DANA CORPORATION

VICTOR PRODUCTS DIVISION
FACTORY STANDARD

F. S. #413
March 10, 1976

Supersedes issue of
December 11, 1972

VICTOCOR 150 WITH HOLLINGSWORTH & VOSE FACING

DESCRIPTION: This Factory Standard covers the manufacture of various gauges of VICTOCOR 150 made with Black Plate Steel Low Prong Core and Hollingsworth & Vose ASBESTOPAC 958 facing material.

MATERIALS:
1. .0066" (60#) P. S. #103 Black Plate F.S. #346 Core
2. .0083" (75#) P. S. #103 Black Plate F.S. #346 Core
3. ASBESTOPAC 958 from Hollingsworth & Vose, F. S. #096
4. Water
5. Formula #597

OBSOLETE 5-26

PROCEDURE:

Assembling: Dept. 205 When individual sheets of VICTOCOR 150 are to be made, steel of proper gauge as required per the table below is perforated and cut to size, then assembled between two pieces of Hollingsworth & Vose ASBESTOPAC 958 of the gauge also specified in the table.

When VICTOCOR 150 is to be made on the continuous process equipment, the steel is set up to feed into the equipment between two continuous lengths of asbestos.

Combining: Dept 205 The assembled materials are combined on an individual sheet combiner or on the continuous process equipment. The following table correlates the proper core; the proper gauge and basis weight of asbestos facing; and the corresponding aim, combined, and final gauge of VICTOCOR 150:

Core Material, Steel Thickness, in.	H&V ASBESTOPAC 958 Basis Weight, lb/480 sq.ft. Nominal	Range	Thickness in.	VICTOCOR 150 Aim Gauge, in.	Combined Gauge, in.	Final Gauge, in.
.0066	55	52-58	.018-.022	.035-.037	.034-.039	.035-.040
.0083	67	63-70	.023-.027	.042-.044	.041-.046	.042-.047
.0083	78	74-81	.026-.030	.049-.051	.049-.054	.050-.055
.0083	82	78-86	.028-.033	.054-.056	.054-.059	.055-.060
.0083	105	100-110	.036-.042	.063-.065	.064-.069	.065-.070

Aim gauge is the desired gauge of material leaving the combiner. Combined gauge is the required gauge of material after having been combined and allowed to recover. Final gauge is the required gauge of finished gaskets that have been blanked, then coated with Formula #597 and baked (if required).

VPD-101-0001756

A very small amount of water may be used to moisten the rolls of the individual sheet combiner if necessary to prevent stick.

The continuous process equipment shall be operated with the roll surfaces at 180-210°F.

Inspection of Combined Material: Dept. 243

Before proceeding with an order after set-up, the Inspection Department shall examine and approve of the quality of the mechanical bond between the core and facing, by attempting to peel the facing from the core on both sides of combined material. It must not be possible to pull the facing from the core, with one exception: material is acceptable even though the facing may be pulled from the core, as long as the prongs remain somewhere between a condition of vertical after separation and a condition of .020" apart at each perforation, and the facing shows that the prongs have cut into the facing and not merely indented.

Finished material shall be free of creases, scuff marks, and warp.

Blanking:

Per analysis card.

Coating: Dept 217

When specified on the order, Formula #597 shall be applied to the blanked parts in accordance with Factory Standard #319.

Then the gaskets shall be baked in the #5 or #6 Precote oven for an 18-20 minute cycle during which the temperature is maintained at 280-300°F for at least 8 minutes, to dry the coating and cure the facing material.

Uncoated gaskets need not be baked unless specified on the order.

Flanging:

Per analysis card.

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Inspection of Gaskets: Dept. 243 — Gaskets shall be inspected per analysis card requirements. The final gauge shall be as specified in the above table.

Materials Engineering

▽ Indicates change.

Revised by:

J. A. Ulrich

Approved by:

V. J. Labrecque
Materials Engingeering

Approved by:

C. J. McNamara
Manufacturing

Copies to:

Application Engineering
Chief Engineer
Gasket Inspection
Gasket Prototype Shop
Gen. Foreman, Gasket Mfg.
Gen. Foreman, Material Mfg.
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Manufacturing Supt. Dept. 205
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Plant Mgr. - Havana
Qual.Cont.Mgr.-Chgo.
Qual.Cont.Mgr.-Havana
Raw Material Inspection
Tool Engineering

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cont'd.