Manville - Industrial Insulations
June 25, 1958

PLAINTIFF'S EXHIBIT K-1635

R.K. Hoagland
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Manufacturing Specifications
Cements

The Manville Factory has discontinued manufacturing cement products.

Please cancel and remove from your files, the following Manufacturing Specifications:

Mfg. Spec.	Product
CT-10 CANCELLED	304 Asb. Cement
CT-15 CANCELLED	319 Asb. Cement
CT-25 CANCELLED	0352 Asb. Cement
CT-36 CANCELLED	Special 450 Cement for U.S.N.
CT-45 CANCELLED	#678 Semi-Refractory Cement
CT-50 CANCELLED	MX 3808 (For Armstrong Cork) (CT-5)
CT-55 CANCELLED	Asbestile Fibrous Mineral
CT-60 CANCELLED	Asbestoment "S"
CT-4 CANCELLED	301 Cement
CT-5 CANCELLED	302 Cement (CT-50)
CT-35 CANCELLED	450 Cement
CT-40 CANCELLED	500 Insulating Cement
CT-65 CANCELLED	Fil-Insul
CT-70 CANCELLED	Fil-Insul, Type "V"
CT-71 CANCELLED	Fil-Insul, Type "V-10"
CT-75 CANCELLED	Fibrofil
CT-90 CANCELLED	Stove Putty Filler
CT-95 CANCELLED	Superex Cement for Navy
CT-96 CANCELLED	Railway Passenger Car Underflooring
CT-100 CANCELLED	Asbestos Textile Adhesive
CT-101 CANCELLED	Thermobestos Adhesive
CT-105 CANCELLED	Ferrotite Iron Compound
CT-106 CANCELLED	Fireproof Glue
CT-120 CANCELLED	Vitribestos Solution
CT-130:5 CANCELLED	Plastiseal F Cement
CT-115 CANCELLED	Standard Fibrous Adhesive Insulating Products Adhesive

S. Bonet

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DEFENDANT'S EXHIBIT OF-206

[illegible] PLANT

[illegible] DEPT.

[illegible] DIVISION

432

PAGE NO. 1

[illegible]:

CANCELLED

Spec. No.	Material	Batch Weight	Batch Per cent
	Fibre Blend		
-	Amosite Fibre, M-1, D-11 or W-3 or a Combination thereof	850#	85%
-	Danville [illegible] Fibre	150	15
		1000#	100%

Spread Amosite in mixing area approximately 2 feet deep, distribute Danville Fiber over patch, mix roughly and run through crusher once, using 1-1/[illegible] bar space. Package quantities over 1,000#, 18# per Fiber Bag and tie with a 16 ga. Wire Bag Tie. Deliver smaller quantities to basement loose in trucks.

Spec. No.	Finished Product		
[illegible]	Fiber Blend (Above	18#	12.00%
[illegible]	Magnesia Plastic	30	20.00
-	J.M. Sil-O-Cel (Uncalcined)*	91-1/2	61.00
P.S. 6111[illegible]	Ground Bentonite (Grade A)	9	6.00
P.S. 6[illegible]12	Powdered Soap	6 oz.	.25
P.S. 6[illegible]30	Gum Arabic	18 oz.	.75
			100.0%

*Note: Celite [illegible].

[illegible]:

1. [illegible] batch quantities of ingredients into hopper of mixer and mix for 3 minutes.
2. [illegible]
3. [illegible]
4. [illegible]
5. [illegible] Lbs. on tag.
6. Package [illegible].

RETURN TO
J-M RESEARCH
FILE ROOM

X— INDICATES CHANGE — REASON: To show replacement of D-3 by D-11 Amosite.

AUTHORITY — FOR CHANGE: Letter of C. [illegible] to H. J. O'Brien dated 8/12/55.

FILE-HOLDERS		IND. ENGR.	WAUKEGAN CONTROL LAB.	SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB.	MGR. QUAL. CONTROL	DIR. QUAL. CONTROL

SUPERSEDES: [illegible] specification issued 2/28/5[illegible]

DATE ISSUED SEP 16 1955

[illegible] 80132-10
[illegible]NTED IN U.S.A.

PIPE COVERING DEPT.

