

7-1-64
SUPERSEDED

PLASTIC CEMENT

Dep. 112

<u>Formula/Batch</u>	<u>Lbs.</u>	<u>Gal.</u>	<u>Total Weight</u>
40/50 Cutback (7.5 lbs/gal)	1853	236	43.2 49.8
Limestone Dust	1200		31.2
7.5 Asbestos	500		13.6
Kerosene	68	10	1.8
	<u>3621 lbs.</u>		<u>100.0</u>

Shrinkage : 5.1 Yield: 3497 lbs. (317.9 gals) 11.0 lbs/gal approx.

Process : The Cutback is metered in the mixing kettle. Then the Asbestos is added, followed by the Limestone and Kerosene. This is mixed for 30 minutes. Sample shall be taken and brought to FSL for consistency test before panning.

Consistency : Conatte Vis. : 77 degrees, 6 75
10 25 Sec. Min. 45 Sec. Std.
10 25 Sec. Max.

Standard Crew: 2 men making 423.9 gals/cre. Hr. for 10 lb. cans
3 " " 423.9 " " 50 lb. cans

Filling & Finishing 10 lb. 50 lb.
gals/cre. hour 50 75

DISCONTINUED

5-22-73

PLASTIC CEMENT ✓

DEPT 112

Thickness: Medium troweling

Primary Use: Caulking & Sealing holes on roofs

<u>Formula/Batch</u>	<u>Lbs.</u>	<u>Quan</u>	<u>\$ by wt.</u>
40/50 cutback	1932	250 gal.	62.8 55.8
7.5 Asbestos	450 500	5 1/2 bags	14.4
Limestone filler	640 740	12 8 bags	28.5 27.8
Kerosene	100 69	10 1/2 gal.	3.3 2.0
TOTAL	3125 3461		100.0

STD. Yield: 62.5 - 5 gal. pails or 312.5 - 10 gal. cans

Loss: 0% wt/gal. 9.506 lbs. (cement)

Process: The asphalt cut back is pumped and metered into #1 or #2 mixing kettle with the paddles turning. After 1/2 of the cutback is in, the addition of asbestos is started by breaking the lumps by hand through a 3 1/2" grill opening on top of the kettle. After the asbestos is in the limestone fi is added and the pails of kerosene are poured in. Then the batch is mix for 30 min. before testing or driving. One batch each day is tested by FSL and any necessary formula adjustments are made.

Plain 29 gauge pails are labeled by applying the adhesive with a paint brush to the back of the label and pasting to the side of the pail. The 10 gal. cans are lithographed.

002498

SUPERSEDED

1-18-57

PLASTIC CEMENT

Dept. Fbu

Formula	Lbs.	Gals.	% by Weight
#14 Asphalt (142°)	1472	-	35.5
Std. White Oil (6.88#/gal.)	664	95	16.0
Sovasol #5 (6.58#/gal.)	164	25	4.0
#6 Fuel Oil (8.14#/gal.)	122	15	3.0
#1 Asbestos (7D)	409	-	9.9
#169 Soapstone	654	-	15.8
Bagged FBW Dust	654	-	15.8
Total	4139		100.0

Shrinkage: 5%Yield: 3932 lbs. (370 gals.), Wt./gal. 10.62 lbs.

Process: Pump #14 Asphalt (300°F. into Dopp Kettle and then start agitator to run at fast speed. Pump in Std. White Oil and then Sovasol #5. Dump in pails of Fuel Oil and follow by screening in Asbestos, Soapstone, and Dust. Mix for 30 min., take sample for testing and OK by FBC. Reduce agitator speed to slow and run until kettle is empty.

Consistency: Schutte Vis. @ 77°F Sec.

Min.	Std.	Max.
6.0	7.5	9.0

(over)

PLASTIC CEMENT

Dept. Fbu

Formula	Lbs.	Gals.	% by Weight
#14 Asphalt (142°)	1472	-	35.5
Std. White Oil (6.88#/gal.)	664	95	16.0
Sovasol #5 (6.58#/gal.)	164	25	4.0
#6 Fuel Oil (8.14#/gal.)	122	15	3.0
#1 Asbestos (7D)	409	-	9.9
#169 Soapstone	654	-	15.8
Bagged FBW or Funkhouser Dust	654	-	15.8
Total	4139		100.0

Shrinkage: 5%Yield: 3932 lbs. (370 gals.), Wt./gal. 10.62 lbs.

Process: Pump #14 Asphalt (300°F.) into Dopp Kettle and then start agitator to run at fast speed. Pump in Std. White Oil and then Sovasol #5. Dump in pails of Fuel Oil and follow by screening in Asbestos, Soapstone, and Dust. Mix for 30 min., take sample for testing and OK by FBC. Reduce agitator speed to slow and run until kettle is empty.

Consistency: Schutte Vis. @ 77°F. Sec.

Min.	Std.	Max.
6.0	7.5	9.0

This cement meets Government Spec. SS-C-153, Type I

002127

-over-

PLASTIC CEMENT

DEPT. FBC

#14 Asphalt 332 lbs.
Kerosene 135 " (20.4 gals.)
Asbestos EX 114 "
80-200 Soapstone 175 "

Material loss in manufacturing approx. 1%

Yield - 750 lbs. Sp. gr. of finished product 1.30 (10.8 lbs. per gal.)

Every batch to be tested and approved by laboratory before filling containers.

Consistency by Schutte Penetrometer @ 77°F: Max. 9 secs.
Stand. 13 "
Min. 17 "

Process: #14 available at 220°F. Run this into mixing tank and immediately commence to add all asbestos and 15 gals. of kerosene slowly with thorough mixing. Then slowly add the soapstone, and finally complete the quantity of kerosene called for.

Put up for shipment in following containers:

1 lb. net. Friction top cans 3 1/2" D x 3 5/8". 12 cans packed in .060 fibre case 14 5/8" x 11 1/8" x 3 7/8" with inside case 14 1/8" x 10 5/8" x 3 5/8" together with one piece 14" x 10 5/8" and one piece 14" x 5" cut from .060 fibre case for dealers' display. Cans labeled, form #7262-A. Ship. wt. 18 lb.

5 lb. net. Friction top cans 5 3/8" D x 6 3/4" with bail handles. 6 cans packed in .060" fibre case 11 7/8" x 16 1/4" x 6 3/4" inside dimensions. Cans labeled, form #7262-B. Ship wt. 37.3 lbs.

10 lbs. net. Friction top cans 6 5/8" D x 8 1/2" with bail handles. 4 cans packed in .080" fibre case 15 3/8" x 13 3/8" x 8 1/2" inside dimensions.

Cans labeled, form #7262-C. Ship. wt. 47.5 lbs.

(OVER)

002105