Bulletin 226

PLAINTIFF'S EXHIBIT

MAR-380

RE-2397 REV. 1/65

MAREMONT PRODUCT ENGINEERING DEPARTMENT ENGINEERING BULLETIN	Bulletin No. 226
	Supplement No.
Product: Mechanical Remanufactured Products	Date 10/5/65
Subject: Shot or Grit Blasting	Page 1 of 1
	Superseding No.
Reference:	Revised 9/20/65 adding G-50

General - The most popular means of cleaning cores for mechanical remanufactured products is shot blasting. This is accomplished by tumbling cores while blasting.

Shot and Grit - Steel shot S-230 or cast grit G-50 conforming to S.A.E. specifications J-444 will be used. See chart below for recommendations as to individual product lines. Variations in size and capacity of blasting machine will necessitate adherence to Manufacturer's recommendations on cycle time and number of pieces per load.

Product	Shot or Grit to be Used
Brake Shoes	S-230 or G-50
Water Pumps	S-230 or G-50
Fuel Pumps	G-50
Clutch Plates	G-50
Pressure Plates	S-230 or G-50
Power Brakes	G-50

Inspection - Be careful to insure that the grit does not become contaminated and leave deposits which may affect further processing of cores. Remove dust by wiping or blowing off. A clean, smudge and dust free surface is especially a necessity in brake shoes, where adhesive bonding is done.

Suppliers - Approved source of supply for S-230 and G-50 is Metal Ores and Fines Corporation; alternate sources are American Wheelabrator Company and Western Industrial. G-50 grit may also be procured from Cleveland Metals. Certification should be requested periodically from the suppliers to insure compliance with S.A.E. specifications on chemical analysis, size, quality and cleanliness.

Distribution:	Issued By:	Approved By:
Reman Products	R. J. Rutka	J. D. Kody

RE-2397 REV. 1/65

MAREMONT PRODUCT ENGINEERING DEPARTMENT ENGINEERING BULLETIN	Bulletin No. 226
	Supplement No.
Product: Unlined Brake Shoes	Date September 20, 1964
Subject: Shot or Grit Blast Cleaning	Page 1 of 1
	Superseding No.
Reference:	Revised and retyped 9-20-65

General - The most popular method of cleaning shoes is in a shot blasting machine that tumbles the shoes while blasting.

Shot - Steel shot S-230, or cast grit G-50 conforming to SAE specification J444 should be used. Due to variations in size and capacity of the blasting machine, the Manufacturer's recommendations on cycle time and number of shoes per load should be adhered to.

Inspection - It is very important to check that the grit does not become contaminated or dirty as these deposits stay with the shoes and affect bonding This is the reason why it is necessary to degrease or burn oily shoes. Any evidence of smudge or dust on blasted shoes is unacceptable. Dust can be wiped off or blown off. Smudge requires burn-off or degreasing.

Suppliers - The approved supplier for the S-230 and G-50 is Metal Ores and Fines Corporation. The alternate source is American Wheelabrator Co. and Western Industrial. For the G-50 grit the approved source is also Cleveland Metals. Certification should be requested periodically from the suppliers to insure conformance to specification on chemical analysis, size, quality and cleanliness.

Distribution: Reman Products	Issued By: J.D Kody	Approved By:

RS-2297

MAREMONT REMANUFACTURING DIVISION
ENGINEERING BULLETIN

Bulletin No.	226
Supplement No.	
Date	September 29, 1964
Page	1 of 1
Superseding No.	
	~~(1) REVISED 9-20-65~~
	~~Revised 6-50~~

Product: Unlined Brake Shoes

Subject: Shot or Grit Blast Cleaning

Reference:

REVISED AND RETYPED 9-20-65

General - The most popular method of cleaning shoes is in a shot blasting machine that tumbles the shoes while blasting.

Shot - Steel shot S-230 OR cast grit G-50 conforming ~~produced~~ to SAE specification J444 should be used. Due to variations in size and capacity of the blasting machine, the Manufacturer's recommendations on cycle time and number of shoes per load should be adhered to.

Inspection - It is very important to check that the grit does not become contaiminated or dirty as these deposits stay with the shoes and affect bonding. This is the reason why it is necessary to degrease or burn oily shoes. Any evidence of smudge or dust on blasted shoes is unacceptable. Dust can be wiped off or blown off. Smudge requires burn-off or degreasing.

Suppliers - The approved supplier for the S-230 and G-50 is Metal Ores and Fines Corporation. The alternate source is American Wheelabrator Co. AND WESTER INDUSTRIAL. For the G-50 grit the approved source is also Cleveland Metals. Certification should be requested periodically from the suppliers to insure conformance to specification on chemical analysis, size, quality and cleanliness.

Distribution: Reman Products ~~Standard~~	Issued By: J.D. Kody	Approved By: J D Kody