MANVILLE PLANT

PRODUCT: Superex Cement for Navy

DIVISION —

CT-95

PAGE NO 1

FORMULA:

CANCELLED 8/16/55

X

Spec. No.	Material	Batch Weight	Batch Per cent
	Fibre Blend		
-	Amosite Fibre, M-1, D-3 or W-3 or a Combination thereof	850#	85%
-	Danville 4M28 Fibre	150	15
		1000#	100%

Spread Amosite in mixing area approximately 2 feet deep, distribute Danville Fiber over patch, mix roughly and run through crusher once, using 1-1/2" bar space. Package quantities over 1,000#, 18# per Fiber Bag and tie with a 16 ga. Wire Bag Tie. Deliver smaller quantities to basement loose in trucks.

Spec. No.	Finished Product		
M.S. PC-215	Fiber Blend (Above	18#	12.00%
M.S. MG-2	Magnesia Plastic	30	20.00
-	J.M. Sil-O-Cel (Uncalcined)*	91-1/2	61.00
P.S. 61114	Ground Bentonite (Grade A)	9	6.00
P.S. 63312	Powdered Soap	6 oz.	.25
P.S. 63430	Gum Arabic	18 oz.	.75
			100.0%

*Note: Celite #395A.

J.M. RESEARCH FILE ROOM

MANUFACTURING INSTRUCTIONS:

1. Dump batch quantities of ingredients into hopper of mixer and mix for 3 minutes.
2. Send a 10 lb. sample, taken approximately 1 lb. every 1/2 hour, to Control Laboratory for tests according to Navy Specification #32-C-14-H.
3. Do not ship until approved by Control Laboratory.
4. Package 60 lbs. per burlap bag (used fibre bag).
5. Attach product label T-86 and mark 60 lbs. on tag.
6. Package to meet Navy Specifications 32-C-14-H and 39-P-16-A.

X— INDICATES CHANGE — REASON: To show use of D-3 and W-3 Amosites as alternates.

AUTHORITY — FOR CHANGE: Letter of C. LaGattuta to H.J. O'Brien dated 4/1/52.

FILE-HOLDERS	IND. ENGR.	P. & S.	WAUKEGAN	CONTROL LAB.	SUPR. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB	MGR. QUAL. CONTROL	DIR. QUAL. CONTROL

SUPERSEDES: Same specification issued 6/15/53.

DATE ISSUED FEB 18 1954

FORM 80132-10 PRINTED IN U.S.A.

PIPE COVERING DEPT.
MANVILLE PLANT

Superex Cement for Navy.

CT-95
PAGE NO. 1

Formula:

CANCELLED 2/1.5/54

Spec. No.	Material	Batch Weight	Per cent
	Fibre Blend		
-	M-1 Amosite Fibre	850#	85%
-	Danville 4M28 Fibre	150	15

Spread Amosite in mixing area approx. 2 ft. deep, distribute Danville Fibre over patch, mix roughly and run through crusher once, using 1-1/2" bar space. Package quantities over 1,000#, 15# per Fibre Bag and tie with a 16 ga. Wire Bag Tie. Deliver smaller quantities to basement loose in trucks.

OK JCR 6-22-53

Spec. No.	Finished Product		
M.S. PC-215	Fibre Blend (Above)	18#	12.00%
M.S. MG-2	Magnesia Plastic	30	20.00
-	J-M Sil-O-Cel (Uncalcined) *	91-1/2	61.00
-	Ground Bentonite A	9	6.00
-	Powdered Soap	6 oz.	.25
-	Gum Arabic	18 oz.	.75
			100.00%

X *Note: Celite #395A.

Manufacturing Instructions:

1. Dump batch quantities of ingredients into hopper of mixer and mix for 3 minutes.
2. Send a 10 lb. sample, taken approx. 1 lb. every 1/2 hour, to Control Laboratory for tests according to Navy Specification #32-C-14-E.
3. Do not ship until approved by Control Laboratory.
4. Package 60 lbs. per burlap bag (used fibre bag).
5. Attach product label T-86 and mark 60 lbs. on tag.
6. Packaging to meet Navy Specifications 32-C-14-E and 39-P-16-A.

RETURN TO J-M RESEARCH FILE ROOM

X—INDICATES CHANGE — REASON: To show type Earth being used.

