NARCO CONFIDENTIAL-RESTRICTED



NARCOCAST E.S. FINE TROWEL

Made at: Curwensville, PA

PRODUCT LIFE: JULY 14, 1961 TO JAN. 17, 1986

ASBESTOS DATES: AUG. 9, 1963 TO AUG. 8, 1977

NARCOCAST E.S. FINE TROWEL MIXES: 326

326A

326B

326-03

CONFIDENTIAL — RESTRICTED

NORTH AMERICAN REFRACTORIES COMPANY

MIX SHEET

NARCO CONFIDENTIAL-RESTRICTED

BRAND NARCOCAST E.S. Fine (Trowel) MIX NO. 326-03

PLANT Curwensville DATE October 3, 1983

	MIX			BATCH	
	RMS No.	Raw Material	Sizing	Wt. %	Batch
1	012	Calcined Flint Clay	-8M	66.7	2230#
2	013	60% CA Cement		28.1	10-94# bags
3	016	Tennessee #5 Ball Clay	A.F.	5.2	3½-50# bags
4				100.0	3345
5					
6					
7					
8					
9					
10					
11					
12					
13					
14					

MIXING INSTRUCTIONS

IN-PROCESS CONTROL SPECIFICATIONS

SCRAP DISPOSITION/REWORKING

1) Approved landfill

2) 10% bled into virgin batch

BRAND ~~NARCOCAST E.S. FINE (Trowel)~~

MIX NO. 326-03

PLANT Curwensville

DATE October 3, 1983

FINISHED PRODUCT SPECIFICATIONS

NARCO CONFIDENTIAL-RESTRICTED

PROPERTY	TEST METHOD	SPECIFICATIONS
Screen analysis on 8M		
35M		
200M		
After Casting		
Bulk density (dried at 230°F		
MOR for 24 hours)		
Water to Cast		
Time of Initial Set		
Working Time		

HANDLING, STORAGE, PACKAGING, ...

Shelf life: 12 months

SAFETY PRECAUTIONS

Potential crystalline silica from clays

(approved dust respirator)

APPROVED Jak RESEARCH

APPROVED Polson OPERATING

APPROVED [illegible] PLANT

REPLACES MIX SHEET DATED 8-8-77

REASON FOR CHANGE

Mix sheet updated

Deletion of Hector Bentonite

Form M67

NARCO CONFIDENTIAL-RESTRICTED

NORTH AMERICAN REFRACTORIES COMPANY

MIX INSTRUCTIONS

PLANT [illegible] Pa. DATE [illegible]

BRAND [illegible] MIX NO. [illegible]

PROCESS BURN

[illegible] SHRINKAGE

MIX

Stiff mud [illegible] 8 M 70 %

Roland [illegible] 30 %

Tenn. [illegible] A.F. [illegible] % [illegible]

SPECIAL INSTRUCTIONS [illegible] "TROWEL" on [illegible]

[illegible] on W.O. 151

CONTROL SPECIFICATIONS

[illegible] Dry 2.30° 900 PSI Min.

2300° Reheat 1.5% Lin Shrk Max.

APPROVED F. W. Schroeder Research

APPROVED R. F. Whitford Operating

APPROVED R. W. Davidson Plant

Replaces Sheet Dated

New - Mix

FORM 116 8

NORTH AMERICAN REFRACTORIES COMPANY

Mix Instructions NARCO CONFIDENTIAL-RESTRICTED

Plant Curwensville, Pa

Date Aug 9, 1963

Brand Narcocast E.S. Fine (Trowel)

Mix No. 326 A

Process

Burn

Class B castable for troweling

Shrinkage

Mix

Stiff Mud Bats (Dry)	8 M	70 %
Rolandshuette Cement (or Refcon Cement)		30 %
Tenn. No 5	A. F	5 % (added)
Asbestos 7 KO 5 (J.M)		1 % (added)

Special Instructions Stencil "TROWEL" on bags.
Reason for change - To improve trowelability

Control Specifications

M/R Dry 230°F 400 psi Min.
Wet screen. 30 to 35% cumulative
on 20 Mesh

Signed Engineering

Approved F W Schroeder Research

Approved R. F. W Seifert Operating

Approved R. W. Donelson Plant

Replaces Sheet Dated
7/14/61
8/9/63

FORM 115 B

NORTH AMERICAN REFRACTORIES COMPANY

Mix Instructions

NARCO CONFIDENTIAL-RESTRICTED

Plant Curwensville, Pa.

Date August 8, 1977

Brand NARCOCAST E.S. (Fine) Trowel

Mix No. 326 B

Process Trowelling Castable

Burn

Shrinkage

Mix

Stiff Mud Bats *	-8 m.	70%
Refcon Cement		30%
Tenn #5 Ball Clay	A.F.	5% added
Hector Bentonite		2% added

Special Instructions * When stiff mud bats are not available Furbar calcine may be substituted. Above mix based on RC-1038-2; reason for change - to eliminate asbestos from mix.

Control Specifications

First order (5 tons) supplied to Foster-Wheeler 7/22/77.

Replaces Sheet Dated

8/9/63 (Mix No 326A)

Approved Robert J. Hess Research

Approved [signature] Operating

Approved R. T. Wright Plant