

Johns-Manville MANUFACTURING SPECIFICATION	PRODUCT:	PLANT & DIV.	Waukegan BP
	Asbestos Paper for Republic Steel Co.	SPEC NO.	442.1-6
		PAGE NO.	1

1. FORMULA

P.S. No.	Ingredients	Lbs./Batch	Percent
-	5R28 Fibre	2000#	88.5%
62028	Cattle Hair	90	4.0
-	Restigouche Pulp	40 (dry wt. basis)	1.8
63491	Corn Gum	80	3.5
-	Celite #545	50	2.2
Total		2260#	100.0%

NOTE: The quantity of Corn Gum may be varied downward at the discretion of the Supt. or his delegated authority, in order to maintain the Finished Product requirements.

I. MANUFACTURING PROCEDURE

1. Charge the materials, except Celite and Hair, to beater and mix approx. 15 minutes with roll raised. Charge Celite to beater two minutes before dumping. Charge hair last; beat, but do not grind, until mixed, and dump.
2. Use the machine screens.
3. Use 4 primary Bauer Cleaners with inlet pressure of 20 p.s.i. Use 3/4" diameter reject nozzle.
4. By-pass the secondary cleaners.
5. Operate Bauer Refiner with plate setting of approx. 110 mils. Vary as necessary to eliminate fibre pencils and control porosity.
6. Operate with second press raised.
7. Calender with a single nip. Raise top calender roll.
8. Operate white water system to keep retained fines at a minimum.
9. Run material to the following Finished Product requirements:

Lbs./100 sq.ft.	4.3# min., 4.7# des., 5.0# max.
Mullen	9 min., 12 desired
Porosity	130 sec./100 cc max., 120 des.
Moisture	1.5% max at machine
Width	30" $\pm$ 1/16"
Roll Size	45" dia. max., 42" desired

PLAINTIFF'S
EXHIBIT
K-1704

DEFENDANT'S
EXHIBIT

01-276

RETURN TO
J-M RESEARCH
FILE ROOM

X- INDICATES CHANGE — REASON: New Number

AUTHORITY FOR CHANGE New numbering system

SUPERSEDES: Page 1 of PM-27 dated 10-3-57

DIR. Q.C.	MGR. Q.C.	SUPR. Q.C.	PROD. SUPT.	PLNT. FIN.	RES. LAB.	Ind. Engr.	Insp. Supv.	Fore-man	Lab.	DATE ISSUED	JAN 6 1958
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