PLAINTIFF'S EXHIBIT FOS-406

FOSECO, INC.

INTER-COMPANY AND INTER-DEPARTMENTAL CORRESPONDENCE

TO: Distribution Below

FROM: G. H. FitzGerald - Quality Control - SMPD

DATE: April 27, 1973

SUBJECT: Critique on Non-Asbestos Production - 4/23 to 2:30 p.m. 4/27/73 by Members of Task Force

Activity: 4/23/73, K-4, EP 5273, #685D Hot Top.

Consensus Remarks:

1. Ran 8 hours, shut down because of concern over fit of boards. Boards taken to mill by Kyle Koepf. Sides fit 5/8 to 1-1/2" below end board. Though unacceptable by present standards, this fit will be tolerated while improvements are being made.

2. Solids began to settle out at end of shift-- poor forming noted. Reason for settling not known by A.S. Recipe was prebatched and pulped under R&D supervision. A.S. has no reason to believe that slurry was misformulated.

3. Analysis of sediment in blow tank - 69.0% SiO_2; L.O.I. 3.0%, theoretical 69.0% and 4.0% respectively, therefore we can assume that there had been no segregation of constituents in the slurry delivery system.

4. Analysis on sedimentation on floor around behind machine - 56.9% SiO_2 - L.O.I. 22.7. Considerable resin must be passing through tool screening.

5. Objective of the run was to produce a lower density product by removing diatomite and substituting pearlite. This goal was achieved: density of product 0.62 - 0.70 compared with 0.86 on EP 5273.

Individual Remarks:

JCM:

1. Tool, blow tank and holding tank plugged with slurry which had settled out. Unable to run P-31 during 2nd or 3rd shift 4/23 or until noon 4/24.

Activity: 4/24 - 4/27, 'B' machine, EP 5273, ##685D Hot top.

Consensus Remarks:

1. Started at 9:00 a.m., very little difficulty in starting up with this recipe.

2. 12 second reduction in cycle time due to reduction in form time.

3. Have run through Wednesday, Thursday and half Friday with increased green scrap; however,number of cycles is good.

Individual Remarks:

JCM:

1. Occasional thick and thin pieces causing increase in green scrap. Normal green scrap in P-31 300-400-lbs./day using 5273B. Tuesday - 955#, Wednesday - 1,110#, Thursday - 800#.

RTC:

1. Traces of same type of sediment around K-4 also found around 'B' machine.

2. Recipe seems to perform better on 'B' due to
   (a) Complete emptying of tankand delivery system during each cycle.
   (b) Better filter cake being formed because dewater takes place differently over 1/2 the tool area and uniformly rather than small area opposite injection holes.
   (c) Boards made on 'B' machine fit ingot acceptably due to difference in machine forming method.

Activity: 4/27, K-4 machine, EP 5273, #685D Hot Top.

1. Cleaned blow tank, form tank, holding tank and examined tool (not plugged).

2. Started at 9:00 a.m., ran 4 stacks, had forming problems - incomplete filling of cavity. At 12:25 agitator in holding tank was discovered not running, probably turned off at lunch break. Tool was cleaned, blow tank cleaned and the form tank cleaned, though not really caked. Agitator was freed and attempted to form again at 3:30 p.m.

3. At 5:30 p.m. holding tank was dumped, cleaned blow tank and new slurry was made supervised by R&D. Immediately began to get good boards through 2nd shift. Began experiencing forming difficulties during 3rd shift. Manually blowing back form tank to holding tank seemed to correct the problem. By 9:00 a.m. Friday, had to stop and clean out blow tank and dumped holding tank. Began forming again with reduced content in holding tank. D. Butler feels that suspension system has an aging characteristic. Since running at such a high solids content increases residence time in holding, reduced volume in holding tank may rectify the problem.

4. Using reduced volume we ran until 2:30 p.m. when poor forming was encountered and the blow tank was found to have caked again with solids. However, the holding tank is not plugged nor is the forming tank. R&D is continuing to run after cleaning out the blow tank.

5. Production will continue to use this procedure through 2nd and 3rd shifts. Discussion with A. Santighian and others must be held on Monday to determine the next step in the program.

Individual Remarks:

B.H.

1. Decreasing the blow back time on Friday morning per A.S. caused forming tank to plug since complete emptying of form tank could not be accomplished in the time allotted.

2. After agitator was turned on and attempts to form were made, noticed that no water was exiting from lower tool during form cycle. Therefore bottom screen must have been blocked and all dewater was taking place through upper tool.

RTC:

1. Recipe on Friday morning was not correct. Excessive laminations were observed.

RTC &BH:

2. Recipe still does not form filter cake. Large areas of tool show no evidence of filter cake, only gross particles trapped against screen.

GHF:mlr:193

Distribution:
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