PLAINTIFF'S EXHIBIT K-1640

[illegible] MANUFACTURING SPECIFICATION	[illegible] #450 Insulating Cement	PLANT [illegible]	Waukegan [illegible]
		[illegible]	[illegible]
		PAGE NO.	[illegible]

I. FORMULA

P.C. No.	PREMIX	NO. OF UNITS	WEIGHT	PERCENT
[illegible]	Bentonite "A"	3 bags	300#	[illegible]
II-3440	#2 Karaya Gum	1 drum - 100#	400	19.05
II-3232	Sodium Nitrite	1 drum	400	19.05
	Duponal Flakes	Part drum	100	4.76
	6D20 Fibre	1 ½ bags	150	7.14
II-3341	Soda Ash	1 ½ bags	150	7.14
II-1450	#50 Blue-Black Slate Dust	10 bags	600	28.58
	TOTAL PREMIX		2100#	100.00%

FINISHED CEMENT

Bentonite "A"	2 bags	200#	22.5
6D20 Fibre	1 ½ bags	150	16.9
#50 Blue-Black Slate Dust	½ bag	30	3.4
Sealtite White Wool *	13 bags	455	51.3
Premix	1 drum	52	5.9
TOTAL BATCH		887#	100.0%

* Richmond batt scrap is an acceptable alternate

II. MANUFACTURING PROCEDURE

A. Mixing Premix (Mix in #111 Mixer)

		Pounds
1.	1 barrel - Sodium Nitrite (screened)	400
2.	1 ½ bags - Soda Ash (weighed & screened)	150
3.	½ bag - 6D20 Fibre	50
4.	Dump lift hoist	
5.	1 bag - Bentonite "A"	100
6.	3 bags - #50 Blue-Black Slate Dust	180
7.	½ bag - 6D20 Fibre	50
8.	100 lbs. - Duponal Flakes (weighed)	100
9.	Dump lift hoist	
10.	1 bag - Bentonite "A"	100
11.	1 drum - #2 karaya gum	300
12.	3 bags - #50 Blue-Black Slate Dust	180
13.	½ bag - 6D20 Fibre (weighed)	50
14.	Dump lift hoist	
15.	1 bag - Bentonite "A"	100
16.	4 bags - #50 Blue-Black Slate Dust	240
17.	100 lbs. - #2 Karaya gum (weighed)	100
18.	Dump lift hoist	
	TOTAL	2100#

DEFENDANT EXHIBIT OE-212

X— INDICATED CHANGE —REASON:	X - Show use of Sealtite White Wool	PLEASE RETURN TO
AUTHORITY FOR CHANGE	S. Lane's enactment letter of 6/13/68	J-M RESEARCH
SUPERSEDES:	Page 1. same spec. issued 8/2/67	LIBRARY (MM)

II. MANUFACTURING PROCEDURE - Continued

A. Mixing Premix (Mix in #111 mixer) - Cont.

19. Mixing Cycle: 5 minutes reverse, 5 minutes forward, 5 minutes reverse.
20. Rotate mixer in original direction and draw off into drums or pails 52 lbs. per drum.

B. Mixing Finished Cement (Mix in #109 mixer)

		No. of Units
1.	6D20 Fibre	½ bag
2.	#50 Blue-Black Slate Dust	1 scoop
3.	Premix	1 scoop
4.	Bentonite "A"	½ bag
5.	Sealtite White Wool	2 bags
6.	#50 Blue-Black Slate Dust	1 scoop
7.	Premix	1 scoop
8.	Bentonite "A"	½ bag
9.	Sealtite White Wool	2 bags
10.	6D20 Fibre	½ bag
11.	#50 Blue-Black Slate Dust	1 scoop
12.	Premix	1 scoop
13.	Sealtite White Wool	2 bags
14.	Premix	1 scoop
15.	#50 Blue-Black Slate Dust	1 scoop
16.	Sealtite White Wool	2 bags
17.	#50 Blue-Black Slate Dust	1 scoop
18.	Bentonite "A"	½ bag
19.	Premix	1 scoop
20.	Sealtite White Wool	2 bags
21.	#50 Blue-Black Slate Dust	1 scoop
22.	6D20 Fibre	½ bag
23.	Premix	1 scoop
24.	Bentonite "A"	½ bag
25.	Sealtite White Wool	2 bags
26.	Premix	1 scoop
27.	#50 Blue-Black Slate Dust	1 scoop
28.	Sealtite White Wool	1 bag

X — INDICATES CHANGE — REASON	X - Show use of Sealtite White Wool	PLEASE RETURN TO
AUTHORITY FOR CHANGE	S. Lane's enactment letter of 6/13/63	J-M RESEARCH
SUPERSEDES	Part of Page 2, same spec. issued 8/1/67	LIBRARY (MM)

[illegible] | [illegible] | [illegible] | [illegible]
[illegible] | [illegible] | [illegible] | [illegible]
[illegible] | #450 Insulating Cement | [illegible] | [illegible]
[illegible] | [illegible] | [illegible] | [illegible]

II. [illegible] - continued

C. [illegible]

1. After all material is in mixer, reverse and mix for five minutes.

2. Reverse mixer and keep rotating constantly during drawing operation.

3. Draw mixture through auger bagger into valve-type paper bags until the net content per bag is 50 lbs. Adjust setting if necessary to obtain correct weight. Weigh at least one (1) bag per batch.

Purchase Spec.	Material
II-9026	Paper bag for #450 Cement

4. Code date per Finished Product Specification. Code is positioned on top part of bag close to the valve.

5. For export shipments, a special waterproof valve type bag is used when so ordered. This special bag is made of burlap and paper plied together with asphalt. (P.S. II-9031)

6. One (1) sample per day will be checked for wet adhesion and density. One (1) sample per week will be submitted to the laboratory for complete tests.

X— INDICATE CHANGE —REASON:	X - Slow code dating procedure	PLEASE RETURN TO
AUTHORITY FOR CHANGE:	Conform to present practices	J-M RESEARCH
SUPERSEDES:	Page 3, same spec. issued 6/1/64	LIBRARY (MM)