

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

Memo To: W. McClung - PS

From: C. J. Patenaude - BBH

Subject: REVISED BLENDS FOR THE
WOOD-LINE SHINGLE - PROJECT #4047

Date: September 27, 1984

The spill blends for the up-coming mill trial at FS to produce the Wood-Line shingle have been reviewed again.

Based on the drum design presented in Progress Report No. 4, the spill for the two Cypresswood blends have been changed slightly to show the effect of the tab lines. The spill for the Oakwood blends and the Weathered Wood blends are the same as given in my memo dated August 21, 1984.

We are now assuming that 10%-20% of the tab line drops make up the spill as well as the normal 50% of the drops from #1 Hopper and #2 Hopper. None of the Interrupted Tone drops will go into the spill. It is diverted into the headlap portion of the shingle. The approximate percentages of the three drops that make up the spill are then:

Tab Line	4.1% to 2.1%
#1 Hopper	48.8% to 49.8%
#2 Hopper	47.1% to 48.1%

We would like to run two Oakwood colors, two Weathered Wood colors, and two Cypresswood colors. The formulas are attached. We plan to study and view the colors from display boards and test roofs in the Walpole and Shreveport areas. The mill trial will start using the contrasting blends first per Mr. Jackson's memo of 9/18/84.

Thank you for your assistance.

References:

Patenaude, C. J., Progress Report #4047-4, 8/1/84,
"Wood-Line Shingle"

Patenaude, C. J., Memo dated August 21, 1984, "Blends
For the Wood-Line Shingle"

CJP/cm

Clifford Patenaude

cc	Mr. Bickum	- BBH
	Mr. Carlson	- BBQ
	Mr. Charbonneau	- BBH
	Mr. Colvin	- MS
	Mr. Jackson	- BBH
	Mr. Ladner	- PSL
	Mr. Maloof	- BBP
	Mr. Wood	- BBP
	Tech File	

CYPRESSWOOD

<u>HOPPER</u>	<u>%</u>	<u>COLORS</u>
1 (Light Band)	20	3M LR 65 Buff
	70	3M LR 68 Buff
	10	3M LR 41 Brown
2 (Dark Band)	40	3M LR 65 Buff
	20	3M LR 68 Buff
	40	3M LR 41 Brown
Spill	5	3M LR 51 Black
	30	3M LR 65 Buff
	45	3M LR 68 Buff
	20	3M LR 41 Brown
Tone Line	100	3M LR 51 Black

CONTRAST CYPRESSWOOD

<u>HOPPER</u>	<u>%</u>	<u>COLORS</u>
1 (Light Band)	20	3M LR 65 Buff
	80	3M LR 68 Buff
2 (Dark Band)	40	3M LR 65 Buff
	10	3M LR 68 Buff
	50	3M LR 41 Brown
Spill	5	3M LR 51 Black
	30	3M LR 65 Buff
	45	3M LR 68 Buff
	20	3M LR 41 Brown
Tone line	100	3M LR 51 Black

OAKWOOD

<u>HOPPER</u>	<u>%</u>	<u>COLOR</u>
1 (Light Band)	70	3M LR 46 Tan
	20	3M LR 41 Brown
	10	3M LR 51 Black
2 (Dark Band)	25	3M LR 46 Tan
	60	3M LR 41 Brown
	15	3M LR 51 Black
Spill	45	3M LR 46 Tan
	40	3M LR 41 Brown
	15	3M LR 51 Black
Tone Line	100	3M LR 51 Black

CONTRAST OAKWOOD

<u>HOPPER</u>	<u>%</u>	<u>COLORS</u>
1 (Light Band)	80	3M LR 46 Tan
	20	3M LR 41 Brown
2 (Dark Band)	10	3M LR 46 Tan
	70	3M LR 41 Brown
	20	3M LR 51 Black
Spill	45	3M LR 46 Tan
	45	3M LR 41 Brown
	10	3M LR 51 Black
Tone Line	100	3M LR 51 Black

WEATHERED WOOD

<u>HOPPER</u>	<u>%</u>	<u>COLORS</u>
1 (Light Band)	10	3M LR 68 Buff
	25	3M LR 76 Gray
	65	GAF A801 Accent tone
2 (Dark Band)	90	GAF A801 Accent Tone
	10	3M LR 51 Black
Spill	5	3M LR 68 Buff
	15	3M LR 76 Gray
	75	GAF A801 Accent Tone
	5	3M LR 51 Black
Tone Line	100	3M LR 51 Black

CONTRAST WEATHERED WOOD

<u>HOPPER</u>	<u>%</u>	<u>COLORS</u>
1 (Light Band)	20	3M LR 68 Buff
	25	3M LR 76 Gray
	55	GAF A801 Accent Tone
2 (Dark Band)	80	GAF A801 Accent Tone
	20	3M LR 51 Black
Spill	10	3M LR 68 Buff
	15	3M LR 76 Gray
	65	GAF A801 Accent Tone
	10	3M LR 51 Black
Tone Line	100	3M LR 51 Black