

MINUTES

CALSILITE RESEARCH COMMITTEE MEETING

JULY 25, 1950

On July 25th in Mr. Eckert's office at Bound Brook a meeting of the above committee was held. The following were present:

Messrs. Abraham, Cowan, Eckert, Gordon, High, Maxwell

Item 1. Report of Calsilite Plant Operations - June 1950

There was a brief discussion of the above June report including the following:

- a. Mr. Abraham questioned the apparent discrepancy between the gross profit figures indicated on the above report prepared at Gloucester and the P. & L. statement. Mr. High answered that the "net sales value" figures used at Gloucester were necessarily estimated whereas the figures on the P. & L. statement were actual. Variations in freight cost to various sales' destinations caused the actual figures to vary from the estimated figures. The Gloucester actual cost figures on the above report were agreed by all present to be accurate.
- b. Even though the gross profit figure of approximately \$2300 is modest, Mr. Abraham expressed his pleasure that June operations were in the black. The fact that the higher proportion of block to pipe covering in June as compared to recent previous months was a major factor in the "black" figure situation was pointed out by Mr. Cowan. The writer also pointed out that the relative proportion of block to pipe covering in June was actually very close to the proportions indicated on the Gloucester Calsilite Cost Survey.

Item 2. Precision Molding

Because of the following the writer reported there had been some delay in the placing of the purchase order for precision mold equipment for all sizes applicable to #1 Miller:

- a. In view of the uncertainty as to steel supply the Purchasing Dept. were only able to get three bids with the greatest of difficulty.
- b. Before a vendor could make an intelligent bid for this job it was necessary that he design and estimate the cost of the dies for pressing out our precision mold shapes. All in all each vendor who quoted had a great deal of detail work to do before he could be in a position to quote.

In spite of the above difficulties the writer reported that the order for the molds had been placed on July 12th with the initial delivery

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expected in three weeks, with the understanding that delivery of all of the above-mentioned precision molds should be completed by late September. In connection with the above, the work on the re-building of #1 Miller to handle precision mold sizes has been underway for sometime and all in all the program outlined in my letter of May 26th is being substantially followed.

Item 3. #2 Miller

The writer reported that the design work on the conversion of #2 Miller to handle precision molded products was very nearly complete. In order to improve the efficiency of the milling operation as indicated in previous reports, #2 Miller has been re-designed to also take the upper range of sizes presently applicable to #1 Miller only down to and including 3 x 1.

Item 4. Segmental Block Miller

With the present equipment the writer pointed out that production rates in connection with milling of segmental block were entirely too low to handle this product on a practical basis in any appreciable volume. In this connection it was suggested that a separate milling cutter designed to handle a number of sections at a time be considered. Mr. Abraham suggested that we re-examine our notes with reference to the equipment which J-M utilizes for this purpose. Mr. High indicated that increases in the sales' volume of segmental products is probable.

Item 5. Formula Research

Mr. Abraham asked for information as to what had been done in connection with the proposals to increase the proportion of fibre in the Calsilite formula. Mr. Eckert replied that asbestos fibre content had been increased on special orders of blocks for certain railroad use only. In connection with the furnishing of Calsilite material to the railroads, Mr. High reported that we had lost ground with the sale of our product to the New York Central Railroad. In his opinion this loss was because of "internal railroad politics" rather than any quality difficulty. With the exception of the above Mr. Eckert indicated that no change in the formula had been made.

Item 6. Cartons

Mr. High gave a brief resume of the development of the carton situation including the following:

- a. That 200# test H. & D. cartons had been satisfactory.
- b. That 200# test Weber and similar cartons had been found highly unsatisfactory.
- c. That satisfactory results had been obtained since we had used 275# test cartons.
- d. That arrangements had been made to test out cartons from the Union Bag Company.

Item 7. Milling Complaints

Mr. High mentioned that we had had no recent complaints from the standpoint of milling. The writer called attention to the fact that some months ago we had obtained spare milling cutters which enabled our operators to properly maintain this item of equipment. This is the major factor counting for the reduction in milling complaints.

Item 8. Pipe Covering in Copper Tubing Sizes

Mr. High brought up the question of adding pipe covering in copper tubing sizes to our line. It was indicated that this problem could be worked out. It was evident that additional milling cutters would be necessary.

Item 9. Pangborn Dust Collector

The writer called attention to the fact that our Pangborn dust collector is inadequate for present conditions, however, it is hoped that the reduction in milling waste expected when precision molding methods are utilized will reduce the load on this dust collecting equipment to the point where it will be satisfactory.

