

MANUFACTURING PROCESS OF A/C PIPE

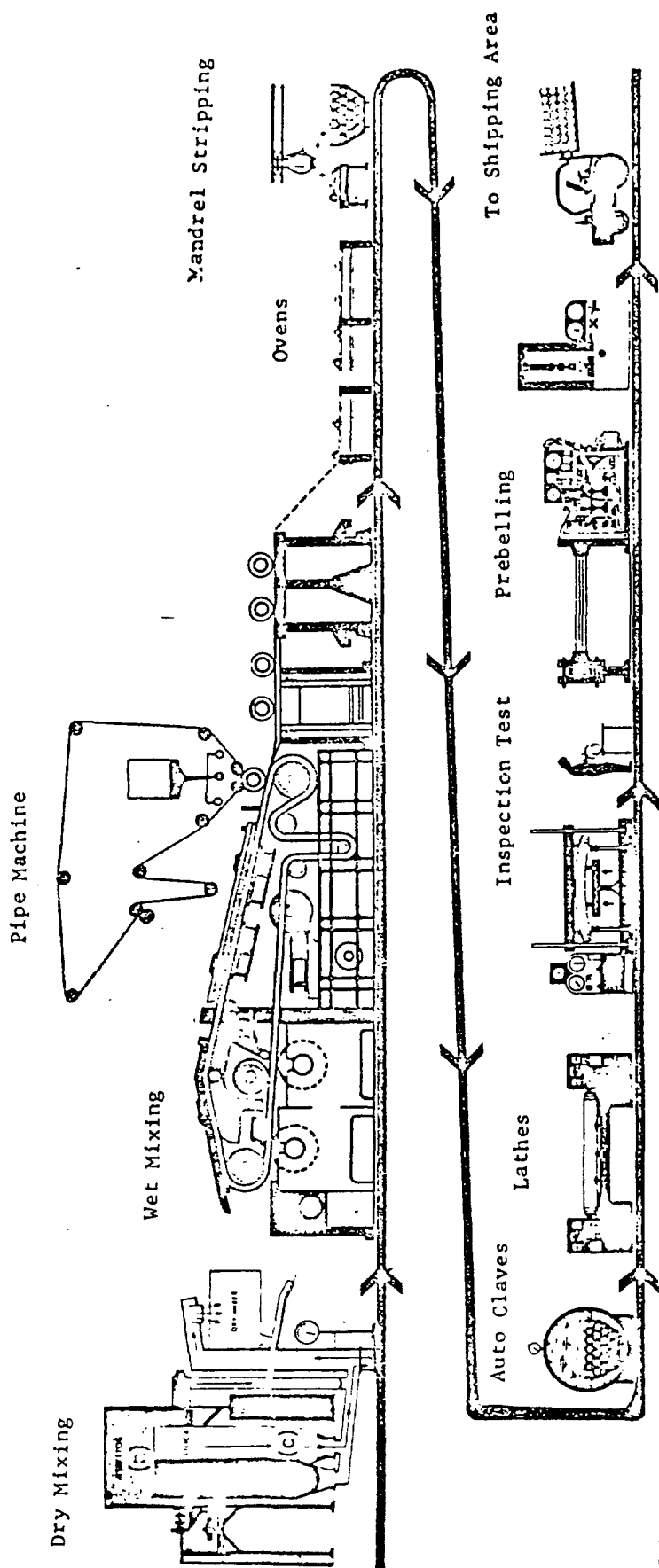
Attached is a basic flow diagram demonstrating the manufacturing process of Asbestos Cement Pipe.

In the dry mixing stage, closely controlled amounts of asbestos fiber, cement and silica are blended. Water is then added to this mixture to form a slurry. This slurry is formed under pressure on a precision sized mandrel on the pipe machine to form the actual Asbestos Cement Pipes. The pipes, still formed on the mandrel, are sent through ovens for an initial cure. The mandrels are then removed leaving a smooth precise bore. The pipe is then sent to high pressure steam autoclaves where controlled temperature and moisture impact chemical stability and physical strength to the pipe. Fully automated lathes accurately machine pipe ends to meet national specifications. Various hydrostatic, flexure and compression tests are then performed to assure compliance with rigid requirements for burst, beam strength, and crush resistance. With the exception of Small Diameter Sewer (4" & 6") the pipe is then factory prebelled with one coupling and Fluid-Tite gasket. Pipe is then stored in a wide variety of sizes and classes available for immediate shipment.

PLAINTIFF'S EXHIBIT

CT-1356

CTD002074



MANUFACTURE OF — ASBESTOS CEMENT PIPE

History of Dust Collectors in Ambler Plant

Location	Volume CFM	Installation Date	Remarks
1. Outside Silica Tank	1000	1957	Still in use.
2. Inside Silica Tank	1000	1964	Still in use.
3. Outside Cement Tank	1000	1954	Still in use.
4. Inside Cement Tank	1000	1964	Still in use.
5. Fines Bin	1000	1964	Still in use.
6. No. 1 Mixing System Dust Collector	8250	1964	Inactive since No. 1 Pipe Machine was shut down 11/1964
7. No. 2 Mixing System Dust Collector	8250	1964	Still in use.
8. Finishing Department Lathe Lines	10900	1964	Still in use.
9. Finishing Department Fitting Area	15260	1964	Still in use.
10. Finishing Department Saws	4100	1961	Still in use, but will be replaced in 1/1979.
11. Scrap Crusher	5500	1962	Same as above.
12. Shotblaster	1000	1970	Still in use.

Dust Collector Equipment that was Replaced

13. Finishing Department Saws	3000	-	Replaced in 1961 by 4100 CFM dust collector. See item #10.
14. Random Saw	3700	-	Replaced in 1964. See item #9.
15. No. 1 Mixing System	3400	-	Replaced in 1964. See item #6.
16. Fittings Area	3100	-	Replaced in 1964. See item #9.

CFM - cubic feet per minute

November 1978

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CTD002076

FLOW DIAGRAM FOR A-C PIPE PLANT

