Interoffice Correspondence

CE REFRACTORIES

January 6, 1982

TO: K. Korn

FROM: T. Beals

SUBJECT: 70 Ram Wet Complaint #110
Refractory & Insulation

CC: G. Andrews
J. Bellington
C. Bisbee
W. Coon
K. Dunham
D. Guca
G. McNellis
C. Morgeneier
F. Steimke
J. Williams
G. Woods

Confidential - For Internal Use Only

#9894

ABSTRACT

A complaint was received on 12-29-81 from Refractory and Insulation 82 cartons of Ram 70 Wet code dated 1H09181 . The nature of the complaint was that the material was too dry and excessive cracking occurred during dry out.

The first point to be made is that this is an experimental product which carries a three month shelf life. At the time of this complaint, the material had passed its shelf life. Secondly, in July of 1981 a change in grain sizing was made. Previous to this date,the coarse aggregate was 20 Mesh Calcined Flint Clay. With this grain sizing, the materials performance was good. There was a problem at the Vandalia plant with the production of the 20 Mesh material. It could not be produced without oversize contamination. To overcome this problem, it was decided to replace the 20 mesh Calcined Flint Clay with 70 Mesh #2 High Burn Rotary Kiln Flint. The results was a finer sized material. This had effect on the consistency of the product due to the increased surface area. More importantly,the fineness has caused the excess cracking that has been witnessed on a couple of occassions. This sizing change should be reviewed because feedback from Sales indicates that it is determential to the prodcuts performance in the foundry industry.

RECOMMENDATIONS

The material should be returned for proper disposition. The disposition should depend on a review of the product grain sizing change.

Tom Beals

TB/f
Attachment

PLAINTIFF'S EXHIBIT tabbies WV-012517

PLAINTIFF'S EXHIBIT tabbies 70060.00

CE0311858

CE/HI (Q) 44174

TABLE I

Sample Test Results Compared to Specifications

	Sample	Typical Data
Moisture (%)	18.0	-
Penetration (1/10 mm)	46.5	= 175 - 200
Screen Analysis Mesh (U S Std)		
20	3.7	5.3
40	3.1	3.5
60	3.7	5.2
100	5.8	7.0
-100	83.7	79.0