MANUFACTURING SPECIFICATIONS

Transite Pipe DEPT.

Waukegan PLANT

PRODUCT: Transite Pipe Fibre Blends and Standard Furnish Batch

DIVISION IP

TP-1

PAGE NO 3

CANCELLED 4-25 3/2/54

I. Formula 13' Machine

A. Fibre Blend

	-1, -2, or -3 Basis			
	M-442		M-440	
	Pound	%	Pound	%
Blue - "A" or "S"	200	20	313	31
Vimy R4T	125	12	125	12
BC4T	125	12	125	12
4Z	350	31	250	25
4X	120	11	200	20
6D	150	14	-	-
	1070	100	1013	100

FEB 5 1954 G. B. BROWN

*

	M-459 (-1, -2, or -3 Basis)	
	Pound	%
Blue "A" or "S"	188	19
Vimy R4T	125	12
BC4T	125	12
4Z	250	25
4X	200	20
C & G3	62-1/2	6
4	62 -1/2	6
	1013	100

PLAINTIFF'S EXHIBIT CSR-578

Note: Add 125# Reprocessed per batch -1 blend, 250# per batch -2 blend, 375# per batch -3 blend.

Fibre and scrap shall be thoroughly mixed in the mixer, willow fibre blend at a rate which will insure a proper buoyancy. Batch si may be varied provided batch proportions are maintained.

XX *C & G are to be substituted up to 10% for blue fibre in M-440 when availabl Use ratio of one part C & G3 to one part C & G4. If intermediate steps are utilized, up to 10%, use the same blend number, but DHQ is to be advised.

RETURN TO J-M RESEARCH FILE ROOM

X— INDICATES CHANGE — REASON: X Delete blends M-423, M-455 and add blends M-442, M-440 & M-45[illegible]
XX Information on C & G fibre in blend M-459

AUTHORITY FOR CHANGE: P. D. Cannon's letter 12-22-53, VanDerbeek's wire 1-[illegible]

FILE HOLDERS: Mvl. SUPR. QUAL. CONTROL | PROD. SUPT. | PLANT FINANCE OFFICE | MGR. QUAL. CONTROL

SUPERSEDES: Page 3 same spec. issued 10-30-53; Notice of Deviation No. 602 issued [illegible]

DATE ISSU[illegible]

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