

Feeling PLANT

#34 Acid Resistant

Workman DEPT.

Sheet Packing

457

PAC

I. BASIS FORMULA

Spec. No.	Ingredients	Weight	Percent
6300	Processed Buna - GRS 1012	57# - 0 oz.	22.3%
P.S. 63345	Sulphur (Rubber Maker's)	3 - 0	1.2
6201	Tunda TMD	2 - 0	1.0
6202	Captan OTI	1 - 0	0.3
FF-1475-1	Zinc Oxide	3 - 0	1.2
63227	Agarite Powder or Neozone D	1 - 0	0.4
FF-6194-1	Standard Grade Carbon Black	25 - 0	9.8
P.S. 61226	Type C Silica Sand	43 - 0	16.3
P.S. 1900	Blended Hino Asbestos Fibre (Crocidolite) or AX25454 Fibre	120 - 0	47.0
	Totals	254# - 0 oz.	100.0%

P.S. FF-0655-1 Petroleum Rubber Solvent Naphtha

II. PREPARATION OF PROCESSED BUNA

Pass the Buna once through a cool rubber mill or a cool three-roll calender with rolls tight together in order to sheet out thin. Put 28% of the above sheeted Buna into a can containing approx. 13 gals. Naphtha. Let soak for 48 hours to properly swell the Buna.

NOTE: 4 gallons of Bunjay may be substituted for an equal quantity of Naphtha when necessary to properly swell the Buna.

III. MIXING PROCEDURE IN ROSS MIXER

1. Dump 2 cans containing Buna and Naphtha along with Dry Compounds into mixer then start mixer.
2. Run mixer 10 minutes.
3. Start mixer, add 14 gallons naphtha. Start willow and feeder and add approx. 75# Fiber. Run mixer 35 minutes.
4. Start mixer, add 8 gallons naphtha. Start willow and feeder and add the remaining fiber. Run mixer 25 minutes.
5. Start mixer and add 8 gallons naphtha. Run mixer 30 minutes.
6. Start mixer and add 5 gallons naphtha. Run mixer 10 minutes.
7. Start mixer, add 15 gallons naphtha. Run mixer 5 minutes.
8. Start mixer, add 5 gallons naphtha, and dump. When dumping, plug is removed and added to the next batch.

- Notes: (a) In extreme hot weather V&P Naphtha may be substituted for Petroleum Naphtha
(b) Mixing time and gasoline addition may be varied at the discretion of the Production Supt.

RETURN TO
J-M RESEARCH
FILE ROOM

X—INDICATES CHANGE REASON:

I - Correct Purchase Spec. No.
XX - Add AX25454 Fibre

AUTHORITY FOR CHANGE

I - Correction
XX - A. D. Carlson's letter of 12-5-57 to H. E. Mies

FILE-HOLDERS

Mvl.

Lab

Res.

P&S

SUPPL. QUAL. CONTROL

PROD. SUPT.

PLANT FINANCE OFFICE

RESEARCH LAB.

MGR. QUAL. CONTROL

SUPERSEDES: Same Spec. and page, dated 3-22-55

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