MANUFACTURING SPECIFICATIONS

~~MANVILLE~~ PLANT

RIGID SHINGLES DEPT.

PRODUCT: Smoothgrain Asbestos Siding Shingles

DIVISION BP

SPEC. NO. RS-7

PAGE NO. 1

423

PRODUCTS:

by [illegible] 4/14/50

Colors	Style	Texture
Heather Green	105-109-117	Smoothgrain Permatone
Autumn Brown	105-109-117	Smoothgrain Permatone
Silver Gray	105-109-117	Smoothgrain Permatone

FORMULA:

Spec. No.	Material	Lbs.	%
-	6D20 Fibre	300#	20%
P.S. 61281	J. M. Special Silica Flour	300	20
P.S. 61 or 61.2	Ground Siding Shingle or Corr. Transite Scrap	450	30
P.S. 61061	Portland Cement St'd. Atlas	470	30
		1520#	100%

NOTE: 6D20 Fibre is considered standard. 6D18 and 6D22 Fibres may be used either 100% or in blends when necessary.

Total Scrap shall not exceed 450 lbs. or 30% of the total batch. At least 78% of the Scrap must be ground Siding Shingles or its equivalent. The remainder may be Mastic Sand, Limestone Dust, Limestone Aggregate, Ground Trap Rock or Graystone.

Up to 50 lbs. of material from the Dust Collectors and/or 50 lbs. of machine drop from the same or other machines producing similar stock may be added to the base.

Proportionately smaller batches may be made as necessary dependent on equipment capacity.

RETURN TO J-M RESEARCH FILE ROOM

PAPER PIPE [illegible] MAR 27 1950

PLAINTIFF'S EXHIBIT JM-2468

MT-000475

X— INDICATES CHANGE — REASON: To establish a separate Specification for Smoothgrain Shingles.

AUTHORITY FOR CHANGE — Research 423-PP-1 Smoothgrain Permatone Siding 1-4-50.

FILE-HOLDERS	Ind.Eng.		Wkg.		SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DIR. QUAL. CONTROL

SUPERSEDES: Page 1 of Specification RS-1 dated 2-24-50.

DATE ISSUED MAR 24 1950

RM 80182-10 NTED IN U.S.A.

MANUFACTURING SPECIFICATIONS

~~MANVILLE~~ PLANT

~~RIGID SHINGLES~~ DEPT.

PRODUCT: Smoothgrain Asbestos Siding Shingles 4x3

DIVISION BP

SPEC. NO. RS-7

PAGE NO. 1

CANCELLED 9/8/50

PRODUCTS:

Colors	Style	Texture
Heather Green	105-109-117	Smoothgrain Permatone
Autumn Brown	105-109-117	Smoothgrain Permatone
Silver Gray	105-109-117	Smoothgrain Permatone
X Weathered Gray	105-109-117	Smoothgrain Permatone

FORMULA:

Spec. No.	Material	Lbs.	%
-	6D20 Fibre	300#	20%
P.S. 61281	J. M. Special Silica Flour	300	20
R.S. 61 or 61.2	Ground Siding Shingle or Corr. Transite Scrap	450	30
P.S. 61061	Portland Cement Std. Atlas	470	30
		1520#	100%

NOTE: 6D20 Fibre is considered standard. 6D18 and 6D22 Fibres may be used either 100% or in blends when necessary.

Total Scrap shall not exceed 450 lbs. or 30% of the total batch. At least 78% of the Scrap must be ground Siding Shingles or its equivalent. The remainder may be Mastic Sand, Limestone Dust, Limestone Aggregate, Ground Trap Rock or Graystone.

Up to 50 lbs. of material from the Dust Collectors and/or 50 lbs. of machine drop from the same or other machines producing similar stock may be added to the base.

Proportionately smaller batches may be made as necessary dependent on equipment capacity.

PAPER PULP BOARD RESEARCH
APR 17 1950
G.B.F.

RECEIVED
APR 18 1950
RESEARCH LABORATORY

RETURN TO J-M RESEARCH FILE ROOM

X— INDICATES CHANGE — REASON: To add Weathered Gray Permatones to the Line.

AUTHORITY FOR CHANGE - Letter H. R. Congdon to W. F. Fischer 3-28-50.