AUTHORITY FOR CHANGE — Additional Information and Clarification.

FILE-HOLDERS		IND. ENGR.	WKS.	P.&S.	SUPV. QUAL. CONTROL	PROD. SUPT.	PLANT FINANCE OFFICE	RESEARCH LAB	MGR. QUAL. CONTROL	DIR. QUAL. CONTROL

SUPERSEDES: Spec. CT-95 (PC-215) issued 11/30/51. DATE ISSUED: JUN 15 1953

FORM 80132-10 PRINTED IN U.S.A.

PIPE COVERING DEPT.
MANVILLE PLANT

PRODUCT: Superex (Cement for Navy. 432

DIVISION 44

PC-215
PAGE NO. #1

Formula:

CANCELLED

Batch

Spec. No.	Material	Weight	Per Cent
	Fibre Blend		
-	M-1 Amosite Fibre	850#	85%
-	Danville 4M28 Fibre	150	15

Spread Amosite in mixing area approx. 2 ft. deep, distribute Danville Fibre over patch, mix roughly and run through crusher once, using 1-1/2" bar space. Package quantities over 1,000#, 15# per Fibre Bag and tie with a 16 ga. Wire Bag Tie. Deliver smaller quantities to basement loose in trucks.

Spec. No.	Finished Product		
M.S. PC-215	Fibre Blend (Above)	18#	12.00%
M.S. MG-2	Magnesia Plastic	30	20.00
-	J-M Sil-O-Cel (Uncalcined)	91-1/2	61.00
-	Ground Bentonite A	9	6.00
-	Powdered Soap	6 oz.	.25
-	Gum Arabic	18 oz.	.75
			100.00%

Manufacturing Instructions:

1. Dump batch quantities of ingredients into hopper of mixer and mix for 3 minutes.
2. Send a 10 lb. sample, taken approx. 1 lb. every 1/2 hour, to Control Laboratory for tests according to Navy Specification #32-C-14-H.
3. Do not ship until approved by Control Laboratory.
4. Package 60 lbs. per burlap bag (used fibre bag).
5. Attach product label T-66 and mark 60 lbs. on tag.
6. Packaging to meet Navy Specifications 32-C-14-H and 39-P-16-A.

X—INDICATES CHANGE — REASON: Corrections and additional information.

AUTHORITY FOR CHANGE — Letter of E.S.Bogart to J.R.Robson dated 11/19/51.

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

SUPERSEDES: Page #1 of same specification issued 3/5/45.

DATE ISSUED NOV 30 1951

Form 80132-10
PRINTED IN U.S.A.

MANVILLE FACTORY PIPE COVERING DEPT.	Superex Cement for Navy	NO. 3	PC-215 PAGE NO. 1

Formula:

CANCELLED

Spec. No.	Material	Batch Weight	%
	Fibre Blend		
-	K-1 Amosite Fibre	850#	85%
-	Manville 4M28 Fibre	150	15

Spread Amosite in mixing area approx. 2 ft. deep, distribute Manville Fibre over patch, mix roughly and run through crusher once, using 1-1/2" bar space. Package quantities over 1000#, 15# per Fibre Bag (P.S. No. 66056) and tie with a 16 ga. Wire Bag Tie (P.S. No. 65109). Deliver smaller quantities to basement loose in trucks.

Spec. No.	Finished Product		
M.S. PC-215	Fibre Blend (Above)	18#	12.00%
-	Magnesia Plastic	90	20.00
-	J-M Sil-O-Cel	91-1/2	61.00
P.S. 61113	Ground Bentonite A	9	6.00
P.S. 63912	Powdered Soap	6 oz.	.25
P.S. 63940	Gum Arabic	18 oz.	.75
			100.00%

Manufacturing Instructions:

1. Dump batch quantities of ingredients into hopper of mixer and mix for 3 minutes.

X 2. Send a 10 lb. sample, taken approx. 1 lb. every 1/2 hour, to Control Laboratory for tests according to Navy Specification #52-C-14 D - 11/2/42 and 52-C-14 G - 11/1/44.

3. Do not ship until approved by Control Laboratory.

For packaging see Packaging Schedules - Dry Cements.

X *Note: Package according to Navy Specifications, 52-C-14-G, and 39P16A.

