MANUFACTURING SPECIFICATIONS

Waukegan PLANT

Millboard DEPT.

PRODUCT: #63 Acid Resisting Sheet Packing

DIVISION IID

SPEC PC-[illegible]

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FORMULA:

		Wet Basis*** Wt.	Wet Basis*** %	Dry Basis Wt.	Dry Basis %
P.S. II-1983	Blue Asbestos Fibre*	600	46.5	600	58.0
P.S. 62301	Dispersed Butyl Rubber	438	34.0	258	25.0
P.S. 63269	C-370 Dispersion	150	11.7	75	7.3
P.S. BP-3208	Alum (Papermakers)**	100	7.8	100	9.7
		1288	100.0	1033	100.0

FORMULA NOTES:

* The approved vendor of Blended Blue fibre is Asbestos Corp. of America. Every shipment must be tested to the Purchase Specification before being used.

** Alum weight may be increased when necessary to facilitate machine operation.

*** Due to varying weights of Dispersed Butyl Rubber per container, the following table indicates the required amounts of other materials necessary to adjust the batch weights.

Blue Fibre	Dispersed Butyl Rubber	C-370	Alum
640 lbs.	468	150	100
620 "	453	150	100
600 "	438	150	100

MANUFACTURING INSTRUCTIONS

1. Add the blue fibre to the beater which is about half full of white or service water at approximately 70° F. and circulate for about 15 minutes.
2. Lower the beater roll to grind the fibre for a minimum of 30 minutes.
3. Raise beater roll and continue to circulate while adding live steam to bring beater temperature to 100° F. This takes about 15 minutes.
4. Stir the C-370 dispersion thoroughly in its container and add to the beater through a No. 12 mesh screen in order to remove any lumps.
5. Continue circulating stock while adding the thoroughly stirred Butyl Rubber through the No. 12 mesh screen.
6. Add the dissolved alum to beater. The alum is prepared in the starch kettle which has been half filled with service water. Add the alum and agitate with live steam until the temperature reaches 160° F.

X — INDICATES CHANGE — REASON: New specification

AUTHORITY FOR CHANGE: E. C. Lindstrom

FILE-HOLDERS: E.S. Bogart, Lab.

SUPERSEDES: None

DATE IS 1-13-

PLAINTIFF'S EXHIBIT WV-04558

REC'D JAN 29 1958

PLAINTIFF'S EXHIBIT 10845.0

FILE ROOM