

Manville Ind. Prods. Plant
August 15, 1950

E.J. O'Brien

Progress Report - Munro Plant
Week of 8/7 to 8/12 Incl

PLAINTIFF'S
EXHIBIT

CSR-561

Furnish

Fibre blend M-320-2-A was run for the entire week. Due to the shortage of white fibre, Munro Pressure Pipe fibre, high pan content munro was used on an attempted true fibre basis as follows:

15% "S" Blue
5% "S" 3
30% Viny H-T
30% "S" 28
25% Munro (5% added to cover Dust Content)

Munro lots used for the week were as follows:

Screen	10F152	10F161	10F162	10F163	BC10T
3	0.0	0.0	0.0	0.6	2.0
4	4.8	1.5	2.8	2.8	4.2
6	18.6	13.2	18.4	15.6	19.0
10	39.2	26.6	39.0	40.3	38.0
20	15.4	16.2	15.2	15.3	18.2
35	5.2	6.2	5.6	6.6	6.0
Pan	16.8	26.2	19.0	15.3	15.4

In addition to the above lots, assorted small lots on which we had no Ro-Tec blended in.

On 8/8/50 at 4:00 PM this department also ran out of Viny H-T and it was necessary to substitute BC-H-T fibre. This blend ran badly, and it was necessary to reformulate on Wednesday morning (8/9/50) as follows:

15% "S" Blue
5% Australian Blue
25% BC-H-T
30% H-T-28
25% Munro

This blend ran fairly well on #2 machine but left a lot to be desired on #3. 12" diameter pipe was run.

Rock Wool coverage tests ranged from 28.0 to 34.0 for the week.

Regular silica 85% through 200 mesh was used and straight National Cement from bin 23 and 24 was used with some improvement noted in the Bin 23 cement.

Operations were slow, with poor forming rates average tonnage on tube mandrels tons and 41.5 tons on solid mandrels.

Agitator speed remained at 100 RPM on #2 but was moved up to 120 for solid mandrels on #3.

Ultimate strength tests were as follows:

Hydrostatic

700, 750, 700, 700, with 4 pipe passing the 750# test.

Flexure

4200, 3800, 3750, 3950, with 6 pipe passing 3400#.

Felts

Special fast filtering Knox felts were used.

Test Results

4374 inspected, 3.0% rej., 0.4% flex., 8.6% hydro.

Future Plans

1. Every effort is being made to rush proper fibres in so that we can resume normal operations.
2. From necessity the same blend must be run to start the week with changes of regular fibres arrive.

15%	"S" Blue
5%	"A" Blue
5%	C&G #3
25%	BC-4T
30%	4428
25%	Mumro (High Pan)
3. Draper bottom felts will be run with Standard Huyck tops.
4. Modifications will be made to #3 circulating system so that the vat level can be dropped at the finish of a pipe.

A.H. Schilling

AHS:ME

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