X- INDICATES CHANGE — REASON: Corrections and additional information

AUTHORITY FOR CHANGE —

FILE-HOLDERS										
	Ind. Eng. Waukegan I & C.				BLDG. DEPT.	LOCAL COST DEPT.	RESEARCH DEPT.	GEN. I. & C. DEPT.	GEN. COST DEPT.	LOCAL I. & C. DEPT.

SUPERSEDES: Same Spec. Issued 5/21/43

DATE ISSUED: MAR 5 1945

Form X-882D 10-43 PRINTED IN U. S. A.

[redacted]

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SUPR. QUAL. CONTROL	
PROD. SUPT.	
PLANT FINANCE OFFICE	
RESEARCH LAB.	✓
MGR. QUAL. CONTROL	
DIR. QUAL. CONTROL	
PLANT MGR.	

DATE _____

NOTICE OF RETURN
TO
MANUFACTURING SPECIFICATION

_____ PLANT

PRODUCT: [illegible]

DIVISION II

SPEC. NO. CP-95

PAGE NOS.

DATES OF ISSUE

DATE OF DEVIATION

IND-829

THIS CANCELS NOTICE OF DEVIATION IDENTIFIED ABOVE. ENTER DATE OF RETURN TO SPECIFICATION AND REMOVE NOTICE OF DEVIATION FROM ACTIVE FILE.

[illegible]

[illegible] Specification [illegible] was formerly numbered [illegible]-215.

RETURN TO
J-M RESEARCH
FILE ROOM

ABC
6/2/53

Form 50199-2 Printed in U.S.A.

SIGNED _____ PROD. SUPT.
E.A. Schermann

[redacted]

DATE OF ISSUE 4/11/52

COPIES TO

SUPR. QUAL. CONTROL
PROD. SUPT.
PLANT FINANCE OFFICE
RESEARCH LAB.
MGR. QUAL. CONTROL
DIR. QUAL. CONTROL
PLANT MGR.
IND. ENGR.
WAUKEGAN
PLANNING & SCHEDULING

NOTICE OF DEVIATION
FROM
MANUFACTURING SPECIFICATION

MANVILLE PLANT 432

PRODUCT: Superex Cement for Navy.

DIVISION IP

SPEC. NO. CT 495 ~~CT 215~~

DEV. NO. IND-829

PAGE NOS.	1				
DATES OF ISSUE	11/30/51				

DATE OF DEVIATION 4/1/52*

TIME OF DEVIATION 7 A.M. _____ P.M.

TYPE OF DEVIATION: ☐ EMERGENCY ☒ AUTHORIZED CHANGE ☐ PLANT SIZE TRIAL

REASON: To use Amosite W-3 or D-3 as a substitute for Amosite M-1 whenever M-1 is not available.

AUTHORITY: Letter of C. LaGattuta to N.J. O'Brien, dated 4/1/52.

STATE: 1. THAT PORTION OF SPECIFICATION FROM WHICH YOU PROPOSE TO DEVIATE.
2. WHAT YOU PROPOSE TO DO INSTEAD.
3. APPROXIMATE DATE YOU EXPECT TO RETURN TO SPECIFICATION, OR WHEN SPECIFICATION WILL BE REVISED.

1. Formula:

2. Change formula as follows whenever M-1 Amosite is not available.

	Specification wt.	Specification %	Deviation wt.	Deviation %
M-1 Amosite Fibre	850#	85%	-	-
D-3 or W-3 Amosite Fibre	-	-	850#	85%
Danville 4M2S Fibre	150	15	150	15
	~~1,000~~	~~100%~~	1,000#	~~100%~~

3. Three months.

*Note: (For matter of record)

Amosite M-1 Fibre has not been available for approximately one year. During this period D-3 and W-3 Amosite have been used.

APR 16 1952

E. R. WILLIAMS

SIGNED R.A. Scharmann
PROD. SUPT.

THIS NOTICE OF DEVIATION CANCELLED BY:

☐ REVISED MANUFACTURING SPECIFICATION ISSUED _____ (DATE)

☐ NOTICE OF RETURN (DATED) _____

RETURN TO J-M RESEARCH FILE ROOM

FORM 50199-1 PRINTED IN U.S.A.