

I. PRODUCTS:

Fibre Blends M-558E, M-559E, and C-209

M-558 E Fibre Blend - For Tube Mandrel Pressure Pipe Products:

Material	Lbs.	Willow Batch		Purchase Spec.
		No. of Bags	\$	
A Hlms	340	4	28.6	
4T-28	250	2 1/2	21.0	
Munro 4Y	300	3	25.2	
R.I.S.	100	1	8.4	
6D20	200	2	16.8	
	1190		100.0	
Reprocessed Material	216			
Total	1296 Lbs.			

RETURN TO
J-M RESEARCH
FILE ROOMM-559 E Fibre Blend - For Spring Arm Mandrel Pressure and Non-Pressure Pipe Products:

Material	Lbs.	Willow Batch		Purchase Spec.
		No. of Bags	\$	
A Hlms	255	3	35.2	
HC-300	125	1		
4T-28	200	2	18.5	
Munro 4Y	350	3 1/2	32.4	
R.I.S.	50	1/2	4.6	
6D20	100	1	9.3	
	1080		100.0	
Reprocessed Material	216			
Total	1296 Lbs			

C-209 Fibre Blend - For Non-Pressure Pipe Products sizes 2" through 8"

Material	Lbs.	Willow Batch		Purchase Spec.
		No. of Bags	\$	
MS Hlms	100	1	7.2	
4Y	300	3	21.4	
R.I.S.	300	3	21.4	
Reprocessed Material	700		50.0	
Total	1400		100.0	

II. MANUFACTURING INSTRUCTIONS:

1. Add fibre and reprocessed material to mixer in such quantities as shown in the above formulas.
2. Mix batch for a minimum of 10 minutes before dropping to the willow.
3. Feed material into the willow at a rate not to exceed 3000 lbs. per hour. It may be necessary to reduce this rate when the bottoms of the willow bacs worn.

X- INDICATES
CHANGE -REASON: Fibre AvailabilityAUTHORITY
FOR CHANGE

E. J. Whalen's letter dated 5/9/58 & T. R. Turnbull's letter -6/30/58

SUPERSEDES: Pages 1 and 2 of Same Specification issued 2/21/58

DIR. Q.C.	MGR. Q.C. 2	SUPR. Q.C.	PROD. SUPT.	PLNT. FIN.	RES. 2	Pipe Plants-5	DATE ISSUED	7/29/58
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