MT-000474

FILE-HOLDERS					SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DIR. QUAL. CONTROL
	Ind.Eng.		Mkg.					✓		

SUPERSEDES: Page 1 of same Spec. issued 3-24-50.

DATE ISSUED APR 14 1950

M 50132-10
NTED IN U.S.A.

MANUFACTURING SPECIFICATIONS	PRODUCT:	SPEC. NO.
MANVILLE PLANT	DIVISION BP	RS-7
RIGID SHINGLES DEPT.	Smoothgrain Asbestos Siding Shingles F-23	PAGE NO. 1

SEP 11 1950 G.E.
CANCELLED

PRODUCTS:

Colors	Style	Texture
Heather Green	105-109-117	Smoothgrain Permatone
Autumn Brown	105-109-117	Smoothgrain Permatone
Silver Gray	105-109-117	Smoothgrain Permatone
Weathered Gray	105-109-117	Smoothgrain Permatone

RETURN TO J-M RESEARCH FILE ROOM

FORMULA:

Spec. No.	Material	Lbs.	%
-	6D20 Fibre	300#	20%
P.S. 61281	J. M. Special Silica Flour	300	20
R.S. 61 or 61.2	Ground Siding Shingle or Corrugated Transite Scrap	450	30
P.S. 61061	Portland Cement Std. Atlas	470	30
		1520#	100%

X NOTE: 6D20 Fibre is considered standard. Munro 6 Grade Fibre may be substituted for Dan 6D20 on a pound for pound basis up to a proportion of one-third of the total fibre content of the base mix. In addition 6D18 and 6D22 Fibres may be used either 100% or in blends when necessary as a substitute for straight 6D20 Fibre.

Total Scrap shall not exceed 450 Lbs. or 30% of the total batch. At least 78% of the Scrap must be ground Siding Shingles or its equivalent. The remainder may be Mastic Sand, Limestone Dust, Limestone Aggregate, Ground Trap Rock or Graystone.

Up to 50 Lbs. of material from the Dust Collectors and/or 50 Lbs. of machine drop from the same or other machines producing similar stock may be added to the base.

Proportionately smaller batches may be made as necessary dependent on equipment capacity.

MT-000473

RECEIVED SEP 11 1950

X— INDICATES CHANGE — REASON Add alternate use of Munro 6 Fibre Ed. Re Specification.

AUTHORITY FOR CHANGE — Product Proposal 423-8 Summarized 8/21/50.

FILE-HOLDERS	Ind. Eng.	Wkg.		SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DIR. QUAL. CONTROL

SUPERSEDES: Page 1 of same Spec. issued 4-14-50.

DATE ISSUED SEP 8 1950

RM 50132-10 NT

MANUFACTURING SPECIFICATIONS

MANVILLE PLANT

RIGID SHINGLES DEPT.

PRODUCT: Smoothgrain Asbestos Siding Shingles

DIVISION EP

SPEC. NO. RS-7

PAGE NO. 1

PAPER PIPE BOARD ASSN. RC JAN 15 1951 G.B.

CANCELLED 2/20/53

PRODUCTS:

	Colors	Style	Texture
	Heather Green	105-109-117	Smoothgrain Permatone
	Autumn Brown	105-109-117	Smoothgrain Permatone
	Silver Gray	105-109-117	Smoothgrain Permatone
	Weathered Gray	105-109-117	Smoothgrain Permatone
X	Permatone White	105-109-117	Smoothgrain Permatone

FORMULA:

Spec. No.	Material	Lbs.	%
-	6D20 Fibre	300#	20%
P.S. 61281	J.M. Special Silica Flour	300	20
R.S. 61 or 61.2	Ground Siding Shingle or Corrugated Transite Scrap	450	30
P.S. 61061	Portland Cement Std. Atlas	470	30
		1520#	100%

NOTES: 6D20 Fibre is considered standard. Munro 6 Grade Fibre may be substituted for Dan 6D20 on a pound for pound basis up to a proportion of one-third of the total fibre content of the base mix. In addition 6D18 and 6D22 Fibres may be used either 100% or in blends when necessary as a substitute for straight 6D20 Fibre.

