



INTERNAL CORRESPONDENCE

UNION CARBIDE PLASTICS COMPANY

RIVER ROAD, ROUND BROOK, NEW JERSEY

To (Name) Mr. G. J. Kuzmak
 Company Union Carbide Corporation
 Location Plastics Division
 Bound Brook, New Jersey

Date October 8, 1964
 Originating Dept. R & D - Applications

Answering letter date

Copy to ~~Mr. D. R. Albright - BB~~
 Mr. F. J. Gallo - BB
 Mr. R. E. Graebert - BB
 Mr. C. F. Martino - BB
 Mr. J. Olszewski - BB
 Mr. P. B. Potter - NY
 Mr. G. Pugliese - BB
 Mr. J. Raffaniello - BB
 Mr. C. J. Smith - BB
 Mr. A. L. Steib - BB
 Mr. P. A. Thomas - BB

Subject *fil* Production Run BMMA-5715

The third production run for BMMA-5715 is scheduled to begin on October 9, 1964, during which time 25,000 pounds of the medium-impact molding material will be produced to fill the requirements for Cutler-Hammer in Milwaukee, Wisconsin.

In order to obtain a more pourable product, I propose to begin the run using the OXX screens (instead of IXX) and blend for 45 minutes in the ribbon blender (instead of the tumbler). The OXX screens will be used to compensate for the fines generated in the blender. If the fines buildup becomes excessive, we will switch back to the IXX screens.

Each load of material put through the ribbon blender will contain 1000 pounds from previously made batch 4 BMMA-5715. Arrangements have been made with Mr. J. Cleveland to accomplish this.

Cutler-Hammer has expressed concern over the "caution label" appearing on our bags. Accordingly, Mr. J. R. Wilkinson has authorized the painting or blanking out of this label on all bags to be used for packaging this and all future materials for Cutler-Hammer (all grade 16).

Lewis D. Fishberg
 Lewis D. Fishberg

LDF:gvc

UCASB00958488

SC-EEI-0760


**UNION
CARBIDE**

INTERNAL CORRESPONDENCE

UNION CARBIDE PLASTICS COMPANY

RIVER ROAD, BOUND BROOK, NEW JERSEY

To (Name) Company Location	Mr. G. J. Kuzmak Plastics Division - UCC Bound Brook, New Jersey	Date November 16, 1964 Originating Dept. Applications R & D - Division 15 Answering letter date	Subject Production Run of <u>BMMA-5715</u>
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Copy to See distribution below.

A "Development Department Request for Use of Production Department Equipment" is being submitted to initiate a production run to make 25,000 pounds of BMMA-5715, Black 25, the new medium impact molding material designed to compete with Durez 1544 and 22532. The material will be made on Unit BA. Cutler-Hammer, in Milwaukee, Wisconsin, has placed an order for this material in a special grade 16.

The manufacturing instructions are attached. During the last run, there was some problem in attaining the required plasticity. For this reason, the glycerol monostearate will be added during the manufacture of the resin instead of at the time of the addition of the other fillers. Experience has shown that, when this was done with other products, a definite improvement in plasticity control resulted. This change in procedure should also give better dispersion of the glycerol monostearate, reducing the smear level which was quite pronounced in the last production batch of BMMA-5715.

As in the previous run, the "caution label" on the bags must be blanked out. Also, each pallet should contain a maximum of 1500 pounds.

LDF:VLK

Lewis D. Fishberg
 Lewis D. Fishberg

Copies to:

~~Mr. D. B. Albright - BB~~
 Mr. F. J. Gallo - BB
 Mr. R. E. Graebert - BB
 Mr. H. E. Kipp - BB
 Mr. C. F. Martino - BB
 Mr. J. Olszewski - BB
 Mr. P. B. Potter - NY
 Mr. G. Pugliese - BB
 Mr. J. Raffaniello - BB
 Mr. C. J. Smith - BB
 Mr. A. L. Steib - BB
 Mr. P. A. Thomas - BB

UCASB00958491



INTERNAL CORRESPONDENCE

UNION CARBIDE PLASTICS COMPANY

To (Name) Mr. G. J. Kuzmak
Company Union Carbide Corporation
Division Plastics Division
Bound Brook, New Jersey

Date January 18, 1965
Originating Dept. Applications - R & D

Answering letter date

Copy to
~~Mr. D. R. Albright - BB~~
Mr. F. J. Gallo - BB
Mr. R. E. Graebert - BB
Mr. H. E. Kipp - BB
Mr. C. F. Martino - BB
Mr. J. Olszewski - BB
Mr. P. B. Potter - NY
Mr. G. Pugliese - BB

COPY
Subject

Production Run of
BMMA-5715 Black 25

Mr. J. Raffaniello - BB
Mr. C. J. Smith - BB
Mr. A. L. Steib - BB
Mr. P. A. Thomas - BB

As a result of the successful evaluation of BMMA-5715 batch 8 at Cutler-Hammer, the customer has placed an order for a truckload quantity of this material, which will include 1500 pounds from a new production batch. Accordingly, a "Development Department Request for Use of Production Department Equipment" is being submitted to cover the production of 25,000 pounds of this material in the special grade 16 for Cutler-Hammer. The material will be made on Unit BA.

The manufacturing instructions are attached. No processing problems are anticipated, since the previous batch (batch 8) was made with no particular difficulties. The preheat latitude of the last batch was found to be considerably improved by using the lowest roll temperatures possible, and by limiting the amount of fines recirculated to 750 pounds per 2000 pound raw mix.

