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Mr. J.W. Cleaveland, Atlanta
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Parlin, N.J.
May 15, 1950

MR. RUSSELL MORGAN:

RC-800 FIELD TEST
WHITE FURNITURE CO.
MEBANE, N.C.

Attached is a joint report by Mr. L.L. Bryant and the writer. In general this customer's reaction was similar to that of Heywood-Wakefield, namely, the desired improvements in clarity, film toughness, resistance to solvents, etc. characteristic of the RC-800 finish, are desired but at no increase in cost. Also a higher solids, of the order of "DULUX" (i.e. 42% instead of 32%) would be welcome, to permit one coat application instead of two.

The present "DULUX" finish at the White Furniture Company is excellent in appearance, being very comparable to lacquer in this respect. This is probably attributable to the long bake (2 hours at 120-155°F. plus 6 hours at 155°F. plus 5 hours 120°F. to room temperature) plus care in processing.

Both the White Management and especially our people at Greensboro, (Messrs. Bindschadler, Bryant and Hurt) did everything possible to help out on the test. Without this exceptionally fine cooperation it would not have been possible to conduct this test successfully.

PARLIN LABORATORY

BY: C.J. Welz

CJW;GMM

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JOINT REPORT BY L.L. BRYANT AND C.J. WELZ

A. Purpose

To conduct a field test of RC-800 Clear on mahogany furniture.

B. Action Taken in Test

Two pilot chests showed that an additional six chests could be finished right on their conveyor using established drying time and temperatures.

System used on all eight pieces was:

Customer's NFL type stain
Tinted 1366 as wash coat
Customer's filler, dried 80 min. at
approx. 125°F. average

Fronts treated with stain out in 1 to 1 mixture alcohol and water, brushed on and wiped for color uniformity.

Tinted 1366 as sealer 1-1/2 hrs. A.D.

Customer's glazing stain dried as follows: 20 minutes at room temperature plus 1 hour ⁴⁵ of which 50 minutes were at a peak average temperature of 125°F. plus a cooling period of 1 hour.

Customer's shading stain

1 ct. RC-800 Clear flashed 12 minutes.
1 ct. RC-800 " " 1 hour
Baked in hot box - end of first hour temperature rose to 120°F.;
during the next 2 hrs. temperature went from 120 to 155°F.;
during the next 6 hrs. temperature averaged 155°F.;
and during the next 5 hrs. temperature gradually dropped to 120°F.

Three cases were rubbed as follows:

- A) Tops were machine sanded with new, faster cutting type "Wetordry" paper and EZ rubbing lubricant; then machine rubbed using pumice with a 30 pound rubbing machine and Grand Rapids EZ rubbing lubricant (vegetable type) was used as lubricant throughout.

Fronts and ends were machine sanded with 360 paper and EZ rubbing lubricant.

Tops and ends were steelwooled dry and waxed. Fronts were steel woolled dry, hand compounded with waste and KENITE #600 hand compound and finally polished with duPont #7 Polish.

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It was estimated that this rubbing of RC-800 amounted to 10% increased labor over present production rubbing of RK-5760.

- B) Rubbed exactly the same as A) except that top and ends received hand compounding and polishing similar to fronts under A).
- C) Tops rubbed the same as A). Front and ends machine sanded with 360 paper and EZ lubricant and then steel woolled dry and waxed.

Present coverage with 1 coat of RK-5760 is approximately 10 chests per gal. Coverage obtained with RC-800 was 4 chests/gallon for the 2 coat application or 8 chests/gallon each coat. Film build on panels indicate about 1/3 more build with RC-800.

Upon completion of tests pieces were lined up and following comments received:

Bill Van Liere - Finishing Superintendent. He was most enthusiastic about the clarity obtained. The clarity of C) was even superior to the clarity of present production which in itself is excellent today. The clarity of A and B was greatly superior to present production. Van Liere objected to orange peel and the fact a low solids non-sanding type of sealer was used. He was justified in the matter of orange peel but there is a question in our mind regarding the necessity of a sanding type sealer being necessary.