Total Scrap shall not exceed 450 lbs. or 30% of the total batch. At least 78% of the Scrap must be ground Siding Shingles or its equivalent. The remainder may be Mastic Sand, Limestone Dust, Limestone Aggregate, Ground Trap Rock or Graystone.

Up to 50 lbs. of material from the Dust Collectors and/or 50 lbs. of machine drop from the same or other machines producing similar stock may be added to the base.

Proportionately smaller batches may be made as necessary dependent on equipment capacity.

RETURN TO J-M RESEARCH FILE ROOM

RECEIVED JAN 3 1951

X— INDICATES CHANGE — REASON: Add Permatone White to the Line.

AUTHORITY FOR CHANGE — Product Proposal 423-12

FILE-HOLDERS	Ind.Eng.	Wkg.		SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DIR. QUAL. CONTR

SUPERSEDES: Page 1 of same Spec. issued 9/8/50

DATE ISSUED JAN 12 1951

M 50132-10 NTED IN U.S.A.

MANUFACTURING SPECIFICATIONS

WAUKEGAN PLANT

RIGID SHINGLES DEPT.

PRODUCT: Smoothgrain Siding Shingles

DIVISION BP

SPEC. I

PAGE I

1

Products: Smoothgrain Permatones - All Styles - All Colors

FORMULAS "B" Type

CANCELLED 6/30/58

Formula No.	1	2	3	4	5	6	7	8
6D20 Fibre *	300	300	300	300	300	300	300	300
Portland Cement	501	501	501	501	501	501	501	501
Silica Flour	333	333	333	333	333	333	333	333
Shingle Scrap (Note 1, 2)	550	525	500	475	450	425	400	375
Min. Batch Weight	1684	1659	1634	1609	1584	1559	1534	1509
Other Scrap (Note 3)	100	125	150	175	200	225	250	275

NOTES:

1: (a) Shingle Scrap should be blended 1 part normal cured to 2 parts steam cured.

From 0 to 100 lbs. of the Shingle Scrap may be replaced by any of the following approved Mineral Fillers: Mastic Filler, Limestone Dust, Limestone Aggregate, Ground Trap Rock, Graystone and Transite Pipe Scrap and Rock Wool Shot.

X When surplus fibre is used in the base furnish of 100 Series Shgls., an additional 104# (total of 204#) of Dolomite may be used to replace Shingle Scrap.

(b) Rock Wool Shot must be introduced at the Shingle Scrap grinders and must be evenly distributed throughout the scrap.

2: At Waukegan Plant, when the Fiberizer is in operation, an additional 100# of Shingle Scrap may be added to the formulas above.

3: (a) Wet Machine Scrap, Corrugated Transite Scrap or Transite Pipe Scrap may be added to the formula bove up to the amounts shown.

(b) Also up to 75# of material from the Dust Collectors and/or 75# of Machine Drop from the same or other machines producing similar stock may be added to the above formulas.

Caution: The use of scrap should be planned so that it will not be necessary to shift more than two successive formulas at any time. Violent shifts should not be made.

* 6DAX-2498 Fibre may be used as an alternate in all base formulas. It is to be used on the basis of a lb. for lb. replacement for both 6D20 Fibre and 6D20 Surplus Fibre.

X— INDICATES CHANGE — REASON: To show additional use of Dolomite

AUTHORITY — FOR CHANGE Prod. Prop. 041-49

MT-000477

FILE-HOLDERS	Ind. Eng.	Foreman	Insp. Supv.	Lab.	Manville	SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DI QU CON

SUPERSEDES:

DATE ISSUE

RETURN TO J-M RESEARCH FILE ROOM

MANUFACTURING SPECIFICATIONS

WAUKEGAN PLANT

RIGID SHINGLES DEPT.

PRODUCT: Smoothgrain Siding Shingles

DIVISION 13

SPEC. RS-F-2

PAGE 1

Products: Smoothgrain Permatones - All Styles - All Colors

OBSOLETE 2/11/57

FORMULAS "B" Type

Formula No.	1	2	3	4	5	6	7	8
6D20 Fibre *	300	300	300	300	300	300	300	300
Portland Cement	501	501	501	501	501	501	501	501
Silica Flour	333	333	333	333	333	333	333	333
Shingle Scrap (Note 1, 2)	550	525	500	475	450	425	400	375
Min. Batch Weight	1684	1659	1634	1609	1584	1559	1534	1509
Other Scrap (Note 3)	100	125	150	175	200	225	250	275

NOTES:

1: (a) Shingle Scrap should be blended 1 part normal cured to 2 parts steam cured.

