

VICTOR MFG. & GASKET CO.

FACTORY STANDARD #311

October 21, 1963

.055"/.060" MULTICOR VICTOCOR

This Standard covers the manufacture of a high density - .055"/.060" five layer construction Victocor having two core and three facing materials.

MATERIALS:

1. 65# Tin Plate (.007") P. S. #450-3
2. Asbestopac #958 - P. S. #506 - 43-48#
Basis Weight (.016")
3. Asbestopac #958 - P. S. #506 - 63-70#
Basis Weight (.022")
4. Formula #458-B
5. Formula #458-BT
6. Formula #597 (If specified on Analysis Card)

PROCEDURE

Perforating and
Cutting of Core:

Dept. 05

Material #1, slit to the required width, is perforated .030"/.035" and cut to the desired length on Machine #2909 (Minster Press). The variation within one sheet of core should not be more than .003" with no broken punches present.

Inspection of this core should be made 4 to 5 times a shift to insure that the above tolerances are maintained.

Degreasing of
Core:

Dept. 06

Cut strips of perforated core are degreased in Dept. 06 using Machine #3148. The core is placed in the baskets provided and allowed to remain 5 minutes in the two compartments and the vapor of this machine.

Cementing and
Drying the Core:

Dept. 19

The strips of degreased core are coated with Material #4 using the Union Tool or Francis two roll coating unit. The use of either machine should result in a uniform coating being applied to the core. The coated sheets are racked into the Victocor drying oven (Machine #1354) for drying at 160-170°F.

As the coated and dried sheets emerge from the oven, they should be assembled into the following five layer construction: Material #2 - Cemented Core - Material #3 - Cemented Core - Material #2.

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