MANUFACTURING SPECIFICATIONS

Asbestos PLANT

Rigid Shingle DEPT.

PRODUCT: Veneers - Graytone, Blue-Gray, And Dover White Siding Shingles 4-3

DIVISION

SPEC. NO. MS - 8

PAGE NO. 1

PLAINTIFF'S EXHIBIT JM-2439

FORMULAE

CANCELLED by letter 1-19-61

Veneer for Graytone and Blue Gray Smoothgrain Shingles

P.S. No:	Materials	Batch Quantity	%
-	7F04 Asbestos Fiber	137# (1 bag + 37#)	7.0
CA 1001	Portland Cement - White	525# (6 bags)	26.9
63386	#10 Dry Ground Whiting	750# (15 bags)	38.6
CA 1281	JM Special Silica Flour	400# (4 bags)	20.5
CA 1272	80 Mesh Sand	137# (1 bag + 37#)	7.0
		1949#	100.0%

Veneer for Dover White Cedargrain Shingles

-	7F04 Asbestos Fiber	140# (1 bag + 40#)	6.8
CA 1001	Portland Cement - White	525# (6 bags)	25.4
63386	#10 Dry Ground Whiting	770# (15 bags + 20#)	37.3
CA 1281	JM Special Silica Flour	420# (4 bags + 20#)	20.3
-	Titanox "A" - 168	70# (Weighed)	3.4
CA 1272	80 Mesh Sand	140# (1 bag + 40#)	6.8
		2065#	100.0%

II. MIXING INSTRUCTIONS:

1. Asbestos Fiber to be dry before charging to the hopper.

2. Add materials in the order shown to the top mixer of the veneer mixing system and mix for 10 - 15 minutes.

3. Drop batch into bottom mixer and feed continuously through the Dietz Disintegrator, from which point the mixed veneer isscrew conveyed to the feed elevator above the Selectro Screen.

III. APPLICATION INSTRUCTIONS

1. Adjust rate of feed through the Selectro Screen so that a uniform coverage of between 12.5 to 14 lbs. per 100 sq. ft. of base sheet area will result for Graytone and Blue-Gray shingles (or between 4 to 4⅓ ozs. per 2 sq. ft.); and between 22.5 to 24.25 lbs. per 100 sq. ft. of base sheet area for Dover White Shingles (or between 7¼ to 7-5/4 ozs. per 2 sq. ft.)

2. Pass veneered sheet under one or more perforated rolls and one smooth press roll to compact the veneer. Adjust pressure on rolls to obtain uniform compaction and to minimize size and number of bare spots.

MT-000267

X—INDICATES CHANGE — REASON: X. To show differences in veneer usage.

AUTHORITY FOR CHANGE X. Research Recommendation (Letter from C.V.F. to N.E.M. of 9/10/57)

FILE-HOLDERS	I.E.	R.S.G.	Dept.		SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DIR. QUAL. CONTROL

SUPERSEDES: Page 1, same titled specification dated 6/10/55

DATE ISSUED 10/10/57

50188-10 TED IN U.S.A.

MANUFACTURING SPECIFICATIONS

Asbestos PLANT

Rigid Shingle DEPT.

PRODUCT: Veneers – Graytone, Blue Gray and Dover White Siding Shingles

DIVISION Ca

Ba – 3

P.S.O. NO. 43

JUN 21 1955 G. B. BROWN

I. FORMULAE:

Veneer for Graytone and Blue Gray Smoothgrain Shingles

P.S.O. No.	Materials	Batch Quantity	
–	7F04 Asbestos Fiber	137# (1 bag + 37#)	[illegible]
61001	Portland Cement – White	525# (6 bags)	26.9
63386	#10 Dry Ground Whiting	750# (15 bags)	38.6
61281	JM Special Silica Flour	400# (4 bags)	20.5
61296	"O" Grade Sand	137# (1 bag + 37#)	7.0
		1949#	100.0%

Veneer for Dover White Cedargrain Shingles

–	7F04 Asbestos Fiber	140# (1 bag + 40#)	6.8%
61001	Portland Cement – White	525# (6 bags)	25.4
63386	#10 Dry Ground Whiting	770# (15 bags + 20#)	37.3
61281	JM Special Silica Flour	420# (4 bags + 20#)	20.3
–	Titanox "A" – 188	70# (weigh[illegible]	3.4
61296	"O" Grade Sand	140# (1 bag[illegible]#)	6.8
		2065#	100.0%

II. MIXING INSTRUCTIONS:

1. Asbestos Fiber to be dry before charging to the hopper.
2. Add materials in the order shown to the top mixer of the veneer mixing system and mix for 10 – 15 minutes.
3. Drop batch into bottom mixer and feed continuously through the Fiber Disintegrator, from which point the mixed veneer is screw conveyed to the feed elevator above the Selectro Screen.

III. APPLICATION INSTRUCTIONS:

1. Adjust rate of feed through the Selectro Screen so that a uniform coverage of 20 (± 1) lbs. per 100 sq. ft. of base sheet area will result.

   The control purposes, veneer should check between 6 to 7 ounces per 2 sq. ft.

2. Pass veneered sheet under one or more perforated rolls and one smooth press roll to compact the veneer. Adjust pressure on rolls to obtain uniform compaction and to minimize size and number of base cracks.

RETURN TO J-M RESEARCH FILE ROOM

X— INDICATES CHANGE — REASON: Complete revisions and inclusion of Blue Gray Blend.

AUTHORITY — FOR CHANGE: Product Proposals Asbestos #961-221 & 961-222 (approved).

FILE-HOLDERS	I.E.	R.S.O.	Dept.		SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DIR. QUAL. CONTROL

SUPERSEDES: None. DATE ISSUED 6/30/55

80132-10 TED IN U.S.A.

MT-000268