From 0 to 100 lbs. of the Shingle Scrap may be replaced by any of the following approved Mineral Fillers: Mastic Filler, Limestone Dust, Limestone Aggregate, Ground Trap Rock, Graystone and Transite Pipe Scrap and Rock Wool Shot.

X When surplus fibre is used in the base furnish of 100 Series Shgls., an additional 50# (total of 150#) of Dolomite may be used to replace Shingle Scrap.

(b) Rock Wool Shot must be introduced at the Shingle Scrap grinders and must be evenly distributed throughout the scrap.

2: At Waukegan Plant, when the Fiberizer is in operation, an additional 100# of Shingle Scrap may be added to the formulas above.

3: (a) Wet Machine Scrap, Corrugated Transite Scrap or Transite Pipe Scrap may be added to the formula bove up to the amounts shown.

(b) Also up to 75# of material from the Dust Collectors and/or 75# of Machine Drop from the same or other machines producing similar stock may be added to the above formulas.

Caution: The use of scrap should be planned so that it will not be necessary to shift more than two successive formulas at any time. Violent shifts should not be made.

* 6DAX-2498 Fibre may be used as an alternate in all base formulas. It is to be used on the basis of a lb. for lb. replacement for both 6D20 Fibre and 6D20 Surplus Fibre.

X—INDICATES CHANGE — REASON: To show additional use of Dolomite

MT-000478

AUTHORITY — FOR CHANGE: H. R. Congdon's letter of 9-8-55 to F. M. Armstrong

FILE-HOLDERS	Ind. Eng.	Foreman	Insp.Supv.	Lab.	Manville	SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DIR. QUAL CONTR.

SUPERSEDES: Page 1 of same spec. issued 4-20-55 & appeals Dec. 5-31

DATE ISSUED

RETURN TO J-M RESEARCH FILE ROOM

MANUFACTURING SPECIFICATIONS

WAUKEGAN PLANT

RIGID SHINGLES DEPT.

PRODUCT: Smoothgrain Siding Shingles

DIVISION

SPEC. RS-F-2

PAGE 1

APR 27 1955

CANCELLED 4/19/56

Products: Smoothgrain Permatones - All styles - All colors

Formulas

"B" Type

Formula No.	1	2	3	4	5	6	7	8
6D20 Fibre *	300	300	300	300	300	300	300	300
Portland Cement	501	501	501	501	501	501	501	501
Silica Flour	333	333	333	333	333	333	333	333
Shingle Scrap (Note 1, 2)	550	525	500	475	450	425	400	375
Min. Batch Weight	1684	1659	1634	1609	1584	1559	1534	1509
Other Scrap (Note 3)	100	125	150	175	200	225	250	275

Notes:

1: (a) Shingle Scrap should be blended 1 part normal cured to 2 parts steam cured

From 0 to 100 lbs. of the Shingle Scrap may be replaced by any of the following approved Mineral Fillers: Mastic Filler, Limestone Dust, Limestone Aggregate, Ground Trap Rock, Greystone and Transite Pipe Scrap and Rock Wool Shot.

(b) Rock Wool Shot must be introduced at the Shingle Scrap grinders and must be evenly distributed throughout the scrap.

2: At Waukegan Plant, when the Fiberizer is in operation, an additional 100# of Shingle Scrap may be added to the formulas above.

3: (a) Wet Machine Scrap, Corrugated Transite Scrap or Transite Pipe Scrap may be added to the formula above up to the amounts shown.

(b) Also up to 75# of material from the Dust Collectors and/or 75# of Machine Drop from the same or other machines producing similar stock may be added to the above formulas.

Caution: The use of scrap should be planned so that it will not be necessary to shift more than two successive formulas at any time. Violent shifts should not be made.

X * 6DAX-2498 Fibre may be used as an alternate in all base formulas. It is to be used on the basis of a lb. for lb. replacement for both 6D20 Fibre and 6D20 Surplus Fibre.

