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K-321

Produced in camera under seal by order of Judges Paul Riley and Gordon Mesg. October 16, 1989, in Jamison v. A. P. Green, et al. 87-L1230

1/24/78

xcc: Mike Swan Mike/62 Lee Swan Lee/62 Lee

OWENS/CORNING FIBERGLAS

PROCESS SPECIFICATION
QUALITY CONTROL & SPECIFICATION DEPARTMENT

No. AH.518.P.0T.10
Issued ~~March 7, 1977~~
Cancels ~~AH.518.P.13.10~~
Dated ~~November 15, 1974~~

PRODUCT: 935 MA DUCT SYSTEM MASTIC, TYPE II (X-694)

FINAL BATCH FORMULA AS SHIPPED 4/4/78

A. FORMULATION

Ingredients listed in the order of addition.

INGREDIENT	P.A.S.	CHARGE WEIGHT	CHARGE VOLUME
Triple-Blend Solvent*	CRM.59.1.714	2490 lbs.	382 gal.
Parcil 170 HV (85%)	.538	238 lbs.	20½ gal.
Thixcin GR	.661	46½ lbs.	
Water			
Phenolic Resin CKM-1634	.531	225 lbs.	
Titanox RA-50	.472	200 lbs.	
Oncor 23 A	.537	43 lbs.	
MgO Maglite D	.534	33 lbs.	
ZnO Kadox 15	.380	33 lbs.	
Zalba Special	.539	9 lbs.	
Asbestos Chrystolite Shorts 6-01	3.273	210 lbs.	
Hydral 710	.533	110 lbs.	
Pre-React for 30 minutes.			
Neoprene W	CRM.59.1.536	425 lbs. (7 bags + 40 lbs	

* Triple-Blend: Toluene, Lacolene, Hexasol - 6.52 lbs./gal.

B. SAFETY - GENERAL

Operator must wear an air mask and protective clothing when charging the Asbestos. Safety glasses must be worn at all times. Triple-Blend solvent is flammable. Keep all sources of ignition away from the area while charging and mixing the batch.

C. MIXING PROCEDURE

1. Add ingredients to churn in the order listed.

2. Start agitator.

SAFETY

When chargin
bestos, wear
tective clot
and air mask

Triple-Blend
Point is bel
20°F.

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C. MIXING PROCEDURE (continued)

3. Allow batch to "Pre-react" for 30 minutes after adding Hydral 710.
4. Shred the Neoprene W and add it to the other ingredients in the churn.
5. When half of the Neoprene is in, begin putting heat on the churn jacket.
6. Heat to 120-130°F and complete the addition of the Neoprene.
7. Churn the batch until it is free of undissolved Neoprene and the viscosity falls within the specification. This is usually two (2) hours after the temperature reaches 120°F.

D. IN-PROCESS SPECIFICATION

Viscosity:
Brookfield RVT, #6 Spindle, 75°F
10 RPM: 27,000-37,000 cps
20 RPM: 16,000-24,000 cps
30 RPM: 9,000-12,000 cps

E. PACKAGING AND PRODUCT CODES

Package Type	Product Code
12 cartridges/5 gallon pail	40V89021
5 gallon pail	40V89013
4 one-gallon cans per case	40V89005
400 pound drum	40V89048

SAFETY

Keep hatch close

Wear dust mask ; ear plugs.

Prepared by:
Benny Williams
Operations Supervisor

Approved by:
L. C. Hullinger
Chemical Plant Superintendent

C. E. Cummons
Production Supervisor

ph)

Produced in CANADA under seal by order of Judges Paul Riley and Gordon Keep, October 16, 1989, in Canada v. A. J. Green et al. 87-01230

1/24/77 xcc: Miller Swan Wilson/62 xcc Lyon

OWENS/CORNING FIBERGLAS

PROCESS SPECIFICATION
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