As in the previous run, the "caution label" on the bags must be blanked out. Also, to facilitate handling in the customer's plant, each pallet should contain a maximum of 1500 pounds of material.

L. D. Fishberg
L. D. Fishberg

LDF:cah
Att.

UCASB00958492



INTERNAL CORRESPONDENCE

UNION CARBIDE PLASTICS COMPANY

To (Name) Mr. D. R. Albright Date July 7, 1965
 Company Plastics Division - UCC
 Location Bound Brook, New Jersey Originating Dept Applications - R & D
 Answering letter date
 Copy to See distribution list below Subject Production Run of BMMA-5715 Black 25

On June of 1965, Cutler-Hammer successfully evaluated batches 8 and 11, BMMA-5715 Black 25, on their new Stokes Injectoset press. These batches had previously been approved for use on their standard plunger presses. Accordingly, Cutler has ordered 2 truck-loads of this material to be delivered during the month of July. Since there is not enough in stock to fill these orders, a "Development Department Request for Use of Production Equipment" is being entered to cover the production of 50,000 pounds of material on Unit BA. It is to be made in Grade 16, a plasticity range set up specifically to meet Cutler's requirements.

The manufacturing instructions are attached. Since this is the sixth time this material has been made (Grade 16 only), transfer will be requested at the conclusion of this run for Grades 16 and 18. No particular processing problems are anticipated as long as the specifications for roll temperatures and the amount of fines to be recirculated are adhered to.

As with previous production batches for Cutler, the "caution label" on each bag must be blanked out. Also, each pallet should contain a maximum of 1500 pounds of material.

LDF:bcm
 Attachment

Lewis D. Fishberg
 Lewis D. Fishberg

cc: Mr. F. Bader - BB
 Mr. F. J. Gallo - BB
 Mr. R. E. Graebert - BB
 Mr. H. E. Kipp - BB
 Mr. C. F. Martino - BB
 Mr. L. W. Michalowicz - BB
 Mr. J. Olszewski - BB

Mr. P. B. Potter - NY
 Mr. G. Pugliese - BB
 Mr. J. Raffaniello - BB
 Mr. C. J. Smith - BB
 Mr. A. L. Steib - BB
 Mr. P. A. Thomas - BB

UNION CARBIDE CORPORATION
PLASTICS DIVISION

RIVER ROAD, BRIDGE PLAZA, N. J. 07035

Product No. DMMA 5715

Color BL 25

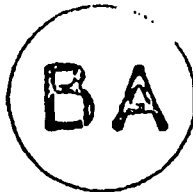
Prepared By L.D. FISHER

Approved By _____

Issue Dated _____

Supersedes - _____
Issue Dated _____

Formula
And
Manufacturing
Instructions



"A" Reel
Blender
Blend for
15
Mins.

Entoleter
Yes No

Tumbler
Blend for

Mins.

"B" Reel
Blender
Max. Hold
1
Hrs.

Cutter
Screens
3/8"

Rotex
Screens
10M/1XX

Reel
Blender
Blend for
45
Mins.

Charge Rolls

Rolling Cycle
40/40

Front
Temp. Max.

150°F

Back
Temp. 60°F
Variation
58 To 62

No. of Cuts 3

Sheet Wgt. 25

Finish Rolls

Rolling Cycle

Front
Temp. Max.

250

Back
Temp. Max.

W

Squeeze Rolls

Front
☐ Water
☒ None

80°F

Back
Temp. Max.

W

Sheet Thick. .110"

Quality Control Tests

See attached sheet

Formula

RM Number	Description	Grade	16	6	9	12	15	18	
RM 5751	(0415411) Two-step resin	1412	835						
RM 46	(4071) Alpha		119						
RM 165	(16036) Wood filler		635						
RM 25A	(25016) Pigment		36						
RM 52C	(52036) Lime		80						
RM 134P	(134166) Poly flock		200						
RM 70B	(10026) Calcium stearate		15						
T.M. 5563	(455636) Ruberite flake (grid free)		80						
	TOTAL		2000 #						
	Re-work fines		750 # (Max)						
RM 1281	(128166) Lithium stearate								
	(blended externally)		1						

TENTATIVE CONDENSED MANUFACTURING INSTRUCTIONS
DEVELOPMENT DEPARTMENT

PRODUCT NO.	BMMA-5715 BK 25
ISSUE NO.	I
DATE	2 September 1965
SUPERSEDES	

HAZARDS TO PERSONNEL, EQUIPMENT, OR MATERIAL: Usual for phenolic molding materials.

MANUFACTURING INSTRUCTIONS: In addition to the Formula and Manufacturing Instructions found on the previous pages, the following guides should be observed:

1. Resin specifications: BRN-5351 - 14.0-17.0 CST viscosity.
2. It is imperative that no more than 750 pounds of fines be re-circulated as rework in each 2000 pound mix. Do not put heat on back finish roll. Also the roll temperatures should be held to those specified. These steps will insure that material will have the maximum plunger molding latitude for which it was designed.
3. Change plasticity by varying resin/hexa with wood flour.
4. Insure that Izod impact does not drop below 0.37 minimum. If low, add 1% RM 134P, and subtract from RM 16C.
5. Be sure to blend each tank for 45 minutes to get highest apparent density. Slide on rotex should be pushed all the way in to get proper fines content.
6. Blend through CBS. Drums, bags or gaylords may be used for packing.
7. Special packing requirements for Cutler Hammer: "Caution" label on container must be blanked out. Each pallet should contain a maximum of 1500 pounds.

SIGNED

- 7 -

Lewis D. Fikberg
ORIGINATOR