RETURN TO J-M RESEARCH FILE ROOM

X— INDICATES CHANGE — REASON: Show new alternate fibre designation

AUTHORITY — FOR CHANGE: E. R. Congdon's letter of 4-5-55

MT-000479

FILE-HOLDERS	Co-Or. Ind. Eng.	Foreman	Insp.Supv.	Lab.	Manville	SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	D. QU CON

DATE ISSU

MANUFACTURING SPECIFICATIONS

PLANT

DEPT.

PRODUCT:

DIVISION

SPEC.

PAGE

4-3

CANCELLED 4/20/55

PIPE AND BOARD DEPARTMENT APR 1955

X	*	300	3[illegible]	5[illegible]	[illegible]				
		500	50.	50[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
		535	535	3[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
	(Note 1 & 2)	530	53[illegible]	50[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
		1384	63[illegible]	1[illegible]	1[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
	(Note 3)	100	12[illegible]	12[illegible]	1[illegible]	[illegible]	[illegible]	[illegible]	[illegible]

(1) Shingle Scrap should be blended 1 part scrap with 2 parts virgin stock.

From 0 to 100 lbs. of the Shingle Scrap may be replaced by the following approved Natural Mineral Fillers: [illegible] Glass Filaments Aggregate, Ground Asbestos Fibre, Granular Cork, Shredded Cork Scrap and Deep Vein Slate.

(2) Wood Pulp Sheet must be incorporated in the Shingle Scrap and must be evenly distributed throughout the scrap.

(3) As Newsprint plant uses two Fibrators in its operation, [illegible] 100% of Shingle Scrap may be added to the formula of the [illegible]

(4) [illegible] Scrap, Unprinted Turnips Scrap or Unprinted [illegible] may be added to the regular Waste Scrap to the [illegible]

(5) [illegible] up to 75% of Newsprint from the Mass Collectors only [illegible] Shingle Scrap from the [illegible] or other machines producing Shingle Scrap [illegible] to the above formulae.

Caution: The use of scrap should be planned so that it will not be necessary to shift more than 2 successive formulas at any time. Violent shifts should not be made.

X * 6DAX-2474M Fibre may be used as an alternate in all base formulae. It is to be used on the basis of a lb. for lb. replacement for both 6D20 Fibre and 6P20 Surplus Fibre.

RETURN TO J-M RESEARCH FILE ROOM

X—INDICATES CHANGE — REASON Show new alternate fibre

AUTHORITY FOR CHANGE H.R.Congdon's wire of 3-24-55

MT-000480

FILE-HOLDERS					SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DI QU. CON:

SUPERSEDES: 9-23-54 & cancels Demo. 4-63 & [illegible] DATE ISSUE

MANUFACTURING SPECIFICATIONS

WAUKEGAN DEPT.

RIGID SHINGLES PLANT

PRODUCT: Smoothgrain Siding Shingles

DIVISION BP

SPEC. N RS-F-2

PAGE N 1

CANCELLED 9/22/54 JR3

PIPE AND BOARD DEPARTMENT JUN 21 1954 C. S. BROWN

Products:

Smoothgrain Permatones - All styles - All colors

Formulas:

"B" Type

Formula No.	1	2	3	4	5	6	7	8
6D20 Fibre	300	300	300	300	300	300	300	300
Portland Cement	501	501	501	501	501	501	501	501
Silica Flour	333	333	333	333	333	333	333	333
Shingle Scrap (Note 1 & 2)	550	525	500	475	450	425	400	375
Minimum Batch Weight	1684	1659	1634	1609	1584	1559	1534	1509
Other Scraps (Note 3)	100	125	150	175	200	225	250	275

X Note 1: (a) Shingle Scrap should be blended 1 part normal cured to 2 parts steam cured.

From 0 to 100 lbs. of the Shingle Scrap may be replaced by any of the following approved Mineral Fillers: Mastic Filler, Limestone Dust, Limestone Aggregate, Ground Trap Rock, Greystone and ground (small size) Transite Pipe Scrap and Rock Wool Shot.

(b) Rock Wool Shot must be introduced at the Shingle Scrap grinders and must be evenly distributed throughout the scrap..

Note 2: At Waukegan plant when the Fiberizer is in operation, an additional 100# of Shingle Scrap may be added to the formulas above.

