling machine 682 has been renumbered 6820. Belt transmission has been reinforced or replaced, power increased from 3.8 to 5.8 KW, rpm increased to about 1,500, rigidity of console increased, and other simple changes made. This machine can now operate at high speeds using tools with hard alloy blades (plastinki).
 - b. Console milling machines types 683 and 615 have had their power increased from 7.8 to 12 KW.
 - c. Slab-milling machines, types 6G55 and 6G65, etc., have had their power increased to 13 KW.

On the whole, alterations to machinery are directed toward high-speed milling.

9. The works produces all sizes of slab-milling machinery from 300 x 1,250 mm to 900 x 3,000 mm. The following machines and several other types have been produced since the war:
- a. Three-spindle (trëkhshpindelny) slab-milling machine model 6643.
 - b. Aggregate two-spindle (agregatny dvukhshpindelny) slab-milling machine model A 666.
 - c. High-speed (skorostnoi) milling machine type 6 A 54 for machining steel and cast iron articles; 37 KW, cutting speed up to 1,000 meters per minute.
 - d. Copying (kopirovalny) slab-milling machine PKF-12.
 - e. Two-spindle vertical rotary boring and turning machine (dvukhshpindelny karuselny frezerny stanok) model 623 for continuous face milling of surfaces of articles in the process of mass production.
 - f. Consoleless thread-milling machine (bezkonsolny rezbofrezerny stanok).
 - g. Specialized machine: a nine-spindle slab-milling machine for turning off lathe standards. These machines were sent to the Moscow Krasny Proletarii Works and other factories.
 - h. Wheel lathe (kolesno-tokarny stanok) type 1937, height of centers 700 mm, distance between centers 2,800 mm, 22 KW, weight 29 tons.
 - i. Wheel lathe (kolesno-tokarny stanok) type 1939, height of centers 950 mm, distance between centers 2,300 mm, 29 KW, weight 41 tons.

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CONFIDENTIALActual Production

10. In 1948, the works produced about 5,600 machines of various types. Of these, about 4,400 were produced in large-scale series in the 1st Assembling Shop and about 950 were produced in medium and small-scale series in the 2nd Assembling Shop. About 150 machines were of heavy type, produced in the Heavy Machine Tool Shop; and about 120 machines were of the experimental type, produced in the Experimental Construction Shop. During 1947 and 1948 the works did not fulfill the annual plan. It is considered backward among the enterprises of the Ministry of Machine Tool Construction.

Shops

11. The following shops exist at the works:

- a. 1st Assembling Shop (Pervy Sborochny Tsakh)
- b. 2nd Assembling Shop (Vtoroi Sborochny Tsakh)
- c. Experimental Construction Shop (Tsakh Opytnykh Konstruktsei)
- d. Heavy Machine Tool Shop (Tsakh Tyazhelykh Stankov)
- e. 1st Engineering Shop (Pervy Mekhanicheski Tsakh)
- f. 2nd Engineering Shop (Vtoroi Mekhanicheski Tsakh)
- g. 3rd Engineering Shop (Treti Mekhanicheski Tsakh)
- h. 4th Engineering Shop (Chetverty Mekhanicheski Tsakh)
- i. Tool Shop (Instrumentalny Tsakh)
- j. Forge Shop (Kuznechny Tsakh)
- k. Repair Shop (Remontny Tsakh)
- l. Electrical Shop (Elektrotsakh)
- m. Thermic Shop (Termicheski Tsakh)
- n. New Foundry Shop (Novy Liteiny Tsakh)
- o. Old Foundry Shop (Stary Liteiny Tsakh)
- p. Preparing Shop (Zagotovitelny Tsakh)
- q. Transport Shop (Transportny Tsakh)

12. In addition, the works has several sections which are usual in the case of large works, such as:

- a. Sales Section (Otdel Sbyt)
- b. Supply Section (Otdel Snabzheniya)
- c. Personnel Section (Otdel Kadrov)
- d. Technical Section (Tekhnicheski Otdel)
- e. Chief Mechanic's Section (Glavnogo Mekhanika Otdel)

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13. The percentage of rejected parts in the works is high, especially in engineering shops Nos. 1 and 4. Among articles returned from the assembling shops to the engineering shops are brackets and machine joints. Some parts have to be discarded completely, as they cannot be altered. There is a shortage of tools at the works, including drills, screw taps, files, milling cutters, and gauges.
14. Electricity is obtained from the area electric power station.
15. The works has wide-gauge branch lines which lead to the main industrial buildings.

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