

MANUFACTURING
SPECIFICATION

TRANSITORY PIPE
ASBESTOS FIBRE BLENDS

SPEC NO.

TR425:1

PAGE NO.

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I. PRODUCTS:

Fibre Blends M-567E, M-568E, and C-209:

M-567E Fibre Blend - For Tube Mandrel Pressure Pipe Products

Material	Lbs.	Willow Batch		Purchase Spec.
		No. of Bags	%	
"A" Hine	350	3 1/2	29.2	
AT-28	250	2 1/2	20.8	
Munro 4Y	300	3	25.0	
6D20	300	3	25.0	
	1200		100.0	
Reprocessed Material	240			
TOTAL	1440			Lbs.

M-568E Fibre Blend - For Swing Arm Mandrel Pressure and Non-Pressure Pipe Products:

Material	Lbs.	Willow Batch		Purchase Spec.
		No. of Bags	%	
"A" Hine	400	4	33.3	
AT-28	250	2 1/2	20.8	
Munro 4Y	350	3 1/2	29.2	
6D20	200	2	16.7	
	1200		100.0	
Reprocessed Material	240			
TOTAL	1440			

C-209 Fibre Blend - For Non-Pressure Pipe Products sizes 2" through 8":

Material	Lbs.	Willow Batch		Purchase Spec.
		No. of Bags	%	
NC-300 Hine	63	1/2	4.7	
AT-28	100	1	7.5	
Munro 4Y	400	4	30.0	
6D20	100	1	7.5	
Reprocessed Material	670		50.3	
TOTAL	1333		100.0	

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II. MANUFACTURING INSTRUCTIONS:

1. Add fibre and reprocessed material to mixer in such quantities as shown in the above formulas.
2. Mix batch for a minimum of 10 minutes before dropping to the willow.
- * 3. Feed material into the willow at a rate not to exceed 3,000 lbs. per hour. It may be necessary to reduce this rate when the hammers of the willow become worn.

X- INDICATES CHANGE — REASON: Substitution of 6D20 for R.I.S.

AUTHORITY FOR CHANGE T. R. Turnbull's letter dated 12/9/58

SUPERSEDES: Page 1 of same specification issued 7/29/58

DIR. Q.C.	MGR. Q.C. 2	SUPR. Q.C.	PROD. SUPT.	PLNT. FIN.	RES. 107	Pipe Plants - 5	DATE ISSUED	1/29/59
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Form 333-2 Ptd. in U.S.A.