

MANUFACTURING SPECIFICATIONS

Transite Pipe DEPT.
Waukegan PLANT

PRODUCT: Transite Pipe, Fibre Blends
and Standard Furnish Batch

DIVISION IP
SPEC. TP-1
PAGE 3

CANCELLED

I. FORMULA 13¹ Machine
A. Fibre Blend

X

Blue - "A" or "S"
Viny EMT
ECHT
L2
LX
6D

A rectangular stamp with a thick black border. Inside, the text "PLAINTIFF'S EXHIBIT" is printed in a bold, sans-serif font. Below this, "CSR-580" is printed in a smaller font. To the left of the text, there is a vertical line and some faint, illegible markings.

-1. -2. or -3 Basis			
M-442		M-440	
Pound	%	Pound	%
200	20	375	31
125	12	166.7	13
125	12	250	20
350	31	250	20
120	11	200	16
150	14	-	-
1070	100	1242.7	100

A circular stamp with the words "DEPT. OF JUSTICE" around the perimeter. In the center, there is a date stamp that reads "JUN 1964".



		M-459 (-1. -2. or -3 Basis)	
		Pound	%
X	Blue "A" or "S"	188	16.5
	Viny EMT	125	11.0
	ECHT	250	22.0
	LX	250	22.0
	L2	200	17.5
	C & G3	62-1/2	5.5
	4	62-1/2	5.5
		1138	100.0



Note: Add 125# Reprocessed per batch -1 blend, 250# per batch -2 blend, 375# per batch -3 blend.

Fibre and scrap shall be thoroughly mixed in the mixer, willow fibre blend at a rate which will insure a proper buoyancy. Batch size may be varied provided batch proportions are maintained.

* C & G are to be substituted up to 10% for blue fibre in M-440 when available. Use ratio of one part C & G3 to one part C & G4. If intermediate steps are utilized, up to 10%, use the same blend number, but D40 is to be advised.

RETURN TO
J-M RESEARCH
FILE ROOM

X- INDICATES REASON: Correction
CHANGE

AUTHORITY— Correction
FOR CHANGE

FILE HOLDERS	1	Myl.	SUP. QUAL. CONTROL	PROD. SUPE.	PLANT FINANCE OFFICE	PLANT QUAL. CONTROL
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SUPERSEDED: Page 3 spec. issued 1-27-54