

Mr. Carl
FLINTKOTE

Ravenna Plant
November 8, 1974

STANDARD P/M FURNISH FORMULAS
(For Cost Purposes)

FIBRE BLEND FORMULAS:

Blend No. R-121A for 10' P/M

<u>Fibre</u>	<u>Lbs./ Batch</u>	<u>%</u>
BL-4D	200	15.4
BC-4T	700	53.8
BC-5M	200	15.4
S-Blue	200	15.4
	<u>1300</u>	<u>100.0</u>

Blend No. R-175 for 13' P/M

<u>Fibre</u>	<u>Lbs./ Batch</u>	<u>%</u>
CT	400	30.3
BL-4D	200	15.15
BC-4T	300	22.7
BC-5M	200	15.15
Blue	<u>220</u>	<u>16.7</u>
	<u>1320</u>	<u>100.0</u>

STANDARD PERCENT FIBRE IN FURNISH:

Product

Fibre required
% Blend

Class 100 Pressure Pipe:

4" (10')	17.0	R-121A
6" (10')	15.2	"
8" (10')	14.9	"
8" (13')	14.6	R-175
10"--14" (13')	16.4	"
16" (13')	16.7	"

Class 150 Pressure Pipe:

4"-- 6" (10')	17.0	R-121A
8" (10')	18.1	"
8"--10" (13')	16.7	R-175
12"--14" (13')	17.2	"
16" (13')	17.8	"

Class 200 Pressure Pipe:

4" (10')	17.2	R-121A
6" (10')	18.4	"
8" (13')	18.1	R-175
10" (13')	17.8	"
12" (13')	18.1	"
14"--16" (13')	18.9	"

STANDARD PERCENT FIBRE IN FURNISH:

<u>Product</u>	<u>Fibre required</u>	
	<u>Z</u>	<u>Blend</u>
6"/200 MOA	18.4	R-175
All other MOA's	Same as MEE Pipe.	
<u>Class 1500 Sewer Pipe:</u>		
4"- 8" (10')	12.1	R-121A
10"-16" (13')	13.0	R-175
<u>Class 2400 Sewer Pipe:</u>		
4"- 6" (10')	12.1	R-121A
8" (10')	13.4	"
10"-16" (13')	13.0	R-175
<u>Class 3300 Sewer Pipe:</u>		
4"- 6" (10')	12.1	R-121A
8" (10')	13.4	"
10"-16" (13')	13.0	R-175
<u>Class 4000 Sewer Pipe:</u>		
10"-16" (13')	13.0	R-175
<u>Class 5000 Sewer Pipe:</u>		
10"-16" (13')	13.0	R-175
<u>Pressure Pipe Couplings: *</u>		
3"- 6", all classes	15.2	R-121A
8"-16", all classes	15.2	R-175
*Including HT couplings.		
<u>Sewer Pipe Couplings & Fittings: **</u>		
3"- 6", all classes	14.0	R-121A
8"-16", all classes	14.0	R-175
**Except fittings made from standard pipe stock.		

STANDARD P/M FURNISH FORMULAS.

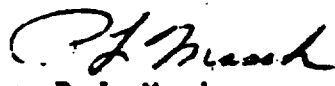
Page 3.

FURNISH BATCH FORMULAS:

<u>Material</u>	<u>Lbs./ Batch</u>
Portland Cement	725
Silica Flour	475
Fibre Blend	See below.

Lbs. Fibre Blend per Furnish Batch:

<u>% Fibre Required</u>	<u>Lbs./ Batch</u>	<u>% Fibre Required</u>	<u>Lbs./ Batch</u>
12.1	165	15.8	225
12.4	170	16.1	230
12.7	175	16.4	235
13.0	180	16.7	240
13.4	185	17.0	245
13.7	190	17.2	250
14.0	195	17.5	255
14.3	200	17.8	260
14.6	205	18.1	265
14.9	210	18.4	270
15.2	215	18.6	275
15.5	220	18.9	280


Prepared by: P. L. Masch

vmy.

c/c W. Carl
D. Gore
J. White

CTD001019