

VICTOR MFG. CO.

GASSET CO.

OBsolete

FACTORY STANDARD #311

October 21, 1963

J. A. ULRICH

DATE: 10/21/63
1060" MULTICORE VICTOCOR

DEPT. 251

MATLS. DEPT.

This Standard covers the manufacture of a high density - .055"/
1060" five layer construction Victocor having two core and three facing
materials.

MATERIALS:

1. 65# Tin Plate (.007") P. S. #450-3
2. Asbestopac #958 - P. S. #506 - 43-48#
Basis Weight (.016")
3. Asbestopac #958 - P. S. #506 - 63-70#
Basis Weight (.022")
4. Formula #458-2
5. Formula #458-BT
6. Formula #597 (If specified on Analysis
Card)

PROCEDURE

Perforating and
Cutting of Core:

Dept. 05

Material #1, slit to the required width, 186 per-
forated .030"/.035" and cut to the desired length
on Machine #2909 (Minster Press). The variation
within one sheet of core should not be more than
.003" with no broken punches present.

Inspection of this core should be made 4 to 5
times a shift to insure that the above tolerances
are maintained.

Degreasing of
Core:

Dept. 06

Cut strips of perforated core are degreased in
Dept. 06 using Machine #3148. The core is placed
in the baskets provided and allowed to remain 5
minutes in the two compartments and the vapor of
this machine.

Cementing and
Drying the Core:

Dept. 19

The strips of degreased core are coated with Ma-
terial #4 using the Union Tool or Francis two roll
coating unit. The use of either machine should re-
sult in a uniform coating being applied to the core.
The coated sheets are racked into the Victocor dry-
ing oven (Machine #1354) for drying at 160-170°F.

I, John R. Derpack Notary Public in and for County of Cook

and State of Illinois do hereby certify that P. T. Assen coated and dried sheets emerge from the oven,

James H. Larsen

they should be assembled into the following five
layer construction: Material #2 - Cemented Core -
Material #3 - Cemented Core - Material #2.

acknowledged this page of laboratory records on October 21, 1963

J. R. Derpack
NOTARY PUBLIC

VPD-101-0001312

DANA-065

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FACTORY STANDARD #311

October 21, 1963

Combining:
Dept. 19

The assembled sheets of five layers are combined on Machine #2913, using induction heating with an output of 50%, to a final gauge of .060"/.065" with an aim gauge of .062".

Recalendering:
Dept. 10

The combined sheets are recalendered to .055"/.060" on the three roll rubber calender (Machine #1433).

Blanking:

As per Analysis Card

Coating:
Dept. 17

The blanked gaskets are roller coated with Material #6 using the Francis two roll coater and dried in the #5 or #6 Precote Oven.

Inspection:

The final gauge after coating of the gaskets should be .055"/.060". The gaskets should be inspected for Analysis Card requirements.

Materials Development Laboratory

Compiled by:

J. Larsen

Approved by:

V. Labrecque

Copies to:

I, John R. Derpack B. R. Basile R. S. McGranahan
Notary Public in and for County of Cook
J. R. Derpack E. Novak
and State of Illinois do hereby certify that Paul P. Turcsany and Robbins
James H. Larsen M. F. Hill A. R. Smith
C. H. King Eng'g Service
S. M. Lillis Industrial Engr.
acknowledged this page of laboratory records on October 21, 1963

Inspection Dept.
Material Control
Quality Control
Dept. 01
Dept. 05
Dept. 06
Dept. 17
Dept. 19

J. R. Derpack
NOTARY PUBLIC

VPD-101-0001313

VICTOR MFG. & GASKET CO.

FACTORY STANDARD #311

October 21, 1963

.055"/.060" MULTICOR VICTOCOR

This Standard covers the manufacture of a high density - .055"/.060" five layer construction Victocor having two core and three facing materials.

MATERIALS:

1. 65# Tin Plate (.007") P. S. #450-3
2. Asbestopac #958 - P. S. #506 - 43-48#
Basis Weight (.016")
3. Asbestopac #958 - P. S. #506 - 63-70#
Basis Weight (.022")
4. Formula #458-B
5. Formula #458-BT
6. Formula #597 (If specified on Analysis Card)

PROCEDURE

Perforating and
Cutting of Core:

Dept. 05

Material #1, slit to the required width, is perforated .030"/.035" and cut to the desired length on Machine #2909 (Minster Press). The variation within one sheet of core should not be more than .003" with no broken punches present.

Inspection of this core should be made 4 to 5 times a shift to insure that the above tolerances are maintained.

Degreasing of
Core:

Dept. 06

Cut strips of perforated core are degreased in Dept. 06 using Machine #3148. The core is placed in the baskets provided and allowed to remain 5 minutes in the two compartments and the vapor of this machine.

