

These spools are next taken to a twisting machine where two or three of the single-ply threads are twisted into one thread. For the manufacture of brake lining or packing the yarn may be reinforced with a fine metallic wire. This addition is performed during the twisting operation. The twisted yarn is finally wound on paper spools about six inches long.

The twisted yarn may be sold as such to other manufacturers, or it may be woven into cloth, tape, or brake lining, or braided in the same plant.

Weaving—Weaving is done on looms in a similar manner to the method employed in weaving wool, cotton or silk. In the weaving of asbestos tape intended for electrical insulation, single-ply yarn with a very low cotton content is used. Most tape looms are constructed so that as many as twelve pieces may be woven at the same time. It is the usual practice in weaving asbestos tape to wet the bobbins or "cops" with water before weaving. The warp is kept dry.

Cloth is woven in much the same way as insulating tape. Two- or three-ply yarn is used. Sometimes the yarn is reinforced with metallic wires, generally brass or copper. Either or both the warp and fill are dry or moistened with water, depending on the use for which the cloth is intended.

Brake lining is woven on looms in the same manner as tape. As many as eight pieces may be woven on one loom at the same time. It may be woven dry or wet, or with the warp impregnated with a "dope" solution. This solution is generally a suspension of gilsonite in gasoline to which other ingredients may be added.

Final operations in the manufacture of woven textiles consist of calendering, inspecting and winding of the products. These operations are all mechanical ones, and require no description.

Gasket Making—One of the important uses of asbestos cloth is in the manufacture of ring gaskets. In this process, the asbestos cloth is spread on the floor and impregnated with a solution of rubber in gasoline, to which has been added barytes and other pigments. The rubber-treated asbestos cloth is cut into strips of predetermined size, and the gaskets formed by hand. They are then coated with soapstone, calendered and packed for shipment. An inexpensive gasket and packing is made by twisting thick rovings into asbestos wick and rope. Still other types of packings are made by braiding asbestos yarn on specially designed machines.

OTHER PROCESSES

Other products containing asbestos are made in some of the plants included in this survey. These products include asbestos paper, insulation for steam pipes, asbestos cements, shingles, lumber, molded brake lining, and cold molded asbestos articles, generally electrical fittings and household appliances. The fiber used for these purposes is of short staple. The percentages of asbestos used in these articles is indicated in Table II.