Note 3: (a) Wet Machine Scrap, Corrugated Transite Scrap, or Transite Pipe Scrap (large size) may be added to the formula above up to the amounts sho

(b) Also up to 75# of material from the Dust Collectors and/or 75# of Machine Drop from the same or other machines producing similar stock may be added to the above formulas.

Caution: The use of scrap should be planned so that it will not be necessary to shift more than 2 successive formulas at any time. Violent shifts should not be made.

MT-000481

RETURN TO J-M RESEARCH FILE ROOM

X—INDICATES CHANGE — REASON: Correction

AUTHORITY — FOR CHANGE H. R. Congdon's letter of 6-4-54

FILE-HOLDERS	Co-Or.	Ind. Eng.	Foreman	Insp.Supv.	Lab.	Manville	SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DI QU CON

SUPERSEDES Page 1 of same spec. issued 5-5-54 & cancels Dovs. 4-26 & 4-30 DATE ISSUE

MANUFACTURING SPECIFICATIONS

WAUKEGAN DEPT.

RIGID SHINGLES PLANT

PRODUCT: Smoothgrain Siding Shingles DIVISION BP

SPEC. RS-F-

PAGE 1

4 v 3

CANCELLED 6/19/54

PIPE AND BOARD DEPARTMENT JUN 23 1954 ... B. BROWN

Products:

Smoothgrain Permatones - All styles - All colors

Formulas:

"B" Type

Formula No.		2	3	4	5	6	7	8
6D20 Fibre	300	300	300	300	300	300	300	300
Portland Cement	501	501	501	501	501	501	501	501
Silica Flour	333	333	333	333	333	333	333	333
Shingle Scrap (Note 1 & 2)	550	525	500	475	450	425	400	375
Minimum Batch Weight	1684	1659	1634	1609	1584	1559	1534	1509
Other Scraps (Note 3)	100	125	150	175	200	225	250	275

X Note 1: **Shingle scrap should be blended 1 part normal cured to 2 parts steam cured. Rock Wool shot, evenly distributed onto conveyor belt, may be used as alternate filler, up to 20% of the shingle scrap.**

From 0 to 100 lbs. of the shingle scrap may be replaced by approved mineral fillers. Ground (small size) Transite Pipe scrap shall be classed as mineral filler.

Note 2: At Waukegan plant when the Fiberizer is in operation an additional 100# of shingle scrap may be added to the Formulas above.

Note 3: (a) Wet Machine scrap, Corrugated Transite scrap, or Transite Pipe scrap (large size) may be added to the Formula above up to the amounts shown.

(b) Also up to 75 lbs. of material from the Dust Collectors and/or 75 lbs. of Machine Drop from the same or other machines producing similar stock may be added to the above formulas.

Caution: The use of scrap should be planned so that it will not be necessary to shift more than 2 successive formulas at any time. Violent shifts should not be made.

RETURN TO J-M RESEARCH FILE ROOM

MT-000482

X—INDICATES CHANGE — REASON: **To show Rock Wool shot as alternate filler**

AUTHORITY FOR CHANGE: Product Proposal 440-PP-302

FILE-HOLDERS	Ind. Eng.	Foreman	Insp. Supv.	Lab.	Manville	SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DI QU CON

SUPERSEDES: DATE ISSUE

MANUFACTURING SPECIFICATIONS

WAUKEGAN DEPT.

RIGID SHINGLES PLANT

PRODUCT: Smoothgrain Siding Shingles DIVISION BP

SPEC. RS-F-4

PAGE 1 1.

423

CANCELLED 5/5/54

Products:

Smoothgrain Permatones - All styles - All colors

Formulas:

"D" Type

Formula No.		2	3	4	5	6	7	8
GD20 Fibre	300	300	300	300	300	300	300	300
Portland Cement	501	501	501	501	501	501	501	501
Silica Flour	333	333	333	333	333	333	333	333
Shingle Scrap (Note 1 & 2)	550	525	500	475	450	425	400	375
Minimum Batch Weight	1684	1659	1634	1609	1584	1559	1534	1509
Other Scraps (Note 3)	100	125	150	175	200	225	250	275

Note 1: Shingle scrap should be blended 1 part normal cured to two parts steam cured.

