

MV 2 & 1990

**JOHNS-MANVILLE RESEARCH
AND ENGINEERING CENTER**

Memorandum No. M431-56-S1

Date October 16, 1967

TITLE: GLASS LINING FOR MOLDS FOR CAST BRICK

Requested by: R. E. Robinson

PLAINTIFF'S
EXHIBIT
K-1619

A lining of glass in the northwest cavity of a mold used for the middle course of slabs for making 3-in. brick was placed in service 4:30 p.m. October 11 at the Zelienople plant. No problems occurred during the first 24 hr of use and no gypsum buildup occurred on the faces of the glass. The Quality Control Supervisor at Zelienople will comment weekly in his regular control report on the condition of the glass lining and on the satisfactoriness of this method of preventing gypsum buildup. The fired slabs from this cavity are being segregated in order to follow them through the finishing process.

The length and width of the stripper foot were reduced so as to clear the glass lining by 1/8 in. The slab was ejected from the mold at the same rate as the other slabs. That is, the slab from the glass-lined cavity did not fall free as soon as ejection began nor did it hang up unduly. It should be noted that the cavity with the glass lining is 1/32 in. narrower at the bottom than the top. This constriction was unintentional. The molded slab was the same length and height, but 1/16 in. narrower than the standard slab molded for 2-1/2 in. brick. The slab from the glass lining had a smooth surface compared to a "washboard" surface on the other slabs from the same mold. All cavities in the mold were cleaned of gypsum buildup just prior to this trial.

The mold for the middle coarse will be used for an extended time of indefinite duration. The intention is to leave the glass lining in service as long as the mold is being used.

A. S. Rankine
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rf

cc: T. H. Eaton, DH
E. C. Truax, DH
D. B. Wingerter, DH
R. E. Robinson, Zel Plt
D. S. Fischer, Zel Plt

F. L. Pundsack
J. A. McKinney
S. E. Wooley
A. S. Rankine
File:

L. R. Blair
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