Packing PLANT

DEPT.

I. BATCH FORMULA

	Purch.Spec. [redacted] no.	Ingredients	Weight	Per
XL		Processed Buna - GRS-86	57# - 0 oz. (30 gal. Naphtha)	22
	P.S. 63345	Sulphur (Rubber Makers')	3 - 0	1
		Tuads	2 - 8	1
		Captax	1 - 0	0
	P.S. 63195	Zinc Oxide	3 - 0	1
X		Agerite Powder or Neozone D	1 - 0	0
	P.S. 63294	Standard Grade Carbon Black	25 - 0	9
	P.S. 61288	#75 Silica Sand	43 - 0	16
	-	Blended Blue Asbestos Fibre (crocidolite)	120- 0	47
		Totals	255# - 8 oz.	100
	P.S. 60755	Petroleum Rubber Solvent Naphtha 78 gallons approx.		

II. PREPARATION OF BUNA S GEL

XL Pass the Buna GRS-86 once through a cool rubber mill or a cool three-roll calender with rolls tight together in order to sheet out thin. Put 28-1/2 of the above sheeted Buna into a can containing 15 gals. Naphtha. Let so for 48 hours to properly swell the Buna.

XL Note: 4 gallons of Ennjay may be substituted for an equal quantity of Naphtha when necessary to properly swell the Buna GRS-86.

III. MIXING PROCEDURE IN ROSS MIXER.

XL

1. Dump 2 cans of Rubber (30 gallons Gasoline) and add Dry Compounds (78#
2. Mix 10 minutes.
3. Willow Fibre into mixer (120#, 6 bags).
4. Add 3 gallons gasoline after each bag of fibre making a total of 15 gal added during willowing operation.
5. Change plug (remove plug and replace in top of mixer).
6. Add 2 gallons gasoline at 2 min. intervals until total of 30 gals. add
7. Mix 10 minutes.
8. Dump with 3 gallons Gasoline.

Note: In the extreme hot weather VM & P Naphtha may be substituted for Petroleum Rubber Solvent Naphtha.

RETURN TO J-M RESEARCH

RECEIVED JUN 21 195 E. R. WILL

X To show the use of Neozone D as an alternate.
XL To correct percentage figures and show Buna currently used no

X — INDICATES CHANGE X Gattuta's letter [redacted] dated 5-29-51. GRS-86
XL Correction

AUTHORITY FOR CHANGE — Manville Foreman Lab.

FILE-HOLDERS Page 1 of same spec. issued 2-11-49.

SUPERSEDES:

PLAINTIFF'S EXHIBIT WV-04585

PLAINTIFF'S EXHIBIT 10873.0

WV-04585