

FORM PS27 8-62

TECHNICAL SPECIFICATIONS

CERTAIN-TEED PRODUCTS CORPORATION ASBESTOS CEMENT PIPE	NUMBER: 532	PAGE 1
	SUPERSEDES: Sept. 20, 1966	DATE OF ISSUE: March 22, 1967
APPLICABLE TO: Plants 56, 57, 58, 59, and 60		CLASSIFICATION: Purchasing Specification
DESCRIPTION: Steel Mandrels		
<u>GENERAL</u> This specification has been devised to define the steel mandrel requirements for use in the Mazza type manufacture of asbestos-cement pipe. <u>MATERIAL</u> Type A - Cold drawn, seamless mechanical steel tubing, maximum carbon content 0.25%, unannealed, chamfered ends. Type B - Centrifugally cast 1025 carbon steel tubing, normalized and tempered, O.D. (outside diameter) machined to 125 micro finish, I.D. (inside diameter) as cast, ends faced and radiused. Finish per ASA B 46.1. Pulling Ring - Flat bar stock, 1040 or 1045 carbon steel. Pulling Bar - Round bar stock, 1010 min. Carbon steel or 1025 carbon steel. <u>STRAIGHTNESS</u> Maximum curvature per foot not to exceed +0.010" in sizes up to 5" and +0.015" in sizes over 5", tubing only. Cast steel mandrels shall have a T.I.R. (Total Indicator Reading) not to exceed 0.050" at center. <u>MARKING</u> The pulling ring of each mandrel 7.51" and larger shall be identified with the nominal outside mandrel diameter applied as follows. Use small stainless steel manual electrode to provide numbers at least 3/4" high, raised approximately 1/8", and completed in a neat, legible manner. Mandrels below 7.50" having smaller pulling rings are to be identified as above, except numbers shall be reduced in size according to the pulling ring "Y" dimension.		
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CTD012692