VICTOR MFG. & GASKET CO. FACTORY STANDARD #311

October 21, 1963

OBSOLETE

J. A. ULRICH

DATE: APR - 9 1968

DEPT. 251

MATLS. DEVEL. LAB.

.055"/.060" MULTICOR VICTOCOR

This Standard covers the manufacture of a high density - .055"/.060" five layer construction Victocor having two core and three facing materials.

MATERIALS:

1. 65# Tin Plate (.007") P. S. #450-3
2. Asbestopac #958 - P. S. #506 - 43-48# Basis Weight (.016")
3. Asbestopac #958 - P. S. #506 - 63-70# Basis Weight (.022")
4. Formula #458-B
5. Formula #458-BT
6. Formula #597 (If specified on Analysis Card)

PROCEDURE

Perforating and Cutting of Core:
Dept. 05

Material #1, slit to the required width, is perforated .030"/.035" and cut to the desired length on Machine #2909 (Minster Press). The variation within one sheet of core should not be more than .003" with no broken punches present.

Inspection of this core should be made 4 to 5 times a shift to insure that the above tolerances are maintained.

Degreasing of Core:
Dept. 06

Cut strips of perforated core are degreased in Dept. 06 using Machine #3148. The core is placed in the baskets provided and allowed to remain 5 minutes in the two compartments and the vapor of this machine.

Cementing and Drying the Core:
Dept. 19

The strips of degreased core are coated with Material #4 using the Union Tool or Francis two roll coating unit. The use of either machine should result in a uniform coating being applied to the core. The coated sheets are racked into the Victocor drying oven (Machine #1354) for drying at 160-170°F.

As the coated and dried sheets emerge from the oven, they should be assembled into the following five layer construction: Material #2 - Cemented Core - Material #3 - Cemented Core - Material #2.

I, John R. Derpack Notary Public in and for County of Cook and State of Illinois do hereby certify that P. Turcsany and James H. Larsen executed and acknowledged this page of laboratory records on October 21, 1963

J. R. Derpack
NOTARY PUBLIC

I, P. Turcsany being first duly sworn, do hereby certify that I typed this page of experimental data on October 21, 1963 the date set forth in the [illegible]

I, James H. Larsen being first duly sworn, do hereby certify that this page of laboratory records was made by me, typed at my [illegible] on October 21, 1963 [illegible] that I have [illegible] this page and that the same is a [illegible] record.

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