Item 10. Unmolding

- a. In connection with the experimental work done thus far vacuum unmolding has worked very nicely approximately 60% of the time, however when the sponge rubber face of the vacuum lifting mechanism fails to make a good contact, stumbling and excessive breakage results. Recently the writer had suggested to Mr. Robinson that sharp knife edge steel cups be tried in place of the sponge rubber. It is our thought that sharp knife edges will cut through any minor inequalities and thus provide a good seal for the vacuum. A single unit for experimental purposes has been designed and will be constructed in our shops as soon as possible. Mr. Cowan suggested that we consider obtaining help from outside consultants with reference to this unmolding problem.
- b. Dr. Gordon described the improvement in block pan design which has been in successful experimental operation on a very limited scale for sometime. Dr. Gordon's design includes a block pan similar to our present block pans except in place of the solid plate bottom, he has provided an open skeleton frame bottom. The material is prevented from flowing out of the bottom of the pan by means of a separate and removable steel plate. When the material is unmolded from the pan, this plate comes out with the block and thus protects the block itself against breakage. Dr. Gordon made the suggestion with which we all concurred that approximately 50 block pans of his improved design should be purchased. The purchase of these block pans which are relatively inexpensive should give us a real commercial test on this apparent worthwhile idea. In order

to reduce rejects at the milling operation, Dr. Gordon further suggested that we make our pans 4" deep in place of $3\frac{1}{2}$ ".

Item 11. "Nesting" of P. C. Sections

Mr. Abraham questioned whether our proposed precision molded products would "nest". Mr. High answered, "Yes".

Item 12. Visit to Carey Operation

While the possibility of having some of our people visit the new Carey insulation operation was discussed, it was decided that this visit would not be wise at this time.

Item 13. Mundet Insulation Operation

Mr. High mentioned his visit to Mundet where he saw a very ingenious machine designed by L. S. Rosener which was capable of automatically handling block blanks from a pile to the fully milled product and placed in cartons.

Item 14. Calsilite Cement

There was a brief discussion of Calsilite cement and it was decided that for the time being our files should be closed with reference to this item. Mr. High mentioned a special type of cement for the F.H.A. and also for the Navy.

Item 15. High Temperature Block

Dr. Gordon reported that the filter press mold necessary for the production of this equipment was delivered sometime ago and that he had made some initial experiments. During these experiments it was found necessary to reenforce the flat plate for the mold and to provide a larger pressure tank. Mr. Robinson ordered this tank several weeks ago and it was scheduled for shipment from Chicago on the 24th. As soon as the necessary additional equipment arrives, Dr. Gordon will continue his experiments with this item. Dr. Gordon indicated that the approximate formula for this high temperature block is as follows:

Lime	-	20%
Scrap Calsilite	-	30
3R Asbestos Fibre-	10	
Pearlite	-	10
Diatomaceous Earth	-	30
		<u>100%</u>

The above formula was worked out by Dr. Gordon.

Item 16. Johns-Manville Thermosbestos

In response to Mr. Abraham's question it was indicated that Dr. Gordon's laboratory report dated July 24th outlined his findings with reference to the J-M product.

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Item 17. Research on Calsilite Pipe Covering by Extrusion Methods

Dr. Gordon showed a sample of pre-set material of consistency suitable for extrusion and indicated that some simple plunger type extrusion apparatus was on order which would place him in a position to make small samples by this method. The question of patenting this pre-set and extrusion method came up and Mr. Abraham expressed the view that we should not consider a process patent at this time. The research work in connection with this method will be continued.

Item 18. Calsilite Corrosive Action Claim on Steel

In view of the fact that Calsilite material is basic in its reaction, it was the consensus of opinion of those present that it could have no corrosive action upon steel.

Item 19. Order Situation Versus Warehouse

Mr. High indicated that receipts of Calsilite orders are slow at the present time, however, our warehouse stock is also low. It was his opinion which is shared by Mr. Robinson and the writer that if the present order situation continues, our warehouse space will be full on or about September 1st. There was some discussion of intensifying the Calsilite sales' effort and possibly increasing the sales' force with reference to this item. Mr. Abraham stated that he would discuss this point with Mr. Woodward upon his return.

A. A. Maxwell

A. A. MAXWELL

AAM/mgl

Confidential

Mr. Herbert Abraham, New York

July 28, 1950

Messrs. Cowan, VanAkin, Eckert, High, Robinson, Gordon, Letcher

Subject: MINUTES CALSILITE RESEARCH COMMITTEE MEETING - BOUND BROOK, N. J.
- JULY 25, 1950 -

Enclosed, herewith, you will find our write-up of the Minutes of the subject meeting.

A. A. Maxwell

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Enc.

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