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PLAINTIFF'S
EXHIBIT

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The fine-milling question again arose, and this time several improvements and modifications accompanied it. The research laboratories of the Titanium Alloy Manufacturing Company had worked with fine milling and high opacifier additions as far back as 1929. But they had met with the same difficulties as others, namely, spray pattern, tearing and crawling, and bad results because of poor ground coats. Since then, spray guns have been developed that give atomization which enables uniform coatings to be applied as low as 25 gm. per sq. ft. Early in 1938, this idea was again brought to the attention of the enameling industry. Milling went as far as 1% on 325-mesh. High mill additions were made, originally 20%, which dropped back to about 12%. Successful commercial trials were made and many of the "bugs" were ironed out. Sodium-nitrite mill addition was found to give better dry strength and to reduce crawling or tearing tendencies. The addition of opacifiers during the late stages of milling cut the milling costs. It was thought that brushing could be eliminated, but it has been discovered that until ground-coat beading can be eliminated this will not work. The advantages of thinner applications are (1) less enamel is processed per foot of coverage, (2) the enamel is more serviceable from the standpoint of chipping and cracking under flexure and there is less warpage, (3) high gloss and less scumming, (4) more reclaims, and (5) higher saving in costs. Owing chiefly to ground-coat difficulties in many plants, the fineness was gradually raised to 0% on 200-mesh. The present trend is to use a superopaque frit milled to 0% on 200-mesh (about 9 grams on 325-mesh) and to use from 8 to 12% of mill addition. A coating of

about 40 gm. per sq. ft. is applied as compared to the old 72 gm. per sq. ft. There are some plants, however, using normal opaque frits with 6 to 8% of mill addition; others are using superopaque frits with 2 to 4% of mill addition.

VII. Cerium Compounds

In recent years, cerium compounds have been used (especially in Germany) with some success as mill-added opacifiers. These have not as yet received much attention or study in this country. At the present time, there are two general types of mill-addition replacements for tin oxide. One is an antimony-base and the other a zirconium-base opacifier. The latter type is offered to the industry in many versatile forms designed to meet all special requirements.

VIII. Conclusions

In the early days when frits lacked high opacity, the mill addition was chiefly tin oxide varying from 8 to 12%. Then as the normal opaque frits appeared, mill-addition opacifiers dropped usually to 6%, and the tin oxide gradually was replaced with substitute opacifiers. In later years, superopaque enamel frits came into prominence whereby mill additions as low as 2% were used successfully at a normal fineness of 10 to 12 gm. on 200-mesh. More recently, the fine-milled, high opacifier mill addition and lightweight application has come into use. The present trend seems to be swinging definitely toward this idea and with still lighter coats the aim.

TITANIUM ALLOY MANUFACTURING COMPANY
NIAGARA FALLS, NEW YORK

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Overbeck Pottery exhibit in The Society executive offices. The tall vases in the background were made by the late Elizabeth Overbeck, a Fellow of The Society.

(1940)



Artware made by students of the Smith-Hughes Extension Course of West Virginia University, Charles R. Tennant, supervisor (see page 273, July, 1940, Bulletin).

All of the exhibits in the executive offices of The Society are being numbered and labeled as a permanent record for members of The Society.