

MANUFACTURING SPECIFICATIONS

PRODUCT

DIVISION 37

SPEC. NO.

RS-5

PAGE NO.

1MANVILLE

PLANT

RIGID SHINGLES

DEPT.

Asbestos Siding Shingles
Smooth Grain for Levitt423PLANTIFF'S
EXHIBIT
JM-2470PRODUCT:Smooth Grain Permatone Siding Shingles, being manufactured on
S.P.P.I. for Levitt Bros.

CANCELLED 7/15/49

ColorsStyleTexture

#3 Gray Colorgrain	Modified 107	Smooth Cedargrain
#7 Brown Colorgrain	Modified 107	Smooth Cedargrain
Green Colorgrain	Modified 107	Smooth Cedargrain

FORMULA:

<u>P.S. No.</u>	<u>Material</u>	<u>Batch</u>	<u>Weight</u>
-	Dan. 6D20 Fibre	2500	100.00
61281	JM Special Silica Flour	400	22.5
RS 62:1 or 84	Willowed Flexboard or Corrugated		
	Transite Scrap	50	3.3
RS 61 & 61:2	Ground Siding Shingle	500	25.2
61061	Portland Cement, Std. Atlas	561	21.8
	Total	1764	100.00

Note: Up to 50% of machine drop from the same or other machines
manufacturing similar stock may be added to the base.

Up to 50% of material from the dust collector may be added
to the base.

GRANULE USAGE:

<u>Color</u>	<u>Purch. Spec.</u>	<u>Granule</u>	<u>Percent</u>
Green Colorgrain	61619	Minn. #3628 Green	90%
	61604	Minn. #5028 Black	10%
#3 Gray Colorgrain	61604	Minn. #5028 Black	60%
	61603	Minn. #5628 Gray	40%
#7 Brown Colorgrain	61616	Minn. #4028 Brown	60%
	61615	Minn. #6328 Buff	50%
	61619	Minn. #2228 Red	10%

Note: Granule Usage shall be between 1-3/64 oz. and 1-1/16 oz.
per Sq. Ft. or 6.7 lbs. per 100 Sq. Ft.

X- INDICATES REASON
FOR CHANGETo establish a Specification covering production of
Levitt type Permatone Shingles on SPP.I.AUTHORITY
FOR CHANGE

Letter L. L. Liggett to H. C. Ellison 7/14/49

MT-000498

FILE-HOLDERS

Ind. Eng.

Wkg.

SUPR.
QUAL.
CONTROLPROD.
SUPT.PLANT
FINANCE
OFFICERESEARCH
LAB.MGR.
QUAL.
CONTROLDIR.
QUAL.
CONTROL

DATE ISSUED

SUPERSEDES: None: New Spec. File in numerical order.

SEP 9 1949

MANUFACTURING SPECIFICATIONS

MANVILLE

DEPT.

RIGID SHINGLES

PLANT

PRODUCT:

Asbestos Siding
Shingles Smooth Grain
for Levitt

DIVISION BP

SPEC. NO.

RS-5

PAGE NO.

1.

423

PRODUCT:

Smooth Grain Pernatone Siding Shingles being manufactured on
S.P.P.I. for Levitt Bros.

Colors	Style	Texture
#3 Gray Colorgrain	Modified 107	Smooth Cedargrain
#7 Brown Colorgrain	Modified 107	Smooth Cedargrain
Green Colorgrain	Modified 107	Smooth Cedargrain

X FORMULA:

P.S. No.	Material	Lbs.	%
-	6D20 Fibre	300	18.0
61281	J.M. Special Silica Flour	300	18.0
RS 61 or	Ground Siding Shingle or		
RS 61:2	Corrugated Transita Scrap	590	35.5
61061	Portland Cement Std. Atlas	470	28.5
		1660#	100%

Note: Up to 50# of machine drop from the same or other machines
manufacturing similar stock may be added to the base.

Up to 50# of material from the dust collector may be added
to the base.

GRANULE USAGE:

Color	Purch. Spec.	Granule	Percent
Green Colorgrain	61619	Minn. #3628 Green	90%
	61604	Minn. #5028 Black	10%
#3 Gray Colorgrain	61604	Minn. #5028 Black	60%
	61606	Minn. #5828 Gray	40%
#7 Brown Colorgrein	61616	Minn. #4028 Brown	60%
	61615	Minn. #6328 Buff	30%
	61613	Minn. #2228 Red	10%

Note: Granule Usage shall be between 1-3/64 oz. and 1-1/16 oz.
per Sq. Ft. or 6.7 lbs. per 100 Sq. Ft.

RECEIVED
MAY 14 1951

X-INDICATES - REASON:
CHANGERevise Formula and change P.S. and Granule No. for
Gray.AUTHORITY -
FOR CHANGE

To agree with the 1951 S.P.P.I.

E. R. WILLIAMS

FILE-HOLDERS

Ind.Eng.

Wkg.

SUPR.
QUAL.
CONTROLPROD.
SUPT.PLANT
FINANCE
OFFICERESEARCH
LAB.MGR.
QUAL.
CONTROLDIR.
QUAL.
CONTROL

SUPERSEDES: Page 1 of same Spec. issued 9/9/49.

DATE ISSUED

MT-000497

MAY 11 1951

