

ST. LOUIS, MO.

#83 ACID RESISTING SHEET
PACKING

4414-30

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FORMULA

		Wet Basis		Dry Basis	
		Wt.	%	Wt.	%
x	Grade H Blue Crocidolite Fibre *	600	45.5	600	58.0
	P.S. 62301 Dispersed Butyl Rubber	438	34.0	258	25.0
	P.S. 3269 C-370 Dispersion	150	11.7	75	7.3
	P.S. II-3208 Alum (Papermakers)**	100	7.8	100	9.7
		1288	100.0	1033	100.0

FORMULA NOTES

- * JM AX2545 Blue Crocidolite Fibre is an approved alternate for Grade H Fibre. 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.

Grade H Blue Fibre	Dispersed Butyl Rubber	C-370	Alum
580 lbs.	423	150	100
640 lbs.	468	150	100
620 lbs.	453	150	100
600 lbs.	438	150	100
560 lbs.	408	150	100

MANUFACTURING INSTRUCTIONS

1. Put the blue fibre through the JB Mill into the beater which is about half full of 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 110° 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 and heating. When the temperature reaches 130° F. add the thoroughly stirred Butyl rubber through the No. 12 mesh screen.
6. Continue to heat beater stock to 160° F. 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 mixer and with live steam until the temperature reaches 160° F. This operation is controlled automatically.

X- INDICATES CHANGE -REASON: Substitute Grade H Blue for AX 2545 Fibre

AUTHORITY FOR CHANGE Summary Product Proposal 011-PP-1032 dated 3-5-62

SUPERSEDED: Page 1, same spec. issued 12-20-60

RETURN TO
J-M RESEARCH
FILE ROOM

DATE 3-23-62