Phonse Bean - General Superintendent - The clarity is outstanding but it also has the tendency to show up any defects such as cross sanding serpentine fronts with 7/0 paper. The orange peel must be eliminated. The increased cost and necessity of 2 coats are most objectionable today with buyers trying to obtain merchandise at lower prices. He is against any increase in costs.

Unfortunately Steve Millender, Sales Manager, was not available this week to examine pieces or to give us his comments. These pieces will be held to observe appearance on aging and Millender's comments will be obtained at first opportunity.

Conclusions - 1. Except for orange peel present, RC-800 could be placed on their conveyor line tomorrow. The first coat could be sprayed in shading stain booth and the shading stain in another booth easily constructed.

2. We believe that by eliminating present orange peel and using rubbing procedure C) that improved clarity could be obtained with no increase in processing cost.

L.L. BRYANT

LLB-CJW:GRM

C.J. WELZ

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RC-800 FIELD TEST
W.W. KIMBALL COMPANY
CHICAGO, ILL.

Joint Report by R.J. Baruth and G.G. Murphy

Purpose

The purpose of this visit was to finish a piano case in the subject customer's plant in the RC-800 system in order to obtain an expression of opinion from him regarding the desirability of using this finish on piano cases.

Conclusions

One Model #72 Mahogany Spinet piano was finished in the RC-800 system and the results were discussed with Mr. Osterhout.

The superior appearance, mar, scratch and solvent resistance was demonstrated to Mr. Osterhout. Its shorter baking schedule was also brought to his attention. While it was not possible to determine how much extra processing this finish required on this test, Mr. Osterhout was given an estimate based on previous experience that approximately one-third more work might be required than in his present system.

Mr. Osterhout was impressed by the appearance of the piano particularly the clarity, depth, and "life" it showed. He was definitely interested in the shorter drying schedule and stated that this might be one means of counter-acting the extra cost of the RC-800 finish, and the extra cost of processing it. He also felt that its scratch, mar and solvent resistance were desirable.

In answer to the following specific questions, Mr. Osterhout stated:

(1) Do you think that this finish would improve the saleability of Kimball pianos?

Answer: It certainly wouldn't hurt their sales, and at the same cost they would be interested in this finish.

(2) Do you feel that the RC-800 finish is sufficiently superior to warrant the extra price?

Answer: We are now getting a premium for blonde and high polish pianos but this question will have to be answered by Mr. Sill, Vice President in charge of Sales. From my standpoint, a production standpoint, my job is to get costs down.

Action Needed

It is recommended that the RC-800 finished piano be held for inspection by Mr. Sill and a discussion with him regarding the test be held by Chicago Sales.

DETAILS OF THE TEST

The finishing system employed in this test is as follows:

Stain: Competitive NGR stain (air dried min. of 6 hrs.)
W.C.: Competitive (air dried min. of 16 hrs.)
Filler: Competitive (" " " " 24 ")
Sealer: 1366 1 coat air dried approx. 1 hr.
Topcoats: 3 coats of 27% T.S. RC-800 Clear topcoat 1/2 hr.
 between 1-2 coats; 3 hrs. dry between 2-3 coats.
 Entire system air dried 4 days then baked overnight
 at 120°F., 20% R.H.

Finished parts processed as follows:

Sanded #320 paper - Sundstrand sander

Rubbed 00 steel wool and F.F.F. pumice

The piano top, fall board, music rack and stand showed a rub thru between coats when processed. This rub through exhibited itself as a scaly appearance which increased with extra rubbing and could only be removed by completely rubbing off the top layer of top coat.

The parts were then recoated with two coats of RC-800 topcoats, air dried overnight and baked 8 hours at 130°F., 21% R.H.

Estimated film build on the recoated parts after processing is 4.5 mils, on the other parts 2.5 mils.

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