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PROCESS SPECIFICATION

Attaching Thermal Insulation Sheeting to the Inside of Turbine Sheet Steel Cover Jackets

60-03-60

SUB. DATE	NO.
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/1/54	2

GENERAL: In order to provide supplemental thermal insulation to turbine installations and to prevent the turbine heat from burning the paint from the outside surfaces of turbine sheet steel cover jackets, a sheet insulation lining shall be applied to the inside surfaces of the metal jacket. The detailed procedures necessary to apply the sheet insulation lining are described in this specification.

OPERATIONS:

(1) Fitting Flexible Asbestos Sheet 7791 to Flat Surfaces

(2) Fitting High Temperature Felt 7789 to Curved Surfaces

(3) Applying Adhesive Cement 7792

(4) Applying Sheet Steel Retaining Strips ASTM-A245

(5) Finishing

(1) Fitting Flexible Asbestos Sheet 7791 to Flat Surfaces

Flexible Asbestos Sheet Material 7791, stocked in one inch thick sheets, shall be applied to all flat surfaces and on curved surfaces with radii of 20 inches or more.

Cut sheets on power shears, by hand or power saw. Wherever possible cover an area with one piece of sheeting. Where joints are necessary, fit the pieces in a manner so that all joints will be under retaining strips. Arrange the joints so the retaining strips will, when applied, form as semetrical a frame as practical.

When covering curved surfaces the sheet shall be cut and fitted in such a manner that good contact shall exist between sheet metal and insulation surfaces and between sheet insulation butt joints.

All insulation joints shall be butt joints and fitted in a manner to prevent heat leakage.

(2) Fitting High Temperature Felt 7789 to Curved Surfaces

High Temperature Felt Material 7789, stocked in rolls or strips 1 inch thick, shall be fitted to all curved surfaces with a radii less than 19.5 inches.

Cut sheets by hand or power shears, the material will not saw readily, to fit all curved surfaces, corners and irregular areas.

All insulation joints shall be butt joints and fitted in a manner to prevent heat leakage.

(3) Applying Adhesive Cement 7792

High Temperature Adhesive Cement Material 7792 is stocked

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in drums.

Apply with a stiff bristle brush a thick, generous coating to all inside jacket surfaces to which sheet and felt insulation will be secured.

When all surfaces have been covered with the coating of adhesive, press the various sections of asbestos sheeting or felt into the respective positions for which each section was cut.

The butt joint faces of the Asbestos Sheeting 7791 shall be coated with adhesive Cement 7792 and fitted to produce good joint face contact.

(4) Applying Sheet Steel Retaining Strips ASTM-A245

Cut from 1/8 inch sheet steel material ASTM-A245, strips 1 inch wide to form a framework to secure the insulation to the inside of the jacket.

On curved insulation surfaces, such as corners or rounded sections, shape the strips to conform to the insulation curvature. On flat insulation areas the strips shall be straight.

The strips shall be spaced approximately 12 inches apart in length and width directions on the insulation surfaces or in a manner to form a supporting framework which shall secure and hold firmly the insulation to the inside of the metal jacket. Where strips join or intersect on the surface of the insulation all joints shall be butt joints and all such joints shall be butt welded. Strips shall not be joined by means of lap joints.

At the insulation edges the strips shall be bent at 90° over the insulation edge and the end of the strip shall be butt welded to the inside surface of the sheet metal jacket.

(5) Finishing

When all retaining strips have been welded in place, all exposed edges and joints of the asbestos sheeting and ALL SURFACES AND EDGES of the felt sheeting shall be covered with a thick coating of the 7792 adhesive cement

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The high temperature felt sheeting is soft and loosely packed and will not resist wear or abrasion.

It is necessary therefore that all exposed felt surfaces and edges be given a protective coating of the adhesive cement which produces a hard, wear resisting, heat resisting surface when dry.

W. A. Tucker
Metallurgical Engineering
March 1, 1954

Approved:

[signature], Mgr.
Quality Control

[signature], Mgr.
Metallurgical Engineering

[signature]
Manufacturing Engineer

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Sheet three

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