From 0 to 100 lbs. of the shingle scrap may be replaced by approved mineral fillers. Ground (small size) Transite Pipe scrap shall be classed as mineral filler.

Note 2: At Waukegan plant when the Fiberizer is in operation an additional 100# of shingle scrap may be added to the Formulas above.

Note 3: (a) Wet Machine scrap, Corrugated Transite scrap, or Transite Pipe scrap (Large size) may be added to the Formula above up to the amounts shown.

(b) Also up to 75 lbs. of material from the Dust Collectors and/or 75 lbs. of Machine Drop from the same or other machines producing similar stock may be added to the above formulas.

Caution: The use of scrap should be planned so that it will not be necessary to shift more than 2 successive formulas at any time. Violent shifts should not be made.

PIPE AND BOARD DEPARTMENT APR 15 1953 G. B. BROWN

RETURN TO J-M RESEARCH FILE ROOM

X— INDICATES CHANGE — REASON: To show standard shingle formulas

MT-000483

AUTHORITY FOR CHANGE: 423-PP-13 F. R. Congdon's letter dated 1-16-53

FILE-HOLDERS: Ind. Eng. | Foreman | Insp. Serv. | Lab. | Manville | SUPR. QUAL. CONTROL | PROD. SUPT. | PLANT FINANCE OFFICE | RESEARCH LAB. | MGR. QUAL. CONTROL | CO.

SUPERSEDES: Pages 1 and 2 of spec RS-SS-1 dated 12-22-50

DATE ISSU

MANUFACTURING SPECIFICATIONS

WAUKEGAN DEPT.

RIGID SHINGLES PLANT

PRODUCT: Smoothgrain Siding Shingles

DIVISION BP

SPEC. RS-F-2

PAGE 1

CANCELLED 4v3 4/29/54

PIPE AND BOARD DEPARTMENT SEP 29 1954 J. B. BROWN

Products:

Smoothgrain Permatones - All styles - All colors

Formulas:

"B" Type

Formula No.	1	2	3	4	5	6	7	8
6D20 Fibre	300	300	300	300	300	300	300	300
Portland Cement	501	501	501	501	501	501	501	501
Silica Flour	333	333	333	333	333	333	333	333
Shingle Scrap (Note 1 & 2)	550	525	500	475	450	425	400	375
Minimum Batch Weight	1684	1659	1634	1609	1584	1559	1534	1509
Other Scraps (Note 3)	100	125	150	175	200	225	250	275

Note 1: (a) Shingle Scrap should be blended 1 part normal cured to 2 parts steam cured.

x From 0 to 100 lbs. of the Shingle Scrap may be replaced by any of the following approved Mineral Fillers: Mastic Filler, Limestone Dust, Limestone Aggregate, Ground Trap Rock, Greystone and Transite Pipe Scrap and Rock Wool Shot.

(b) Rock Wool Shot must be introduced at the Shingle Scrap grinders and must be evenly distributed throughout the scrap.

Note 2: At Waukegan plant when the Fiberizer is in operation, an additional 100# of Shingle Scrap may be added to the formulas above.

Note 3: (a) Wet Machine Scrap, Corrugated Transite Scrap, or Transite Pipe Scrap

x may be added to the formula above up to the amounts shown

(b) Also up to 75# of material from the Dust Collectors and/or 75# of Machine Drop from the same or other machines producing similar stock may be added to the above formulas.

Caution: The use of scrap should be planned so that it will not be necessary to shift more than 2 successive formulas at any time. Violent shifts should not be made.

MT-000484

RETURN TO J-M RESEARCH FILE ROOM

X—INDICATES CHANGE — REASON Small and large Transite Pipe scrap now interchangeable.

AUTHORITY FOR CHANGE H. R. Congdon's letter of 8-5-54.

Co-Op. FILE-HOLDERS	Ind. Eng.	Foreman	Insp.Supv.	Lab.	Manville	SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DI QU/ CONT

SUPERSEDES: Page 1 of same spec. issued 6/18/54 & cancelled Date 4-29-54 DATE ISSUED

COPY FORM		INITIALS	DATE
			12/3/2002

BOX NUMBER	SEGMENT NO.	REQUESTING PARTY
P-462		Baron & Budd

NOTES