

B I R D I N C O R P O R A T E D

Memo To: W. C. Kinsey - BRM

From: *RC* R. J. Carlson - BBQSubject: SHREVEPORT - FISHMOUTHING OF
WIND SEAL SHINGLES

Date: November 6, 1984

In belated response to your Oct. 9 memo, this subject was investigated during my Oct. 15-16 quality Audit at Shreveport.

While the exact mechanism by which a fishmouth distortion occurs is unknown, at least to me, the following conditions are recognized as being contributing factors:

Moisture - Introduced during manufacture, storage, or improperly ventilated building. Not likely a factor in recent increase of complaints unless shingles are being packaged wetter than pre-1983 material.

Back Coating - Insufficient amount or poorly applied as to create voids. Inspection results and audit indicate sufficient weight of back coating. Integrity of back coating is suspect. By copy of this memo I am requesting P. Ladner to run Head of Water tests (with dye) on samples from stock and complaint samples to determine percent moisture gain and evidence of voids.

Percent Saturation - Undersaturated felt more prone to moisture absorption, although usually manifests as a curling complaint. Not a likely factor in this case as low saturation has been a historic problem. Also, Allied, who purchases our dry felt is reported to saturate well, but is also reported as experiencing a fishmouthing problem.

Dry Felt Formulation - Different furnishes result in different dry felt properties. Highly suspect as a contributing factor being that a major change in formulation (removal of wood chip) appears to be coincidental with increased incidence of fishmouth complaints. Also, as mentioned, Allied is reporting a similar experience. Pat Ladner has begun compiling data to develop a frequency histogram based on application date.

Based on the conclusiveness of Head of Water testing and relation to dry felt formulation change, recommendations will be forthcoming as to corrective actions.

RJC/cm

cc:	J. K. Colvin	- MS
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