Cementing and
Drying the Core:

Dept. 19

The strips of degreased core are coated with Material #4 using the Union Tool or Francis two roll coating unit. The use of either machine should result in a uniform coating being applied to the core. The coated sheets are racked into the Victocor drying oven (Machine #1354) for drying at 160-170°F.

As the coated and dried sheets emerge from the oven, they should be assembled into the following five layer construction: Material #2 - Cemented Core - Material #3 - Cemented Core - Material #2.

VPD-101-0001314

October 21, 1963

Combining:

Dept. 19

The assembled sheets of five layers are combined on Machine #2913, using induction heating with an output of 50%, to a final gauge of .060"/.065" with an aim gauge of .062".

Recalendering:

Dept. 01

The combined sheets are recalendered to .055"/.060" on the three roll rubber calender (Machine #1433).

Blanking:

As per Analysis Card.

Coating:

Dept. 17

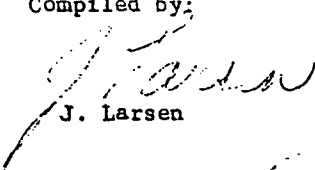
The blanked gaskets are roller coated with Material #6 using the Francis two roll coater and dried in the #5 or #6 Precote Oven.

Inspection:

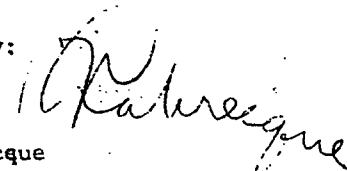
The final gauge after coating of the gaskets should be .055"/.060". The gaskets should be inspected for Analysis Card requirements.

Materials Development Laboratory

Compiled by:


J. Larsen

Approved by:


V. Labrecque

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Engr. Service
Industrial Engr.

Inspection Dept.
Material Control
Quality Control
Dept. 01
Dept. 05
Dept. 06
Dept. 17
Dept. 19

VPD-10F-0001315

October 21, 1963

.055"/.060" MULTICOR VICTOCOR

This Standard covers the manufacture of a high density - .055"/.060" five layer construction Victocor having two core and three facing materials.

MATERIALS:

1. 65# Tin Plate (.007") P. S. #450-3
2. Asbestopac #958 - P. S. #506 - 43-48#
Basis Weight (.016")
3. Asbestopac #958 - P. S. #506 - 63-70#
Basis Weight (.022")
4. Formula #458-B
5. Formula #458-BT
6. Formula #597 (If specified on Analysis Card)

PROCEDURE**Perforating and
Cutting of Core:**

Dept. 05

Material #1, slit to the required width, is perforated .030"/.035" and cut to the desired length on Machine #2909 (Minster Press). The variation within one sheet of core should not be more than .003" with no broken punches present.

Inspection of this core should be made 4 to 5 times a shift to insure that the above tolerances are maintained.

**Degreasing of
Core:**

Dept. 06

Cut strips of perforated core are degreased in Dept. 06 using Machine #3148. The core is placed in the baskets provided and allowed to remain 5 minutes in the two compartments and the vapor of this machine.

**Cementing and
Drying the Core:**

Dept. 19

The strips of degreased core are coated with Material #4 using the Union Tool or Francis two roll coating unit. The use of either machine should result in a uniform coating being applied to the core. The coated sheets are racked into the Victocor drying oven (Machine #1354) for drying at 160-170°F.

As the coated and dried sheets emerge from the oven, they should be assembled into the following five layer construction: Material #2 - Cemented Core - Material #3 - Cemented Core - Material #2.

VPD-101-0001316

October 21, 1963

Combining:
Dept. 19

The assembled sheets of five layers are combined on Machine #2913, using induction heating with an output of 50%, to a final gauge of .060"/.065" with an aim gauge of .062".

Recalendering:
Dept. 01

The combined sheets are recalendered to .055"/.060" on the three roll rubber calender (Machine #1433).

Blanking:

As per Analysis Card.

Coating:
Dept. 17

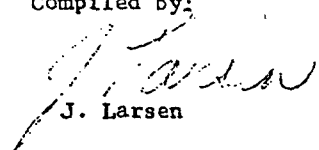
The blanked gaskets are roller coated with Material #6 using the Francis two roll coater and dried in the #5 or #6 Precote Oven.

Inspection:

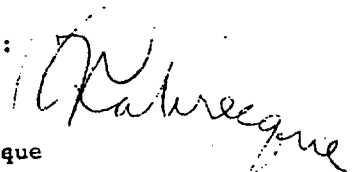
The final gauge after coating of the gaskets should be .055"/.060". The gaskets should be inspected for Analysis Card requirements.

Materials Development Laboratory

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J. Larsen

Approved by:


V. Labrecque

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		Dept. 19

VPD-101-0001317