

DANA

DANA CORPORATION

VICTOR PRODUCTS DIVISION
FACTORY STANDARDF. S. #413
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VICTOCOR 150 WITH HOLLINGSWORTH & VOSE FACING

DESCRIPTION: This Factory Standard covers the manufacture of various gauges of VICTOCOR 150 made with Black Plate Steel Low Prong Core and Hollingsworth & Vose ASBESTOPAC 958 facing material.

MATERIALS:

1. .0066" (60#) P. S. #103 Black Plate F.S. #346 Core
2. .0083" (75#) P. S. #103 Black Plate F.S. #346 Core
3. ASBESTOPAC 958 from Hollingsworth & Vose, F.S. #096
4. Water
5. Formula #597

PROCEDURE:

Assembling: When individual sheets of VICTOCOR 150 are to be made, Dept. 205 steel of proper gauge as required per the table below is perforated and cut to size, then assembled between two pieces of Hollingsworth & Vose ASBESTOPAC 958 of the gauge also specified in the table.

When VICTOCOR 150 is to be made on the continuous process equipment, the steel is set up to feed into the equipment between two continuous lengths of asbestos.

▽ Combining: The assembled materials are combined on an individual Dept 205 sheet combiner or on the continuous process equipment. The following table correlates the proper core; the proper gauge and basis weight of asbestos facing; and the corresponding aim, combined, and final gauge of VICTOCOR 150:

Core Material, Steel Thickness, in.	H&V ASBESTOPAC 958		Thickness in.	VICTOCOR 150		
	Basis Weight,			Aim Gauge, in.	Combined Gauge, in.	Final Gauge, in.
	lb/480 sq.ft.					
	Nominal	Range				
.0066	55	52-58	.018-.022	.035-.037	.034-.039	.035-.040
.0083	67	63-70	.023-.027	.042-.044	.041-.046	.042-.047
.0083	78	74-81	.026-.030	.049-.051	.049-.054	.050-.055
.0083	82	78-86	.028-.033	.054-.056	.054-.059	.055-.060
.0083	105	100-110	.036-.042	.063-.065	.064-.069	.065-.070

Aim gauge is the desired gauge of material leaving the combiner. Combined gauge is the required gauge of material after having been combined and allowed to recover. Final gauge is the required gauge of finished gaskets that have been blanked, then coated with Formula #597 and baked (if required).

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